

SRG

High precision grinding Steady Rests

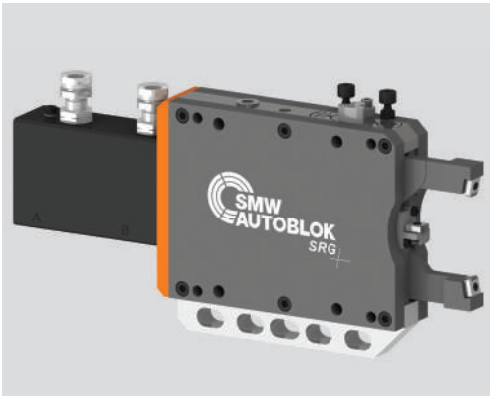
Grinding diameter \varnothing 20 - 85 mm

- Fine adjustment of the grinding center
- Retractable arms
- Suitable for follow down grinding
- High rigidity

New grinding Steady Rest with fine adjustment of the center

SRG

Grinding Steady Rest



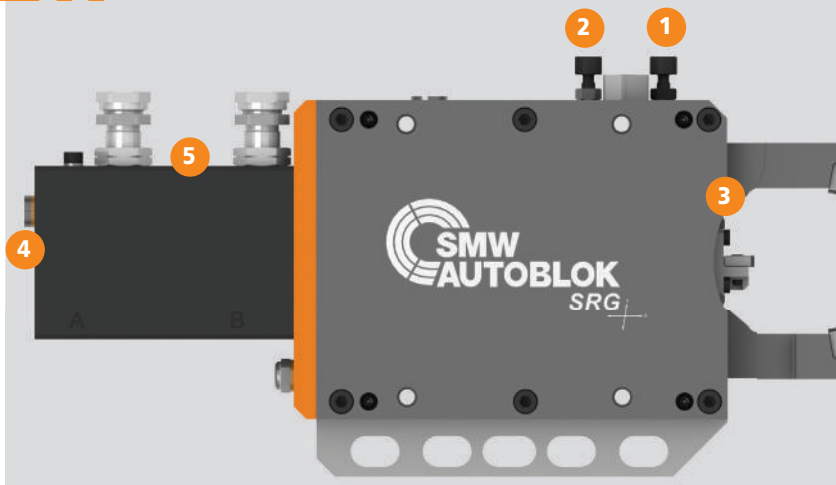
Application/customer benefits

- 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 diameter due to the fine adjustment
- Suitable for Follow down grinding

Scope of delivery

- Basic Grinding Steady Rest SRG
 - Delivery in transport box
- (Padholder for the middle piece, Clamping Kit and Pad Kits are not scope of delivery. See therefor the overview for the configurations below.)

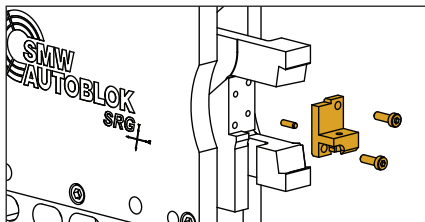
NEW



Technical Features

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 standard proximity switches (switches not included)

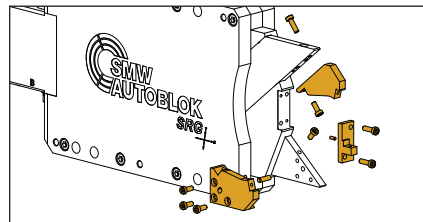
Overview Configuration



Select padholder for the middle piece (SRG 1 and 2)

Padholder for the middle piece

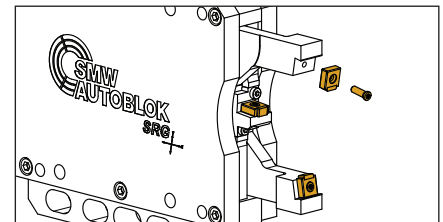
- Consisting of padholder middle piece (incl. mounting material)
- 3 versions available:
 - 0 degree, ± 5 degree, ± 7 degree
- Can be rotated by 180 degrees



Select clamping kit (SRG 2.1 and SRG 4)

Clamping Kit for the arms

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



Select Pad Kit

Pad Kit

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

SMW-AUTOBLOK Type		SRG 1	SRG 2	SRG 2.1			SRG 4			
Basic Steady Rest	Id.No.	221175	221871	222260			221930			
Clamping range	mm	20-35	30-60	12-60			43-85			
Padholder 0 degree	Id.No.	203977*	203985*							
Padholder ± 5 degree	Id.No.	203978*	203986*							
Padholder ± 7 degree	Id.No.	203979*	203987*							
Clamping kit				I	II	III	I	II	III	IV
Clamping range	mm			12-28	28-44	44-60	43-55	49-61	61-73	73-85
Clamping kit 0 degree	Id.No.			204383**	204382**	204381**	204165**	204164**	204163**	204162**
Clamping kit ± 5 degree	Id.No.						204202**	204201**	204200**	204199**
Clamping kit ± 7 degree	Id.No.						204206**	204205**	204204**	204203**
Pad Kit Standard	Id.No.	203976	203976	203976			204161			
Pad Kit Special***	Id.No.	203939	203939	203939			-			
Working pressure	bar	15-30	15-30	15-30			7-25			
Follow down grinding		Yes	Yes	Yes			Yes			

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

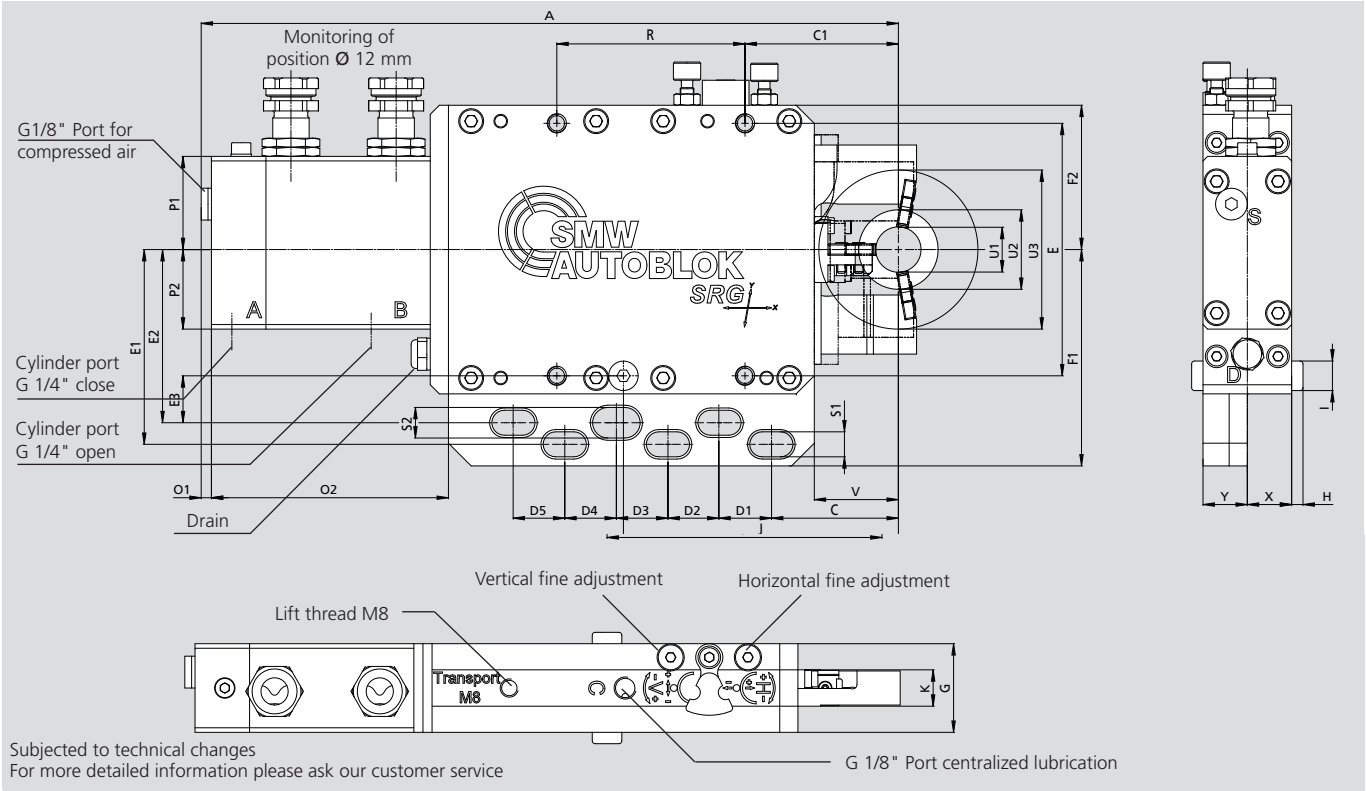
** Consisting of padholder for the middle piece and the nests for the arms incl. mounting material

*** Clamping range -5 mm

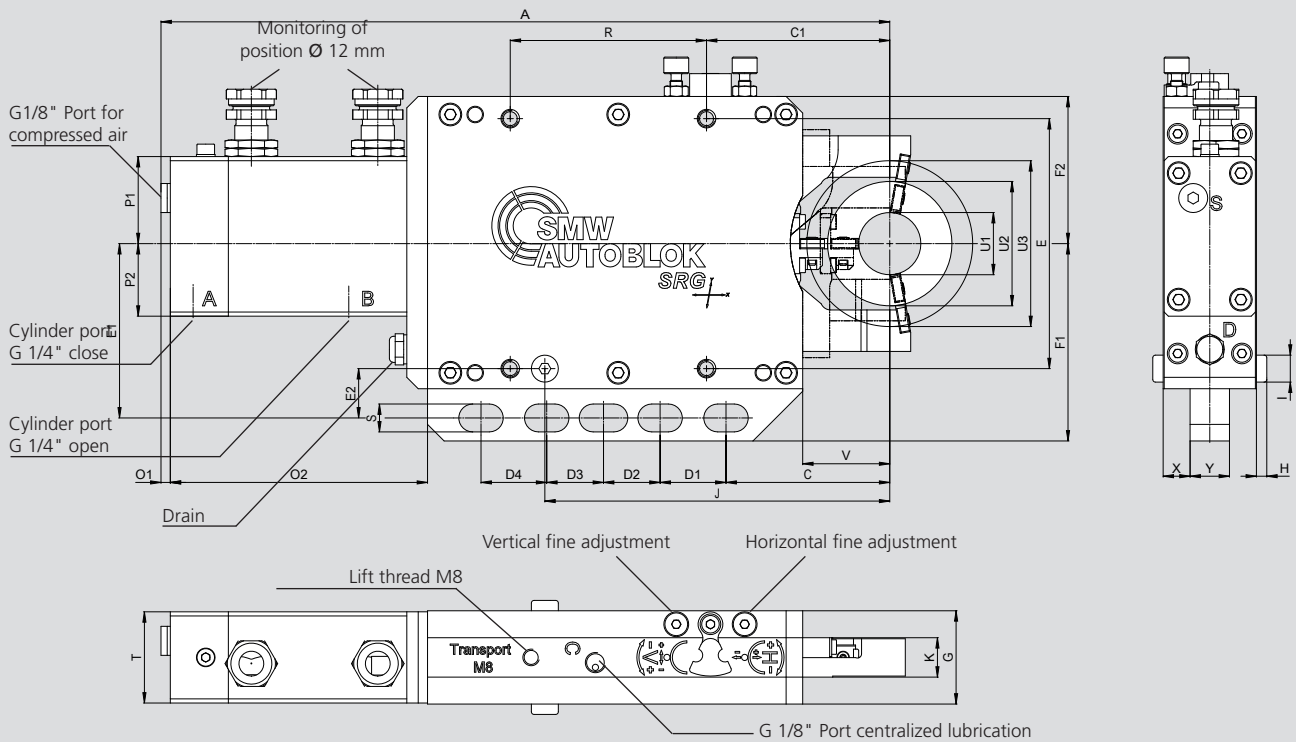
SRG 1

Grinding Steady Rest

Dimensions and technical data



SMW-AUTOBLOK Type Id. No.			SRG 1 221175
Minimum clamping diameter	U1	mm	20
Maximum clamping diameter	U2	mm	35
Clear for part loading	U3	mm	70
Horizontal adjustment range	mm	mm	± 0.20
Vertical adjustment range	mm	mm	± 0.10
	A	mm	306.8
	C	mm	55.9
	C1	mm	67.5
	D1	mm	22.8
	D2	mm	22.7
	D3	mm	22.7
	D4	mm	22.7
	D5	mm	22.6
	E	mm	111.1
	E1	mm	76.2
	E2	mm	85.7
	E3	mm	20.7
	F1	mm	95.2
	F2	mm	63.5
	G	mm	39
	H	mm	5
	I	mm	13
	J	mm	121.2
	K	mm	16
	O1	mm	4.5
	O2	mm	104.3
	P1	mm	41
	P2	mm	35
	R	mm	82.8
	S1	mm	11
	S2	mm	13.5
	T	mm	39
	V	mm	37
	X	mm	19.5
	Y	mm	19.5
Cylinder stroke		mm	69.9
Piston area		cm ²	6.38
Operating pressure	max	bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	0.001
Mass		kg	8.7



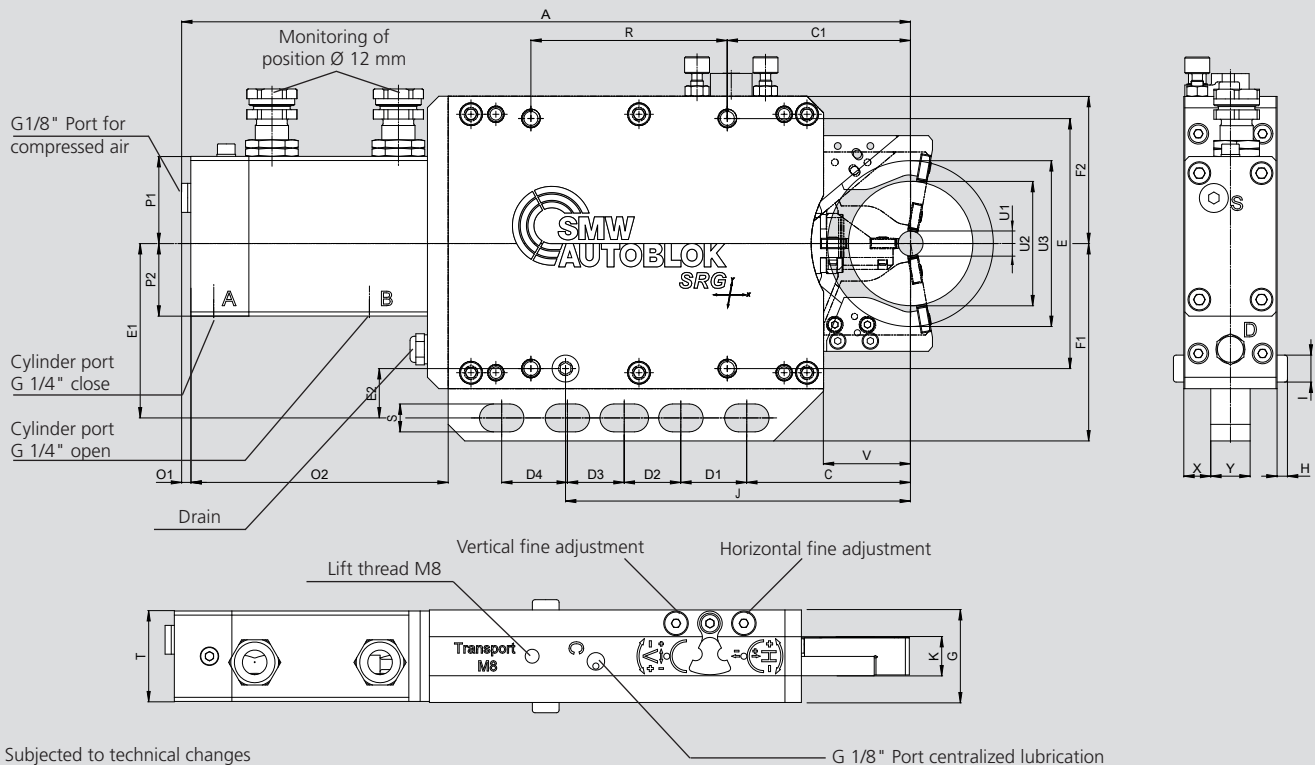
Subjected to technical changes
For more detailed information please ask our customer service

SMW-AUTOBLOK Type			SRG 2
Id. No.			221871
Minimum clamping diameter	U1	mm	30
Maximum clamping diameter	U2	mm	60
Clear for part loading	U4	mm	80
Horizontal adjustment range	mm	mm	± 0.20
Vertical adjustment range	mm	mm	± 0.14
	A	mm	351.6
	C	mm	79
	C1	mm	88.4
	D1	mm	31.8
	D2	mm	27.4
	D3	mm	27.3
	D4	mm	31.7
	E	mm	120.6
	E1	mm	84.1
	E2	mm	23.8
	F1	mm	95.2
	F2	mm	71
	G	mm	45
	H	mm	5
	I	mm	13
	J	mm	166.4
	K	mm	19
	M	mm	41
	O1	mm	4.5
	O2	mm	124.1
	P1	mm	42
	P2	mm	35
	R	mm	94.7
	S	mm	13.5
	T	mm	45
	V	mm	42
	X	mm	13
	Y	mm	19
Cylinder stroke		mm	73.4
Piston area		cm ²	7,07
Operating pressure	max	bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	0.001
Mass		kg	11.8

SRG 2.1

Grinding Steady Rest

Dimensions and technical data



Subjected to technical changes

For more detailed information please ask our customer service

G 1/8" Port centralized lubrication

SMW-AUTOBLOK Type Id.No.			SRG 2.1 222260		
Minimum clamping diameter	U1	mm	12 *	28 **	44 ***
Maximum clamping diameter	U2	mm	28 *	44 **	60 ***
Clear for part loading	U3	mm	30 *	46 **	62 ***
Horizontal adjustment range	mm	mm	± 0.20		
Vertical adjustment range	mm	mm	± 0.14		
	A	mm	351.6		
	C	mm	79		
	C1	mm	88.4		
	D1	mm	31.8		
	D2	mm	27.4		
	D3	mm	27.3		
	D4	mm	31.7		
	E	mm	120.6		
	E1	mm	84.1		
	E2	mm	23.8		
	F1	mm	95.2		
	F2	mm	71		
	G	mm	45		
	H	mm	5		
	I	mm	13		
	J	mm	166.4		
	K	mm	19		
	M	mm	41		
	O1	mm	4.5		
	O2	mm	124.1		
	P1	mm	42		
	P2	mm	35		
	R	mm	94.7		
	S	mm	13.5		
	T	mm	45		
	V	mm	42		
	X	mm	13		
	Y	mm	19		
Cylinder stroke		mm	66.4		
Piston area		cm ²	7,07		
Operating pressure		bar	45		
Working pressure		bar	15-30		
Repeatability accuracy		mm	0.001		
Mass		kg	11.2		

Modular nests for the arms:

(*) 12-28 mm clamping range by using clamping kit I

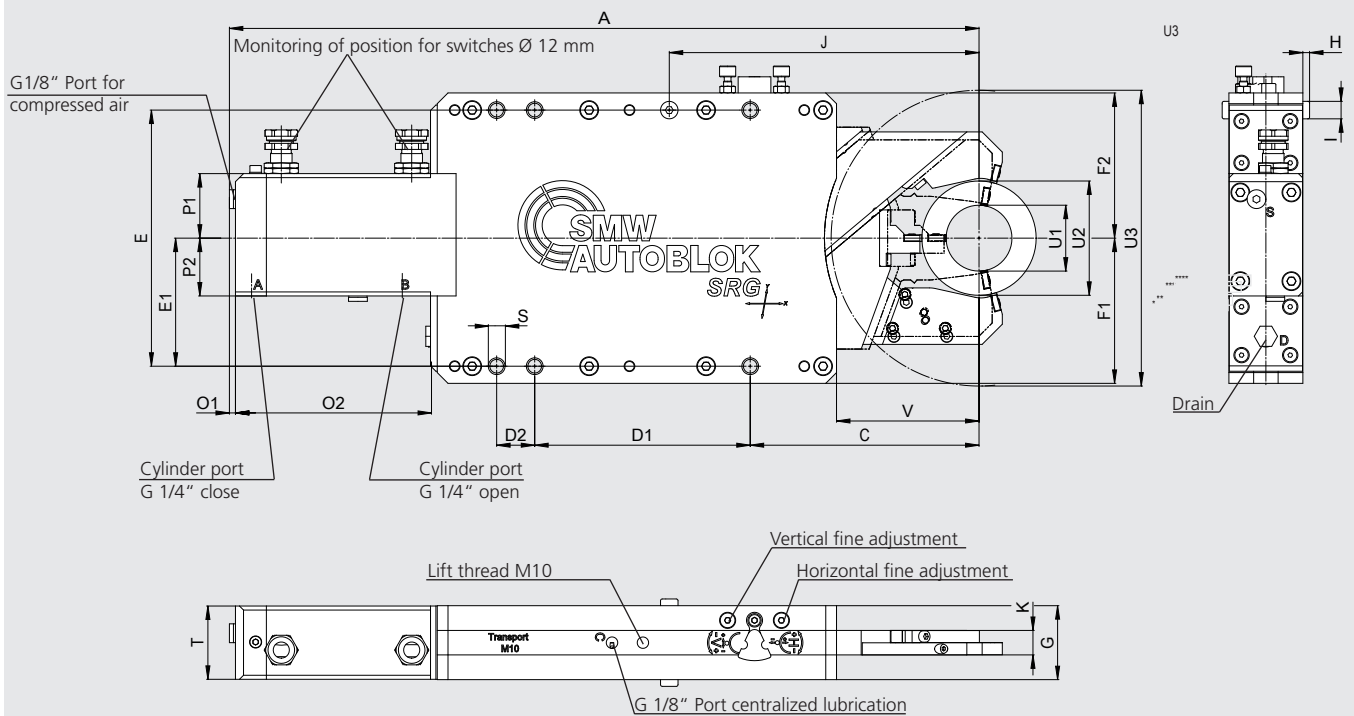
(**) 28-44 mm clamping range by using clamping kit II

(***) 44-60 mm clamping range by using clamping kit III

SRG 4

Grinding Steady Rest

Dimensions and technical data



Subjected to technical changes
For more detailed information please ask our customer service

SMW-AUTOBLOK Type Id. No.			SRG 4 221930			
Minimum clamping diameter	U1	mm	43 *	49 **	61 ***	73 ****
Maximum clamping diameter	U2	mm	55 *	61 **	73 ***	85 ****
Clear for part loading	U3	mm	220			
Horizontal adjustment range	mm	mm	± 0.20			
Vertical adjustment range	mm	mm	± 0.14			
	A	mm	557.6			
	C	mm	170.2			
	D1	mm	160.3			
	D2	mm	28.3			
	E	mm	190.5			
	E1	mm	95.25			
	F1	mm	108			
	F2	mm	108			
	G	mm	55			
	H	mm	5			
	I	mm	13			
	J	mm	230.4			
	K	mm	18			
	O1	mm	4.5			
	O2	mm	145.1			
	P1	mm	48			
	P2	mm	43			
	S	mm	M12 (6x)			
	T	mm	54.5			
	V	mm	106			
Cylinder stroke		mm	127.2			
Piston area		cm ²	12.56			
Operating pressure	max	bar	30			
Working pressure		bar	7-25			
Repeatability accuracy		mm	0.001			
Mass		kg	20			

Modular nests for the arms:

- (*) 43-55 mm clamping range by using clamping kit I
- (**) 49-61 mm clamping range by using clamping kit II
- (***) 61-73 mm clamping range by using clamping kit III
- (****) 73-85 mm clamping range by using clamping kit IV