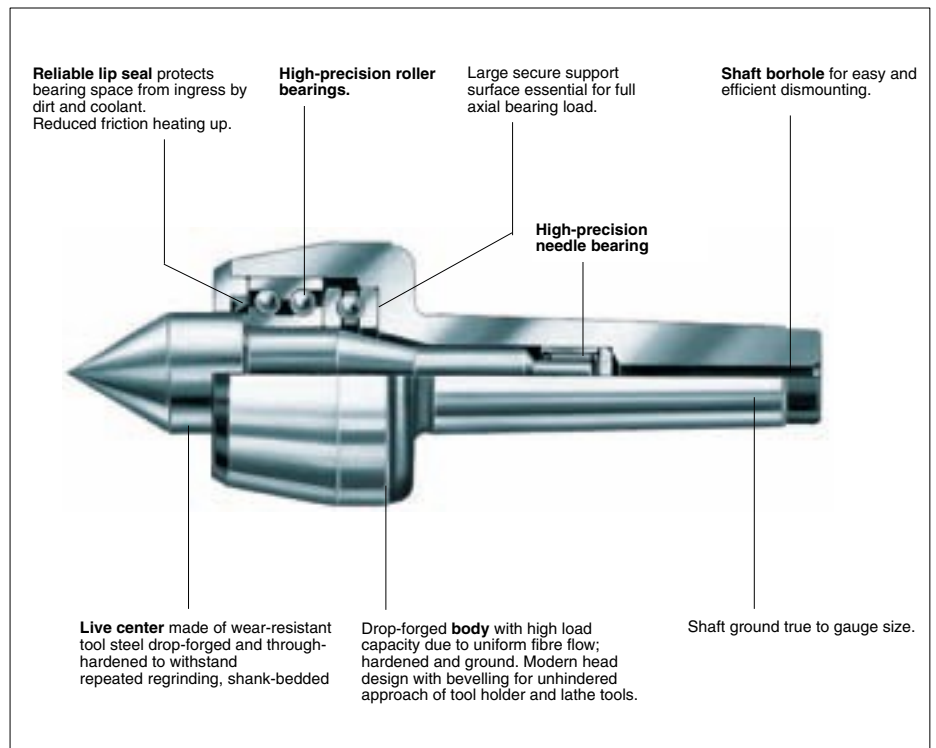


Advantages:

- Triple bearing method
- High runout accuracy
- Life-time lubricated
- Different models suitable to various applications
- High speeds
- Heavy duty
- Long life



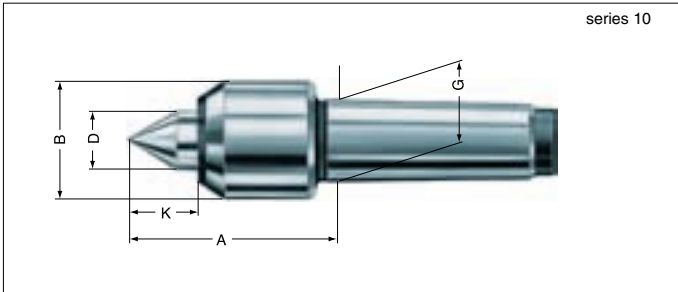
RÖHM Revolving Tailstock Centers

tip angle 60°

TIR .0002"

2
Revolving Tailstock Centers

Type 600 with small body diameter

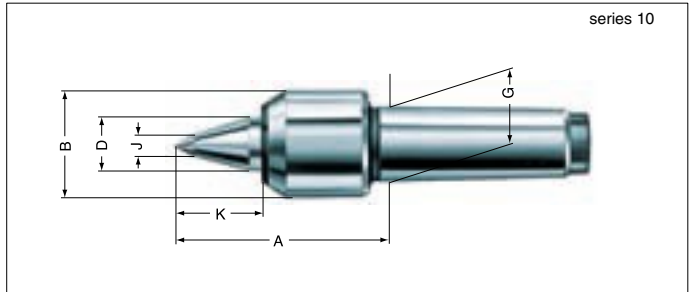


Size	02	04	08	10	14
MT	2	3	4	5	6
Id.-No.	005336	005429	005469	005490	005547
Workpiece weight max. kg	200	400	800	1600	3500
Max.concentr. error	0,005	0,005	0,005	0,01	0,02
Speed max. min ⁻¹	7000	7000	6300	4300	3000
A	62	62	75,5	104	143
B	32	34	42	58	80
D	15	15	20	30	42
G	17,780	23,825	31,267	44,399	63,348
J	-	-	-	-	-
K	18	18	25	34	49

Spare spindles

Id.-No.	005339	005432	005472	005493	005550
ca. g	85	90	190	510	1340

Type 600-20 with extended live center

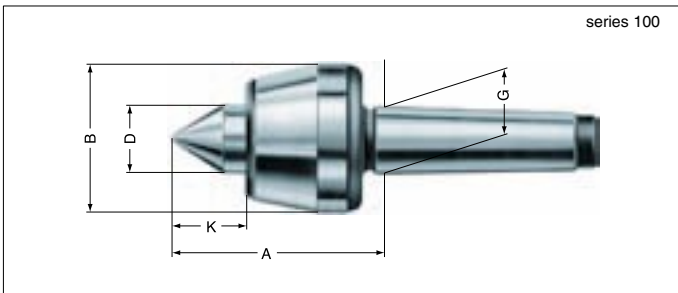


Size	02	04	08	10	14
MT	2	3	4	5	6
Id.-No.	362080	362081	362082	362083	362084
Workpiece weight max. kg	170	340	700	1400	3000
Concentr. error	0,008	0,008	0,008	0,01	0,02
Speed max. min ⁻¹	7000	7000	6300	4300	3000
A	73	74	88,5	119	164
B	32	34	42	58	80
D	15	15	20	30	42
G	17,780	23,825	31,267	44,399	63,348
J	10	11	13	14	18
K	29	30	38	49	70
ca. kg	0,32	0,46	1,0	2,6	7,1

Spare spindles

Id.-No.	362085	362086	362087	362088	362089
ca. g	85	90	190	510	1340

Type 601 N standard design, body only ground

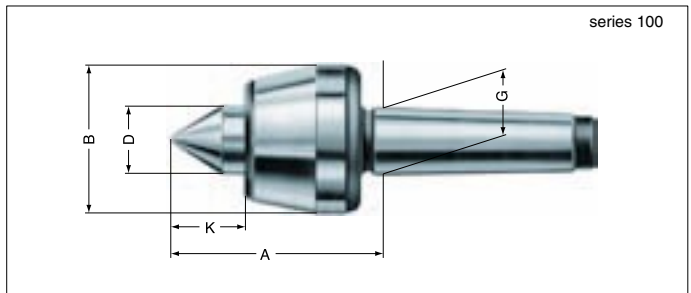


Size	100	101	102	104	108	110
MT	0	1	2	3	4	5
Id.-No.	061740	043395	043111	042310	042171	042839
workpiece weight max. kg	10	80	180	300	750	1800
concentr. error max.	0,01	0,005	0,005	0,005	0,005	0,005
speed max. min ⁻¹	15000	7000	7000	6300	3800	3000
A	44	60,5	65	70,5	102,5	129
B	25	36	45	50	70	90
D	10	15	20	22	32	40
G	9,045	12,065	17,780	23,825	31,267	44,399
K	11	17	24	27,5	41	50,5
ca. kg	0,2	0,4	0,5	0,8	2,3	4,7

Spare spindles

Id.-No.	005660	043398	005728	005780	005796	005806
ca. g	13	45	80	150	380	710

Type 604 H body hardened and ground



Size	101	102	104	106	108	110	114	116	116
MT	1	2	3	3	4	5	6	6	m 80
Id.-No.	043400	043115	042315	042776	042175	042843	043532	093439	093440
Workpiece weight kg	100	200	400	500	800	2000	3500	4500	7500
Concentr. error max.	0,005	0,005	0,005	0,005	0,005	0,005	0,01	0,01	0,015
Speed max. min ⁻¹	7000	7000	6300	5000	3800	3000	2600	1500	1500
A	60,5	65	70,5	79,5	102,5	129	152	196	196
B	36	45	50	60	70	90	105	140	140
D	15	20	22	25	32	40	50	60	60
G	12,065	17,780	23,825	23,825	31,267	44,399	63,348	63,348	80,000
K	17	24	27,5	31	41	50,5	57,5	67	68
ca. kg	0,4	0,5	0,8	1,3	2,3	4,7	10,2	17,8	23

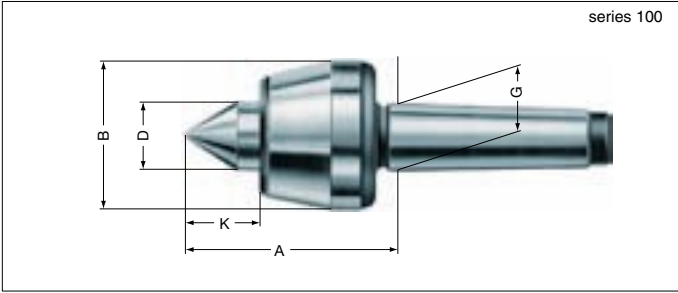
Spare spindles

Id.-No.	043398	005728	005780	005896	005796	005806	005911	093458	093464
ca. g	45	80	150	200	380	710	1330	2700	3200

Tool group 06

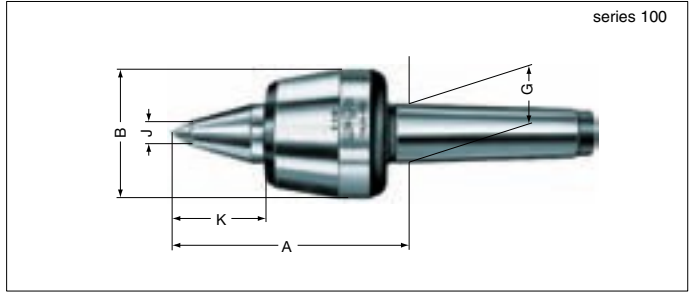
TIR .00015"

Type 604 HP precision version



Size	102	106	108	110
MT	2	3	4	5
Id.-No.	082392	318227	082394	082395
Workpiece weight max. kg	200	500	800	2000
Concentr. error max.	0,003	0,003	0,003	0,003
Speed max. min ⁻¹	7000	5000	3800	3000
A	65	82	102,5	129
B	45	55	70	90
D	20	25	32	40
G	17,780	23,825	31,267	44,399
J	-	-	-	-
K	24	30,5	41	50,5
ca. kg	0,5	1,3	2,3	4,7
Spare spindles				
Id.-No.	005728	324478	005796	005806
ca. g	80	200	380	710

Type 604 HVL with extended live center



Size	101	102	106	108	110	114
MT	1	2	3	4	5	6
Id.-No.	058668	058669	058670	058671	058672	058673
Workpiece weight max. kg	80	140	400	500	1200	2500
Concentr. error max.	0,01	0,005	0,005	0,005	0,005	0,01
Speed max. min ⁻¹	7000	7000	5000	3800	3000	2600
A	70,5	75	95,5	114,5	143,5	172,5
B	36	45	60	70	90	105
D	15	20	25	32	40	50
G	12,065	17,780	23,825	31,267	44,399	63,348
J	9	10	12	14	16	18
K	27	34	47	53	65	78
ca. kg	0,4	0,5	1,3	2,3	4,8	10,2
Spare spindles						
Id.-No.	068722	068723	068724	068725	068727	068728
ca. g	240	350	400	400	750	1500

Tool group 06

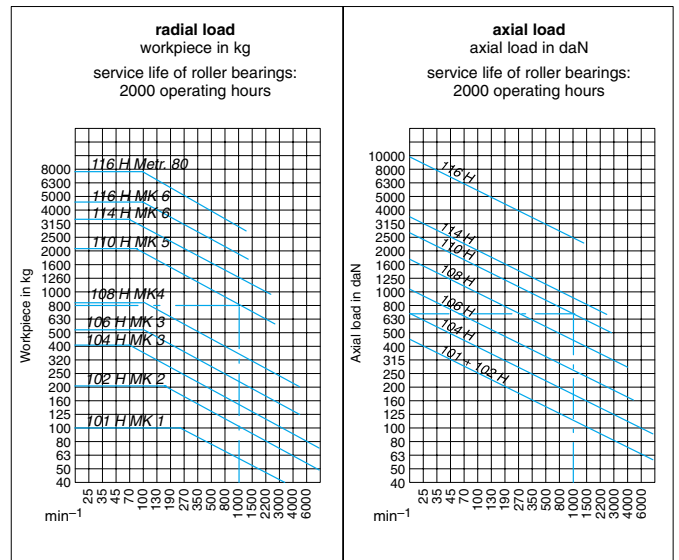
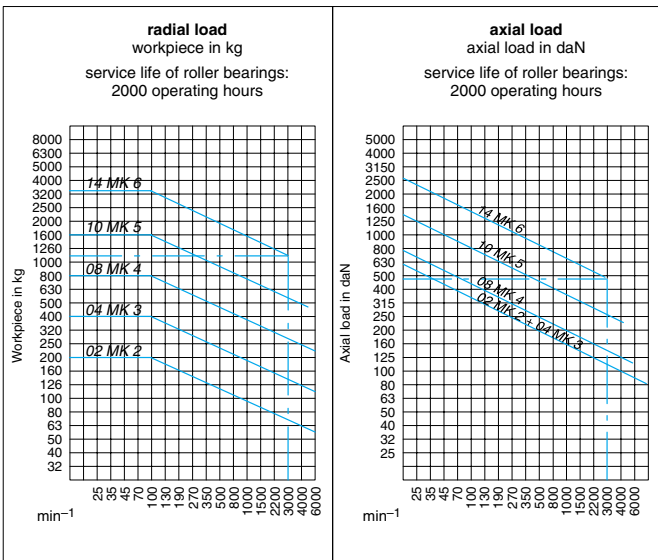
2
Revolving Tailstock Centers

Load Diagrams

Example Type 600:
admissible load of revolving tailstock center 14 at 3000 min⁻¹,
radially = 1130 kg workpiece, axially = 480 daN

Type 600-20: At radial load reduced workpiece weight

Example Type 604 H and HP:
admissible load of revolving tailstock center 110 H at 1000 min⁻¹,
radially = 800 kg workpiece, axially = 695 daN

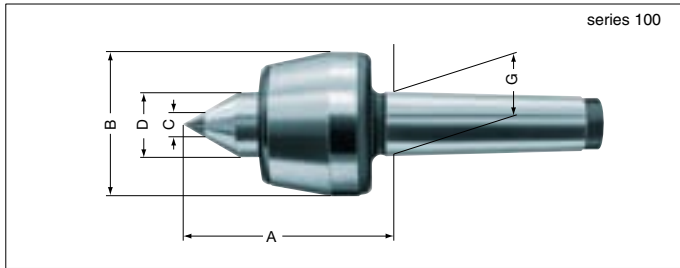


RÖHM Revolving Tailstock Centers

tip angle 60°

TIR .0002"

Type 604 HM with carbide insert

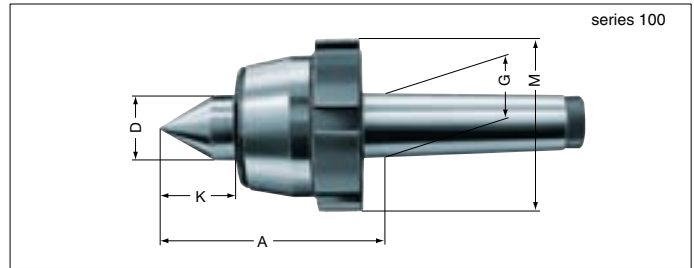


Size	101	102	104	106	108	110	114
MT	1	2	3	3	4	5	6
Id.-No.	225297	032140	090089	237413	093306	221016	221017
Workpiece weight max. kg	60	120	240	360	500	1000	1800
Concentr. error max.	0,005	0,005	0,005	0,005	0,005	0,005	0,01
Speed max. min ⁻¹	7000	7000	6300	5000	3800	3000	2600
A	60,5	65	70,5	79,5	102,5	129	152
B	36	45	50	60	70	90	105
C	7	11	11	14	14	18	18
D	15	20	22	25	32	40	50
G	12,065	17,780	23,825	23,825	31,267	44,399	63,348
K	17	24	27,5	31	41	50,5	57,5
ca. kg	0,4	0,6	0,9	1,3	2,3	4,7	10

Spare spindles

Id.-No.	097545	032141	090090	090330	090214	221033	221034
ca. g	60	90	160	220	390	720	1330

Type 604 HG with draw-off nut

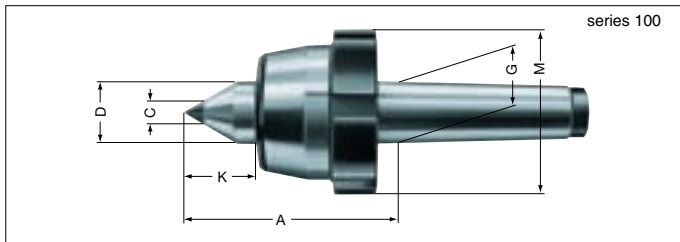


Size	102	104	106	108	110	114
MT	2	3	3	4	5	6
Id.-No.	221018	221019	205036	207148	074390	221020
Workpiece weight max. kg	200	400	500	800	2000	3500
Concentr. error max.	0,005	0,005	0,005	0,005	0,005	0,01
Speed max. min ⁻¹	7000	6300	5000	3800	3000	2600
A	65	70,5	79,5	102,5	129	152
B	45	50	60	70	90	105
C	11	11	14	14	18	18
D	20	22	25	32	40	50
G	17,780	23,825	23,825	31,267	44,399	63,348
K	24	27,5	31	41	50,5	57,5
M	56	62	74	82	105	120
ca. kg	0,6	1,0	1,4	2,4	5,2	10,5

Spare spindles

Id.-No.	005728	005780	005896	005796	005806	005911
ca. g	80	150	200	380	710	1330

Type 604 HMG with draw-off nut and carbide insert

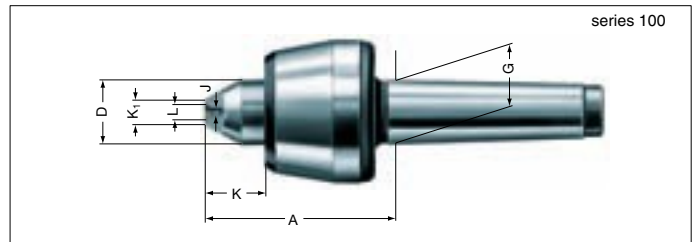


Size	102	104	106	108	110	114
MT	2	3	3	4	5	6
Id.-No.	221021	221022	221023	221024	221025	221026
Workpiece weight max. kg	120	240	360	500	1000	1800
Concentr. error max.	0,005	0,005	0,005	0,005	0,005	0,01
Speed max. min ⁻¹	7000	6300	5000	3800	3000	2600
A	65	70,5	79,5	102,5	129	152
B	45	50	60	70	90	105
D	20	22	25	32	40	50
G	17,780	23,825	23,825	31,267	44,399	63,348
K	24	27,5	31	41	50,5	57,5
M	56	62	74	82	105	120
ca. kg	0,6	1,0	1,4	2,4	5,2	10,5

Spare spindles

Id.-No.	032141	090090	090330	090214	221033	221034
ca. g	90	160	220	390	720	1330

Type 624 HZ with center bore



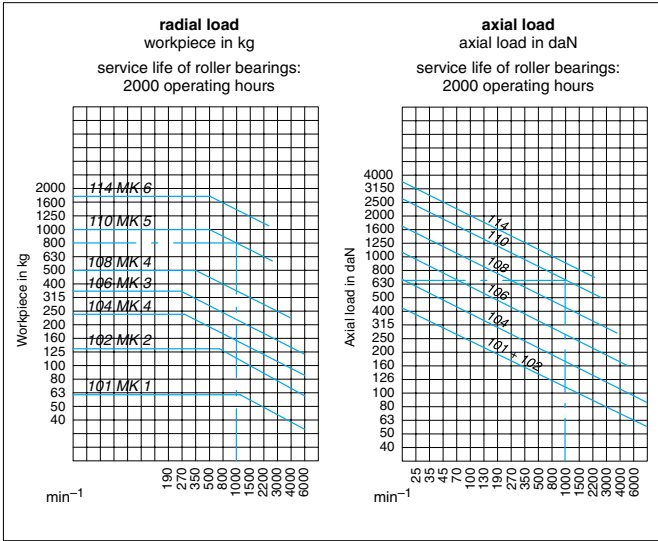
Size	101	102	104	106	108	110	114
MT	1	2	3	3	4	5	6
Id.-No.	221260	221261	221262	221263	221264	221265	221266
Workpiece weight max. kg	50	100	200	250	400	1000	1700
Concentr. error max.	0,005	0,005	0,005	0,005	0,005	0,005	0,01
Speed max. min ⁻¹	7000	7000	6300	5000	3800	3000	2600
A	56,5	60	65	72	92	115	135
B	36	45	50	60	70	90	105
C	7	11	11	14	14	18	18
D	15	20	22	25	32	40	50
G	12,065	17,780	23,825	23,825	31,267	44,399	63,348
J	1	1,5	2	2,5	3,15	5	6,3
K	13	19	21,5	23,5	30	36	40,5
K ₁	5	6	7	9	12	16	20
L	3	4	5	6,5	8	12	16
ca. kg	0,4	0,5	0,9	1,3	2,3	4,7	10

Spare spindles

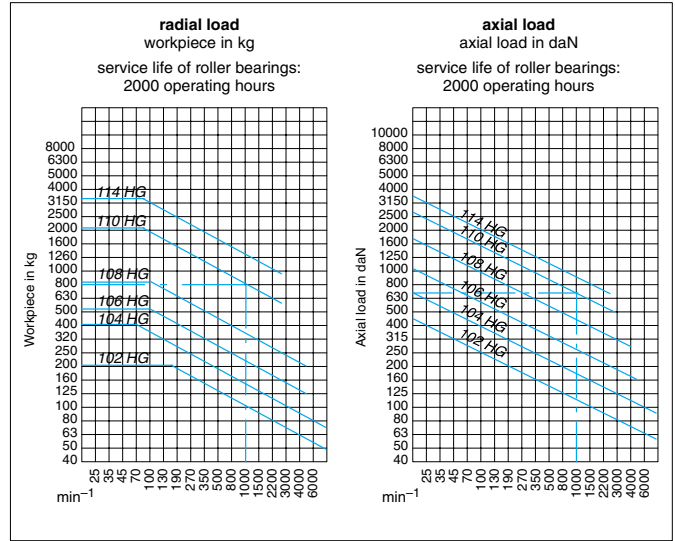
Id.-No.	221267	221268	221269	221270	221271	221272	221273
ca. g	40	80	140	190	360	700	1300

Load Diagrams

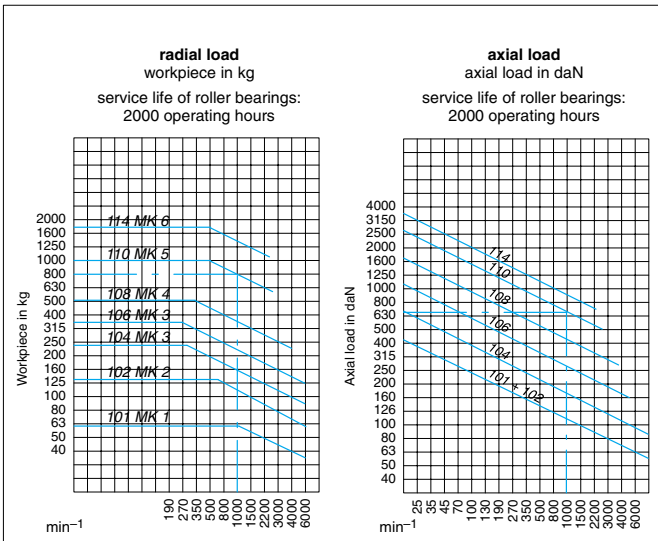
Example Type 604 HM:
admissible load of revolving tailstock center 110 HM
at 1000 min⁻¹, radially = 800 kg workpiece, axially = 695 daN



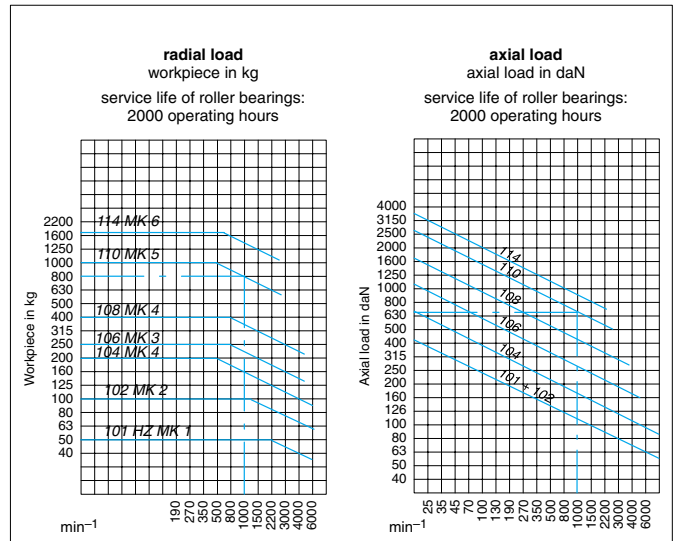
Example Type 604 HG:
admissible load of revolving tailstock center 110 HG
at 1000 min⁻¹, radially = 800 kg workpiece, axially = 695 daN



Example Type 604 HMG:
admissible load of revolving tailstock center 110 HMG
at 1000 min⁻¹, radially = 800 kg workpiece, axially = 695 daN



Example Type 624 HZ:
admissible load of revolving tailstock center 110 HZ
at 1000 min⁻¹, radially = 800 kg workpiece, axially = 695 daN



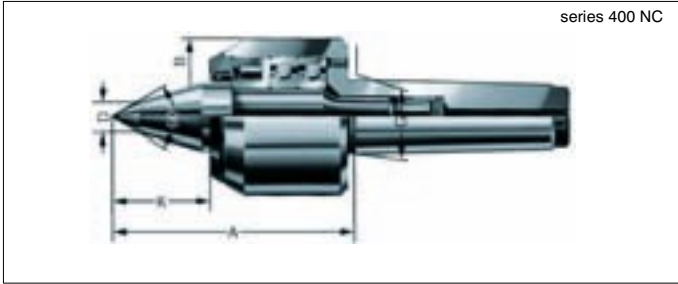
RÖHM Revolving Tailstock Centers

tip angle 60°

TIR .0002"

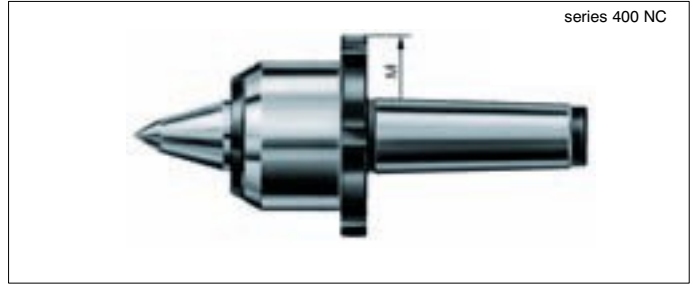
2
Revolving Tailstock Centers

Type 640-20 for high load at high speeds



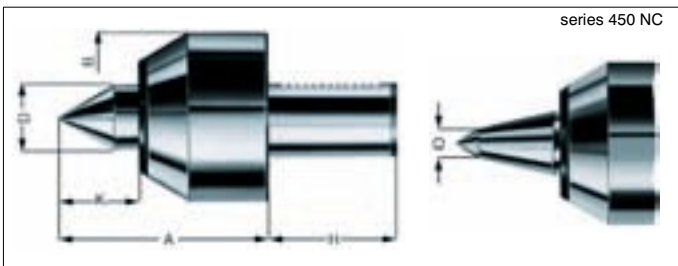
Size	425	425	426			
MT	4	5	6			
Id.-No.	303598	303599	301696			
Workpiece weight max. kg	1000	2000	3000			
Concentr. error max.	0,005	0,005	0,005			
Speed max. min ⁻¹	7000	6000	4800			
A	122	150	180			
B	70	95	120			
D	16	20	26			
G	31,267	44,399	63,348			
K	44	59	77			
ca. kg	2,6	5,5	11,5			
Spare spindles						
Id.-No.	306202	306182	301978			
ca. g	460	1060	2580			

Type 640-80 with draw-off nut



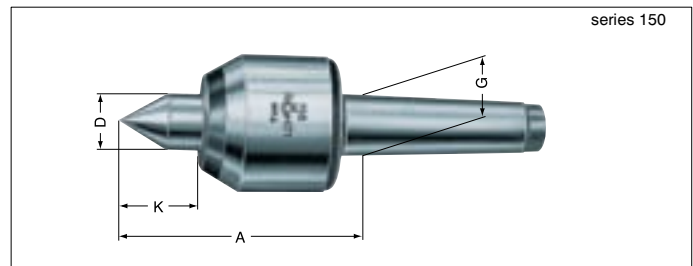
Size	484	485	486			
MT	4	5	6			
Id.-No.	304521	304522	304523			
Workpiece weight max. kg	1000	2000	3000			
Concentr. error max.	0,005	0,005	0,005			
Speed max. min ⁻¹	7000	6000	4800			
A	122	150	180			
B	70	95	120			
C	16	20	26			
K	44	59	77			
M	100	125	155			
ca. kg	2,8	5,4	12,3			
Spare spindles						
Id.-No.	306202	306182	301978			
ca. g	460	1060	2580			

Type 645-00 with shaft VDI 3425/DIN 69880, live center spring-loaded
Type 645-20 with extended and spring-loaded live-center



	Type 645-00			Type 645-20		
Size	453	454	455	453	454	455
Shaft-Ø	30	40	50	30	40	50
Id.-No.	664630	664631	664632	664633	664634	664635
Workpiece weight max. kg	400	800	1600	300	650	1400
Concentr. error max.	0,01	0,01	0,01	0,01	0,01	0,01
Speed max. min ⁻¹	7000	5500	4000	7000	5500	4000
axial load max. daN	580	900	1800	580	900	1800
Preload	1,7	2	2,2	1,7	2	2,2
A	90	102	135	105	116	152
B	68	83	98	68	83	98
D	25	32	40	25	32	40
K	31,5	39	49	46,5	53	66
O	-	-	-	11	14	15
ca. kg	2,2	3,6	8,4	2,3	3,7	8,5
Spare spindles						
Id.-No.	009192	009205	009325	079924	079925	079926
ca. g	190	360	760	200	400	800

Type 615 with impact damping



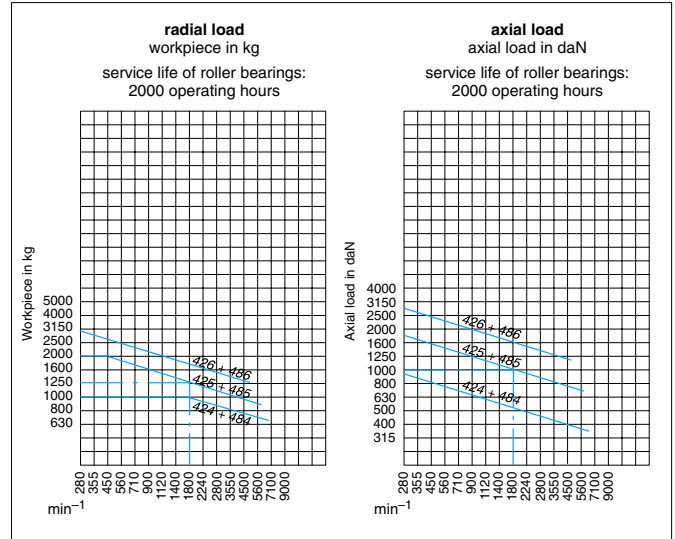
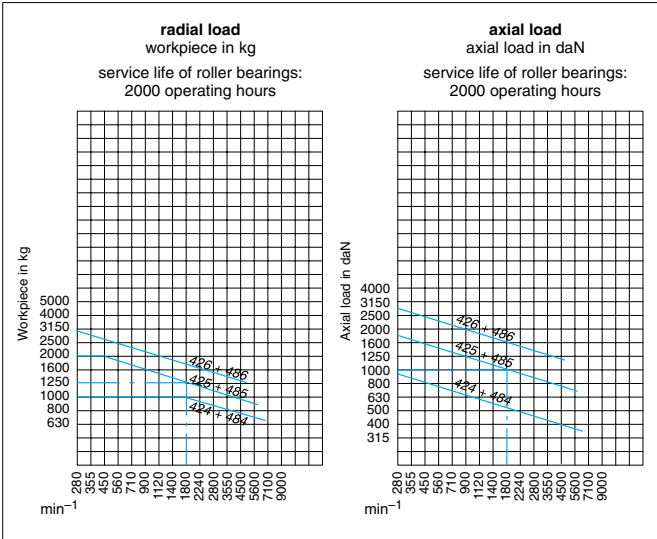
Size	156	158	160			
MT	3	4	5			
Id.-No.	060779	060846	060881			
Workpiece weight max. kg	150	300	600			
concentr. error max.	0,01	0,01	0,01			
speed max. min ⁻¹	8000	7000	5000			
A	97	113,5	147			
B	60	70	95			
D	25	32	40			
G	23,825	31,267	44,399			
K	31,5	39,5	49,5			
ca. kg	1,5	2,5	7,1			
Spare spindles						
Id.-No.	009841	010175	012677			
ca. g	150	300	610			

Tool group 06

Load Diagrams

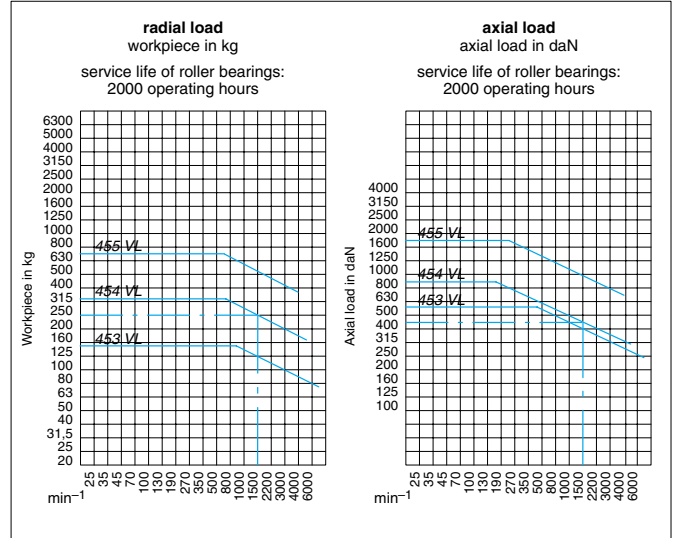
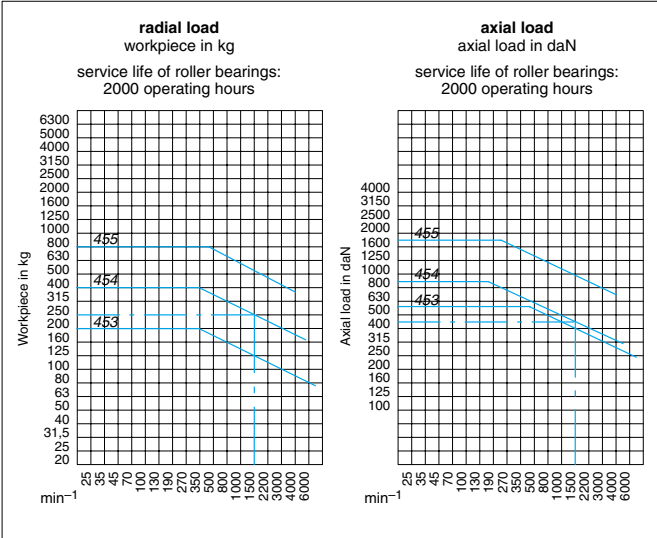
Example type 640-20: admissible load of revolving tailstock center 425 NC at 1800 min⁻¹, radially = 1250 kg workpiece, axially = 1000 daN

Example type 640-80: admissible load of revolving tailstock center 425 NC at 1800 min⁻¹, radially = 1250 kg workpiece, axially = 1000 daN



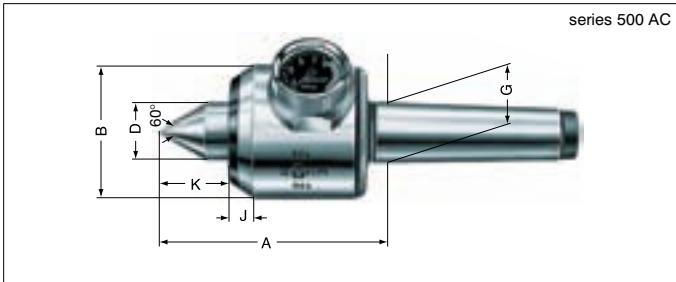
Example type 645-00: admissible load of revolving tailstock center 454 at 1500 min⁻¹, radially = 250 daN, axially = 450 daN

Example type 645-20: admissible load of revolving tailstock center 454 VL at 1500 min⁻¹, radially = 250 daN, axially = 450 daN



TIR .0002"

Type 652 AC with pressure display, as counter center for Constant face drivers

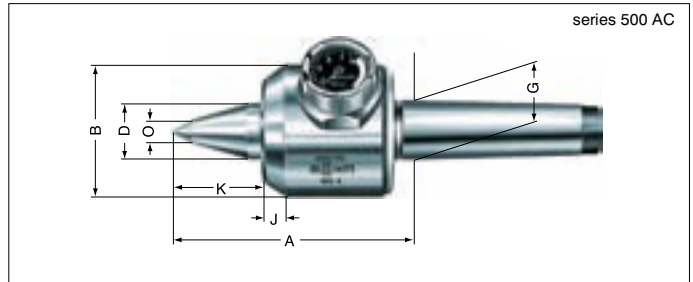


Size	503	504	505	506
MT	3	4	5	6
Id.-No.	207440	207441	207442	207443
Workpiece weight kg	400	800	1600	3200
Concentr. error max.	0,01	0,01	0,01	0,015
Axial load max. daN	550	900	1500	2000
A	105	123,5	160,5	202
B	64	72	95	120
D	25	32	40	52
G	23,825	31,267	44,399	63,348
J	12	15	16	23
K	31,5	39	49	59
ca. kg	2,1	3,5	8,3	17

Spare spindles

Id.-No.	009192	009205	009325	009413
ca. g	190	360	760	1610

Type 652 AC-VL with extended live center

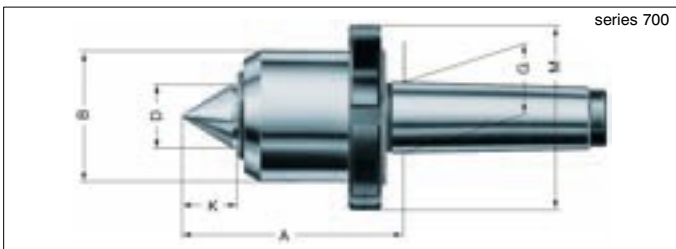


Size	503	504	505	506
MT	3	4	5	6
Id.-No.	222324	222325	222326	222327
Workpiece weight kg	400	800	1600	3200
Concentr. error max.	0,01	0,01	0,01	0,015
Axial load max. daN	550	900	1500	2000
A	120	137,5	177,5	223
B	64	72	95	120
D	25	32	40	52
G	23,825	31,267	44,399	63,348
J	12	15	16	23
K	46,5	53	66	80
O	11	14	15	24
ca. kg	2,1	3,5	8,3	17

Spare spindles

Id.-No.	079924	079925	079926	079927
ca. g	200	400	800	1700

Type 663 for especially high speeds, different head diameters at same size of shank

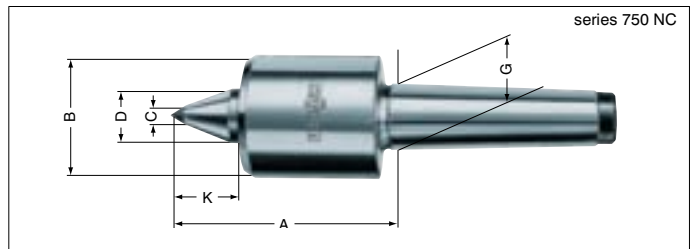


Size	704/52	704/70	705/65	705/82	706/82	706/110
MT	4	4	5	5	6	6
Id.-No.	340911	340910	338595	338594	344809	344808
Workpiece weight kg	360	800	560	1250	1250	2500
Concentr. error max.	0,005	0,005	0,005	0,005	0,005	0,005
Speed max. min ⁻¹	15000	10000	12000	10000	10000	7000
A	90	110	100	130	133	168
B	52	70	65	82	82	110
D	25	35	32	40	40	55
G	31,267	31,267	44,399	44,399	63,348	63,348
K	28	38	34	41	41	58
M	80	110	100	115	115	150
ca. kg	1,9	2,3	4,0	5,2	8,4	12,0

Spare spindles

Id.-No.	344924	344923	338895	338901	338901	344925
ca. g	200	500	410	710	710	1890

Type 664 extended NC-center with carbide insert, for high speed, powerful, for small and medium components



Size	752	753	754	755
MT	2	3	4	5
Id.-No.	772389	772390	772391	772392
Workpiece weight max. kg	100	100	250	250
Concentr. error max.	0,01	0,01	0,01	0,01
Speed max. min ⁻¹	12000	12000	9000	9000
A	99	99	141	141
B	45	45	66	66
C	7	7	11	11
D	20	20	32	32
G	17,780	23,825	31,267	44,399
K	40	40	63	63
ca. kg	1,2	1,6	2,6	5,0

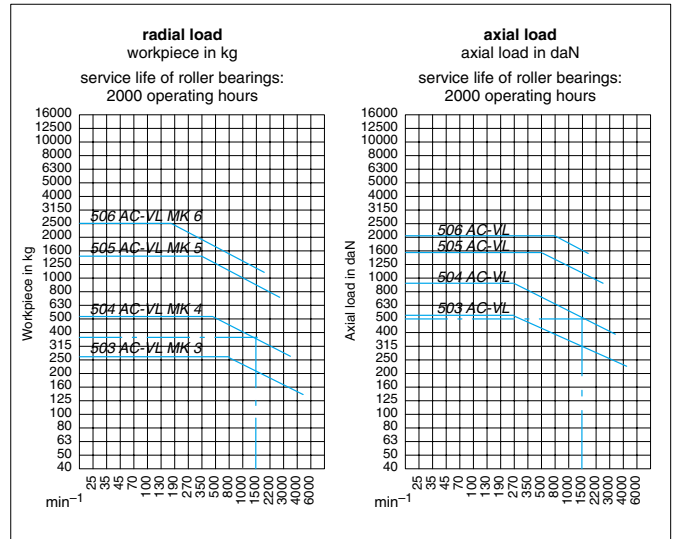
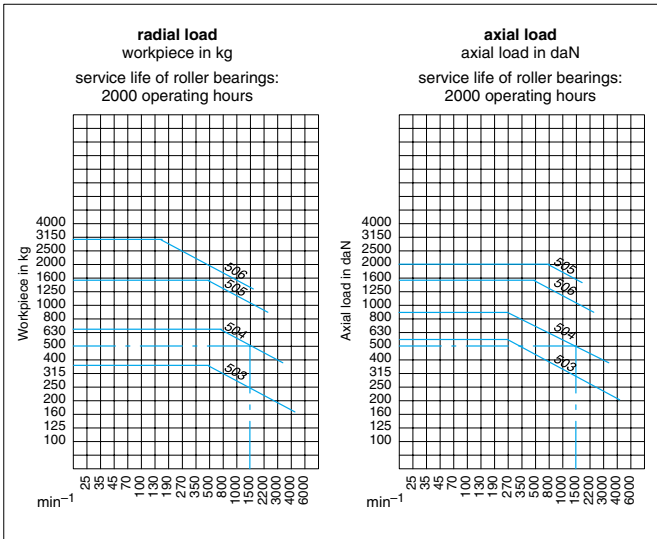
Spare spindles

Id.-No.	009192	009205	009325	009325
ca. g	190	360	760	760

Load Diagrams

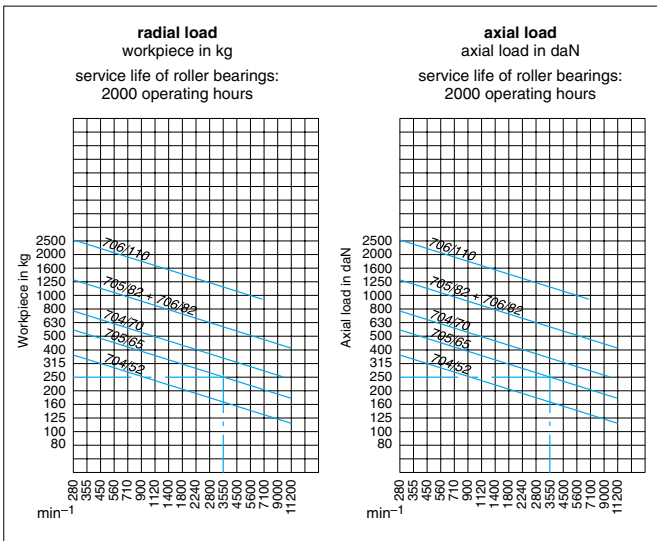
Example Type 652 AC: admissible load of revolving tailstock center AC 504 at 1500 min⁻¹, radially = 1500 kg workpiece, axially = 500 daN

Example Type 652 AC-VL: admissible load of revolving tailstock center AC 504 at 1500 min⁻¹, radially = 375 kg workpiece, axially = 500 daN



Example type 663: admissible load of revolving tailstock center 705/65 at 3500 min⁻¹, radially = 250 daN, axially = 250 daN

Example type 664: admissible load of revolving tailstock center 752 at 5600 min⁻¹, radially = 100 kg workpiece, axially = 360 daN



TIR .0004"

