

GS/NC – rigid design

For the machining of clockwise and anticlockwise threads – with taps – on mechanical and numeric controlled machines and CNC machines with tool magazine.

Type GSA

For automatic tool changing, with length compensation acting on compression and expansion.

Positive Taper Lock acc. DIN 69893
 Steep Taper acc. DIN 69871/A,
 Steep Taper for MAS-BT (one-piece)
 Steep Taper for MAS-BT (two-piece)

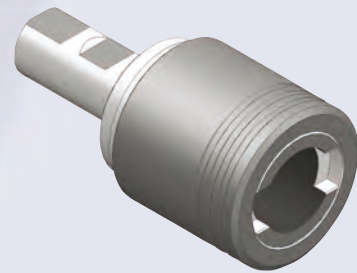


Type GS/C

The newly developed push and length compensation acting on compression and expansion marks the RÖHM GS/C Chuck for tapping. The axial movement gives the chuck a rigid grip with a narrow axial play due the asymmetric arrangement of the balls and thus the ideal force distribution.

A tough lead force pressure and an easy going length compensation guarantees threads in between the allowance and production security even under hardest conditions. The tapping chuck offers highest security during the tapping cycle. Few maintenance required.

Adjustable Adapter Shaft acc. DIN 6327,
 Morse Taper acc. DIN 228-A,
 Morse Taper acc. DIN 228-B,
 Module Shaft acc. DIN 1835 - form B+E
 Cylindrical Shaft acc. VDI without toothing,
 Reception type ABS.

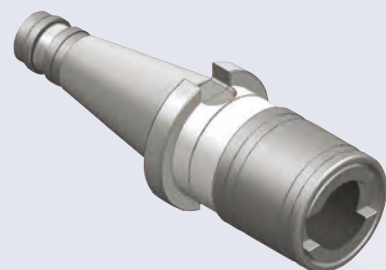


Type GS/NC

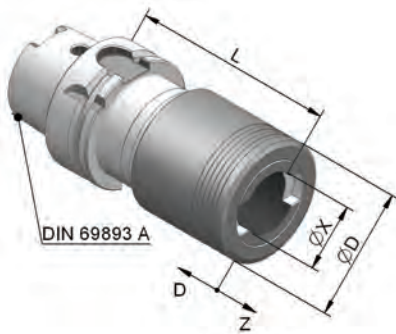
Tapping Chuck with an extremely easy going and low friction compression and expansion length compensation due to the ball guiding sleeve.

This results in a very accurate compensation of the differences between machine feed movement and the pitch of the tap. The lead force mechanism provides that the tap immediately starts to cut the thread when the permissible axial forces – depending on the material strength and specific cutting force. Only if the effectively produced axial force exceeds the normal permissible lead force the lead force mechanism releases the length compensation ability. The ball pretension resp. the lead force may be raised or reduced by the threaded pin via the pressure spring.

Adjustable Adapter Shaft acc. DIN 6327,
 Morse Taper acc. DIN 228-A,
 Morse Taper acc. DIN 228-B,
 Cylindrical Shaft similar to DIN 1835 - form B+E,
 Cylindrical Shaft similar to DIN 1835 - with clamping surface,
 Steep Taper acc. DIN 2080.

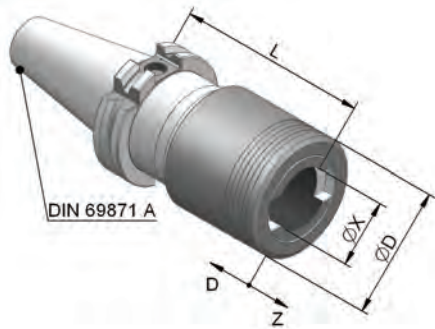


Tool group A19
Type 354-80 **GSA HSK**
hollow taper shank DIN 69893 A



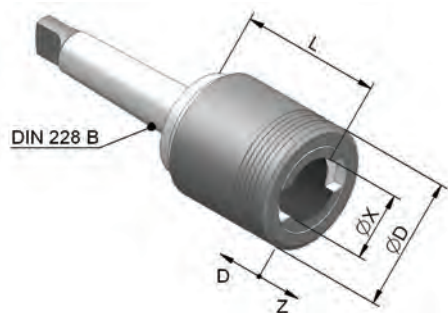
Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
1132809	1	M3 - M12	7,5	7,5	HSK-100	39	19	80
1132813	1	M3 - M12	0	12,5	HSK-100	39	19	72,5
1132806	1	M3 - M12	7,5	7,5	HSK-50	39	19	72
1132810	1	M3 - M12	0	12,5	HSK-50	39	19	64,5
1132807	1	M3 - M12	7,5	7,5	HSK-63	39	19	72
1132811	1	M3 - M12	0	12,5	HSK-63	39	19	64,5
1132808	1	M3 - M12	7,5	7,5	HSK-80	39	19	75
1132812	1	M3 - M12	0	12,5	HSK-80	39	19	67,5
1132817	2	M8 - M20	10	10	HSK-100	60	31	100
1132821	2	M8 - M20	0	16,5	HSK-100	60	31	90
1132814	2	M8 - M20	10	10	HSK-50	60	31	110
1132818	2	M8 - M20	0	16,5	HSK-50	60	31	100
1132815	2	M8 - M20	10	10	HSK-63	60	31	110
1132819	2	M8 - M20	0	16,5	HSK-63	60	31	100
1132816	2	M8 - M20	10	10	HSK-80	60	31	95
1132820	2	M8 - M20	0	16,5	HSK-80	60	31	85
1132824	3	M14 - M33	17,5	17,5	HSK-100	86	48	144
1132827	3	M14 - M33	0	35	HSK-100	86	48	126,5
1132822	3	M14 - M33	17,5	17,5	HSK-63	86	48	141
1132825	3	M14 - M33	0	35	HSK-63	86	48	123,5
1132823	3	M14 - M33	17,5	17,5	HSK-80	86	48	141
1132826	3	M14 - M33	0	35	HSK-80	86	48	123,5

Tool group A19
Type 354-85 **GSA SK**
with steep taper shank DIN 69871 - form A



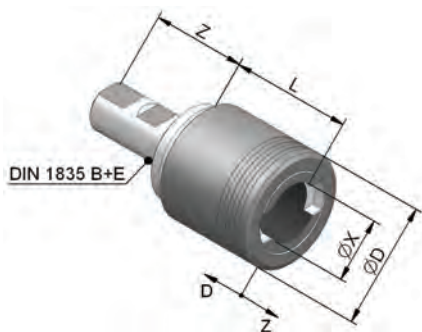
Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
1132768	0	M1 - M10	6,5	6,5	SK 40	26	13	94
1132769	0	M1 - M10	6,5	6,5	SK 50	26	13	104
1132828	1	M3 - M12	7,5	7,5	SK 30	39	19	65
1132830	1	M3 - M12	0	12,5	SK 30	39	19	57,5
1132829	1	M3 - M12	7,5	7,5	SK 40	39	19	65
1132831	1	M3 - M12	0	12,5	SK 40	39	19	57,5
1132832	2	M8 - M20	10	10	SK 30	60	31	103
1132835	2	M8 - M20	0	16,5	SK 30	60	31	93
1132833	2	M8 - M20	10	10	SK 40	60	31	103
1132836	2	M8 - M20	0	16,5	SK 40	60	31	93
1132834	2	M8 - M20	10	10	SK 50	60	31	88
1132837	2	M8 - M20	0	16,5	SK 50	60	31	78
1132838	3	M14 - M33	17,5	17,5	SK 40	86	48	134
1132840	3	M14 - M33	0	35	SK 40	86	48	116,5
1132839	3	M14 - M33	17,5	17,5	SK 50	86	48	134
1132841	3	M14 - M33	0	35	SK 50	86	48	116,5

Tool group A19
Type 353-65 **GS/C**
with morse taper DIN 228 B



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
1132914	1	M3 - M12	7,5	7,5	MK 2	39	19	52
1132916	1	M3 - M12	0	12,5	MK 2	39	19	44,5
1132915	1	M3 - M12	7,5	7,5	MK 3	39	19	52
1132917	1	M3 - M12	0	12,5	MK 3	39	19	44,5
1132918	2	M8 - M20	10	10	MK 3	60	31	75
1132920	2	M8 - M20	0	16,5	MK 3	60	31	65
1132919	2	M8 - M20	10	10	MK 4	60	31	76
1132921	2	M8 - M20	0	16,5	MK 4	60	31	66
1132922	3	M14 - M33	17,5	17,5	MK 4	86	48	107
1132924	3	M14 - M33	0	35	MK 4	86	48	89,5
1132923	3	M14 - M33	17,5	17,5	MK 5	86	48	107,5
1132925	3	M14 - M33	0	35	MK 5	86	48	90

Tool group A19
Type 353-55 **GS/C**
with parallel shank DIN 1835 - form B + E



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L	Z
1132858	1	M3 - M12	7,5	7,5	25	39	19	45	53
1132859	1	M3 - M12	0	12,5	25	39	19	37,5	53
1132860	2	M8 - M20	10	10	25	60	31	68	53
1132861	2	M8 - M20	0	16,5	25	60	31	58	53
1132862	3	M14 - M33	17,5	17,5	32	86	48	99	60
1132863	3	M14 - M33	0	35	32	86	48	81,5	60

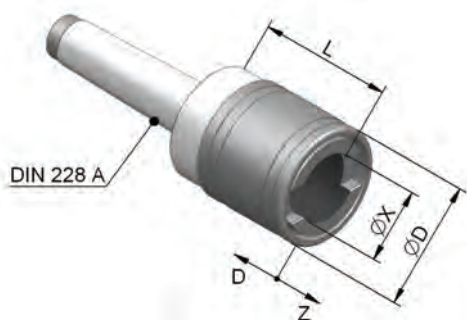
Tool group A19
Type 344-01 **GS/NC** with trapezoidal thread DIN 6327
woodruff key DIN 6888



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637100	0	M1 - M10	6,5	6,5	Tr 16x1,5	25,5	13	49
637101	0	M1 - M10	6,5	6,5	Tr 20x2	25,5	13	49
637102	1	M3 - M12	7,5	7,5	Tr 16x1,5	36	19	51
637103	1	M3 - M12	7,5	7,5	Tr 20x2	36	19	51
637104	1	M3 - M12	7,5	7,5	Tr 28x2	36	19	51
637105	1	M3 - M12	7,5	7,5	Tr 36x2	36	19	53
652058	2	M8 - M20	12,5	12,5	Tr 20x2	53	31	75
637106	2	M8 - M20	12,5	12,5	Tr 28x2	53	31	75
637107	2	M8 - M20	12,5	12,5	Tr 36x2	53	31	77
707994	3	M14 - M33	20	20	Tr 28x2	78	48	108
637108	3	M14 - M33	20	20	Tr 36x2	78	48	110
637109	3	M14 - M33	20	20	Tr 48x2	78	48	114
691303 ¹⁾	4	M22 - M48	22,5	22,5	Tr 36x2	96	60	121
637110	4	M22 - M48	22,5	22,5	Tr 48x2	96	60	125

¹⁾ special design

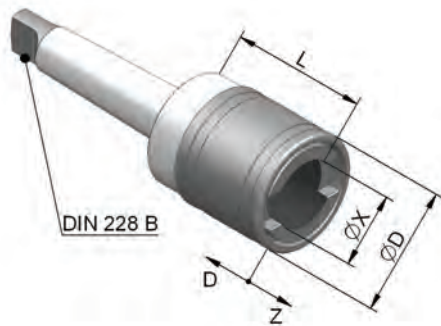
Tool group A19
Type 344-12 **GS/NC**
with morse taper DIN 228 A



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637134	0	M1 - M10	6,5	6,5	MK 2	25,5	13	44
637135	1	M3 - M12	7,5	7,5	MK 2	36	19	46
637136	1	M3 - M12	7,5	7,5	MK 3	36	19	46
637137	2	M8 - M20	12,5	12,5	MK 3	53	31	70
637138	2	M8 - M20	12,5	12,5	MK 4	53	31	71
1132762	3	M14 - M33	20	20	MK 3	78	48	163
637139	3	M14 - M33	20	20	MK 4	78	48	104
637140	3	M14 - M33	20	20	MK 5	78	48	104
637141	4	M22 - M48	22,5	22,5	MK 5	96	60	115
637142	4	M22 - M48	22,5	22,5	MK 6	96	60	117

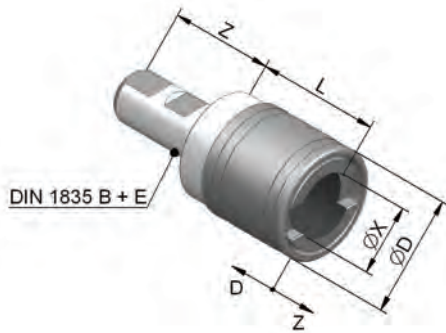
GS/NC

Tool group A19
Type 344-11 **GS/NC**
with morse taper DIN 228 B



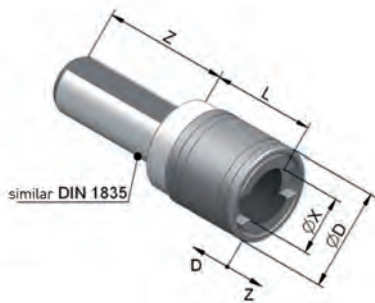
Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637125	0	M1 - M10	6,5	6,5	MK 2	25,5	13	44
637126	1	M3 - M12	7,5	7,5	MK 2	36	19	46
637127	1	M3 - M12	7,5	7,5	MK 3	36	19	46
637128	2	M8 - M20	12,5	12,5	MK 3	53	31	70
637129	2	M8 - M20	12,5	12,5	MK 4	53	31	71
637130	3	M14 - M33	20	20	MK 4	78	48	104
637131	3	M14 - M33	20	20	MK 5	78	48	104
637132	4	M22 - M48	22,5	22,5	MK 5	96	60	115
637133	4	M22 - M48	22,5	22,5	MK 6	96	60	117

Tool group A19
Type 344-64 **GS/NC**
with parallel shank DIN 1835 - form B + E



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L	Z
697807	0	M1 - M10	6,5	6,5	16	25,5	13	37	49
1132755	0	M1 - M10	6,5	6,5	20	25,5	13	37	51
672875	1	M3 - M12	7,5	7,5	20	36	19	39	51
697808	1	M3 - M12	7,5	7,5	25	36	19	39	53
672876	2	M8 - M20	12,5	12,5	25	53	31	63	53
697809	2	M8 - M20	12,5	12,5	32	53	31	63	60
1132756	3	M14 - M33	20	20	25	78	48	170	53
672877	3	M14 - M33	20	20	32	78	48	124	60
1132757	4	M22 - M48	22,5	22,5	32	96	60	140	60

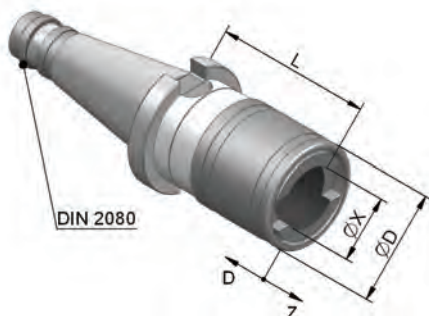
Tool group A19
Type 344-62 **GS/NC**
with cylindrical shank similar to DIN 1835, with clamping flat



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L	Z
637115	0	M1 - M10	6,5	6,5	16	25,5	13	37	56
637116	0	M1 - M10	6,5	6,5	20	25,5	13	37	56
637117	1	M3 - M12	7,5	7,5	16	36	19	39	56
697798	1	M3 - M12	7,5	7,5	20	36	19	39	58
637118	1	M3 - M12	7,5	7,5	25	36	19	39	58
1132988	1	M3 - M12	7,5	7,5	30	36	19	39	58
637119	1	M3 - M12	7,5	7,5	32	36	19	39	58
637120	1	M3 - M12	7,5	7,5	40	36	19	39	58
637121	2	M8 - M20	12,5	12,5	30	53	31	63	77
637122	2	M8 - M20	12,5	12,5	32	53	31	63	77
637123	2	M8 - M20	12,5	12,5	35	53	31	63	77
637124	2	M8 - M20	12,5	12,5	40	53	31	63	77
608540 ¹⁾	3	M14 - M33	20	20	25	78	48	98	100
697810	3	M14 - M33	20	20	30	78	48	98	100
697811	3	M14 - M33	20	20	32	78	48	98	100
697812	3	M14 - M33	20	20	35	78	48	98	100
697813	3	M14 - M33	20	20	40	78	48	98	100

¹⁾ special design

Tool group A19
Type 344-21 **GS/NC**
with steep taper shank DIN 2080



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637143	1	M3 - M12	7,5	7,5	SK 30	36	19	58
637144 ¹⁾	1	M3 - M12	7,5	7,5	SK 40	36	19	71
733898	1	M3 - M12	7,5	7,5	SK 50	36	19	59
637145 ¹⁾	2	M8 - M20	12,5	12,5	SK 40	53	31	85
1132946	2	M8 - M20	12,5	12,5	SK 45	53	31	95
733899	2	M8 - M20	12,5	12,5	SK 50	53	31	79
637147 ¹⁾	3	M14 - M33	20	20	SK 40	78	48	142
637148	3	M14 - M33	20	20	SK 50	78	48	129
1132947	4	M22 - M48	22,5	22,5	SK 40	96	60	157
637149	4	M22 - M48	22,5	22,5	SK 50	96	60	143

¹⁾ with ring groove for automatic tool clamping