LIVE CENTRES
FACE DRIVERS

EDITION 8
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LIVE CENTRES | FACE DRIVERS

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MZK 2030

Solid centres
FZS 2034

Constant face drivers
CoE - turning and milling 2040
CoA - turning 2043
CoK - power-operated 8-80 mm 2052

Special solutions 2055
# Operation guide

## PRO

<table>
<thead>
<tr>
<th>Size MT</th>
<th>Workpiece weight max. (kg)</th>
<th>Concentricity deviation max. (mm)</th>
<th>Speed max min⁻¹</th>
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## PRO with HMG Pro

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<td>120 240 360 500 1000 1800</td>
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## H Pro

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## HG Pro

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## PRO & ORANGE LINE

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2002  | www.eshop.roehm.biz
### Operation guide

#### HEAVY SPEED

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#### SLIM

| Size MT | 2 | 3 | 4 | 5 | 6 | Workpiece weight max. (kg) | 200 | 400 | 800 | 1600 | 3500 | 170 | 340 | 700 | 1400 | 3000 | 50 | 100 | 150 | 180 |
|---------|---|---|---|---|---|----------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| Concentricity deviation max. (mm) | 0,005 | 0,01 | 0,02 | 0,008 | 0,01 | 0,02 | 0,008 | 0,01 |
| Speed max min⁻¹ | 7000 | 7000 | 6300 | 4300 | 3000 | 7000 | 7000 | 6300 | 4300 | 3000 | 7000 | 7000 | 6300 | 4300 |
| Page    | 2020 | 2021 | 2022 |

#### CONTROL FLEX

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## MZK Revolving centering tapers

### Pointed

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<td>0.01</td>
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<td></td>
<td>0.015</td>
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</tr>
<tr>
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### Revolving centering tapers with interchangeable inserts

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### Fixed shafts with interchangeable inserts and draw-off nut

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**Operation guide**

www.eshop.roehm.biz
### Operation guide

#### FZS Solid centres

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Page: 2034

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#### FZS Solid centres With full carbide tip

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#### FZS Solid centres Full point

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#### FZS Solid centres Full point, draw-off nut and SW

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#### FZS Solid centres Half point with carbide insert

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#### FZS Solid centres Half point, draw-off nut, SW and extended point

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#### FZS Solid centres Full point, carbide insert and regrinding line

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#### FZS Solid centres Half point

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Solid centres in high precision design on request.

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
THE RIGHT LIVE CENTRE FOR EVERY APPLICATION

For small and large centres
For cramped work area
For lower-lying centres
For large boreholes
The requirement for high cutting capacities and high working precision demands an additional support by a revolving live centre for many workpieces due to their shape and length. Thanks to their precision bearings, RÖHM live centres offer optimal force absorption and a maximum concentricity deviation of up to 0.003 mm. The centre points are maintenance-free thanks to the lifetime lubrication.

ADVANTAGES AT A GLANCE

- Maximum concentricity and optimal force absorption thanks to proven precision bearings
- Special lubrication for long service life and little required maintenance
- Minimum interference contour thanks to slender housing shape

Shaft hole for easy centre point change

Lip seal and spray water groove as protection against the penetration of cooling lubricant

Support surface for ensuring the full loadability of the axial bearing

Shaft ground true to gauge size in acc. with DIN 228 AT5 for narrow tolerance and maximum concentricity

Precise roller and needle bearings for maximum concentricity for long service life

Centre point with wear-proof carbide insert, can be reground several times and has shaft bearing
Pro - carbide insert

APPLICATION
For counter-clamping workpieces on turning and grinding machines.

TYPE
Centre point with wear-proof carbide insert.

CUSTOMER BENEFITS
- Maximum service life and wear resistance thanks to carbide insert
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

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A06
HM Pro with carbide insert, body hardened and ground - tip angle 60°

Radial load
- Workpiece in kg
- Service life of roller bearings: 2000 operating hours

Axial load
- Workpiece in daN
- Service life of roller bearings: 2000 operating hours

www.eshop.roehm.biz
Pro - carbide insert

APPLICATION
For counter-clamping workpieces on turning and grinding machines.

TYPE
Centre point with wear-proof carbide insert. With draw-off nut.

CUSTOMER BENEFITS
- Maximum service life and wear resistance thanks to carbide insert
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06
HMG Pro with draw-off nut and carbide insert, body hardened and ground - tip angle 60°

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www.eshop.roehm.biz
Pro - standard design

APPLICATION
For counter-clamping workpieces on turning and grinding machines.

TYPE
All-round live centre in classical design for nearly any standard clamping situation.

CUSTOMER BENEFITS
- Proven 3-fold bearing for high axial and radial load
- Lifetime lubrication for minimum required maintenance
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground (MT 1 - Metr. 80)
- Tip angle 60°

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1) Body only ground not hardened

www.eshop.roehm.biz
Pro - standard design

APPLICATION
For counter-clamping workpieces on turning and grinding machines.

TYPE
All-round live centre in classical design for nearly any standard clamping situation.
With draw-off nut.

CUSTOMER BENEFITS
- Proven 3-fold bearing for high axial and radial load
- Lifetime lubrication for minimum required maintenance
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground (MT 2 - 6)
- Tip angle 60°

A06
HG Pro with draw-off nut, body hardened and ground - tip angle 60°

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Version with extended centre point on request

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APPLICATION
For counter-clamping of workpieces on turning and grinding machines using lathe chucks, collet chucks and tool take-ups. Take-up for tool magazine / turret.

TYPE
All-round live centre with cylinder shaft.

CUSTOMER BENEFITS
- Proven 3-fold bearing for high axial and radial load
- Lifetime lubrication for minimum required maintenance
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

Note:
Live centres with cylindrical shank and with clamping surface on request

A06
HZA Pro with cylindrical shank, body hardened and ground - tip angle 60°

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Radial load
Workpiece in kg
Service life of roller bearings: 2000 operating hours

Axial load
Axial load in daN
Service life of roller bearings: 2000 operating hours

www.eshop.roehm.biz
Live centres

Pro - high precision design

APPLICATION
For counter-clamping workpieces on turning and grinding machines for highest demands.

TYPE
High precision design.

CUSTOMER BENEFITS
- Maximum concentricity deviation of 0.003 mm for maximum precision
- Lifetime lubrication for minimum required maintenance
- Proven 3-fold bearing for high axial and radial load

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06
HP Pro precision version, body hardened and ground - tip angle 60°

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www.eshop.roehm.biz
Pro - extended centre point

APPLICATION
For counter-clamping workpieces on turning and grinding machines. Especially suited for cramped work area between centre point and workpiece.

TYPE
All-round live centre with extended centre point.

CUSTOMER BENEFITS
- Enlarged work area and better workpiece accessibility thanks to extended centre point
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06
HVL Pro with extended centre point, body hardened and ground - tip angle 60°

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Version with draw-off nut on request

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Pro - profiled, extended centre point

**APPLICATION**
For counter-clamping workpieces on turning and grinding machines. Especially suited for cramped work area between centre point and workpiece as well as low-lying workpiece centres.

**TYPE**
All-round live centre with profiled and extended centre point.

**CUSTOMER BENEFITS**
- Enlarged work area and better workpiece accessibility thanks to profiled and extended centre point
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

**TECHNICAL FEATURES**
- Body hardened and ground
- Tip angle 60°

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<td>K mm</td>
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Version with draw-off nut on request

---

Radial load
- Workpiece in kg
- Service life of roller bearings: 2000 operating hours

Axial load
- Axial load in daN
- Service life of roller bearings: 2000 operating hours
Orange Line

APPLICATION
For counter-clamping workpieces on turning and grinding machines.

TYPE
All-round live centre in classical design for all basic requirements for turning machining.

CUSTOMER BENEFITS
- Centre point through-hardened and therefore can be reground as desired
- Lifetime lubrication for minimum required maintenance
- Good price/performance ratio

TECHNICAL FEATURES
- Body ground
- Tip angle 60°

Note:
- For higher rotation Speed at reduced lateral load

Radial load

<table>
<thead>
<tr>
<th>Workpiece in kg</th>
<th>Service life of roller bearings: 2000 operating hours</th>
</tr>
</thead>
<tbody>
<tr>
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<tr>
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Axial load

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<td>D mm</td>
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<tr>
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<td>44,399</td>
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A06
Orange Line, body only ground- tip angle 60°
Heavy - extended centre point

APPLICATION
For counter-clamping especially heavy workpieces on turning and grinding machines. Especially suitable for use on NC-machines.

TYPE
Universal version with extended centre point for heavy workpieces.

CUSTOMER BENEFITS
- Robust 4-fold precision bearing for high speeds as well as high axial and radial loads
- Reliable and safe clamping of heavy workpieces
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

Radial load
Workpiece in kg
Service life of roller bearings: 2000 operating hours

Axial load
Axial load in daN
Service life of roller bearings: 2000 operating hours

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<td>180</td>
</tr>
<tr>
<td>B mm</td>
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<td>95</td>
<td>120</td>
</tr>
<tr>
<td>D mm</td>
<td>32</td>
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<tr>
<td>G mm</td>
<td>31,267</td>
<td>44,399</td>
<td>65,348</td>
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<td>26</td>
</tr>
<tr>
<td>K mm</td>
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<td>59,5</td>
<td>76</td>
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<td>5500</td>
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**Heavy - extended centre point**

**APPLICATION**
For counter-clamping especially heavy workpieces on turning and grinding machines. Especially suitable for use on NC-machines.

**TYPE**
Universal version with extended centre point for heavy workpieces. With draw-off nut.

**CUSTOMER BENEFITS**
- Robust 4-fold precision bearing for high speeds as well as high axial and radial loads
- Reliable and safe clamping of heavy workpieces
- Maximum concentricity deviation of 0.005 mm for maximum precision

**TECHNICAL FEATURES**
- Body hardened and ground
- Tip angle 60°

---

**A06**
Heavy with draw-off nut, especially for high load at high speeds, body hardened and ground - tip angle 60°

<table>
<thead>
<tr>
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<tr>
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<td>B mm</td>
<td>70</td>
<td>95</td>
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</tr>
<tr>
<td>D mm</td>
<td>32</td>
<td>42</td>
<td>58</td>
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<tr>
<td>G mm</td>
<td>31,267</td>
<td>44,399</td>
<td>63,348</td>
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<tr>
<td>J mm</td>
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<td>26</td>
</tr>
<tr>
<td>K mm</td>
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<td>59,5</td>
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</table>

**Radial load**
- Workpiece in kg
- Service life of roller bearings: 2000 operating hours

**Axial load**
- Axial load in daN
- Service life of roller bearings: 2000 operating hours

---

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Speed - extended centre point

APPLICATION
For counter-clamping workpieces on turning and grinding machines. Especially suitable for complex machining at high speeds.

TYPE
Special design for very high speeds with extended centre point and wear-resistant carbide insert.

CUSTOMER BENEFITS
- Maximum rigidity for high speeds up to 12000 rpm thanks to compact design
- Enlarged work area and better workpiece accessibility thanks to extended centre point
- Maximum concentricity deviation of 0.01 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06 Speed extended NC-centre point with carbide insert, for high speed, body hardened and ground - tip angle 60°

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<td>141</td>
<td>141</td>
</tr>
<tr>
<td>B mm</td>
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<td>45</td>
<td>66</td>
<td>66</td>
</tr>
<tr>
<td>C mm</td>
<td>7</td>
<td>7</td>
<td>11</td>
<td>11</td>
</tr>
<tr>
<td>D mm</td>
<td>20</td>
<td>20</td>
<td>32</td>
<td>32</td>
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<tr>
<td>G mm</td>
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<td>23,825</td>
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<td>44,389</td>
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<td>K mm</td>
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<td>63</td>
<td>63</td>
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<td>1600</td>
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<td>100</td>
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<td>250</td>
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<td>0,01</td>
<td>0,01</td>
<td>0,01</td>
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Slim - standard design

APPLICATION
For counter-clamping workpieces on turning and grinding machines. Especially suited for cramped work area between centre point and workpiece.

TYPE
Compact design with minimum casing diameter.

CUSTOMER BENEFITS
- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter
- Maximum rigidity at high speeds thanks to compact design
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06
Slim with small casing diameter, body hardened and ground - tip angle 60°

<table>
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<tr>
<td>Size</td>
<td>02</td>
<td>04</td>
<td>06</td>
<td>10</td>
<td>14</td>
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<tr>
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<td>62</td>
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<td>105</td>
<td>143</td>
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<td>32</td>
<td>34</td>
<td>42</td>
<td>58</td>
<td>80</td>
</tr>
<tr>
<td>D mm</td>
<td>15</td>
<td>15</td>
<td>20</td>
<td>30</td>
<td>42</td>
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<tr>
<td>G mm</td>
<td>17,78</td>
<td>23,825</td>
<td>31,267</td>
<td>44,399</td>
<td>63,348</td>
</tr>
<tr>
<td>K mm</td>
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<td>19,5</td>
<td>24,5</td>
<td>37</td>
<td>49,5</td>
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</table>

Radial load
Workpiece in kg
Service life of roller bearings: 2000 operating hours

Axial load
Axial load in daN
Service life of roller bearings: 2000 operating hours

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Slim - extended centre point

**APPLICATION**
For counter-clamping workpieces on turning and grinding machines. Especially suited for cramped work area between centre point and workpiece as well as low-lying workpiece centres.

**TYPE**
Compact design with minimum casing diameter. With extended centre point.

**CUSTOMER BENEFITS**
- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter and extended centre point
- Maximum rigidity at high speeds thanks to compact design
- Maximum concentricity deviation of 0.008 mm for maximum precision

**TECHNICAL FEATURES**
- Body hardened and ground
- Tip angle 60°

---

**A06**
Slim with small casing diameter and extended centre point, body hardened and ground - tip angle 60°

<table>
<thead>
<tr>
<th>Item no.</th>
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<td>6</td>
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<td>Size</td>
<td>02</td>
<td>04</td>
<td>08</td>
<td>10</td>
<td>14</td>
</tr>
<tr>
<td>A mm</td>
<td>73</td>
<td>74</td>
<td>88,6</td>
<td>119</td>
<td>164</td>
</tr>
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<td>B mm</td>
<td>32</td>
<td>34</td>
<td>42</td>
<td>58</td>
<td>80</td>
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<tr>
<td>G mm</td>
<td>17,78</td>
<td>23,825</td>
<td>31,267</td>
<td>44,399</td>
<td>63,348</td>
</tr>
<tr>
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<td>29,5</td>
<td>32</td>
<td>37,5</td>
<td>51,5</td>
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<tr>
<td>J mm</td>
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<td>11</td>
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<td>14</td>
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<td>0,008</td>
<td>0,008</td>
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<td>7000</td>
<td>6300</td>
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**Radial load**
Workpiece in kg
Service life of roller bearings: 2000 operating hours

**Axial load**
Axial load in daN
Service life of roller bearings: 2000 operating hours

---

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# Slim - profiled, extended centre point

**APPLICATION**
For counter-clamping workpieces on turning and grinding machines. Especially suited for cramped work area between centre point and workpiece.

**TYPE**
Compact design with minimum casing diameter. With extended and profiled centre point.

**CUSTOMER BENEFITS**
- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter and extended and profiled centre point.
- Maximum rigidity at high speeds thanks to compact design.
- Maximum concentricity deviation of 0.008 mm for maximum precision.

**TECHNICAL FEATURES**
- Body hardened and ground
- Tip angle 60°

---

**A06**
Slim with small casing diameter and profiled and extended centre point, body hardened and ground - tip angle 60°

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<th>1243509</th>
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<tr>
<td>Size</td>
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<td>04</td>
<td>08</td>
<td>10</td>
</tr>
<tr>
<td>A mm</td>
<td>73</td>
<td>74</td>
<td>88,5</td>
<td>119</td>
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<tr>
<td>B mm</td>
<td>32</td>
<td>34</td>
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<td>58</td>
</tr>
<tr>
<td>D mm</td>
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<td>15</td>
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<tr>
<td>G mm</td>
<td>17,76</td>
<td>23,825</td>
<td>31,267</td>
<td>44,399</td>
</tr>
<tr>
<td>K mm</td>
<td>29,5</td>
<td>32</td>
<td>37,5</td>
<td>51,5</td>
</tr>
<tr>
<td>P mm</td>
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<td>10</td>
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<tr>
<td>R mm</td>
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**Radial load**
- Workpiece in kg
- Service life of roller bearings: 2000 operating hours

**Axial load**
- Axial load in daN
- Service life of roller bearings: 2000 operating hours

---

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
Control - standard design

APPLICATION
For counter-clamping workpieces on turning and grinding machines. Optimally suited as counter-centre for face drivers.

TYPE
With pressure display and length compensation.

CUSTOMER BENEFITS
- Fast adjustment and check of axial load by means of pressure display
- Resilient centre point for safe, deformation-free workpiece clamping
- Maximum concentricity deviation of 0.01 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06
AC Control with pressure display and length compensation as counter-centre for face drivers, body hardened and ground - tip angle 60°

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<td>72</td>
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<td>D mm</td>
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<td>44,399</td>
<td>63,348</td>
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<tr>
<td>K mm</td>
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¹ At max. axial load

Radial load
Workpiece in kg
Service life of roller bearings: 2000 operating hours

Axial load
Axial load in daN
Service life of roller bearings: 2000 operating hours

www.eshop.roehm.biz
CONTROL - extended centre point

APPLICATION
For counter-clamping workpieces on turning and grinding machines. Especially suited as counter-centre for face drivers as well as for cramped work area between centre point and workpiece.

TYPE
With pressure display, length compensation and extended centre point.

CUSTOMER BENEFITS
- Fast adjustment and check of axial load by means of pressure display
- Enlarged work area and better workpiece accessibility thanks to extended centre point
- Resilient centre point for safe, deformation-free workpiece clamping
- Maximum concentricity deviation of 0.01 mm for maximum precision

TECHNICAL FEATURES
- Body hardened and ground
- Tip angle 60°

A06
AC-VL Control with pressure display, length compensation and extended centre point as counter-centre for face drivers, body hardened and ground - tip angle 60°

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1) At max. axial load

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Flex - interchangeable inserts

APPLICATION
For counter-clamping workpieces on turning and grinding machines.

TYPE
With interchangeable inserts made of wear-resistant tool steel for maximum flexibility.

CUSTOMER BENEFITS
- Wide range of applications thanks to interchangeable inserts
- Quick change of interchangeable inserts

TECHNICAL FEATURES
- Body hardened and ground
- Inserts through-hardened and ground

A06
A Flex for interchangeable inserts, body hardened and ground

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Version with draw-off nut on request
Concentricity deviation measured at internal cone

Radial load
Workpiece in kg
Service life of roller bearings: 2000 operating hours

Axial load
Axial load in daN
Service life of roller bearings: 2000 operating hours

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## Interchangeable inserts

**A06**

### Interchangeable inserts 60°

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### Interchangeable inserts 75°

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### Interchangeable inserts 60° VL

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### Interchangeable inserts for tubular workpieces 60°

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Interchangeable inserts

**A06**
Interchangeable inserts **A** for centerless workpieces 60°

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**A06**
Interchangeable inserts **B** for centerless workpieces 60°

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**A06**
Extractor

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**A14**
Mounting sleeve for clamping the live centre in the lathe chuck

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</table>
Flex - interchangeable inserts

APPLICATION
For counter-clamping workpieces on turning and grinding machines. Especially for individual production of various workpieces through different inserts.

TYPE
With interchangeable inserts made of wear-resistant tool steel for maximum flexibility. Assortment with different inserts.

CUSTOMER BENEFITS
- Wide range of applications thanks to interchangeable inserts
- Quick change of interchangeable inserts

TECHNICAL FEATURES
- Body hardened and ground
- Inserts through-hardened and ground

Delivery includes:
- 1 basic body for interchangeable inserts
- 1 extractor for disassembly
- 1 insert 60°, 75°, 90°, 60°VL
- Insert for tubular workpieces 60°
- 2 inserts for centerless workpieces 60°
- Inclusive wooden case

Table:

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<td>3700</td>
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</table>

Complete with all inserts in a sturdy wooden case

Version with draw-off nut on request
REVOLVING CENTERING TAPER

For counter-clamping workpieces with large boreholes, (e.g. pipes) on turning and grinding machines, in one set-up. The centre point of the revolving centering taper from RÖHM is hardened and ground for maximum wear resistance.

REVOLVING CENTERING TAPER

- Large clamping range for a wide range of boreholes and centres
- Robust precision bearing for high axial and radial loads

REVOLVING CENTERING TAPER WITH INTERCHANGEABLE INSERTS

- Maximum flexibility thanks to use of exchangeable centering taper attachments
- Quick change of centering taper attachment in case of wear
Revolving centering taper

MZK

APPLICATION
For counter-clamping workpieces with large boreholes, such as pipes on lathes and grinding machines.

TYPE
Revolving centering taper in pointed version or cone truncated version.

CUSTOMER BENEFITS
- Large clamping range for a wide range of boreholes and centres
- Proven 3-fold bearing for high axial and radial load

TECHNICAL FEATURES
- Body hardened and ground

### A06
Revolving centering taper, pointed, as revolving centre for tubular workpieces as well as centre for machining standard workpieces

<table>
<thead>
<tr>
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<th>A mm</th>
<th>B mm</th>
<th>G mm</th>
<th>Workpiece weight max. kg</th>
<th>Concentricity deviation max. mm</th>
<th>Speed max. min⁻¹</th>
<th>Weight g</th>
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<td>1100</td>
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### A06
Revolving centering taper, cone truncated, 60°

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<th>D mm</th>
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<th>G mm</th>
<th>Workpiece weight max. kg</th>
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<th>Speed max. min⁻¹</th>
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### A06
Revolving centering taper, cone truncated, 75°

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Revolving centering taper

MZK

APPLICATION
For counter-clamping workpieces with large boreholes, such as pipes on lathes and grinding machines.

TYPE
With interchangeable centering taper attachments.
Optionally with draw-off nut or fixed shaft.

CUSTOMER BENEFITS
- High flexibility thanks to interchangeable centering taper attachments
- Quick change of interchangeable centering taper attachments

TECHNICAL FEATURES
- Body hardened and ground
- Centering taper insert hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Mount MT</th>
<th>A (mm)</th>
<th>Workpiece weight max. (kg)</th>
<th>Concentricity deviation max. (mm)</th>
<th>Speed max. (min⁻¹)</th>
<th>Weight (g)</th>
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With fastening screw and disc, without centering taper attachment
Concentricity deviation measured at conical mount

A06
Revolving centering taper

<table>
<thead>
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<th>Item no.</th>
<th>Size</th>
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<th>A (mm)</th>
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<th>Concentricity deviation max. (mm)</th>
<th>Speed max. (min⁻¹)</th>
<th>Weight (g)</th>
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With fastening screw and disc, without centering taper attachment
Concentricity deviation measured at conical mount

A07
Fixed shafts

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<th>Workpiece weight max. (kg)</th>
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With fastening screw and disc, without centering taper attachment
Version with draw-off nut on request
Concentricity deviation measured at conical mount

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## MZK

**A06**

Suitable inserts AZ for centering tapers, standard version, taper 75°

<table>
<thead>
<tr>
<th>Item no.</th>
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<th>C mm</th>
<th>D mm</th>
<th>E mm</th>
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</table>

1) Without fixing by screw and washer
SOLID CENTRES

Optimally suited for the counter-clamping of workpieces on turning machines with tailstock bearing and grinding machines in one set-up as well as for measurement technology. The solid centres are hardened and ground.

ADVANTAGES AT A GLANCE

- High wear resistance thanks to tool steel / carbide insert
- High load capacity and rigidity thanks to compact design
- Concentricity deviation of up to 0.005 mm

Take-up shaft for use in turning machines with tailstock bearing and grinding machines as well as measuring machines

Concentricity deviation of up to 0.005 mm

Numerous versions available with carbide, full tip, half tip as well as draw-off nut

High load capacity and rigidity thanks to compact design made of one piece
FZS

APPLICATION
For counter-clamping workpieces on lathes with tailstock bearing and grinding machines.

TYPE
Designs with concentricity of 0.003 mm or higher are available on request.

CUSTOMER BENEFITS
- High wear resistance thanks to tool steel / carbide insert
- High load capacity and rigidity since tips are one piece

TECHNICAL FEATURES
- Solid centres are hardened and ground

A07
DIN 806, full point, ground, with full carbide tip

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Mount MT</th>
<th>A mm</th>
<th>B mm</th>
<th>d1 mm</th>
<th>l1 mm</th>
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A07
DIN 806, full point, ground, with carbide insert and regrinding line

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<th>D mm</th>
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<th>l1 mm</th>
<th>Weight g</th>
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A07
DIN 806, full point, material: tool steel

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<th>B mm</th>
<th>d1 mm</th>
<th>l1 mm</th>
<th>Weight g</th>
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## FZS

### A07

**Similar DIN 807, full point**, with draw-off nut and SW, material: tool steel

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<th>Item no.</th>
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<th>Key-width SW</th>
<th>Weight g</th>
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### A07

**Similar DIN 807, full point**, with draw-off nut and SW, with extended centre point, material: tool steel

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<th>d1 mm</th>
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### A07

**Draw-off nut**

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<th>Weight</th>
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### A07

**DIN 806, half point**, ground, with carbide insert

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<th>E mm</th>
<th>F mm</th>
<th>d1 mm</th>
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<th>Weight g</th>
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<tbody>
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### A07

**DIN 806, half point**, material: tool steel

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<th>F mm</th>
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</table>

[www.eshop.roehm.biz](www.eshop.roehm.biz)
TURNING AND MILLING IN ONE SET-UP

Application example face driver CoE in combination with a revolving live centre.
Turning and milling workpieces in one set-up.
The Constant face drivers of RÖHM are optimally suited for the rational turning and milling of workpieces over their entire length. All Constant face drivers are developed according to the modular principle, so that a universal exchange of a large multitude of driver discs and centre points is possible.

ADVANTAGES AT A GLANCE

- Maximum flexibility thanks to the modular principle
- High concentricity thanks to narrow tolerances
- Constant clamping force thanks to mechanical or hydraulic pressure compensation, even for uneven workpiece faces

Various take-up types for every application or for all common machine types

Axially adjustable spring package for flexible adaptation of the centering force

Quickly exchangeable driver disc and centre point for maximum flexibility

Centre point for maximum concentricity of up to 0.01 mm
## Operation guide

### TYPE CoE CoA CoK

<table>
<thead>
<tr>
<th>Machining</th>
<th>Turning and milling in one set-up</th>
<th>Turning</th>
<th>Turning for machining workpieces which are highly unbalanced, very heavy, for high chip removal or for irregular cutting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Concentricity deviation max.</td>
<td>0.015 mm</td>
<td>0.015 mm</td>
<td>0.015 mm</td>
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<tr>
<td>Actuation</td>
<td>not power-operated</td>
<td>not power-operated</td>
<td>power-operated</td>
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<tr>
<td>Pressure compensation</td>
<td>mechanical</td>
<td>hydraulic / mechanical</td>
<td>mechanical</td>
</tr>
<tr>
<td>Workpiece weight</td>
<td>up to 100 kg</td>
<td>up to 100 kg</td>
<td>up to 350 kg</td>
</tr>
<tr>
<td>Centre point</td>
<td>resilient</td>
<td>resilient</td>
<td>fixed</td>
</tr>
<tr>
<td>Clamping-Ø</td>
<td>8 - 80 mm</td>
<td>8 - 80 mm</td>
<td>8 - 80 mm</td>
</tr>
<tr>
<td>Adapter</td>
<td>with morse taper / with cylindrical shank</td>
<td>with morse taper / with morse taper and draw-off nut / with cylindrical shank for clamping in lathe chucks / with short taper / in flange type</td>
<td>with centring mount for adapter plate</td>
</tr>
<tr>
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<td>2040</td>
<td>2043</td>
<td>2052</td>
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### TYPE CoM CoB

<table>
<thead>
<tr>
<th>Machining</th>
<th>Turning for clamping large and heavy workpieces, as well as workpieces with extremely uneven faces</th>
<th>Turning for clamping large and heavy workpieces, as well as workpieces with extremely uneven faces</th>
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</thead>
<tbody>
<tr>
<td>Concentricity deviation max.</td>
<td>0.015 mm</td>
<td>0.015 mm</td>
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<tr>
<td>Actuation</td>
<td>not power-operated</td>
<td>not power-operated</td>
</tr>
<tr>
<td>Pressure compensation</td>
<td>mechanical</td>
<td>hydraulic</td>
</tr>
<tr>
<td>Workpiece weight</td>
<td>up to 500 kg</td>
<td>up to 500 kg / 1.000 kg</td>
</tr>
<tr>
<td>Centre point</td>
<td>resilient, axially adjustable</td>
<td>resilient, axially adjustable</td>
</tr>
<tr>
<td>Clamping-Ø</td>
<td>50 - 250 mm</td>
<td>63 - 160 mm</td>
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<tr>
<td>Adapter</td>
<td>with morse taper / with short taper</td>
<td>with morse taper / with short taper</td>
</tr>
<tr>
<td>Page</td>
<td>2055</td>
<td>2055</td>
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</tbody>
</table>
Clamping power diagramm

When using several cutters at once, the calculated tailstock loading must be added.

### Workpiece strength daN/mm²

<table>
<thead>
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<th>Material</th>
<th>40</th>
<th>50</th>
<th>63</th>
<th>80</th>
<th>100</th>
<th>125</th>
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<td>ST 50</td>
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<td>50CrMo 4</td>
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</table>

### Nominal values for tailstock loading

- $F_{\text{Tailstock}} \times 1.5$
- $F_{\text{Tailstock}} \times 2$

---

The RÖHM slide rule, Item No. 88230 may also be used for easy calculation of the axial clamping power.

---

Example

A Turning against the headstock
1. Cutting capacity: $6 \times 0.4$
2. Workpiece strength:
3. Clamping ratio: $60 \div 50$
4. Tailstock loading from graph: $F_{\text{Tailstock}}$

* Conversion factor:
B Radial grooving
C Turning against tailstock

$$F_{\text{Tailstock}} = 2.4 \text{ mm}^2$$
$$= 63 \text{ daN/mm}^2$$
$$= 1.2$$
$$= 450 \text{ daN}$$
CoE - turning and milling

APPLICATION
For the rational turning and milling of workpieces on its entire length without reclamping with maximum precision.

TYPE
Basic body with morse taper and mechanical pressure compensation. Clamping circuit Ø 8-80 mm. Workpiece weight max. 100 kg.

CUSTOMER BENEFITS
- For turning and milling in one set-up
- Compensating driving disc, radially backlash-free
- Maximum concentricity deviation of 0.015 mm for maximum precision
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES
- Guide value for axially permissible total load on 3 support pistons: 9000 N

A14
Basic body with morse taper (all basic bodies without driving disc and centre), mechanical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>MT</th>
<th>A mm</th>
<th>B mm</th>
<th>H mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
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<td>62</td>
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<td>4</td>
<td>62</td>
<td>65</td>
<td>max. 38 min. 26</td>
<td>16</td>
<td>10</td>
<td>1900</td>
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<tr>
<td>310068</td>
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<td>10</td>
<td>2000</td>
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A14
Basic body with cylindrical shank (all basic bodies without driving disc and centre), mechanical

<table>
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<th>A mm</th>
<th>B mm</th>
<th>H mm</th>
<th>Z mm</th>
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<th>Weight approx. g</th>
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<td>62</td>
<td>56</td>
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<td>62</td>
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Other take-ups available on request
## Accessories CoE

### A14
**Driving discs, toothed, right- and left-hand rotation, free from play, max. workpiece hardness 35 HRC**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
<th>Approx. turning range</th>
<th>I mm</th>
<th>R mm</th>
<th>V mm</th>
<th>Assoc. centre point Ø Y mm</th>
<th>Axial load max. N</th>
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<td>1209001</td>
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<td>11-20</td>
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<td>16</td>
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<td>16</td>
<td>9000</td>
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Driving discs with carbide toothing on request

### A14
**Driving discs, with interchangeable carbide driving plates 6 x 3.2, right- and left-hand rotation, free from play, max. workpiece hardness 40 HRC**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
<th>Approx. turning range</th>
<th>I mm</th>
<th>R mm</th>
<th>V mm</th>
<th>Assoc. centre point Ø Y mm</th>
<th>Axial load max. N</th>
</tr>
</thead>
<tbody>
<tr>
<td>1209007</td>
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<td>6</td>
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<td>1209008</td>
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<td>1209009</td>
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### A14
**Centres**

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<th>Z mm</th>
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<td>1209012</td>
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<td>1209013</td>
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Centering taper on request

### A14
**Carbide driving plates, right- and left-hand rotation**

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<tbody>
<tr>
<td>088970</td>
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Accessories CoE

A14

Mounting sleeve for clamping the face driver in the lathe chuck

<table>
<thead>
<tr>
<th>Item no.</th>
<th>MT inside</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
<th>D mm</th>
<th>G mm</th>
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<td>085033</td>
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<td>39</td>
<td>32</td>
<td>40</td>
<td>23,825</td>
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<td>085034</td>
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CoE - product ranges

A14

CoE small assortment in wooden box, mechanical pressure compensation, clamping circuit ø 12-50 mm, turning range 13-100 mm

Included in delivery: 1x basic body, 4x driving discs (clamping circuit ø 12, 20, 32, 50), 3x centre points (centering ø 6, 12, 16)

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Mount</th>
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<tr>
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<td>ZA 32</td>
<td>3600</td>
</tr>
<tr>
<td>1209048</td>
<td>MK 3</td>
<td>3600</td>
</tr>
<tr>
<td>1209049</td>
<td>MK 4</td>
<td>3870</td>
</tr>
<tr>
<td>1209050</td>
<td>MK 5</td>
<td>4050</td>
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CoA - turning

APPLICATION
For the rational turning of workpieces on its entire length without reclamping with maximum precision.

TYPE
Basic body with morse taper and hydraulic pressure compensation. Clamping circuit Ø 8-80 mm. Workpiece weight max. 100 kg.

CUSTOMER BENEFITS
- Constant clamping force thanks to hydraulic pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity deviation of 0.015 mm for maximum precision
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES
- Guide value for axially permissible total load on 3 support pistons: 20,000 N

A14
Basic body with morse taper (basic body without driving disc and center), hydraulic

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Mf</th>
<th>A mm</th>
<th>B mm</th>
<th>H mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
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<td>54</td>
<td></td>
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<td>1600</td>
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<td>088174</td>
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<td>088175</td>
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<td>70</td>
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<td>16</td>
<td>15</td>
<td>2800</td>
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<td>088176</td>
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<td>70</td>
<td>56.5</td>
<td></td>
<td>16</td>
<td>15</td>
<td>4400</td>
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</tbody>
</table>

A14
Basic body with morse taper, with draw-off nut (basic body without driving disc and centre), hydraulic

<table>
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<th>Mf</th>
<th>A mm</th>
<th>B mm</th>
<th>H mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
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<tbody>
<tr>
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</table>

www.eshop.roehm.biz
CoA - turning

APPLICATION
For the rational turning of workpieces on its entire length without re-clamping with maximum precision.

TYPE
Basic body with cylindrical shank and hydraulic pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS
- Constant clamping force thanks to hydraulic pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity deviation of 0.015 mm for maximum precision
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES
- Guide value for axially permissible total load on 3 support pistons: 20,000 N

A14
Basic body with cylindrical shank for clamping in lathe chucks, with spring package (basic body without driving disc and centre), mechanical / hydraulic

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Clamping diameter A mm</th>
<th>B mm</th>
<th>G mm</th>
<th>H mm</th>
<th>M mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
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<tr>
<td>088074</td>
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<td>max. 45 mm. 26</td>
<td>110</td>
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<td>15</td>
<td>2300</td>
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<tr>
<td>313085</td>
<td>85</td>
<td>45</td>
<td>25</td>
<td>max. 45 mm. 26</td>
<td>110</td>
<td>16</td>
<td>15</td>
<td>2300</td>
</tr>
</tbody>
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A14
Basic body with short taper ISO 702-1 (DIN 55026), with spring package (basic body without driving disc and center), mechanical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Short-taper A mm</th>
<th>B mm</th>
<th>E mm</th>
<th>F mm</th>
<th>G mm</th>
<th>H mm</th>
<th>K mm</th>
<th>M mm</th>
<th>O mm</th>
<th>P mm</th>
<th>T mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
</tr>
</thead>
<tbody>
<tr>
<td>313905</td>
<td>5</td>
<td>133</td>
<td>-</td>
<td>M 10</td>
<td>15</td>
<td>25</td>
<td>max. 45 mm. 26</td>
<td>62,563</td>
<td>32</td>
<td>90</td>
<td>86</td>
<td>104,8</td>
<td>16</td>
<td>10</td>
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<tr>
<td>313906</td>
<td>6</td>
<td>165</td>
<td>35</td>
<td>M 12</td>
<td>18</td>
<td>25</td>
<td>max. 45 mm. 26</td>
<td>106,375</td>
<td>32</td>
<td>90</td>
<td>86</td>
<td>133,4</td>
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<td>10</td>
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<tr>
<td>313907</td>
<td>8</td>
<td>210</td>
<td>40</td>
<td>M 16</td>
<td>22</td>
<td>25</td>
<td>max. 45 mm. 26</td>
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<td>90</td>
<td>86</td>
<td>171,4</td>
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</tbody>
</table>

A14
Basic body with short taper 702-1 (DIN 55026), with spring package (basic body without driving disc and center), mechanical / hydraulic

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Short-taper A mm</th>
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<th>E mm</th>
<th>F mm</th>
<th>G mm</th>
<th>H mm</th>
<th>K mm</th>
<th>M mm</th>
<th>O mm</th>
<th>P mm</th>
<th>T mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
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</thead>
<tbody>
<tr>
<td>313905</td>
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<td>133</td>
<td>-</td>
<td>M 10</td>
<td>15</td>
<td>25</td>
<td>max. 45 mm. 26</td>
<td>62,563</td>
<td>32</td>
<td>90</td>
<td>86</td>
<td>104,8</td>
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<td>10</td>
</tr>
<tr>
<td>313906</td>
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<td>35</td>
<td>M 12</td>
<td>18</td>
<td>25</td>
<td>max. 45 mm. 26</td>
<td>106,375</td>
<td>32</td>
<td>90</td>
<td>86</td>
<td>133,4</td>
<td>16</td>
<td>10</td>
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<tr>
<td>313907</td>
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<td>210</td>
<td>40</td>
<td>M 16</td>
<td>22</td>
<td>25</td>
<td>max. 45 mm. 26</td>
<td>139,719</td>
<td>32</td>
<td>90</td>
<td>86</td>
<td>171,4</td>
<td>16</td>
<td>10</td>
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CoA - turning

APPLICATION
For the rational turning of workpieces on its entire length without re-clamping with maximum precision.

TYPE
Basic body with centreing mount and hydraulic/mechanical pressure compensation. Clamping circuit ø 8-80 mm. Workpiece weight max. 100 kg.

CUSTOMER BENEFITS
- Constant clamping force thanks to hydraulic/mechanical pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity deviation of 0.015 mm for maximum precision
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES
- Guide value for axially permissible total load on 3 support pistons: 20,000 N

A14
Basic body flange type, with spring set (basic body without driving disc and center), mechanical / hydraulic

<table>
<thead>
<tr>
<th>Item no.</th>
<th>A mm</th>
<th>B mm</th>
<th>D mm</th>
<th>E</th>
<th>F mm</th>
<th>G mm</th>
<th>H mm</th>
<th>M mm</th>
<th>O mm</th>
<th>P mm</th>
<th>T mm</th>
<th>Z mm</th>
<th>Centres stroke mm</th>
<th>Weight approx. g</th>
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<td>min. 26</td>
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<td>M 10</td>
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<td>min. 26</td>
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<td>98</td>
<td>120</td>
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<td>10</td>
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1) With hydraulic compensation
2) With mechanical compensation
## Adapter plate CoA

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<th>Design</th>
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<th>A mm</th>
<th>B mm</th>
<th>D mm</th>
<th>l mm</th>
<th>K mm</th>
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<tr>
<td>088491</td>
<td>ISO 702-3</td>
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<td>35</td>
<td>100</td>
<td>38</td>
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<td>40</td>
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<td>8700</td>
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<td>196.885</td>
<td>17000</td>
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</table>
### Accessories CoA

#### A14

**Driving discs, with interchangeable carbide driving plates 6 x 3.2, right- and left-hand rotation, max. workpiece hardness 40 HRC**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
<th>Approx. turning range</th>
<th>I mm</th>
<th>R mm</th>
<th>V mm</th>
<th>Assoc. centre point Ø Y mm</th>
<th>Axial load max. N</th>
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<tbody>
<tr>
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<td>21-40</td>
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<td>5</td>
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</table>

#### A14

**Driving discs, with interchangeable carbide driving plates 6 x 3.2, right-hand rotation, max. workpiece hardness 40 HRC**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
<th>Approx. turning range</th>
<th>I mm</th>
<th>R mm</th>
<th>V mm</th>
<th>Assoc. centre point Ø Y mm</th>
<th>Axial load max. N</th>
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<td>5</td>
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<td>25 H</td>
<td>26-50</td>
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<td>30</td>
<td>8</td>
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<td>089067</td>
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<td>33-64</td>
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<td>30</td>
<td>10</td>
<td>16</td>
<td>8200</td>
</tr>
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#### A14

**Driving discs, with interchangeable carbide driving plates 6 x 3.2, left-hand rotation, max. workpiece hardness 40 HRC**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
<th>Approx. turning range</th>
<th>I mm</th>
<th>R mm</th>
<th>V mm</th>
<th>Assoc. centre point Ø Y mm</th>
<th>Axial load max. N</th>
</tr>
</thead>
<tbody>
<tr>
<td>089065</td>
<td>20 H</td>
<td>21-40</td>
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<td>30</td>
<td>5</td>
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</tr>
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<td>089066</td>
<td>25 H</td>
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<td>11</td>
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#### A14

**Driving discs, toothed, right- and left-hand rotation, max. workpiece hardness 35 HRC**

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<th>V mm</th>
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Driving discs with carbide toothing on request

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Accessories CoA

**A14**

**Driving discs, toothed, right-hand rotation, max. workpiece hardness 35 HRC**

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<th>Item no.</th>
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Driving discs with carbide toothing, friction lining or diamond grain on request

**A14**

**Driving discs, toothed, left-hand rotation, max. workpiece hardness 35 HRC**

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Driving discs with carbide toothing, friction lining or diamond grain on request

**A14**

**Driving discs, with interchangeable carbide driving plates 9.5 x 3.2, right- and left-hand rotation, max. workpiece hardness 40 HRC**

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**A14**

**Driving discs, with interchangeable carbide driving plates 9.5 x 3.2, right-hand rotation, max. workpiece hardness 40 HRC**

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### Accessories CoA

**A14**

**Driving discs**, with interchangeable carbide driving plates 9.5 x 3.2, left-hand rotation

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**Centres CoA**

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**A14**

**Carbide driving plates**, right- and left-hand rotation

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**Carbide driving plates**, right- or left-hand rotation

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**A14**

**Mounting sleeve** for clamping the face driver in the lathe chuck

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Accessories CoA

C15

Threaded pin

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C15

O-ring

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A14

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C15

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CoA - product ranges

**A14**

**Basic equipment** in a carton, hydraulic pressure compensation, clamping dia. 12 - 32 mm, turning range 13-64 mm

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**A14**

**Small assortment** in wooden box, hydraulic pressure compensation, clamping dia. 12-50 mm, turning range 13-100 mm

**Included in delivery:** 1x basic body, 4x driving discs (clamping circuit Ø 12, 20, 32, 50), 2x centre points (centering Ø 6, 12)

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<th>Item no.</th>
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</table>

**A14**

**Large assortment** in wooden box, hydraulic pressure compensation, clamping dia. 10-80 mm, turning range 11-160 mm

**Included in delivery:** 1x basic body, 10x driving discs (clamping circuit Ø 10, 12, 16, 20, 25, 32, 40, 50, 63, 80), 5x centre points (centering Ø 4, 6, 10, 12, 16)

<table>
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<th>Left-hand rotation</th>
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</tbody>
</table>
CoK - power-operated 8-80 mm

APPLICATION
For machining workpieces with high unbalance, heavy weight, high chip removal or irregular cutting.

TYPE
Force-actuated face driver with mechanical pressure compensation. Clamping circuit Ø 8-80 mm. Max. workpiece weight 350 kg.

CUSTOMER BENEFITS
- Maximum concentricity deviation of 0.015 mm for maximum precision
- Workpiece longitudinal stop realized in centering
- Low centering force, even at max. cutting load
- Maximum flexibility thanks to universal exchange of driving disc and center point

TECHNICAL FEATURES
- The drivers are pressed against the workpiece with force-actuation

C15
Basic body (without centre, without draw-off nut), mechanical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>A mm</th>
<th>B mm</th>
<th>D mm</th>
<th>E</th>
<th>F mm</th>
<th>G mm</th>
<th>O mm</th>
<th>P mm</th>
<th>T mm</th>
<th>Z mm</th>
<th>Stroke mm</th>
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Draw-off nut M 14x1.5 Id.No. 089229

Adapter plate CoK

A14
Adapter plate short taper

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<th>I mm</th>
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www.eshop.roehm.biz
## Accessories CoK

### A14
**Driving discs, toothed, right-hand rotation, max. workpiece hardness 35 HRC**

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<tr>
<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
<th>Approx. turning range</th>
<th>I mm</th>
<th>R mm</th>
<th>V mm</th>
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Driving discs with carbide toothing, friction lining or diamond grain on request.

### A14
**Driving discs, toothed, left-hand rotation, max. workpiece hardness 35 HRC**

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<th>Item no.</th>
<th>Clamping circuit Ø S mm</th>
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<th>R mm</th>
<th>V mm</th>
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Driving discs with carbide toothing, friction lining or diamond grain on request.

### A14
**Driving discs, with interchangeable carbide driving plates 9.5 x 3.2, right-hand rotation, max. workpiece hardness 40 HRC**

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<th>Clamping circuit Ø S mm</th>
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### A14
**Driving discs, with interchangeable carbide driving plates 9.5 x 3.2, left-hand rotation, max. workpiece hardness 40 HRC**

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Accessories CoK

C15
Centres, CoK

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<th>U mm</th>
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<th>Z mm</th>
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A14
Carbide driving plates, right- or left-hand rotation

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A14
Carbide driving plates, right- and left-hand rotation

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C15
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C15
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</table>
CoM - mechanical pressure compensation with driving disc

APPLICATION
For clamping large and heavy workpieces, as well as workpieces with extremely uneven faces.

TYPE
Basic body and adapter plate with disc spring package and morse taper or short taper.

CUSTOMER BENEFITS
- Resilient, stable centre point, axially adjustable
- Workpiece weight up to 500 kg
- Clamping circuit diameter 50-250 mm
- Interchangeable driving disc

CoB - hydraulic pressure compensation with driving pin

APPLICATION
For clamping large and heavy workpieces, as well as workpieces with extremely uneven faces.

TYPE
Basic body with morse taper or short taper. Adapter plate with disc spring package.

CUSTOMER BENEFITS
- Resilient, stable centre point, axially adjustable
- Workpiece weight up to 500 kg / 1000 kg
- Clamping circuit diameter 63-160 mm
The RÖHM main plant is located in Sontheim/Brenz. In this ultra-modern production facility comprising 41,000 m² optimum conditions have been achieved in order to solve the extensive range of discerning construction and production tasks making the company even better, faster and more efficient in the future.

All national and international activities are planned and coordinated at the administrative headquarters in Sontheim. Thanks to the excellent infrastructure and transport routes, this location is ideal for a company relying on perfect product quality as well as maximum flexibility. Furthermore, the region around Sontheim offers another key basis for the success of our company: it is rich in quality awareness and motivated employees with the result that we are ideally prepared for the challenges of the future. The main plant uniquely unites mass production, serial production and customised individual production under a single roof.
Key locations for the company: Dillingen and St. Georgen

Such strong growth on the part of the RÖHM Group is also obviously associated with higher requirements on development and production capacities. The demands of today and tomorrow can be complied with the two facilities in Dillingen and St. Georgen.

Plant Dillingen/Danube | This branch plant in Dillingen was put into operation by the RÖHM Group as early as 1953. Thanks to extremely positive development, the plant is subject to constant expansion and modernisation. For this reason, new modern production facilities were built in 1982 and 1991. In 2007 RÖHM built a new production hall for two portal turning and milling machines. This enables machining of workpieces up to 4 metres in length which will secure a leading market position for RÖHM in the future. More than 300 employees are primarily involved in engineering and manufacturing lathechucks, machine vices and special clamping equipment for turning and milling machinery as well as for machining centres.

Engineering and sales department St. Georgen | Apart from standard mandrels, tailor-made solutions for a wide variety of requirements are also manufactured here in this small but accomplished high-tech forge. RÖHM retains mechanical or power-operated mandrels, sliding jaw mandrels and hydraulic mandrels for its customers for tensioning workpieces in drill holes or interior contours.
Always close to our customers. With locations all around the world.

Customer orientation at RÖHM has less to do with marketing than with attitude. We consider customer proximity as an intensive dialogue with our partners as well as direct presence on key international markets.
Your contacts at RÖHM

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Fax 0055 – 11 – 37 35 30 97
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Presence on all continents from A for Australia to V for Vietnam. You can receive the contact information of our worldwide representatives easily through www.roehm.biz.
§ 1 Offer, conclusion of contract and contractual contents
1. Our Terms of Sale shall apply exclusively; we do not recognise contradictory terms and conditions or terms and conditions which deviate from our Terms of Sale unless we have expressly agreed in writing to the contrary. If we do not deliver without reservation in the knowledge of contradictory terms and conditions of the buyer or terms and conditions which deviate from our Terms of Sale,
2. Our Terms of Sale shall only apply towards an entrepreneur within the meaning of Section 14 BGB [German Civil Code].
3. Our General Terms of Service shall apply with precedence over these Terms of Sale in the respective valid version in cases, which comprise the service offer of RÖHM GmbH.
4. Our offers are always to be understood as invitatio ad offerendum and are therefore not binding. If a contract shall only be concluded with our written confirmation and in line with its contents and – if a written confirmation is missing – by the service/delivery. If a delivery/service is carried out immediately without a confirmation then the invoice shall at the same time be deemed as an order confirmation.
5. Costs for the production of drawings for special constructions are to be borne by the customer as far as the offer does not lead to an order for reasons, for which we are not responsible.
6. All details concerning weights, dimensions, services and technical data, which are contained in printed material, catalogues, price lists or in other contractual documents, merely serve for purposes of information and are only binding insofar as they are explicitly described as binding.
7. We reserve the right to alter the construction and form changes to the object of contract as far as changes are not made hereto, which are deemed unreasonable for the orderer.
8. The documentation consists of the compilation drawing, the BOM with marking of the parts and the pack plan. In case of damages beyond the statutory warranty the buyer is responsible for the costs. The contract shall only be concluded with our written confirmation and in line with its contents.
9. The corresponding measurement methods for tests, with which certain temperatures, times and other measured or control values should apply, must be stipulated before stating the delivery and recognised by both parties as assembly instructions upon request. Respectively in German and/or, upon request, in English. This free documentation will be supplied in a digital form. The PDF format shall apply to drawings, BOMs and text files. Any other format beyond this is only created according to special agreements.
10. The documents may not be reproduced in full or in part, not made accessible to third parties or used for any other purpose apart from that for which they were handed over to the customer without our prior written authorization.
11. We will inform the customer if the product ordered by the customer is temporarily or permanently unavailable.
12. A purchase in the online shop is only possible if the customer actively agrees to our terms and conditions or terms and conditions which deviate from our Terms of Sale unless we make the respective valid version known.
13. Our basic data protection regulations are modified to the requirements of the GDPR.
14. In case of export business the delivery is carried out at the conditions agreed on the order confirmation, the international regulations for the interpretation of customary contractual forms shall apply in addition (incoterms 2010 of the International Chamber of Commerce, respective valid status), with regard to the part of the order that has not yet been completed or to adjust the prices of export business the supplier is entitled to terminate the contract extraordinarily with the orderer. The orderer is to be notified immediately of the occurrence of the event and of the expected implications.
15. Our “product information”, technical information leaflets as well as other product-specific publications shall apply in addition to the General Business Terms. These are always to be compiled with in their current version.

§ 2 Prices
1. In the absence of special written agreements the prices in the Federal Republic of Germany shall apply. carriage paid recipient plus the statutory value added tax. With export business the object of delivery shall be deemed as sold ex works if nothing is determined in the contract concerning the type of sale. A processing fee of EUR 15.00 will be charged for individual orders with a goods value of less than EUR 150.00 net, a processing fee of EUR 30.00 for orders with a goods value of less than EUR 50.00 net respectively, plus the applicable rate of value added tax. This shall apply to deliveries within the domestic country and overseas. At the customer’s request the goods can be delivered to an alternative shipping address against a logistics fee in the amount of EUR 10.00.
2. We would like to point out that we will only carry out the shipment at the customer’s request. This shall have no effect on the regulations according to Section 6.
3. We shall charge the prices valid upon conclusion of the contract, which are based on the cost factors which are valid at this time. Should these cost factors (in particular material, wages, energy, etc.) change between conclusion of the contract and the agreed delivery time then we are entitled to make a corresponding change to the prices. In case of changes in the contract with the customer the adjustment of the contract shall only be due to the fact that the customer is not in any way affected by the change of price.
4. In case of conclusion ex works the goods will be conveyed at the costs and risk of the orderer. With all other consignments the provisions stipulated in the incoterms 2010, respective valid status, will apply with regard to insurance and the assumption of risks.
5. We will inform the buyer of our production quantity for parts/products, which are produced especially according to the buyer’s requests. The buyer undertakes to purchase their respective quantities within 3 months.
6. Excess and shortfalls in deliveries of up to 5 %, with special tools up to 10 %, at least however 2 pieces, are permitted and do not substantiate any quality defects. The respective delivery will be charged.

§ 3 Terms of payment
1. In the absence of a special agreement the payment is to be made without any deduction free paying agent within 10 days after the invoice date – also with partial deliveries.
2. In case of default of payment the buyer shall be charged in the amount of the credit costs charged by banks, at least however interest in the amount of 9 % above the respective base lending rate of the ECB.
3. In case of export business the payments are to be made in line with the agreed terms of payment.
4. Costs of the payment transactions, in particular bank charges for overseas transfers to us, shall principally be for the expense of the customer.

§ 4 Delivery time
1. The start of the delivery deadline stated by us presumes the clarification of all technical questions. Delivery dates stated by us are – insofar as not explicitly agreed or described as binding – non-binding and shall merely represent an expected delivery date.
2. The compliance with our delivery obligation further presumes the timely and proper fulfilment of the buyer’s obligations, in particular the compliance with the agreed terms of payment. The right is reserved to the plea of the unfilled contract. This right shall also consist of obligations from previous deliveries which have not been stated.
3. The delivery deadline shall begin with the sending of the order confirmation, however not before the provision of the documents, permit, releases, etc., which are to be procured by the orderer, as well as not before the receipt of the agreed-down payment.
4. If a binding delivery date has been agreed then the supplier also has to deliver within the deadline. The delivery deadline shall have been adhered to if the object of delivery has left the plant by the time it expires or notification has been given that the delivery is ready for delivery, the right is reserved to the timely and correct self-delivery. If the supplier changes his order with regard to parts of the delivery then the delivery deadline shall be revoked and the supplier is to begin to apply new again with the confirmation of the change.
5. Force majeure, war, civil commotion, strike, lock-out or measures of authorities, no matter for which reason, which oppose a delivery, as well as deficiencies of raw materials, of tools or of means as well as breakdown of plants and machines at the sub-suppliers – shall release the supplier from the obligation to deliver within the agreed deadline. The orderer is to be notified immediately of the occurrence of the event and of the expected implications.
6. Deliveries before expiry of delivery time and in reasonable parts are permitted.
7. The adherence to the delivery time presumes the fulfilment of the orderer’s contractual obligations.
8. The regulations of Subclause 10 shall apply in the event of the delay in delivery or impossibility.

§ 5 Passing of risk and acceptance
1. The risk shall pass to the orderer by no later than with the dispatch of the delivered parts also if partial deliveries are made or we have taken over other services e.g. the shipping costs or delivery to the location and installation.
2. At the orderer’s request the shipment shall be insured by us against theft, damages caused by breakage, transport, fire and water and other insurable risks at his costs.
3. If the shipment is delayed as a result of circumstances, for which the orderer is responsible, then the risk shall pass to the orderer from the day upon which the goods are ready for shipment; however we are obliged to procure the insurances, which he requests, at the request of the orderer and the costs of the insurer.
4. Delivered objects are, even if they feature insignificant features, to be accepted by the customer as a characteristic of the object of contract.

§ 6 Delay in acceptance, order on call
1. If the orderer does not accept the object of contract within the deadline we are entitled to charge him a reasonable yet not exorbitant “delay fee”, to dispose otherwise over the object and its expiry and to supply the orderer with a reasonably extended deadline. Our rights to cancel the contract under the pre-requisites of Section 326 BGB and to request damages are not restricted.
2. At the orderer’s request the shipment shall be insured by us against theft, damages caused by breakage, transport, fire and water and other insurable risks at his costs.
3. If the shipment is delayed as a result of circumstances, for which the orderer is responsible, then the risk shall pass to the orderer from the day upon which the goods are ready for shipment; however we are obliged to procure the insurances, which he requests, at the request of the orderer.
4. Delivered objects are, even if they feature insignificant features, to be accepted by the customer as a characteristic of the object of contract.

§ 7 Reservation of title
1. The objects of the deliveries (reserved goods) shall remain our property until the full payment of all claims to which we are entitled against the buyer from the business relationship. Insofar as the value of all security rights, to which we are entitled against the buyer, exceeds the amount of all security claims of more than 10 %, we will release a corresponding part of the security rights at the buyer’s request.
2. During the existence of the reservation of title the buyer is prohibited from a pledge or assignment as collateral and the resale only permitted for resellers in the customary course of business and only under the condition that the reseller receives a payment from his customer or stipulates the reservation that the property shall only pass to the customer when he has paid his obligations.
3. In case of attachments, seizes or other disposals or interventions of third parties the buyer has to inform us immediately so that we can file an action according to Section 771 ZPO [German Code of Civil Procedure]. Insofar as the third party is not in the position to reimburse us the court and out-of-court costs of an action according to Section 771 ZPO, the buyer will be liable for the loss incurred to us.
4. The orderer undertakes to inform the buyer with due care and attention; he is in particular obliged to sufficiently insure these value at a new at his own costs against damages caused by fire, water and theft. Insofar as maintenance and inspection work is necessary the buyer must carry this out in time at his own costs.

General Terms of Sale and Delivery
General Terms of Sale and Delivery

5. In case of breaches of duty by the buyer, in particular with default of payment we are entitled to cancel the contract and to take the goods over. The taking back of goods respectively the assertion of the reservation of title shall remain unaffected by this; these acts or an attachment of the reserved goods by us shall not represent a cancelation of the contract unless we had explicitly declared that.

8. If the buyer has instructed the object of purchase in the ordinary course of business then he shall hereby now already assign all claims to us in the amount of the final invoice amount (including value added tax) of our claim, to which he is entitled from the resale agreement, in favour of us, irrespective of whether the object of purchase has been resold without or after processing. The buyer shall also remain authorized to collect this claim after the assignment. Our authorization to collect the claim ourselves shall remain unaffected by this; however, we undertake to not to collect the claim as long as the buyer satisfies his payment obligations from the collected proceedings, is not in default and in particular no application has been filed for the opening of insolvency proceedings. If this is not possible for us at reasonable conditions, the buyer shall be entitled to the proceeds sole ownership or co-ownership on our behalf.

§ 6 Quality defects

We shall be liable for quality defects as follows:

1. All those parts or services are to be subsequently improved free of charge at our choice, if reports of defects are noted – irrespective of the operating duration – feature a quality defect if this cause existed already at the time when the risk was passed.

2. Claims for quality defects shall become statute-barred in 12 months. The deadline will begin with the passing of the risk (Subclause 8).

3. The buyer has to report quality defects to us immediately in writing.

4. In case of reports of defects payments of the buyer may be withheld in a scope, which is proportionate to the defect. If the defect is not unambiguously reported we are entitled to request reimbursement of the expenses incurred to us by the buyer.

5. We are first of all always to be granted the opportunity for the subsequent fulfilment within a reasonable period of time.

6. If the subsequent fulfilment fails the buyer can – irrespective of possible claims for damages – cancel the contract or reduce the remuneration. The buyer can only request reimbursement for fruitless expenses if we are responsible for the defect owing to wilful intent or gross negligence.

7. Defects shall not exist with an only insignificant deviation from the agreed conditions, with an only insignificant impairment to the usability, with natural wear and tear or damages, which are caused after the risk has passed as a result of faulty or negligent treatment of the object of purchase by the buyer or by the fact that the delivery is changed by the buyer or is used together with other objects so that the usability of the object of purchase is impaired. The buyer has to use the object of purchase in the manner and for the purpose intended.

8. Claims of the buyer owing to the expenses, which are necessary for the purpose of the subsequent fulfilment, in particular transport, route, labour and material costs, are excluded if the expenses increase, because the object of the delivery has subsequently been taken to another location than the buyer’s branch unless the transportation corresponds with its use as intended.

9. Statutory claims for recourse of the buyer against us shall only exist to the extent that the buyer has not reached any agreements with its buyer that go beyond the statutory claims for defects.

10. Subclause 9 shall apply to claims for damages. Further or other than claims regulated in this Subclause or in Subclause 9 owing to a quality defect are excluded.

§ 9 Industrial property rights and copyrights, defects of title

Insolvent as not otherwise agreed, we are obliged to merely provide the delivery in the country of the place of delivery free of industrial property rights, copyrights and third party rights (hereinafter property rights). Insolvent as a third party asserts justified claims owing to the infringement of property rights due to deliveries provided by us and used as per contract for the benefit of the buyer, we shall be liable towards the buyer as follows within the deadline determined in Subclause 8.2:

1. We will, at our choice and at our costs, either obtain a right of use for the deliveries concerning the change for rights in property which is not infringed, or if not possible as at reasonable conditions, the buyer shall be entitled to the statutory rights to cancellation or reduction. The buyer can only request reimbursement for fruitless expenses if we are responsible for the defect owing to wilful intent or gross negligence. Our obligation to pay compensation is extendable to Subclause 10.

2. The afore-mentioned obligations shall only exist if the buyer informs us immediately in writing about the third party’s claim that the buyer does not recognize an infringement and we reserve the right to all defence measures and settlement negotiations. If the buyer discloses the reason for reasons to minimise damages or on the request of the buyer, he undertakes to inform the third party that the discontinuation of the use is not associated with a recognition of an infringement of property right.

3. If the buyer are excluded insolvent as he is responsible for the infringement of property right.

4. Claims of the buyer are further excluded insofar as the infringement of property right is caused by special stipulations of the buyer, due to an application that is not foreseeable for us or by the fact that the delivery is changed by the buyer or is used together with products of other manufacturers not delivered by us.

5. In the event of infringements of property rights the provisions of Subclauses 8.4, 8.5 and 8.9 shall apply accordingly to the claims of the buyer regulated in Subclause 13.

6. Further or other claims of the buyer against us or our vicarious agents owing to a defect of title than those regulated in this Subclause 9 are excluded.

§ 10 Joint and several liability

1. Claims of the buyer for damages – irrespective of the legal nature of the asserted claim – are excluded.

2. Excluded from this are:

a) Damages owing to the breach of essential contractual obligations. Deemed as essential are such contractual obligations, the fulfilment of which makes the proper execution of the contract possible at all and on the compliance with which the contractual partner may as a rule rely and depends.

b) Damages which are due to a willful or grossly negligent breach of duty, whereby our breach of duty is deemed equivalent to that of our legal representatives or vicarious agents.

c) Liability according to the Produkthaftungsgesetz [German Product Liability Act]

d) A change to the burden of proof for the disadvantage of the buyer is not associated with the afore-mentioned regulations.

e) As far as the liability for damages excluded or limited against us, this shall also apply with regard to the personal liability for damages of our employees, our commercial agents and our vicarious agents.

§ 11 Obligations of the buyer to provide assistance

1. Assistance services required by the contract and the goods have to be performed and carried out respectively by the buyer, as far as the processing or conversion of the object of purchase by the buyer is always carried out on our behalf. If the processing or conversion of the object of purchase is carried out to the extent that the object of purchase is changed by the buyer or is used together with other objects, such that the object of purchase cannot be used or not used in full, the buyer shall be entitled to claim the applicable incurred destruction costs in the event of a premature change to its material scheduling. This shall also apply to products, with which we had to order minimum quantities on the part of our suppliers if we have informed the customer hereof in advance.

2. The buyer guarantees that the products supplied by him for processing are suitable for this purpose. We are not obliged to examine the products supplied by the buyer for the processing suitability for the further processing. Within the framework of ongoing business relationships as well as if an object for processing has initially been inspected, tested and measured, the buyer undertakes to inform us of each product change without request in writing. In the case of regular processing of objects the buyer is further obliged to examine the object that is to be processed by us for deviations and changes for each change to the production conditions and in his company, in particular with the exchange of tools, machines or with the introduction of new production processes and to notify us of such changes and modifications in writing.

3. We do not have to examine the instructions of our buyers, the material selection or other regulations, which are made by our buyer, for their accuracy.

4. Therefore, the buyer has to examine all instructions, which he issues as well as the quality and the materials stipulated or made available to us for the compliance with the statutory and technical regulations.

5. If the buyer is in default with regard to his obligation for provision or to provide assistance after a written warning we are entitled to the statutory rights.

6. Goods may only be returned with the supplier’s express permission. Any returned goods must be delivered free in their original packaging and must be accompanied by the return receipt provided by the supplier. Any expenses for return shall only be charged to the buyer. Returned goods will no longer be accepted when six months have lapsed from the date of delivery. Returns of specially designed or custom-made items, as well as used goods will not be accepted. We will charge a handling fee of 20 % - 40 % of the value of the goods, however, at least EUR 100 per item plus statutory VAT. Following presentation of appropriate evidence, the supplier reserves the right to charge a higher amount to the purchaser in individual cases; the purchaser is free to prove that the damage was lower.

§ 12 Place of performance and place of jurisdiction/miscellaneous

1. The place of performance and place of payment is the registered seat of our company in Sontheim/Brenz.


3. With all disputes ensuing from the contractual relationship, if the orderer is a merchant, a legal entity under public law or a special fund under public law, the action is to be filed at the court that has jurisdiction for our headquarters. We are also entitled to an action at the headquarters of the orderer.

4. We store your data according to Section 23 Federal Data Protection Act.

RÖHM GmbH
89655 Sontheim (Germany)
Status: July 2019
1. Validity
1.1 These ASB form the basis for all business transactions with our customers, which refer to the repair or maintenance of the products manufactured or delivered by us insofar as these customers concern entrepreneurs within the meaning of Section 14 BGB [German Civil Code].
1.2 Contradictory, supplementary contractual terms and conditions of the customer or the customer's representatives, which were not ASB will not be binding.
1.3 Within the framework of a regular business relationship these ASB will also be valid after the effective inclusion for the first time if we do not explicitly refer hereto in follow-up transactions.
1.4 Insofar as the ASB do not include any regulations, the General Terms of Sale and Delivery of RÖHM GmbH shall apply.

2. Offer and conclusion of the contract
2.1 Any offer for the repair of a product will only be explicitly marked as binding – without obligation and merely to be understood as invitation to offer. The offer is accepted in the form submitted.
2.2 Contracts with us will only be concluded with our written acceptance declaration or – if such is not carried out – by our delivery and service. Changes and supplemental agreements to the contracts concluded with us require a written form.
2.3 If the object of maintenance or repair was not determined by us then the customer must point out existing industrial property rights with regard to the object if we are not responsible for any fault the customer shall indemnify us from possible claims of third parties from industrial property rights.
2.4 Insofar as we are responsible for negligence Par. 2.3 shall apply accordingly.

3. Contractual parts
The offer and the product list respectively available to us and the customer are a part of the contract.

4. Technical documents and plans
4.1 All rights to our offer documents as well as documents, which have been handed over, remain reserved.
4.2 The customer shall recognise our rights and will not reproduce the documents in full or in part, not make these accessible to third parties or use these for any other purpose than the repair or for a deferred repair.
4.3 The offer documents are a part of the contract.
4.4 The offer and the product list respectively available to us and the customer are a part of the contract.

5. Scope of services, maintenance, condition of device, repair
5.1 Decisive for the scope of our delivery and service is our binding offer or – if such is not available – the written acceptance declaration of acceptance. Both individual services can be agreed, which are principally to be remunerated according to Subclause 12.1, as well as the service packages described under Subclause 5.2, which are to be remunerated according to Subclause 12.2 respectively 12.3.
5.2 The following activities are a part of our service obligation with the processing of service packages:
   a) Commissioning of service
      • skillfully executed commissioning of the clamping device and control at the place of installation in line with the regulations of the manufacturer.
   b) Assembly work over the course of the commissioning together with the machine manufacture.
   c) first instructions and operator training.
   d) provision of suitable, theft-proof recreation rooms and work rooms (with heating, lighting, ventilation, prevention of fire and theft, etc.).
   e) Provision of necessary, dry rooms, which can be locked for the storage of the tool for the repair personnel.
   f) provision of the repair place and materials against harmful influences of all kinds, cleaning of the repair place.
   g) Provision of suitable, theft-proof recreation rooms and work rooms (with heating, lighting, ventilation, preventions of fire and theft) and First Aid equipment.
   h) Provision of the materials and undertaking of all other acts, which are necessary for the adjustment of the object of repair and for carrying out a testing that is envisaged as per contract.
   i) The technical assistance of the orderer must guarantee that the service can be started immediately after the arrival of our personnel and carried out without delay until the acceptance by the orderer. Insofar as special plans or instructions of RÖHM are necessary, RÖHM shall make these available to the orderer in time.

6. Obligations of the customer to provide assistance in case of maintenance
6.1 The products shall be used as intended and according to their protection type and in line with the operating instructions together with their annexes.
6.2 In case of an agreement of one of the service packages described in Subclause 5, the customer will place the products that are to be installed, maintained or repaired into our possession without our prior written consent. The removal of the devices and required materials.
6.3 In case of a repair that cannot be carried out RÖHM GmbH shall not be liable subject to sentence 2 for damages to the object of repair, the breach of contractual secondary obligations and for damages, which were not suffered to the object of repair itself, no matter which legal ground gives rise to the damage. In the other hand, will be liable in case of willful intent, with gross negligence of the owner / the executive bodies or executives as well as with the culpable breach of essential contractual duties. Such contractual secondary obligations and on therein essential, the fulfilment of which makes the proper execution of the contract possible at all and the compliance with which the contractual partner may as a rule rely and depend upon.

7. Duration of the service
7.1 The details with regard to the duration of repairs and services are based upon estimates and merely serve as information and a first estimate by the customer. They are therefore not binding if they have not been explicitly marked as binding.
7.2 In case of subsequent additional or supplementary services and with necessary additional repair work the agreed repair deadline shall be extended accordingly.

8. Obligations to provide assistance of the customer
8.1 The customer has to draw our attention to the statutory. official and company safety and other regulations applicable at the place of destination of our delivery and service, which refer to the delivery, the assembly and the operation.
8.2 The customer shall inform us if the repair / maintenance personnel that the necessary special measures for the place of installation, which maybe an impaction on the proper function of the products, in particular about the structural condition and the concrete operating environment.
8.3 The customer shall ensure – also during the warranty period according to Subclause 17.5 – a regular and skilled maintenance of the products delivered by us as insofar as this was not taken over by us as per contract.
8.4 The customer shall dispose of the goods delivered by us at his own responsibility and at his own costs according to the respective valid regulations. We are not obliged to create feasibility for the repair personnel, it would have been stipulated by law.
8.5 The customer has to support the repair / maintenance personnel with the execution of the repair at his own costs.
8.6 The customer has to observe the special measures, which are necessary for the protection of persons and objects at the workplace. He also has to inform the repair managers about existing special safety regulations insofar as these are of significance for the repair personnel. He shall inform us if there may be present any repair personnel of such safety regulations. In case of serious breaches he can refuse the interfering party access to the repair location by mutual agreement with the repair manager.
8.7 The customer shall bear a supervisory and assistance obligation for the compliance with the statutory working time limits. Breaks are to be reported to RÖHM GmbH.
8.8 The customer is obliged to provide the reasonable and necessary technical assistance in costs, in particular:
   a) Provision of the necessary, suitable assistants in the number that is necessary for the repair and for the necessary time, the assistants have to follow the instructions of the repair manager. We do not assume any liability for the assistants, if a defect or damage were caused by the assistants owing to instructions of the repair manager, then the regulations of Sections 17 and 18 shall apply accordingly.
   b) Understaking of all construction, bedding and scaffolding work including the procurement of the necessary building materials.
   c) Provision of the necessary devices and heavy tools as well as the necessary commodities and required materials.
   d) Provision of heating, lighting, operating power, water, including the necessary connection.
   e) Provision of necessary, dry rooms, which can be locked for the storage of the tool for the repair personnel.
   f) Provision of the repair place and materials against harmful influences of all kinds, cleaning of the repair place.
   g) Provision of suitable, theft-proof recreation rooms and work rooms (with heating, lighting, ventilation, prevention of fire and theft) and First Aid equipment.
   h) Provision of the materials and undertaking of all other acts, which are necessary for the adjustment of the object of repair and for carrying out a testing that is envisaged as per contract.
   i) The technical assistance of the orderer must guarantee that the service can be started immediately after the arrival of our personnel and carried out without delay until the acceptance by the orderer. Insofar as special plans or instructions of RÖHM are necessary, RÖHM shall make these available to the orderer in time.

9.2.2 Inspection service
Skilled execution of the necessary inspection of the clamping device and control at the place of installation in line with the regulations of the manufacturer. Insofar as additional maintenance repairs become necessary at the customer’s request or owing to special loads, these are to be remunerated separately by the customer.

5.3 Service Maintenance
Skilled execution of the necessary maintenance of the clamping device and control at the place of installation in line with the regulations of the manufacturer. Insofar as additional maintenance repairs become necessary at the customer’s request or owing to special loads, these are to be remunerated separately by the customer.

5.4 Service obligation
5.5 Our service obligation shall lapse if the product was not subjected to the function necessary, RÖHM shall make these available to the orderer in time.
5.6 Our service obligation shall lapse if the product was not subjected to the function necessary, RÖHM shall make these available to the orderer in time.
5.7 Our service obligation shall lapse if the product was not subjected to the function necessary, RÖHM shall make these available to the orderer in time.
5.8 Our service obligation shall lapse if the product was not subjected to the function necessary, RÖHM shall make these available to the orderer in time.
5.9 Our service obligation shall lapse if the product was not subjected to the function necessary, RÖHM shall make these available to the orderer in time.
5.10 Our service obligation shall lapse if the product was not subjected to the function necessary, RÖHM shall make these available to the orderer in time.
10.2 The customer undertakes to accept our services under this contract immediately after the report that they have been completed. Upon request he has to declare their acceptance in writing to us and/or to our vicarious agents or insurers as there is no essential defect detected by our employees, according to the signed service report.

10.3 Our services shall be deemed as accepted free of defects with the re-commencement of the operational use of the maintained or repaired product, in particular for precautionary purposes. Any defects in the products have been previously reported by the customer.

11. Cost details and cost estimate

11.1 The creation of the cost estimates is liable to costs if the execution of the repair is not approved.

11.2 The costs for a cost estimate amount to the flat rates fixed in the current price list.

11.3 If the repair cannot be carried out at these costs or if our employees or vicarious agents consider the execution of additional work to be necessary during the repair the customer’s consent is to be obtained if the stated costs are exceeded by more than 15%.

12. Remuneration, maturity and terms of payment

12.1 Insofar as not otherwise agreed and there is no warranty case our services are to be remunerated according to the actual work requirement pursuant to our respectively valid general price lists. The time required by our employees will be settled in time sections of 15 min. In addition to the time required for the work that is to be performed in these cases the customer will pay the travelling and waiting times, overtime surcharges, expenses, travelling and accommodation costs as well as the costs of spare parts, materials subject to wear and tear and consumables and replacement part sets according to our prices lists or in line with the offer.

12.2 Insofar as a flat rate remuneration was agreed for a service package, our work and travelling costs and expenses are thus covered, not however the costs for waiting times, overtime at the customer’s request, spare parts, materials subject to wear and tear and consumables, replacement parts sets as well as other accessories. Our work for applicable necessary repairs is to be remunerated separately by the customer according to Subclause 12.1.

12.3 The prices for our services can be derived from the respective price list valid upon conclusion of the contract and are deemed ex works according to our current price list. The calculation basis for the remuneration is the one-shift operation, i.e. the use of the products up to 160 hours in a calendar month. A surcharge to the list price of 50% is charged for the two-shift operation, i.e. 100% for three-shift operation. The customer’s price list shall only apply to service packages described under Subclause 5. If the customer requests assignments outside of our normal working hours (Mo - Fr, 6:30 am - 6:30 pm, a max. of 7 h per day) surcharges will be calculated according to the respective valid price list.

12.4 If our personal and material costs are increased then we are entitled to adjust the contract prices, the service packages of the first year up to a maximum of 5% above the price of the previous year. Price changes will be announced to the customer at least one month before the new contractual prices come into force. The customer is entitled to terminate the contract effective as of the time at which the new price would become valid for him for the first time.

13. Transport and insurance with the repair in the plant of RÖHM GmbH

13.1 The object for repair will be delivered by the customer to us at his costs together with the repair and service form and after execution of the repair collected by the customer again or return to him at the customer’s costs.

13.2 The customer shall bear the risk of transport.

13.3 At the customer’s request a shipment carried out by us will be insured at the customer’s request at the customer’s costs. If the insurance cover exists during the repair time in our plant. The customer hereby asserts claims in the reciprocal relationship, in particular claims for defects.

13.4 No insurance cover exists during the repair time in our plant. The customer has to ensure the maintenance of the existing insurance cover for the object of repair e.g. with Subclauses 5.2.1, 5.2.2 and 5.2.3 the following applies: If our services are faulty then we are first of all entitled and obliged to subsequent satisfaction according to Section 634 No. 1 BGB. If the subsequent satisfaction finally fails the customer can according to Section 634 No. 3 cancel the contract or reduce the remuneration and according to Section 634 No. 4 BGB request damages. Claims of the customer for reimbursement of expenses according to Section 634 No. 2 BGB (self-execution) are excluded. Subclause 18 shall apply to claims for damages.

13.5 In case of delay of the customer with the take-over we can charge a storage fee of current account the afore-mentioned property shall be deemed as security for our payment claims against him, in the amount of the value of Civil Procedure the customer shall be liable for the loss incurred to us.

13.6 As long as the property has not yet been assigned, the customer has to inform us immediately in writing if the delivered object is attached or is exposed to other interventions of third parties. Insofar as the third party is not in the position to reimburse us the court and out-of-court costs of an action according to Section 717 ZPO [German Code of Civil Procedure] the customer shall be liable for the loss incurred to us.

13.7 We undertake to release the securities to which we are entitled at the customer’s request inssofar as their value exceeds the claims which are to be secured by more than 20 %.

17. Warranty

17.1 Insofar as the creation of a work has been agreed and thus the law governing contracts for work and services applies the following shall apply: If our services are faulty then we are first of all entitled and obliged to subsequent satisfaction according to Section 634 No. 1 BGB. If the subsequent satisfaction finally fails the customer can according to Section 634 No. 3 cancel the contract or reduce the remuneration and according to Section 634 No. 4 BGB request damages. Claims of the customer for reimbursement of expenses according to Section 634 No. 2 BGB (self-execution) are excluded. Subclause 18 shall apply to claims for damages.

17.2 Insofar as we provide planning services without executing these and thus the law governing service contracts applies (e.g. in the event of a breach of our duties under Subclauses 5.2.1, 5.2.2 and 5.2.3) the following applies: If our services are faulty then we are first of all entitled and obliged to subsequent improvement. If the subsequent improvement finally fails the customer is entitled to damages according to Subclause 18.

17.3 Excluded from the warranty are damages as a result of natural wear and tear, faultly maintenance – insofar as we have not carried out this maintenance as per contract, failure to comply with operating equipment regulations, excessive use, unsuitable operating equipment, chemical or electrolytic influences, faulty construction and assembly work of third parties as well as other causes, for which we are not responsible.

17.4 The warranty shall lapse if the customer or third party makes changes or repairs to our services/products without our prior written consent unless the defect is not a result thereof.

17.5 Claims of the customer owing to defects of quality and title shall become statute-barred with the expiry of 12 months after the acceptance of the work or the knowledge of defects with the provision of planning services.

18. Liability

18.1 We shall be liable to an unlimited extent in case of willful intent and gross negligence as well as with the injury to life, the body and the health as well as with the culpable breach of essential contractual obligations. Deemed as essential are such contractual obligations, the fulfilment of which makes the proper execution of the contract possible at all and the compliance with which the contractual partner may as a rule rely and depend on.

18.2 Incidentally our liability is excluded.

18.4 A liability according to the Product Liability Act remains unaffected.

18.5 The personal liability of our legal representatives and vicarious agents is limited as our own liability according to the afore-mentioned provisions.

19. Term of the contract; termination

19.1 Service agreements according to Subclause 5. shall come into force when signed by both parties and shall initially apply until the end of the calendar year, that follows the year in which the contract was concluded. The contractual relationship will subsequently be extended respectively by one further year unless it is terminated by one of the parties with a period of notice of 3 months at the end of the second or a following year. Contractual relationships can be terminated on the whole or only with regard to particular products or risks at the exclusive will of the customer.

19.2 The right to the extraordinary termination for an important reason remains unaffected.

20. Place of jurisdiction; applicable law

20.1 With all disputes ensuing from the contractual relationship if the orderer is a merchant, a legal entity under public law or a special fund under public law, the action is to be filed at the court that has jurisdiction for our headquarters. We are also entitled to file an action at the headquarters of the orderer.

20.2 The legal relationship is subject to the law of the Federal Republic of Germany.


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