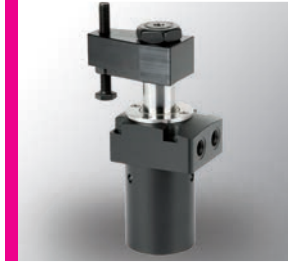




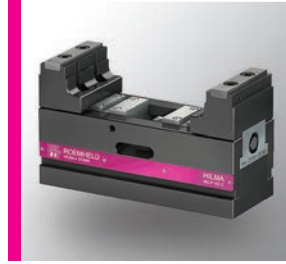
ROEMHELD
HILMA ■ STARK

PRODUCT SOLUTIONS

HYDRAULIC CYLINDERS
WORKHOLDING ELEMENTS



WORKHOLDING SYSTEMS
MACHINE VISES



ZERO POINT
CLAMPING SYSTEMS



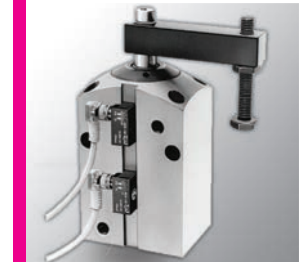
CLAMPING POWER UNITS



HYDRAULIC COMPONENTS



PNEUMATIC ELEMENTS



ASSEMBLY AND
HANDLING SYSTEMS



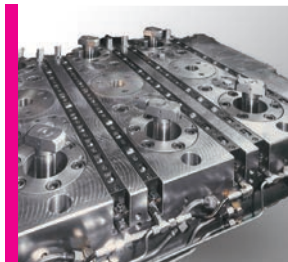
PRESS-IN DEVICES



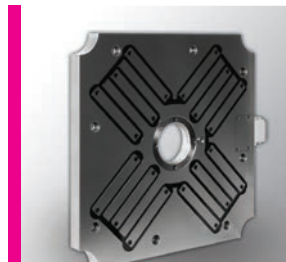
DRIVE TECHNOLOGY



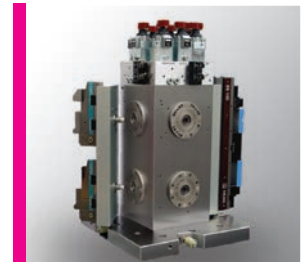
DIE CLAMPING SYSTEMS



MAGNETIC CLAMPING
TECHNOLOGY



SYSTEM SOLUTIONS



ROEMHELD North America

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QUALITY

is an obligation

ROEMHELD is committed to researching and designing technological innovations that are driven by customer needs. Despite the continuously changing market demands, the high quality of our products and processes remains unchanged. Our world-class quality systems are backed by the ROEMHELD name, driving continuous improvement into all we do for you. We provide you with peace of mind through our certification EN ISO 9001:2015, to consistently provide products and services that meet customer and regulatory requirements.

SOLUTIONS

customer-specific design

Thanks to the diversity of our products and long-standing experience, ROEMHELD is able to develop and supply customer-specific solutions across North America. We develop, design, manufacture, and supply workholding and clamping solutions across a wide range of manufacturing and assembly applications and industries. Please contact us to see how we can help you with your customer-specific solution or product selection by emailing info@clrh.com.

INTERNATIONAL

aimed at global presence

The ROEMHELD Group has its global headquarters located in Laubach, Germany with manufacturing at its factories there and Rankweil, Austria. To provide premier and responsive customer support globally, ROEMHELD has subsidiaries worldwide.

ROEMHELD North America is responsible for sales and service in the USA, Canada, and Mexico. Based in Fenton, Missouri, near St. Louis, our dedicated team can provide you with technical support, applications solution assistance, replacement parts, and services.

ENVIRONMENT

the protection of the environment is important to us

The companies of the ROEMHELD Group have their own environmental management system (EMS), which is designed to provide a globally consistent set of procedures to manage the way our organizations interact with the natural environment. This facilitates the implementation of cleaner production techniques and ensures that the impact of our products on the outside world is kept to a minimum. This ensures that only the necessary extent of emissions occur. Resources such as energy, water, air, and raw materials are carefully used. Our products help you to conserve resources.

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ROEMHELD North America

Your solution provider in clamping and handling technology

Our experienced consultants can help you find the optimal solution based on your requirements and goals. Our catalog contains **more than 25,000 products or we can design a solution** that meets your specific needs with our product managers and application engineers.

ROEMHELD North America is a joint venture formed in 1982 between ROEMHELD GmbH, a global leader in highly engineered power workholding systems, and Carr Lane Manufacturing, America's premier tooling component supplier. We provide highly engineered solutions for Power Workholding, Zero Point Mounting & CNC Vises for Precision Metal Cutting, Assembly & Handling Technology, and Hydraulic & Magnetic Die Clamping Systems for Quick Mold and Die Changes.

ROEMHELD North America

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STARK Spannsysteme GmbH

Römergrund 14
6830 Rankweil
Austria

www.stark-roemheld.com





Hydraulic cylinders | Hydraulic workholding elements

Hydraulic cylinders for linear motions of every type | Operating pressure: up to 500 bar

Hydraulic cylinders

Hydraulic cylinders, design with tube with/without end position monitoring
piston diameter: 25 to 80 mm
stroke: 60 to 1200 mm



Universal cylinders

Hydraulic cylinders with round housing for axial adjustability
piston diameter: 10 to 63 mm
stroke: 8 to 100 mm



Threaded-body cylinders

Compact hydraulic cylinders and built-in pistons for screwing in
piston diameter: 8 to 50 mm
stroke: 4 to 40 mm



Block cylinders

Hydraulic cylinders with block-type body made of steel, aluminum or bronze with/without end position monitoring
piston diameter: 16 to 200 mm
stroke: 8 to 200 mm



Hydraulic slides

Hydraulic cylinders with integrated guides with/without end position monitoring
piston diameter: 25 to 100 mm
stroke: 20 to 200 mm



Hydraulic elements for positioning and clamping of workpieces | Operating pressure: up to 500 bar

Bore clamps

Clamping elements for clamping in bore holes with/without centering function / with pull-down clamping with/without seat check
bore hole diameter: 6.6 to 46 mm
max. low-clamping force 0.6 to 24.5 kN



Position flexible clamping elements

Clamping elements for "floating" clamping for exterior and interior clamping with/without position monitoring
max. clamping force: 7.5 kN



Clamps / clamping cylinders

Clamping elements for clamping in small recesses with/without position monitoring with/without self-locking
max. clamping force: 2.5 to 50 kN



Hinge clamps

Clamping elements with operation of a clamping lever with/without position monitoring
max. clamping force: 1.3 to 21.5 kN
clamping stroke/clamping range: 2.0 to 9.0 mm



Swing clamps

Clamping elements with swing piston with/without position monitoring
max. clamping force: 0.6 to 41 kN
clamping stroke: 6 to 50 mm



Work supports

Elements to support workpieces single or double acting
max. load force: 4 to 102 kN
plunger diameter: 16 to 50 mm
plunger stroke: 6 to 20 mm



Concentric clamping elements

Clamping elements for concentric positioning and clamping for exterior and interior clamping
max. clamping force: 5 to 44 kN
repetitive clamping accuracy : ± 0.005 mm



Fixture clamps

Compact standard clamping systems for use on fixtures with fixed jaw, concentric or position flexible
max. clamping force: 6.5 to 15 kN
jaw width: 40 to 65 mm



Hollow-piston cylinders

Clamping cylinders with through hole in the piston
piston diameter: 20 to 80 mm
max. push force: 10 to 153 kN
clamping stroke: 6 to 40 mm





Workholding systems | Machine vises

Mechanically, mechanical-hydraulic or hydraulically operated vises for workpieces

Machine vises

- mechanically-hydraulically or hydraulically operated clamping against the fixed jaw
- with hydraulic power transmission
- completely encapsulated lead screw area
- sizes: 100 to 160 mm
- max. clamping force: 25 to 50 kN

Series NC



Series KNC



5-axis workholding systems

- mechanically or hydraulically operated clamping against the fixed jaw or concentric clamping
- compact design
- collision-free tool paths
- sizes: 40 to 125 mm
- max. clamping force: 8 to 35 kN

Series MC-P



Series SCS



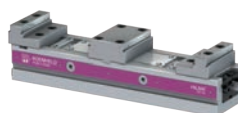
Series PC



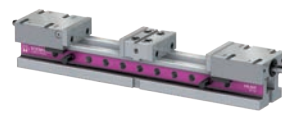
Double workholding systems

- mechanically, mechanically-hydraulically or hydraulically-operated clamping against the fixed jaw
- safe loading and unloading by 3rd-hand function
- sizes: 80 to 160 mm
- max. clamping force: 25 to 63 kN

Series DS



Series DF



Series DUO



Multiple workholding systems

- mechanically operated clamping against the fixed jaw
- compact design
- modular design
- sizes: 24 to 120 mm
- max. clamping force: 15 to 40 kN

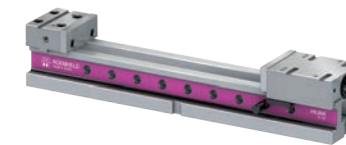
Series MSH



Variet workholding system VarioLine

- mechanically-hydraulically or hydraulically operated clamping against the fixed jaw
- optional: clamping force gauge
- system with variants for customized machine vises
- sizes: 100 to 160 mm
- max. clamping force: 25 to 60 kN
- length of base: up to 750 mm

Series VL



Concentric workholding systems

- hydraulically operated, double acting concentric clamping
- high repetitive clamping repeatability ± 0.01 mm
- fixing and mounting possibilities for customer-specific clamping jaws
- sizes: 100 to 160 mm
- max. clamping force: 16 to 64 kN

Series ZH



Automation

- hydraulically operated, double acting clamping against the fixed jaw
- also available with position measuring system (electrically or via flow rate)
- setups can be automated
- sizes: 100 and 125 mm
- hydraulic stroke: up to 250 mm
- max. clamping force: 32 kN

Series ASH



Tower workholding systems

- arrangement of the clamping points: TS: 4 x 90° | TS TriStar: 3 x 120°
- mechanically operated clamping against the fixed jaw
- version with 3rd-hand function
- version TS Vector
- sizes: 80 to 125 mm
- max. clamping force: 20 to 40 kN

Series TS



Series TS TriStar



Series TS Vector



Milling and turning machining

- Box jaws mechanically operated
- lead screw and nut completely encapsulated
- easy pre-adjustment using a scale
- track: 150 and 180 mm
- max. clamping force: 30 to 63 kN

Series KK



Clamping jaws

- top jaws with grip
- spacer jaws
- precision step reversible jaws
- precise step bars
- formed jaws
- central jaws
- pendulum jaws
- precision step jaws
- Vee jaws
- QIS base jaws
- with permanent magnets
- QIS interchangeable jaws, smooth
- QIS interchangeable jaws, serrated
- QIS interchangeable jaws, crowned
- QIS interchangeable jaws, stepped
- QIS interchangeable jaws, prismatic
- QIS interchangeable jaws, soft
- floating central jaws
- SlimFex jaws
- clamping jaws, soft
- clamping jaws, extra high
- clamping jaws, extra large
- clamping jaws with grip bar
- special grip jaws
- reversible step jaws
- interchangeable inserts, round, with grip
- interchangeable inserts with grip / smooth
- interchangeable inserts with hard-metal coating / smooth
- reversible jaws





Zero Point clamping systems

Clamping systems for exact zero point positioning and clamping of workpieces and fixtures

STARK.metec

easy, compact and sturdy
clamping: mechanically
unclamping: mechanically
max. retention force: 12 to 50 kN



STARK.classic

clamping force monitoring, seat check,
blast cleaning, flow power
clamping: mechanically
unclamping: hydraulically or
pneumatically
max. insertion force: 30 kN
max. retention force: 55 kN



STARK.airtec

quick and precise
clamping: mechanically
unclamping: pneumatically
max. clamping force: 20 kN
max. retention force: 55 kN



STARK.easyclick

clamping by pressing
clamping: mechanically
unclamping: pneumatically
max. clamping force: 5 kN
max. retention force: 10 kN



STARK.hydratec

quick and flexible
clamping: hydraulically
unclamping: hydraulically
max. clamping force: 20 kN
max. retention force: 38 kN



STARK.sweeper

for the automation
clamping: mechanically
unclamping: hydraulically or
pneumatically
max. insertion force: 20 kN
max. retention force: 38 kN



System 3000

strong and unique
clamping: hydraulically
unclamping: hydraulically
max. clamping force: 50 kN



STARK speedy connect

fast closing clamps made of
high-quality tool steel.

double-action pneumatic w/ clamping
force boost.



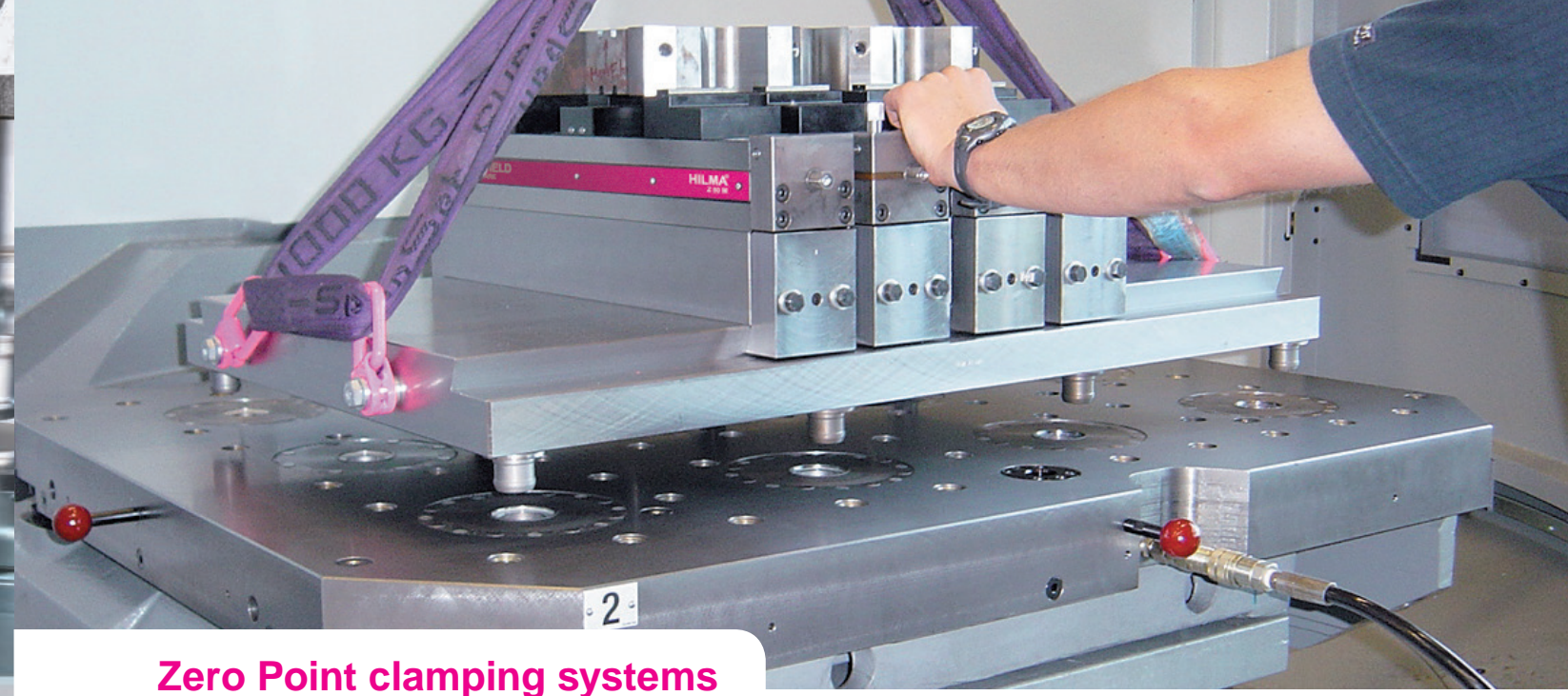
Couplings

universal and compact
for hydraulics, pneumatics,
vacuum and electrics
nominal diameters: 3 to 8 mm



Drop Zero

for modular tooling plates or machinable
fixture plates
clamped and unclamped
mechanically
max. retention force: 12 kN.



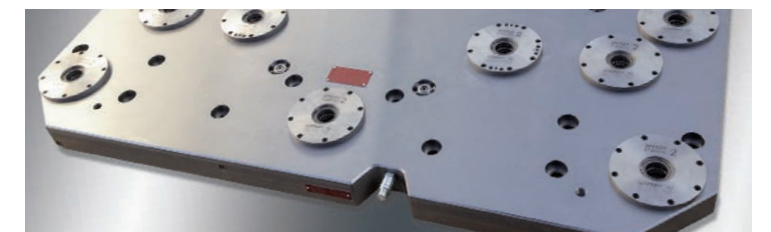
Zero Point clamping systems

From standard elements to systems for flexible use with minimum set-up time

• mechanical • hydraulic • pneumatic • electrical • single acting • double acting

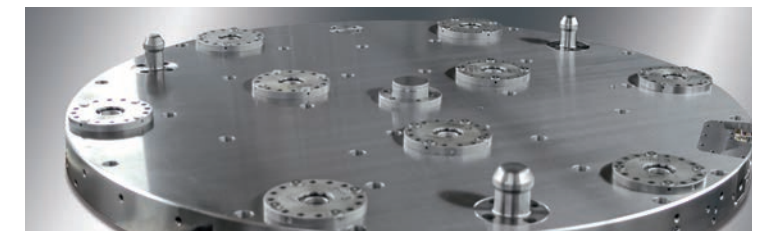
Quick-locking pallets

for milling machining
from standard components, adapted to
the machine and machining task
• fully assembled with 3D dimensional
and functional test



Quick-locking pallets

for turning machining
from standard components, adapted to
the machine and the machining task
• standard clamping monitoring
• applicator for pre-centering



Quick-locking tombstone

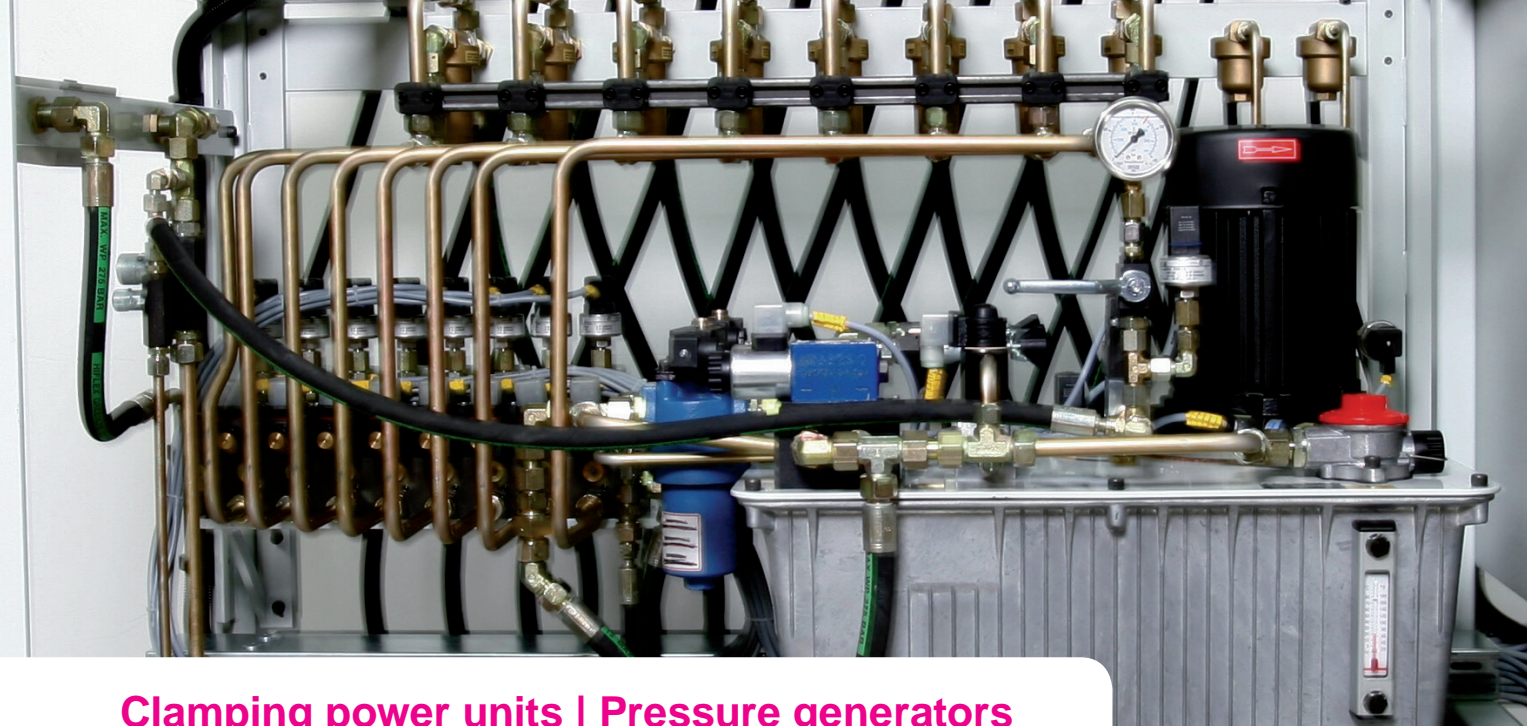
for milling machining
from standard components, adapted to
the machine and the machining task
• 3rd hand-function (DHF) prevents the
dropping of the parts



Quick-locking plates

for the automation
from standard components, adapted to
the machine and machining task
• flow power as interface for pneumatic or
hydraulic clamping fixtures and signal
queries



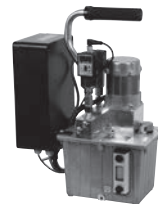


Clamping power units | Pressure generators

Clamping power units, hydraulic power units, hydro-pneumatic pump units and manually-operated pumps to generate and control hydraulic pressure

Power units D 8.010

compact and lightweight
energy-saving intermittent cycling
flow rate: 0.5 to 0.8 l/min
max. operating pressure: 200 bar
reservoir volume: approx. 3.5 l
voltage: 400 VAC or 24 VDC



Power units D 8.0115

ready for connection
energy-saving intermittent cycling
flow rate: 0.8 to 3.5 l/min
max. operating pressure: 160 to 500 bar
reservoir volume: approx. 5 l
voltage: 400 VAC



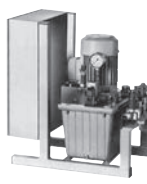
Power units D 8.013

with two-hand operator console
flow rate: 0.9 to 4.5 l/min
max. operating pressure: 50 to 500 bar
reservoir volume: approx. 11 l
voltage: 400 VAC



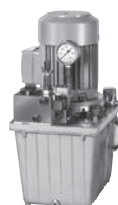
Power units D8.015

with proportional pressure adjustment
flow rate: 0.9 l/min
max. operating pressure: 500 bar
reservoir volume: approx. 11 l
voltage: 400 VAC



Power units D8.021 | D8.031

basic versions
flow rate: 0.9 to 24 l/min
max. operating pressure: 50 to 500 bar
reservoir volume: 11, 27, 40 and 63 l
voltage: 400 VAC



Power units D 8.026

modular design
flow rate: 0.9 to 24 l/min
max. operating pressure: 120 to 500 bar
reservoir volume: 11, 27, 40 and 63 l
voltage: 400 VAC



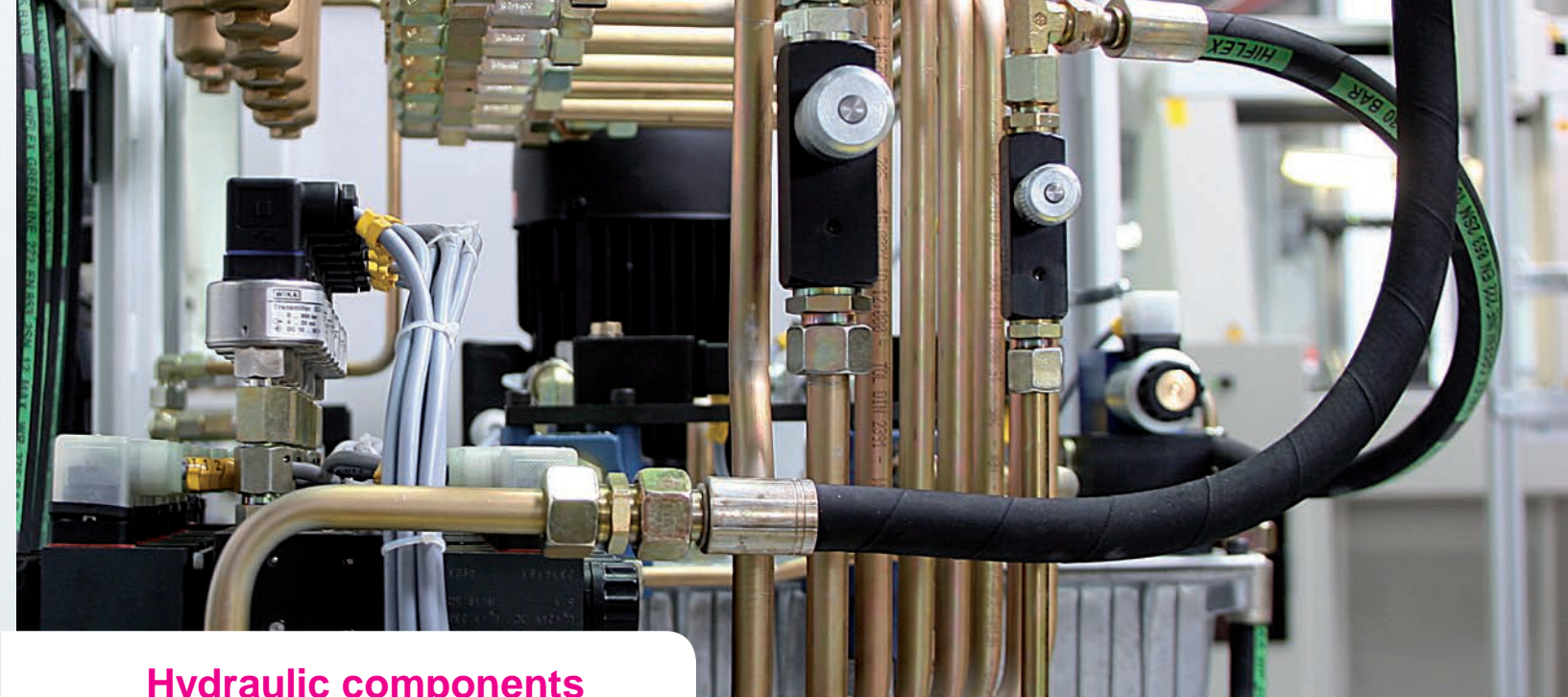
Hydro-pneumatic pump units D8.600

for single and double acting cylinders
flow rate: 0.85 to 1.5 l/min
air pressure: 0.85 to 5.0 bar
max. operating pressure: 500 bar



Manually-operated pumps D8.800 | D8.919

hydraulic pumps
for single-acting cylinders
operation by hand or foot lever
displacement per stroke: 2 to 12 cm³
Screw pumps
displacement: 21 cm³



Hydraulic components

Elements for oil supply and control to hydraulic elements

Hydraulic valves

Directional control and shut-off valves
Throttle and pressure control valves
Pressure relief valves
Check valves
Sequence valves
Valve combinations



Hydraulic accumulator

Diaphragm accumulator for hydraulic oil
with nitrogen gas filling
nominal volume: 13 to 750 cm³
ports: G¹/₄ and G¹/₂
max. operating pressure: 250 and 500 bar



Rotary couplings

Rotary couplings and rotary valve couplings
for oil supply to rotating
and swivelling installations
max. operating pressure: 500 bar



Intensifiers

hydraulic-hydraulic or
pneumatic-hydraulic
single and double acting
max. output pressure: 500 bar



Pressure transducer

piston pressure switch
with continuously adjustable switching point
manifold mounting or G¹/₄
pressure sensors with radio transmission
receiver units with data interfaces



Coupling elements

for hydraulic oil,
compressed air and vacuum
nominal diameter: ND 3 to 8
max. flow rate: 8 to 35 l/min
max. operating pressure: 300 and 500 bar



Multi-couplings

2 to 12 passages
nominal diameter: ND 5 - 8
depressurised coupling
or coupling against pressure
max. operating pressure: 300 bar



High-pressure filters

In-line filters, plug-in filters
and rectifier filter
filter fineness: 10 and 100 µm
material: stainless steel and steel
max. operating pressure: 350 and 500 bar



Coupling units and systems

manually or automatically operated
for single or double acting elements
max. operating pressure: 400 and 500 bar



Piping elements

Fittings
Hydraulic hoses / Hydraulic oil
Precision steel pipes
Plug-in connectors
Pressure gauges / pipe clamps





Electro-mechanical clamping elements

Electric swing clamps

max. clamping force: 7 kN
clamping stroke: 23 mm
swing angle: max. 180°
voltage: 24 VDC



Electric wedge clamps

max. retention force: 130 to 320 kN
clamping stroke: 20 mm
voltage: 24 VDC



Parallel drive electric swing clamp

max. load force: 6.9 kN
clamping stroke: 20 mm
swing angle: max. 180°
voltage: 24 VDC



Drive technology

Electrically and manually operated linear motions in demanding conditions in industry, automotive engineering and durable medical equipment technology

Electrically-operated linear actuators

version with limit switches
or stroke measuring system
max. lifting force: 0.3 to 6.0 kN
stroke: 100 to 600 mm
voltage: 12 or 24 VDC



Manually-operated linear actuators

manual-hydraulic version
max. lifting force: 4.5 to 12.5 kN
stroke: 140 to 600 mm



FSS clamping systems

Flexible clamping and support elements for clamping of thin-walled workpieces with free-form surfaces

Clamping and supporting elements

elements with their own linear actuator
and vacuum clamping technology
piston rod Ø: up to 70 mm
strokes: 100 to 1000 mm
max. axial support force: 1.2 to 12.0 kN



The core elements of a FSS clamping system are the clamping and support elements that can be used in unlimited quantity and that together form the contact surface of the workpiece. Since each element can be positioned individually on the relevant workpiece geometry, FSS clamping systems allow for a flexible configuration of individual surfaces to clamp and support workpieces. Depending on the workpiece surface and geometry, clamping forces of 300 N per element and more can be obtained.



Pneumatic elements

Pneumatically operated swing clamps and rotary couplings for pneumatics

Pneumatic swing clamps

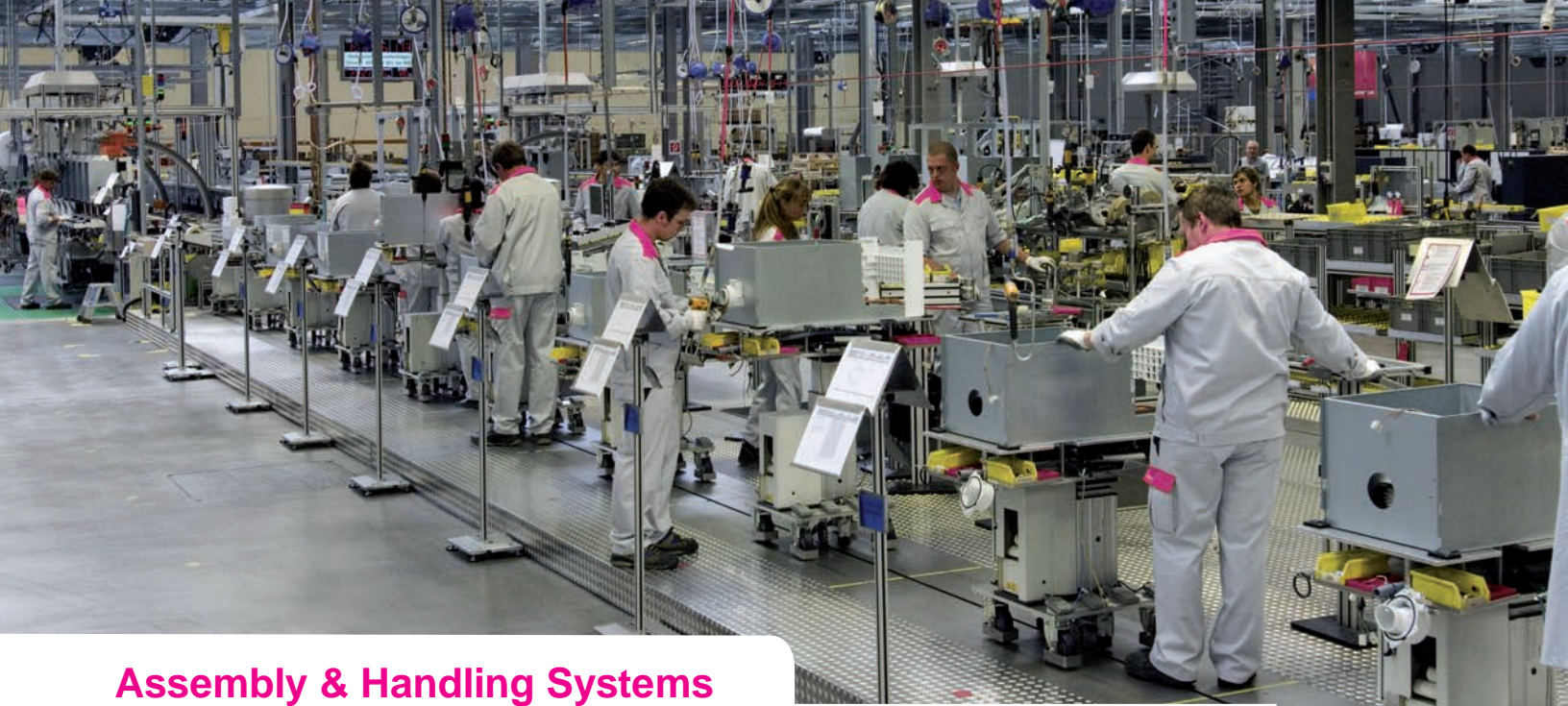
with adjustable magnetic sensors
double acting
max. clamping force: 140 to 1400 N
max. operating pressure: 7 bar



Pneumatic rotary valve couplings

number of stations: 5 to 8
nominal diameter 3 mm
max. operating pressure: 10 bar





Assembly & Handling Systems

Modules for rotating, lifting, tilting and moving of heavy workpieces
Individual modules can be easily combined to built multi-functional work stations

Rotating modules – horizontal or vertical axis

for rotation of the workpiece around the horizontal or vertical axis
manually or electrically operated
option: indexing
option: flow power
workpiece weight: up to 200 kg



Tilting modules

for tilting or swiveling of the workpiece around an axis between the final positions 0° and 90°
manually or electrically operated
option: indexing
workpiece weight: up to 100 kg



Lifting modules

for guided lifting and lowering of the workpiece
operated by a hydraulic or electrical actuator
workpiece weight: up to 600 kg
max. strokes: 200 to 1000 mm



Floor modules

base frame for 1 or 2 modules to compensate unevenness of the floor space and good stability
max. load: 6000 and 8000 N



Cart modules

to displace manually individual modules or module combinations with parking brake
max. load: 2000 and 6000 N



Accessories

base plates, adapter plates, flange plate, table plates, supply units, hand panel, foot switch, operating panels, power supply for mobile systems, and command modules



Clamping jaws

to clamp workpieces on modules
• hydraulic and mechanical clamping elements with universal clamping plate
• quick-change mounting plate with STARK zero point clamping system



Electrical lifting assembly table

table plate with two electrical lifting columns in synchronism.
maximum load per set: 600 kg



Press-in devices

Modupress – hydraulically or electrically-operated press in devices
for power-operated processes such as jointing, pressing-in, jolting, deforming and riveting

Press-in devices P 1.100

portal design
hydraulic drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 40 to 100 kN



Press-in devices P 1.200

c-frame design
hydraulic drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 40 to 100 kN



Press-in devices P 1.101

portal design
electrical drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 7 to 25 kN



Press-in devices P 1.201

c-frame design
electrical drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 7 to 25 kN



Accessories

protection cabins, light grids, sliding tables, sensor technology, quick-disconnect couplings



Die clamping systems

Die clamping and changing systems for press automation

Quick changing systems for mechanical, hydraulic and forging presses; and injection molding/die cast machines

Hydraulic clamping elements

Hollow-piston cylinders

for retrofitting on press bed and ram

Spring clamping cylinders

for spring-loaded long-term clamping

Angular clamps

for clamping on small clamping edges

Clamping bars

flat clamping element for bed and ram

max. clamping force: 30 to 116 kN, piston stroke: up to 8 mm

Double-T clamping bars

to use the complete bed or ram surface

max. clamping force: 16 to 320 kN

Sliding clamps

for insertion in T-slots

max. clamping force: 19 to 78 kN, piston stroke: up to 12 mm

Swivel and pull clamps

clamping cylinders with tie rods

Wedge clamps

sturdy clamping elements for straight or inclined/clamping edge

max. clamping force: 1250 kN

Block clamps

with self-locking mechanical lock

max. clamping force: 200 kN

Pivot and pull clamps

max. clamping force: 104 to 160 kN

Swing / swing sink clamps

without interfering edges when inserting the die max. clamping

force: 60 to 164 kN

Rapid clamping systems

automatic travelling units with clamping element

Pull clamps

pull-type cylinder with tie rod for inaccessible points

Wedge swing clamps

with mechanical lock

Grip rail couplings

Rapid clamping systems for grip rails



Electro-mechanical clamping elements

Tenon-type clamps

clamping by grip and pull movement

Swivel and pull clamps

clamping by swivel and lifting movement

Swing clamps

clamping by swing and lifting movement

max. clamping force: 70 to 160 kN

Wedge clamps

compact electro-mechanical power package

max. clamping force: 160 kN, retention force: 300 kN

Angular clamps

clamping in any position of the travelling path

max. clamping force: 50 kN, retention force: 320 kN



Mechanical clamping elements

Sliding clamps

max. clamping force: 40 to 80 kN

High-pressure spindles

max. clamping force: 40 to 140 kN

Clamping nuts, mechanical

max. clamping force: 60 to 200 kN

Clamping nuts, hydro-mechanical

max. clamping force: 60 to 150 kN



Die changing technology

Roller and ball bars

hydraulic or spring-loaded

Roller conveyors

without lifting

Roller and ball inserts

spring-loaded

Carrying consoles, hanging

max. load per pair: 5 to 30 kN

Carrying consoles, supported

max. load per pair: 20 to 250 kN

Carrying consoles, swivelling

max. load per pair: 10 to 60 kN

Changing carts

for handling of dies up to 1600 kg

with ball table, hydraulic height adjustment

and safety docking station

Die changing consoles

with drive system for die weights up to 250 kN



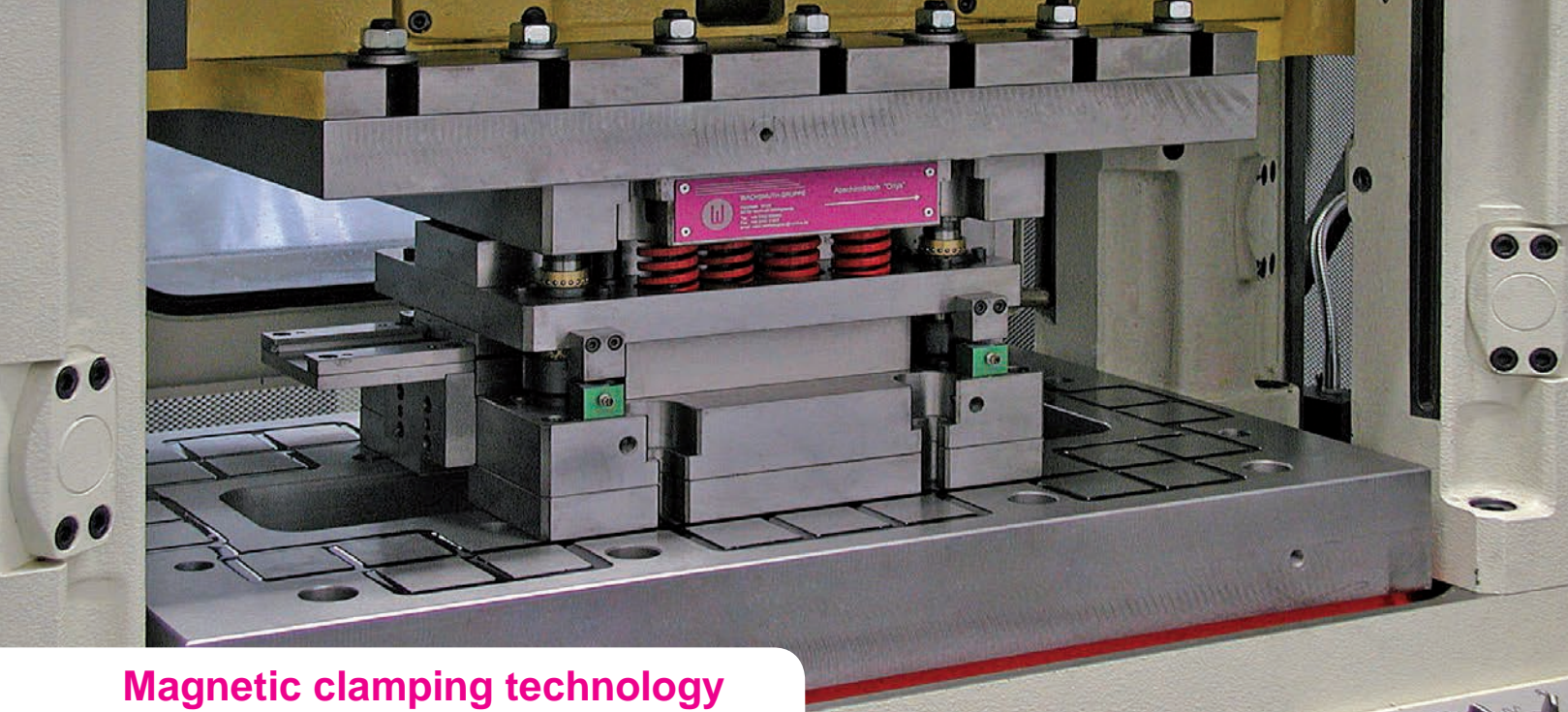
Locking cylinders

To fix rotors of on/and offshore wind power plants for maintenance work

Rotorlock

hydraulic, mechanical or electro-mechanical
 sizes: up to 7500 kN side load
 with position monitoring
 corrosion protection as per DIN ISO 12944
 max. temperature range: -40 to +70 °C





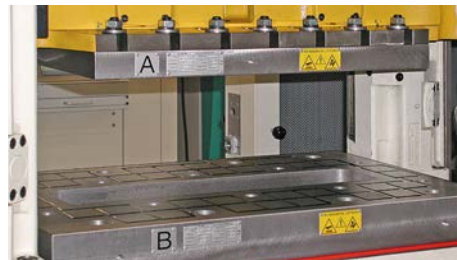
Magnetic clamping technology

M-TECS magnetic clamping plates and systems for injection molding machines, forming presses, rubber presses and mold carts.



M-TECS M

for sheet metal forming
max. temperature: 80°C
plate thickness: 55 mm



M-TECS P

for the plastics industry
max. temperature: 120°C
plate thickness: 47 mm



M-TECS R

for the rubber and duroplast industry
max. temperature: 240°C
plate thickness: 55 to 85 mm



System specific solutions for your industry

ROEMHELD provides solutions for many different industries with our quality systems and products including hydraulic clamps and cylinders, work supports, coupling systems, die clamping, machine vises and many other items.

PLASTICS INDUSTRY

ROEMHELD offers a broad portfolio of system solutions that can be optimized for each step in the injection molding process. This includes the mold maintenance & design, mold functionality, and the mold changing process.

In order to maximize your profitability, each step needs to be considered. Through our highly engineered expertise, ROEMHELD engineers can provide solutions for your injection molding machines. These solutions will effectively streamline your operation and implement Lean Manufacturing, a primary driver of profitability.



AEROSPACE INDUSTRY

ROEMHELD leads the industry with solutions for the aerospace industry. We provide a full selection of state-of-the-art, air and hydraulically powered components and accessories.

More than 80 different types of power workholding devices are available, allowing you to speed up and streamline many manual workholding operations. We lead the industry by utilizing our exceptional knowledge and expertise in manufacturing complex aerospace tooling parts for military aircraft, commercial aircraft and other aviation needs.



OTHER INDUSTRIES

- Automation & Test Fixtures
- Mid-Size Machining
- Forging
- Agriculture
- Welding
- Fixture Builders
- High Speed Stamping
- Automotive Stamping (Hi Volume Transfer Lines)
- Durable Medical Equipment
- Industrial Distributors
- Machine Builders
- Automotive Machining (High Volume Machining)



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ROEMHELD
HILMA ■ STARK

Your solution provider in **clamping and handling** technology

Our experienced consultants will find the optimal solution based on your requirements and goals. Whether it's one of our more than **25,000 products** or a **customer-specific solution** designed with our product managers and development engineers.

Program Summary 3/2022 Subject to modifications