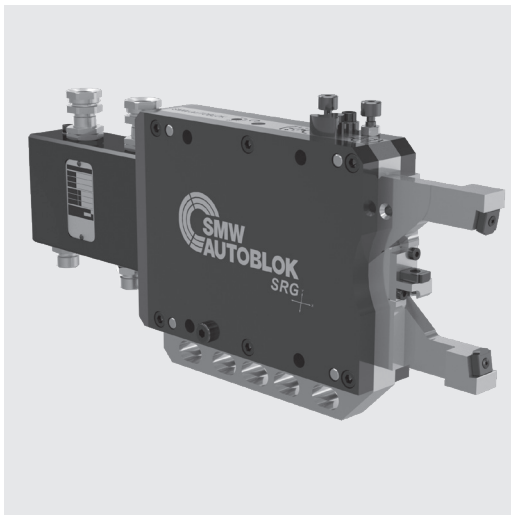


- Fine adjustment of the center
- Retractable Steady Rest arms



### Application/customer benefits

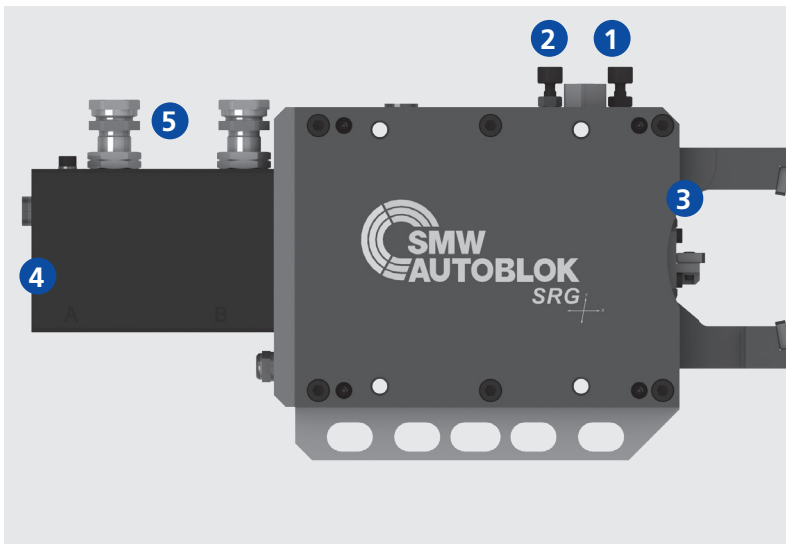
- Support of shaft type workpieces on grinding machines
- Particularly suitable for the machining of crankshafts and camshafts
- Rapid set up of the Steady Rest to the grinding center with the sensitive fine adjustment of the grinding center
- Suitable for follow down grinding
- Retractable Steady Rest arms for autoloading
- Monitoring of end positions for process safety

### Standard equipment

Basic grinding Steady Rest SRG

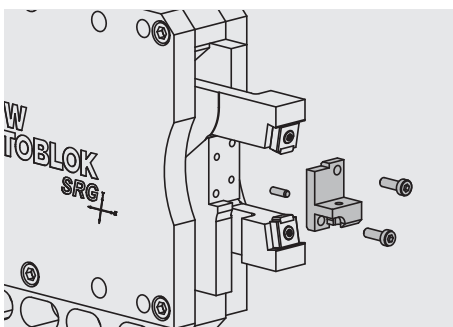
(Padholder for the middle piece, clamping kit and pad kits are not scope of delivery. For these parts please see the overview for the configurations below)

## Technical details



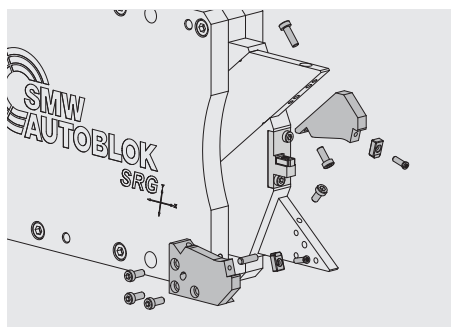
1. Horizontal fine adjustment of the grinding center.
2. Vertical fine adjustment of the grinding center.
3. Retractable Steady Rest arms.
4. Port for compressed air against dust and coolant.
5. Monitoring of end positions with proximity switches (switches not included).

## Overview Configuration



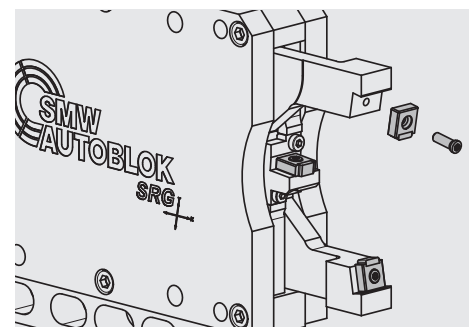
Select padholder for the middle piece\*  
(SRG 1, 1S, 2)

- Consisting of padholder middle piece (incl. mounting material).
- 3 versions available:  
0 degree,  $\pm 5$  degree,  $\pm 7$  degree.
- Can be rotated by 180 degrees.



Select clamping kit\*\*  
(SRG 2F, 3F, 4F, 5F, 5.1FS | SRG-B 4F, 5F)

- Consisting of 2 nests for the arms and 1 padholder for the middle piece (incl. mounting material).
- The different clamping ranges can be covered with different clamping kits.



Select Pad kit\*\*\*

- Consisting of 3 pads incl. 3 mounting screws.
- Standard for clamping range as shown on the Steady Rest.
- Special pad kit for shifting of the clamping range -5 mm available.

\* Consisting of padholder for the middle piece incl. mounting material.

\*\* Consisting of padholder for the middle piece and the nests for the arms incl. mounting material.

\*\*\* Consisting of 3 pads and 3 mounting bolts.

- Fine adjustment of the center
- Retractable Steady Rest arms

## Overview clamping range

Type	Clamping range in mm															Page
SRG 0.8	3 - 18															399
SRG 1			20 - 35													400
SRG 1 S			20 - 35													401
SRG 2				30 - 60												402
SRG 2 F																
I Kit	12 - 28															403
II Kit			28 - 44													
III Kit					44 - 60											
SRG 3 F																
I Kit	10 - 30															404
II Kit			30 - 50													
III Kit					50 - 70											
IV Kit							70 - 90									
SRG 4 F SRG 4.1 FS SRG-B 4 F																
I Kit			22 - 35													405- 365
II Kit				35 - 48												
III Kit					48 - 61											
IV Kit						61 - 74										
V Kit								74 - 87								
VI Kit										87 - 100						
SRG 5 F SRG-B 5 F																
I Kit						48 - 70										366- 367
II Kit							70 - 92									
III Kit									92 - 114							
IV Kit											114 - 136					
SRG 5.1 FS																
I Kit										96 - 102						368
II Kit										102 - 108						
III Kit											108 - 114					
IV Kit												114 - 120				
V Kit													120 - 126			
	0	10	20	30	40	50	60	70	80	90	100	110	120	130	140	

# SRG / SRG-B

Grinding Steady Rests

Ordering review

SMW-AUTOBLOK type Basic Steady Rest		SRG 0.8 223250	SRG 1 221175	SRG 1 S 223060	SRG 2 221871
Clamping range	mm	3-18	20-35	20-35	30-60
Padholder 0 degree*	Id. No.	-	203977	205191	203985
Padholder ± 5 degree*	Id. No.	-	203978	205196	203986
Padholder ± 7 degree*	Id. No.	-	203979	205197	203987
Pad Kit Standard	Id. No.	205439	203976	204161	203976
Pad Kit Special ***	Id. No.	-	203939	-	203939
Working pressure	bar	20-50	15-30	20-50	15-30
Follow down grinding		Yes	Yes	Yes	Yes
Dosing element kit	Id. No.	224379 (0.03 cm³)	224360 (0.01 cm³)	224379	224360

SMW-AUTOBLOK type Basic Steady Rest		SRG 2 F 222260			SRG 3 F 224450				SRG 4 F 221930				SRG-B 4 F 223140	
Clamping range	mm	12-60****			10-90****				22-100					
Clamping kit		I	II	III	I	II	III	IV	I	II	III	IV	V	VI
Clamping range	mm	12-28	28-44	44-60	10-30	30-50	50-70	70-90	22-35	35-48	48-61	61-74	74-87	87-100
Clamping kit 0 degree**	Id. No.	204383	204382	204381	224298	224297	224296	224295	205000	205001	205002	205003	205004	205005
Clamping kit ±2 degree**	Id. No.	-	-	-	-	-	-	-	205006	205007	205008	205009	205010	205011
Clamping kit ±3 degree**	Id. No.	-	-	-	-	-	-	-	-	-	-	-	-	-
Clamping kit ±5 degree**	Id. No.	206349	206348	206347	224302	224301	224300	224299	224453	224454	224455	224456	224457	224458
Clamping kit ±7 degree**	Id. No.	206346	206345	206344	224306	224305	224304	224303	224459	224460	224461	224462	224463	224464
Pad Kit Standard	Id. No.	203976			203976				204161					
Pad Kit Special***	Id. No.	203939			203939				-					
Working pressure	bar	15-30			10-30				7-25					
Follow down grinding		Yes			Yes				Yes					
Dosing element kit	Id. No.	224360			224360				-					

SMW-AUTOBLOK type Basic Steady Rest		SRG 4.1 FS 222410						SRG 5 F 223774				SRG-B 5 F 222530				SRG 5.1 FS 222665				
Clamping range	mm	22-100						48-136								96-126				
Clamping kit		I	II	III	IV	V	VI	I	II	III	IV	I	II	III	IV	V				
Clamping range	mm	22-35	35-48	48-61	61-74	74-87	87-100	48-70	70-92	92-114	114-136	96-102	102-108	108-114	114-120	120-126				
Clamping kit 0 degree**	Id. No.	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-				
Clamping kit ±2 degree**	Id. No.	204719	204720	204721	204722	204723	204724	205018	205019	205020	205021	-	-	-	-	-				
Clamping kit ±3 degree**	Id. No.	-	-	-	-	-	-	-	-	-	-	205200	205201	205202	205203	205204				
Clamping kit ±5 degree**	Id. No.	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-				
Clamping kit ±7 degree**	Id. No.	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-				
Pad Kit Standard	Id. No.	205228						204161				204161								
Pad Kit Special***	Id. No.	-						-				-								
Working pressure	bar	-						10-30				7-25								
Follow down grinding		Yes						Yes				Yes								

- \* Consisting of padholder for the middle piece incl. mounting material.
- \*\* Consisting of padholder for the middle piece and the nests for the arms incl. mounting material.
- \*\*\* Clamping range -5 mm.
- \*\*\*\* Padholder middle piece pivoting for contact angle.
- SRG-B Side mounted cylinder.

## Pad position middle piece / contact angle

