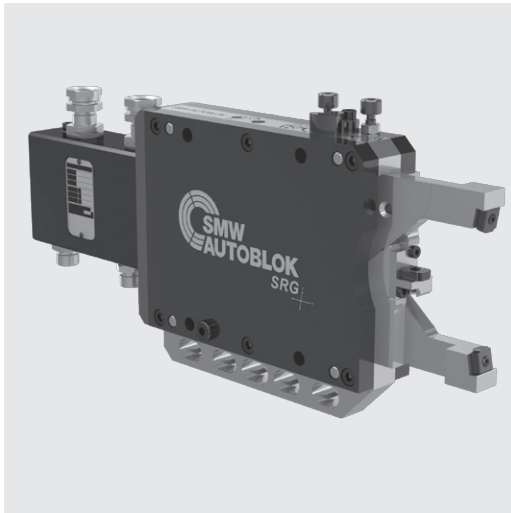


- Fine adjustment of the center
- Retractable Steady Rest arms



Application / customer benefits

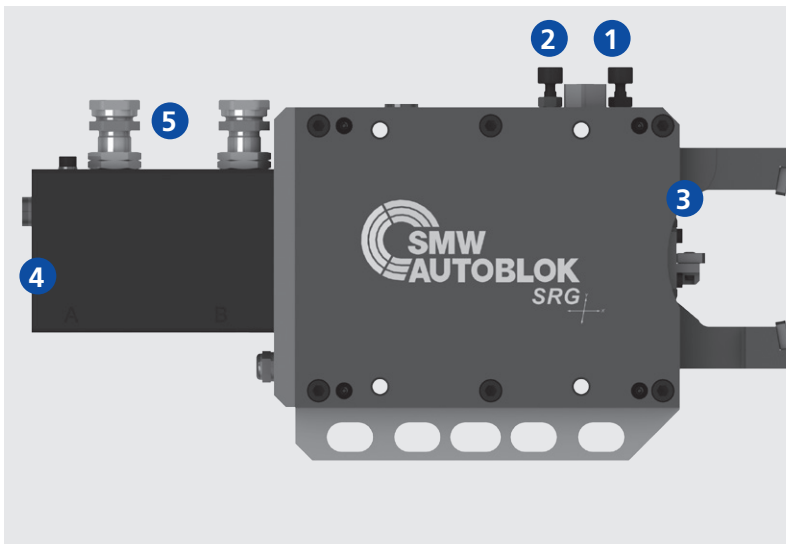
- Support of shaft type workpieces on grinding machines
- Particularly suitable for the machining of crankshafts and camshafts
- Rapid set up of the steady rest to the grinding center with the sensitive fine adjustment of the grinding center
- Suitable for follow down grinding
- Retractable steady rest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

Standard equipment

Basic Grinding Steady Rest SRG

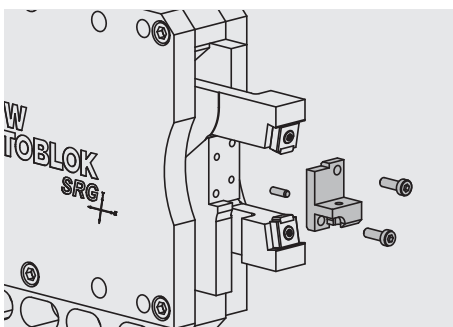
(Padholder for the middle piece, clamping kit and pad kits are not scope of delivery. For these parts please see the overview for the configurations below)

Technical details



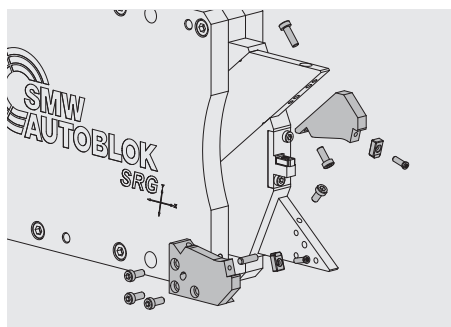
1. Horizontal fine adjustment of the grinding center
2. Vertical fine adjustment of the grinding center
3. Retractable Steady Rest arms
4. Port for compressed air against dust and coolant
5. Monitoring of end positions with proximity switches (switches not included)

Overview Configuration



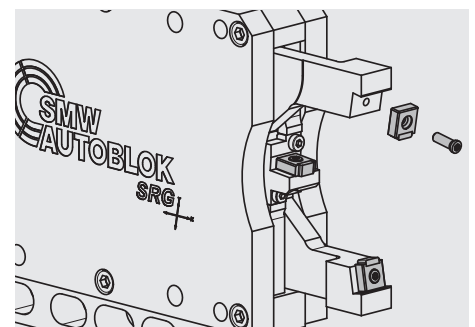
Select padholder for the middle piece* (SRG 1, 1S, 2)

- Consisting of padholder middle piece (incl. mounting material)
- 3 versions available:
0 degree, ± 5 degree, ± 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														357	
SRG 1			20 - 35												358	
SRG 1 S			20 - 35												359	
SRG 2				30 - 60											360	
SRG 2 F																
I Kit	12 - 28														361	
II Kit			28 - 44													
III Kit				44 - 60												
SRG 3 F																
I Kit	10 - 30														362	
II Kit			30 - 50													
III Kit				50 - 70												
IV Kit					70 - 90											
SRG 4 F SRG-B 4 F																
I Kit			22 - 35												363- 364	
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									365- 366	
II Kit							70 - 92									
III Kit								92 - 114								
IV Kit									114 - 136							
SRG 5.1 FS																
I Kit									96 - 102							367
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

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					

SMW-AUTOBLOK Type Basic Steady Rest		SRG 5 F 223774		SRG-B 5 F 222530		SRG 5.1 FS 222665				
Clamping range	mm	48-136				96-126				
Clamping kit		I	II	III	IV	I	II	III	IV	V
Clamping range	mm	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.	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.	204161				204161				
Pad Kit Special***	Id. No.	-				-				
Working pressure	bar	10-30				7-25				
Follow down grinding		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 for contact angle
- SRG-B Side mounted cylinder

Pad position middle piece / contact angle

