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**Rotating module – horizontal axis DMH 200**  
**Max. load 2,000 N, manual operation**

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## 1 Description of the product

### 1.1 General description

The rotating module - horizontal axis DMH is a double supported rotation axis that can compensate high axial and radial forces. The angle of rotation in both directions is 360°.

Due to special bearings it is insensitive to shocks and thrusts.

The design of the rotating module allows its integration in applications with light as well as with heavy loads.

When using the rotating module in assembly processes, workpieces can be rotated rationally, quickly and safely and can be assembled ergonomically from all sides.

Except in its basic version, the rotating module is equipped with an indexing.

The indexing angle is 8 x 45°, 6 x 60°; 4 x 90°; 3 x 120°.

### 1.2 Version without indexing

The rotating module does not have an indexing in its basic version.

The rotating operation is effected manually at the workpiece or at the assembly fixture.

### 1.3 Automatic indexing

The rotating module with automatic indexing is a compact and functional unit.

Rotating as well as indexing are ergonomically operated by one hand lever only.

### 1.4 Actively-operated indexing

The rotating module - horizontal axis DMH 200 with actively operated indexing is a compact and functional unit.

Rotating as well as indexing are ergonomically operated by one hand lever only.

The rotating module with hydraulic indexing is a compact and functional unit.

It consists of a basic module with integrated indexing mechanism and an operating unit with foot pedal, connected by a 2 m long hydraulic hose.

This flexible connection allows the individual placement of the operating unit at the most favourable ergonomic position.

The rotating operation is manually effected at the workpiece or at the assembly fixture.

## 2 Validity of the documentation

This document applies to the following products:

Rotating modules - horizontal axis of data sheet M 1.101. The following types or part numbers are concerned:

Version without indexing:	Automatic indexing:	Actively-operated indexing:	Indexing with foot pedal:
6505-02-36-O	6505-01-36-M	6505-02-36-M	6508-02-45-O-I, 6508-02-60-O-I, 6508-02-36-O-I, 6508-02-12-O-I.

## 3 Target group of this document

- Specialists, fitters and set-up men of machines and installations with hydro-mechanical expert knowledge.

### Qualification of the personnel

**Expert knowledge** means that the personnel must

- be in the position to read and completely understand technical specifications such as circuit diagrams and product-specific drawing documents,
- have expert knowledge of function and design of the corresponding components.

A specialist is somebody who has due to its professional education and experiences sufficient knowledge and is familiar with the relevant regulations so that he

- can judge the entrusted works,
- can recognize the possible dangers,
- can take the required measures to eliminate dangers,
- knows the acknowledged standards, rules and guidelines of the technology.
- has the required knowledge for repair and mounting.

## 4 Symbols and signal words

### **WARNING**

#### **Person damage**

Stands for a possibly dangerous situation.

If it is not avoided, death or very severe injuries will result.

### **CAUTION**

#### **Easy injuries / property damage**

Stands for a possibly dangerous situation.

If it is not avoided, minor injuries or material damages will result.



#### **Hazardous to the environment**

The symbol stands for important information for the proper handling with materials that are hazardous to the environment.

Ignoring these notes can lead to heavy damages to the environment.

### **Note**

This symbol stands for tips for users or especially useful information. This is no signal word for a dangerous or harmful situation.

## 5 For your safety

### 5.1 Basic information

The operating instructions serve for information and avoidance of dangers when installing the products into the machine as well as information and references for transport, storage and maintenance.

Only in strict compliance with these operating instructions, accidents and property damages can be avoided as well as trouble-free operation of the products can be guaranteed.

Furthermore, the consideration of the operating instructions will:

- avoid injuries
- reduce down times and repair costs,
- increase the service life of the products.

### 5.2 Safety instructions

The product was manufactured in accordance with the generally accepted rules of the technology.

Observe the safety instructions and the operating instructions given in this manual, in order to avoid personal damage or material damage.

- Read these operating instructions thoroughly and completely, before you work with the product.
- Keep these operating instructions so that they are accessible to all users at any time.
- Pay attention to the current safety regulations, regulations for accident prevention and environmental protection of the country in which the product will be used.
- Use the ROEMHELD product only in perfect technical condition.
- Observe all notes on the product.
- Use only accessories and spare parts approved by the manufacturer in order to exclude danger to persons because of not suited spare parts.
- Respect the intended use.
- You only may start up the product, when it has been found that the incomplete machine or machine, in which the product shall be mounted, corresponds to the country-specific provisions, safety regulations and standards.
- Perform a risk analysis for the incomplete machine, or the machine.  
Due to the interactions between the product and the machine/fixture or the environment, risks may arise that only can be determined and minimized by the user, e.g. :
  - generated forces,
  - generated movements,
  - Influence of hydraulic and electrical control,
  - etc.

## 6 Application

### 6.1 Intended use

Rotating modules are designed for universal use in assembly and handling processes in the industry.

They are used for industrial applications in order to rotate workpieces rationally, quickly and safely.

Furthermore the following are possible uses:

- Max. forces and / or torques only with the values indicated below technical characteristics.
- Use only within closed, low-dust rooms

- Use within the capacity indicated in the technical characteristics (see data sheet).
- Use as per operating instructions.
- Compliance with service intervals.
- Qualified and trained personnel for the corresponding activities.
- Mounting of spare parts only with the same specifications as the original part.

## 6.2 Misapplication

### **WARNING**

#### **Injuries, material damages or malfunctions!**

- The product must never be opened. At the product no changes must be made, except the ones expressly mentioned in the operating instructions!

The use of the products is not authorised:

- For domestic use.
- For use at fairgrounds and amusement parks.
- In food processing or in areas with special hygiene regulations.
- In mines.
- In ATEX areas (in explosive and aggressive environments, e.g. explosive gases and dusts).
- If physical effects (welding currents, vibrations or others) or chemically acting media damage the seals (resistance of the seal material) or components and this can lead to functional failure or premature failure.

**Special solutions are available on request!**

## 7 Installation

### 7.1 Design

#### **WARNING**

##### **Injury by dropping parts!**

Some products have a heavy weight and can cause injury when dropping.

- Transport products professionally.
- Wear personal protection equipment!

Weight specifications see chapter "Technical characteristics".

#### **CAUTION**

##### **Heavy weight may drop**

- Some product types have a considerable weight. These have to be secured against dropping during transport.
- Weight specifications see chapter "Technical characteristics".

##### **Transverse forces and forced conditions!**

Side loads and forced conditions on the product lead to the premature failure.

- Avoid forced conditions (overdetermination) of the product.
- Max. forces and torques see technical characteristics.

##### **Max. adm. operating torque**

The maximum operating torque at the operating shaft must not be exceeded.

This can be achieved e.g. by limiting the operating stroke of the customer's operating element (hand lever or pedal) by the floor.

#### 7.1.1 Version without indexing

The rotating module does not have an indexing in its basic version.

The rotating operation is effected manually at the workpiece or at the assembly fixture.

### 7.1.2 Version with automatic indexing

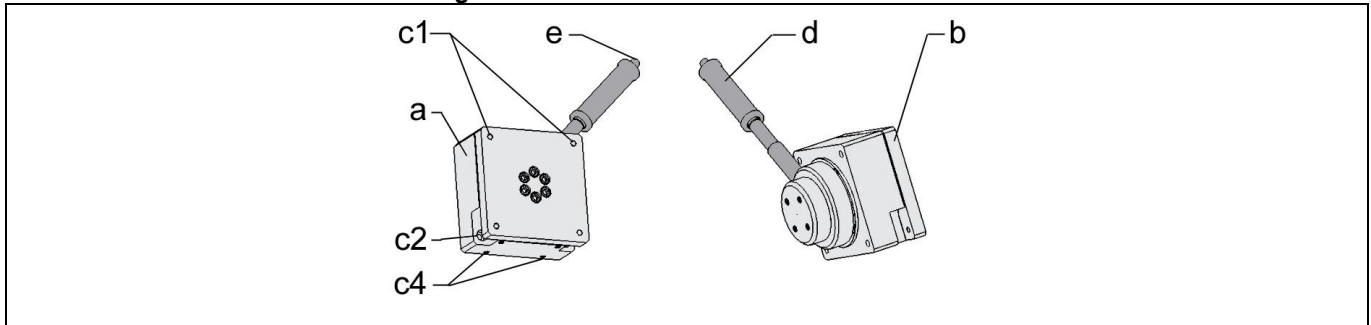


Figure 1: Components

<p>a Basic unit</p> <p>b Flange plate</p> <p>c1 Threads (4 x M10) to fix further components</p> <p>c2 Counterbores (for 4 x M10) to fix the rotary module at the fixture</p>	<p>c4 Threads (4 x M10) to fix further components vertically on the fixture</p> <p>d Hand lever</p> <p>e Button for unlocking</p>
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### 7.1.3 Version with actively-operated indexing

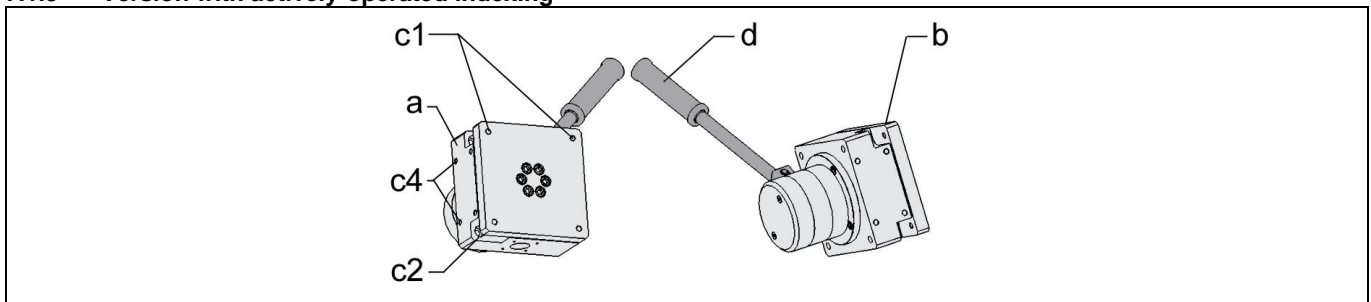


Figure 2: Components

<p>a Basic unit</p> <p>b Flange plate</p> <p>c1 Threads (4 x M10) to fix further components</p> <p>c2 Counterbores (for 4 x M10) to fix the rotary module at the fixture</p>	<p>c4 Threads (4 x M10) to fix further components vertically on the fixture</p> <p>d Hand lever</p>
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## ⚠ CAUTION

### Stroke module, pump lever not operate on bottom base plate

Foot pedal is pressed down below the lower edge of the base plate.

- The customer has to make sure that this will be prevented by the concrete floor or a corresponding base plate connecting construction.

#### 7.1.4 Version with hydraulic indexing

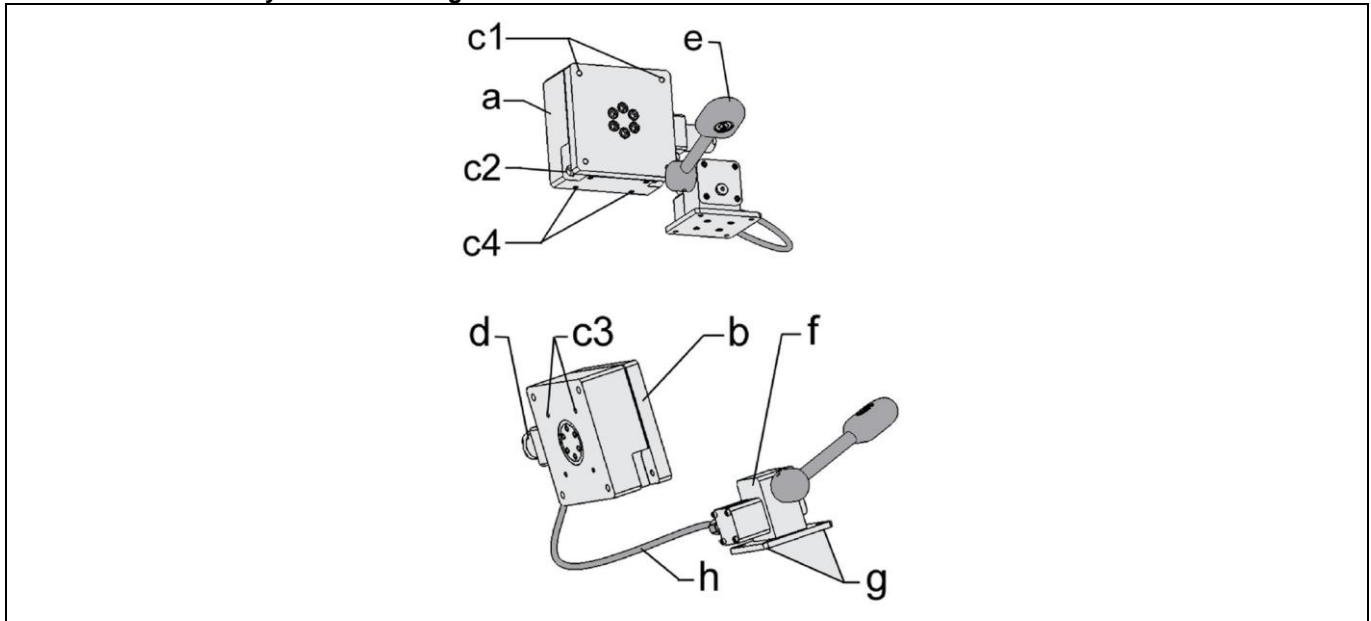


Figure 3: Components

### **CAUTION**

#### **Stroke module, pump lever not operate on bottom base plate**

Foot pedal is pressed down below the lower edge of the base plate.

- The customer has to make sure that this will be prevented by the concrete floor or a corresponding base plate connecting construction.

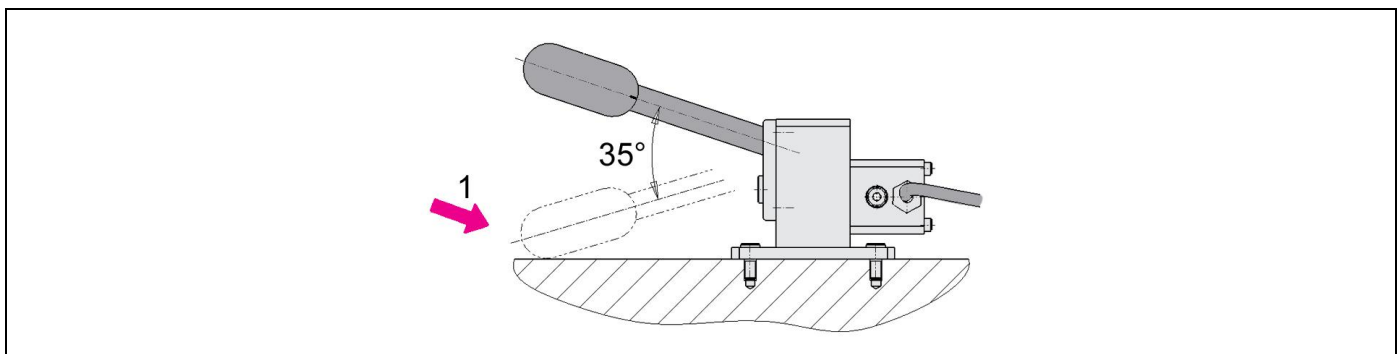


Figure 4: External stop

<p>a Basic unit</p> <p>b Flange plate</p> <p>c1 Threads 4 x M10 to fix further components</p> <p>c2 Counterbores for 4 x M10 to fix the rotary module at the fixture</p> <p>c1 Threads 4 x M10 to fix the index. Not suitable to fix additions.</p> <p>c4 Threads 4 x M10 to fix the rotating module vertically on the fixture</p>	<p>d Hydraulic indexing (receiver unit)</p> <p>e Foot pedal</p> <p>f Pressure generator (transmitter unit)</p> <p>g Bore holes 4 x M8 to fix the pressure generator</p> <p>1 External stop</p>
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### **NOTE**

Pressure generators, hoses and hydraulic indexing must not be opened.  
Penetrating air can lead to malfunction.

## 7.2 Fixing of the product

### **⚠ WARNING**

#### **Injury due to overturning product!**

- Overturning product due to missing or incorrect fixing!
- Fasten bottom plate on the floor.
- When introducing torques within the load limit (see technical characteristics) we recommend to use an additional base plate (accessory) and to secure this plate correctly.

### **⚠ CAUTION**

#### **Stroke module, pump lever not operate on bottom base plate**

Foot pedal is pressed down below the lower edge of the base plate.

- The customer has to make sure that this will be prevented by the concrete floor or a corresponding base plate connecting construction.

1. Install the product so that for the required cleaning and maintenance works there is all around a clearance zone of at least 700 mm.
2. The product has to be mounted horizontally on a plane and solid concrete floor (concrete strength grade B 25) or a rigid connecting construction of the customer (flatness 0.20 mm).
3. Fasten the bottom plate of the product with hexagon socket head cap screws ISO 4762 - M10 onto the concrete floor or the connecting construction of the customer.
4. For this purpose professionally insert into the concrete floor heavy-duty dowels (e.g. Fischer part-no.: SL M-10 N).

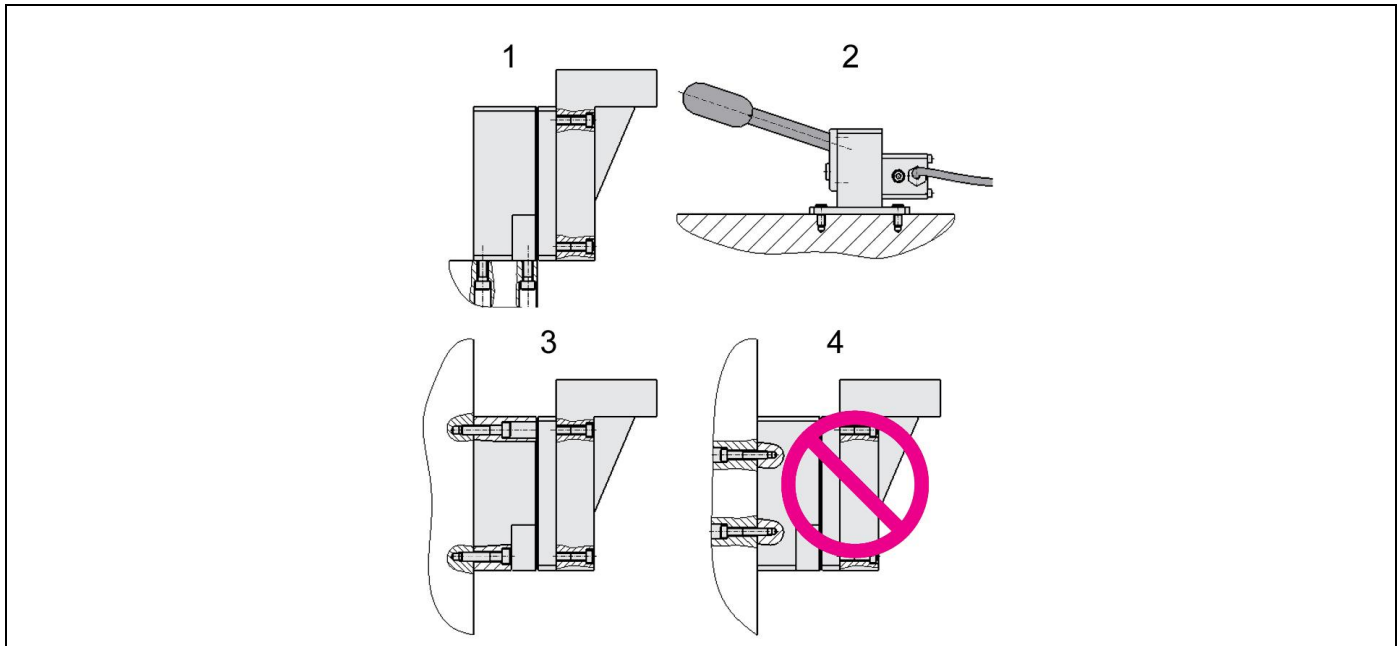


Figure 5: Possible principles of fixation.

1 Fixation for vertical mounting screwed through customer's fixture if required through flange plate (see accessories)	3 Wall mounting screwed through rotary module Angle bracket provided by the customer at the flange plate
2 of pressure generator (transmitter unit)	4 Not admissible!

### **i NOTE**

In case of vertical mounting of the rotating module it has to be considered that the hand lever can only be rotated by 270°. To reach the third indexing position a swing angle of ~230° is required.  
The mounting types depend on the design of the rotating module.

### 7.3 Mounting of the customer's connecting construction

#### **WARNING**

##### **Injury due to overturning product!**

- Overturning product due to eccentric load provided by the user!
- The centre of gravity of the user's load must be within the 4 fixing screws of the bottom plate.
- When introducing torques within the load limit (see technical characteristics) we recommend to use an additional base plate (accessory) and to secure this plate correctly.

1. For fixing of the customer's connecting construction there are 4 bore holes (for M10 - Ø 10.5 mm ) at the top plate.  
All provided bore holes have to be used!
2. Fasten the connecting construction at the top plate.

#### **NOTE**

##### **Dangers due to the connecting construction of the customer**

Dangers due to the connecting construction of the customer, as e.g. squeezing points have to be excluded by the customer's design.

In the case of eccentric loads, it is recommended to compensate these by counterweights. This prevents unregulated swinging of the load (changing - swivelling).

In off-position the indicated maximum torques may occur (see Technical characteristics).

The required forces and torques, around the axis of rotation, have to be considered by the operator.

The max. force of 50 N (rotation or holding) must not be exceeded by the operator.

## 8 Start up

#### **WARNING**

##### **Injury by crushing!**

- Loads (torques) can lead to an unexpected start of the product.
- When releasing the index, counter hold the existing load.
- Pay attention to an ergonomic working place and max. physical forces.

##### **Injury by crushing!**

Due to protruding components there can be pinch points during installation.

- Keep hands and fingers away from pinch points!

The following tests have to be carried out before start up:

1. Check tight seat (check seating torque of the fixing screws).
2. Check the freedom of motion of the existing loads.  
Rotate the rotating modules with mounted customer's fixture 4 x 90°.
  - Pay attention to shearing and squeezing points. Mount a protective guard, if required.
  - Pay attention to collision-free motion with regard to surrounding equipment.
  - Pay attention to ergonomic working conditions.
  - Pay attention to maximum and admissible physical forces.
3. Check movement and resulting loads. Carefully rotate the mounted construction and the workpiece.
  - Carry out tests as listed below 2.
4. Check the functions of the rotary module. Pay attention to smooth running.

### 8.1 Operation

#### **WARNING**

##### **Injury by crushing!**

- Loads (torques) can lead to an unexpected start of the product.
- When releasing the index, counter hold the existing load.
- Pay attention to an ergonomic working place and max. physical forces.

##### **Injury by crushing!**

Components of the product make a movement while they are in operation, this can cause injuries.

- Keep parts of the body and items out of the working area!



## ⚠ CAUTION

### Indexing dynamically overloaded!

If the indexing bolt engages in full motion, the indexing will be dynamically overloaded.

- The module must only be moved to the engaging position in a controlled manner (counterhold).

### 8.1.1 Version without indexing

The rotating module does not have an indexing in its basic version.

The rotating operation is effected manually at the workpiece or at the assembly fixture.

### 8.2 Automatic indexing

## ⚠ CAUTION

### Load swings unexpectedly!

This can lead to injuries or damages.

During swinging under load the unlocking must not be actuated.

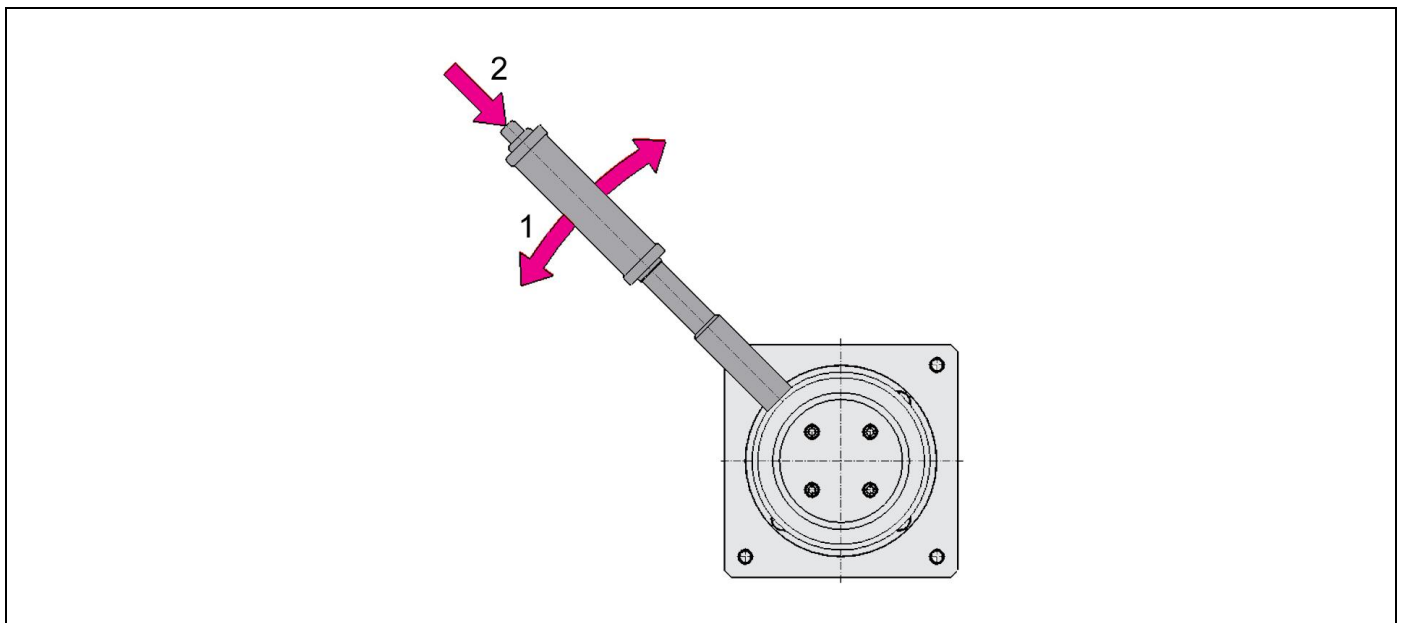


Figure 6: Operation - Automatic indexing

1 Operation of the hand lever	2 Unlocking of the hand lever
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To rotate the workpiece the hand lever is operated in any direction (1).

Every 90° indexing of the position is made automatically. Engagement and disengagement of the indexing is also effected automatically.

The off-position of the hand lever can be engaged in steps of 90°, so that for every rotation the desired off-position can be adjusted.

With engaged indexing the button for unlocking (2) can be pushed and the lever freely swivelled.

To engage the indexing, release the button.

## i NOTE

The lever must only be released when the flange plate was set to one of the four index positions and is engaged using the lever.

## ⚠ WARNING

### Unlocking of the hand lever Pos. 2

This leads to a destruction of the device and to the danger of the operator.

During the rotating movement, the button at the end of the lever must in no circumstances be pressed!

### 8.2.1 Version with actively-operated indexing

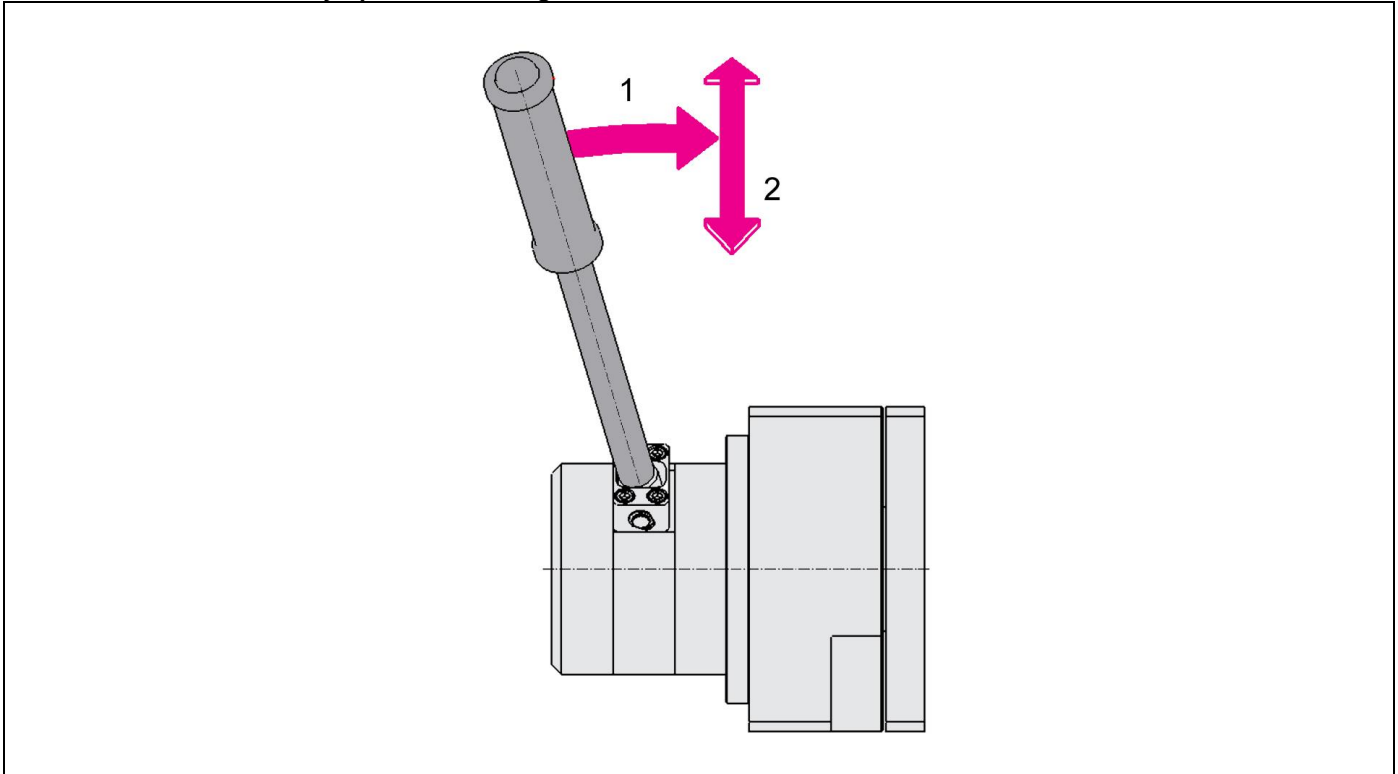


Figure 7: Operation - Actively-operated indexing

1 Unlocking of the load	2 Operation of the hand lever
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To unlock the indexing position the hand lever has to be tilted in axial direction by approx. 10° **(1)** to get connected by form fit with the rotating module.

The workpiece can now be rotated in any direction **(2)** by means of the hand lever.

Only after safe locking in the desired position, by tilting back the lever, the hand lever is free again and the workpiece locked with the housing by form fit.

The off-position of the hand lever can be engaged in steps of 90°, so that for every rotation the desired off-position can be adjusted.

#### 8.2.1.1 Hydraulic indexing

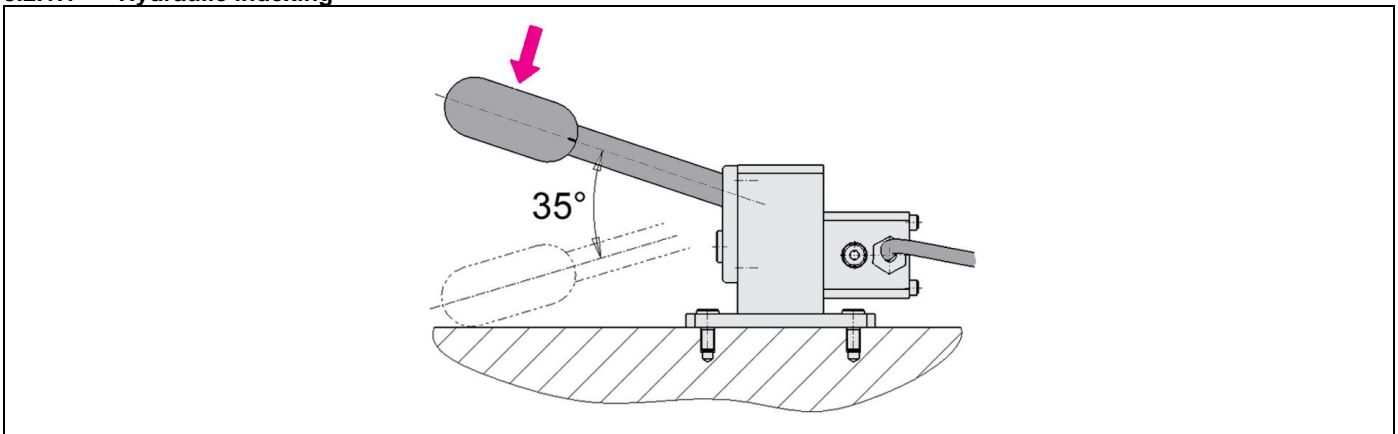


Figure 8: Operation - Indexing operated by a foot pedal

By operating the foot pedal by 35° the index is released and the workpiece or the fixture can be rotated.

If the foot pedal is not operated, the index bolt engages automatically into the next indexing position.

The operation with a foot pedal guarantees that the operator always has both hands free.

## 9 Maintenance

### 9.1 Plan for maintenance

Maintenance works	Interval	by...
Cleaning, visual inspection of the rotating module and control of the indexing	daily	Operator
Check tightness and leakage of hydraulic connections (visual control) every day.		
Check all fixing screws, retighten if required. Control of the indexing	half-yearly checks	Expert
Check smooth running with little load over the entire rotating range	yearly	Expert
Check smooth running with load over the entire rotating range		
An expert has to check all hydraulic hoses at least once a year if they are still work-proof. Assessed damages have to be repaired immediately.		
Hydraulic hoses have to be exchanged in accordance with the BGR 237 with new hydraulics hoses.	after 6 years	Specialist with expert knowledge in hydraulics
Revision by the manufacturer (recommendation)	after 50,000 cycles	ROEMHELD service staff
Repair	in case of damages	ROEMHELD service staff

### NOTE

#### Qualification

Pay attention to the qualification of the personnel.

### 9.2 Cleaning

The following cleaning works have to be effected daily at the mechanical components.

1. Clean with cleaning clothes or cleaning rags.
2. Slightly lubricate the metallic components (plates, guides, etc.).

#### 9.2.1 Monthly checks

- Visual inspection.
- Check the unit for damages and possible running marks, repair if required.
- Check the axial and radial clearance, repair if required.
- Check the indexing for smooth running and clearance

### NOTE

#### Repair works

- Repair works, as e.g. the change of the interior lifting jack may only be effected by the ROEMHELD service technicians.

#### 9.2.2 Yearly checks

##### Hydraulic system, hydraulic hoses

An expert has to check all hydraulic components at least once a year if they are still work-proof. Assessed damages have to be repaired immediately.

The following checks and works have to be effected:

- An expert has to check all hydraulic hoses at least once a year if they are still work-proof. Assessed damages have to be repaired immediately.
- The hydraulic hoses of the device have to be exchanged as per BGR 237 at least after 6 years by new ones.

### 9.3 Repair

### NOTE

#### Repair works

- Repair works, as e.g. the change of the interior lifting jack may only be effected by the ROEMHELD service technicians.

### 9.3.1 Maintenance of the hydraulic indexing

The rotating module with hydraulic indexing is a compact and functional unit.

It consists of a basic module with integrated indexing mechanism and an operating unit with foot pedal, connected by a 2 m long hydraulic hose.

This flexible connection allows the individual placement of the operating unit at the most favourable ergonomic position.

The rotating operation is manually effected at the workpiece or at the assembly fixture.

The design of the indexing is a closed system.

When opening the system, the preloaded effect will get lost.

To guarantee a system free from air, the transmitter unit, the high-pressure hose and the receiver unit must be flushed.

#### Procedure:

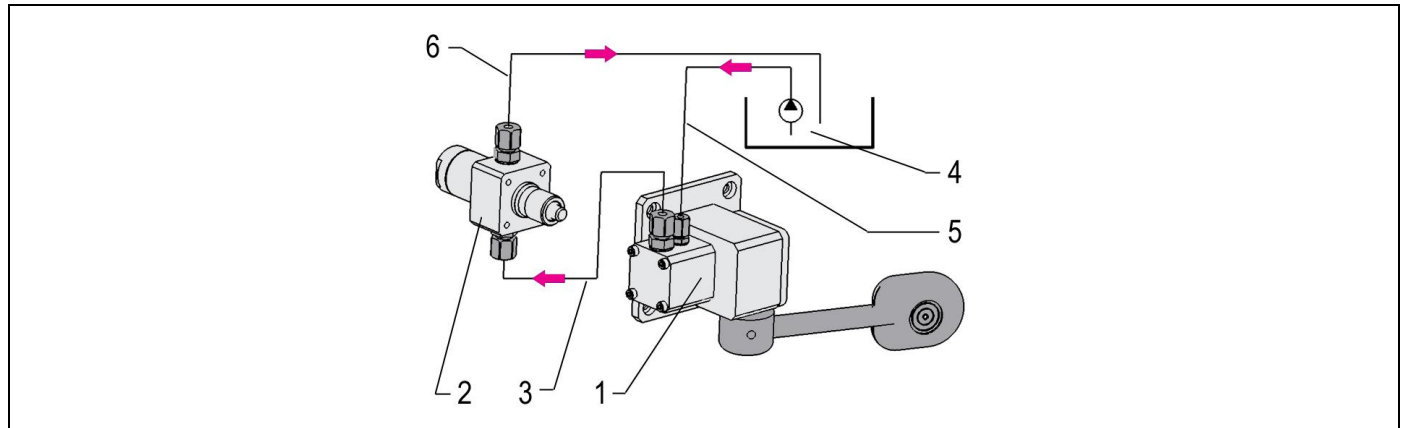


Figure 9: Sketch how to vent the indexing

➔ Direction of flushing	4 Pressure generator for flushing, with return line to the reservoir
1 Transmitter unit	5 Flushing line
2 Receiver unit	6 Reservoir line
3 High-pressure hose 2 m	

1. Connection of hose lines (see fig. of the sketch).

#### **NOTE**

The ports have to be aligned towards the top.

2. Connect to a pressure generator (preferably to a small power unit).

3. Flush the system several minutes.

Actuate the pedal several times to loosen trapped air bubbles.

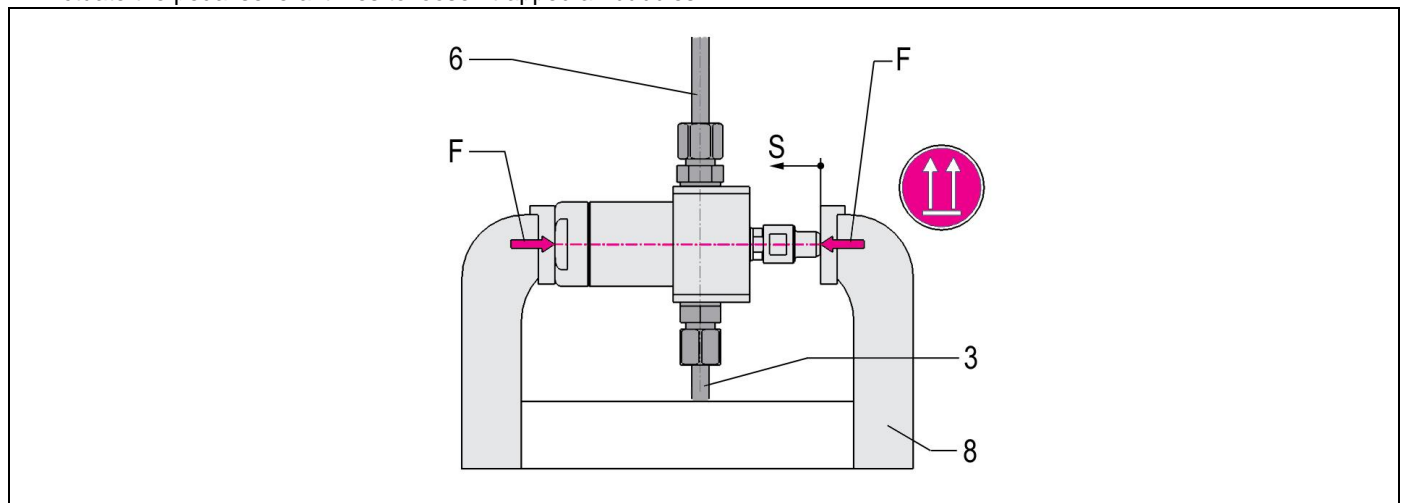


Figure 10: Alignment for bubble free mounting of the fittings

! Pay attention to the oil level	7 Plug
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4. Align the transmitter unit as shown and remove the flushing line.

## **NOTE**

Align the transmitter unit as shown in the figure.  
Oil must be in the connecting port up to the upper edge of the connecting thread.  
Refill oil, if required.

Put the plug slightly tilted onto the surface of the oil and screw in.

5. Vent the receiver unit

## **CAUTION**

**Injury due to the spring in the subassembly!**

The component can slip and the piston extends.  
Provide a holding device!

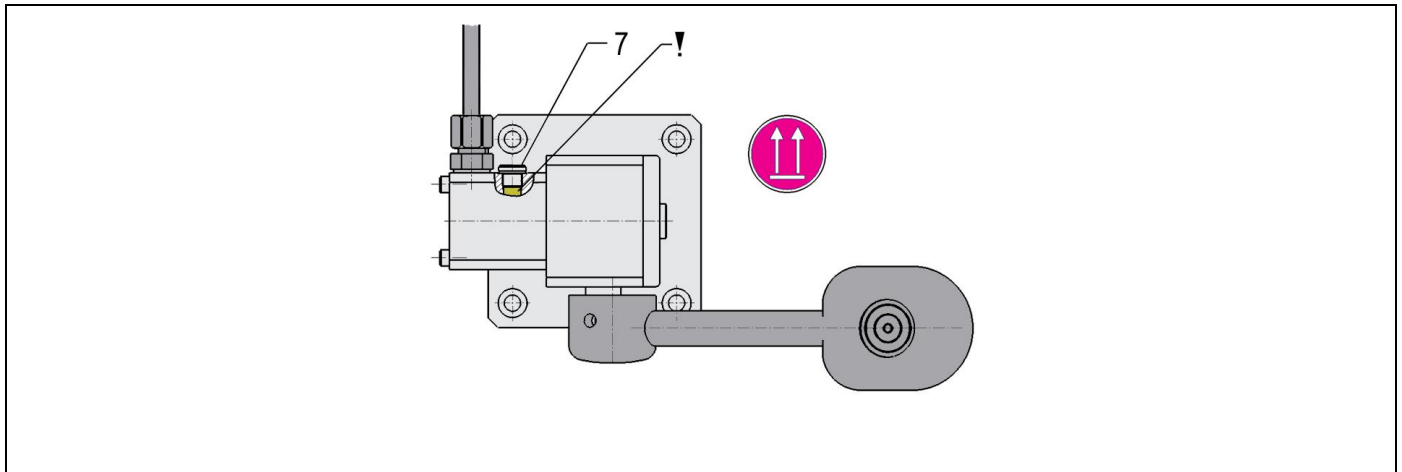


Figure 11: Alignment for bubble free mounting of the fittings

3 High-pressure hose 2 m	F Force required
6 Reservoir line	S Stroke approx. 13.5 mm
8 Vice or clamp	

Receiver unit in shown alignment, in the vice, preload and remove reservoir line.

## **NOTE**

Align the receiver unit as shown in the figure.  
Oil must be in the connecting port up to the upper edge of the connecting thread.  
Refill oil, if required.

Put the plug slightly tilted onto the surface of the oil and screw in.

6. Loosen the preload of the receiver unit.
7. Check function.

## **10 Trouble shooting**

### **CAUTION**

**All work by service personnel only!**

- All works only to be effected by ROEMHELD service staff.

### **All rotating modules**

Trouble	Cause	Remedy
Indexing does not engage	Too fast rotation	Decelerate rotation
	Max. admissible torques exceeded In-indexing defect	<b>Caution ! Works only to be effected by ROEMHELD service personnel.</b>
Clearance in the indexing too large	Wear or max. admissible torques exceeded	<b>Caution ! Works only to be effected by ROEMHELD service personnel.</b>

### Only for indexing with foot pedal

Trouble	Cause	Remedy
Indexing does not disengage	Air in the hydraulic system Components were opened	<b>⚠ Caution !</b> Works only to be effected by ROEMHELD service personnel.

## 11 Accessory

### NOTE

#### Accessories

- See data sheet.

## 12 Technical characteristics

### Maximum admissible load

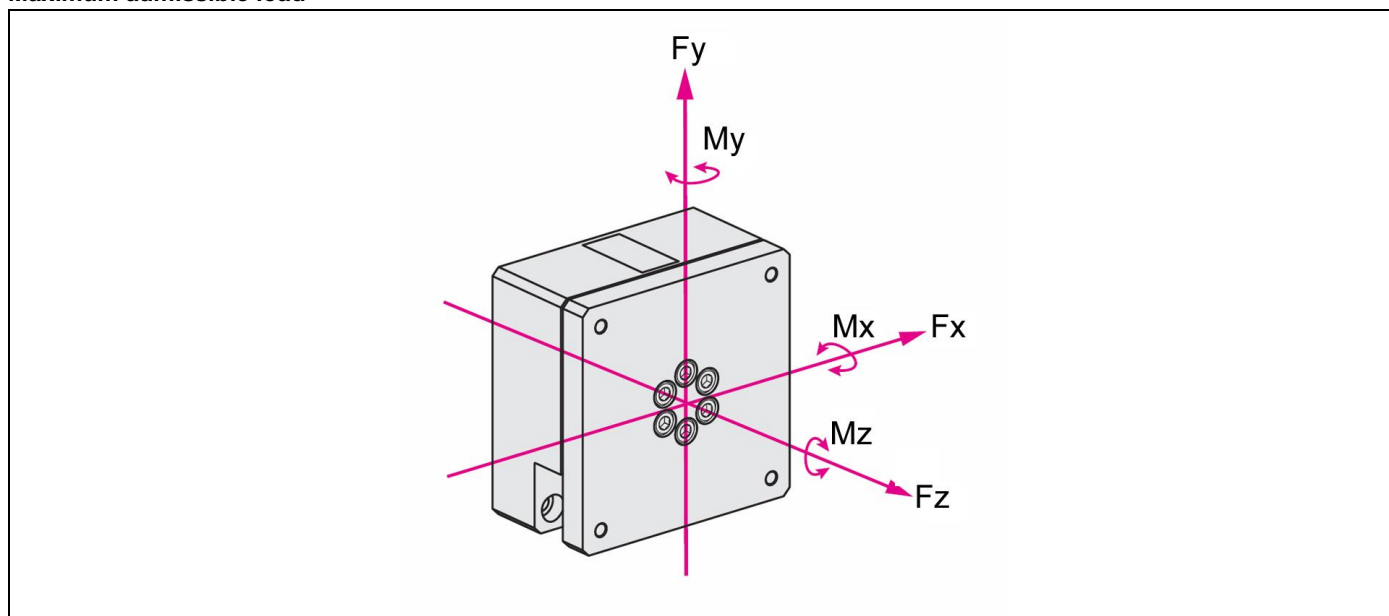


Figure 12: Axes of the introduced forces and torques

M Max. torques in the axes: X, Y or Z	F Max. admissible forces in the axes: X, Y or Z
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#### Max. admissible forces, for all versions

$F_x = \pm 2,000 \text{ N}$

$F_y = \pm 2,000 \text{ N}$

$F_z = \pm 1,000 \text{ N}$ .

#### Max. admissible torques

### NOTE

These torques are valid for all versions with indexing in engaged mode.

In the case of eccentric loads, it is recommended to compensate these by counterweights. In off-position the indicated maximum torques may occur.

### General characteristics

Type		Mz [Nm]
6505 02 36 O	Without indexing	not relevant
6505 01 36 M	Automatic indexing	250
6505 02 36 M	Actively-operated indexing	500
6508 02 XX O I	Indexing with foot pedal	800

### Weight (dead weight)

Type		m [kg]
6505 02 36 O	Without indexing	14
6505 01 36 M	Automatic indexing	19

6505 02 36 M	Actively-operated indexing	19
6508 02 XX O I	Indexing with foot pedal	25

## NOTE

### Further information

- For further technical data see ROEMHELD data sheet.

## 13 Disposal



### Hazardous to the environment

Due to possible environmental pollution, the individual components must be disposed only by an authorised expert company.

The individual materials have to be disposed as per the existing regulations and directives as well as the environmental conditions. Special attention has to be drawn to the disposal of components with residual portions of hydraulic fluids. The instructions for the disposal at the material safety data sheet have to be considered.

For the disposal of electrical and electronic components (e.g. stroke measuring systems, proximity switches, etc.) country-specific legal regulations and specifications have to be kept.

## **14 Declaration of manufacture**

### **Manufacturer**

Römheld GmbH Friedrichshütte  
Römheldstraße 1-5  
35321 Laubach, Germany  
Tel.: +49 (0) 64 05 / 89-0  
Fax: +49 (0) 64 05 / 89-211  
E-mail: [info@roemheld.de](mailto:info@roemheld.de)  
[www.roemheld.com](http://www.roemheld.com)

### **Responsible person for the documentation:**

Dipl.-Ing. (FH) Jürgen Niesner, Tel.: +49(0)6405 89-0.

### **Declaration of manufacture of the products**

They are designed and manufactured in line with the relevant versions of the directives **2006/42/EC**(EC MSRL) and in compliance with the valid technical rules and standards.

In accordance with EC-MSRL, these products are components, that are not yet ready for use and are exclusively designed for the installation in a machine, a fixture or a plant.

According to the pressure equipment directives the products are not to be classified as pressure reservoirs but as hydraulic placing devices, since pressure is not the essential factor for the design, but the strength, the inherent stability and solidity with regard to static or dynamic operating stress.

The products may only be put into operation after it was assessed that the incomplete machine / machine, in which the product shall be installed, corresponds to the machinery directives (2006/42/EC).

The manufacturer commits to transmit the special documents of the products to state authorities on request.  
The technical documentation as per appendix VII part B was prepared for the products.

Laubach, 09.01.2026