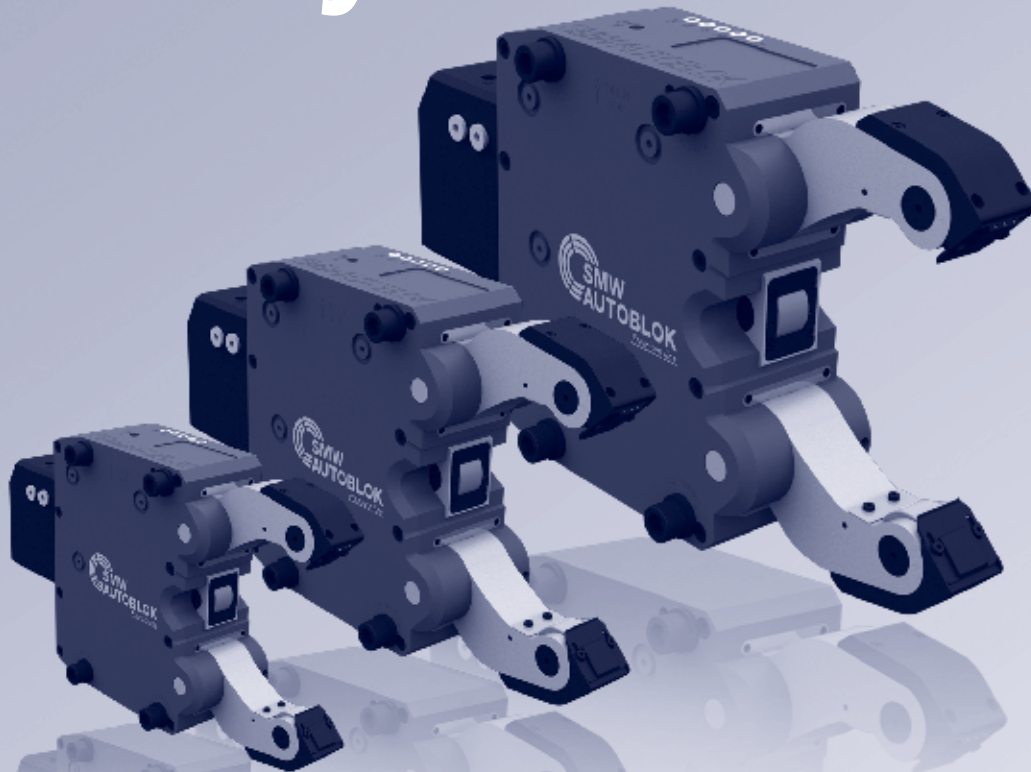


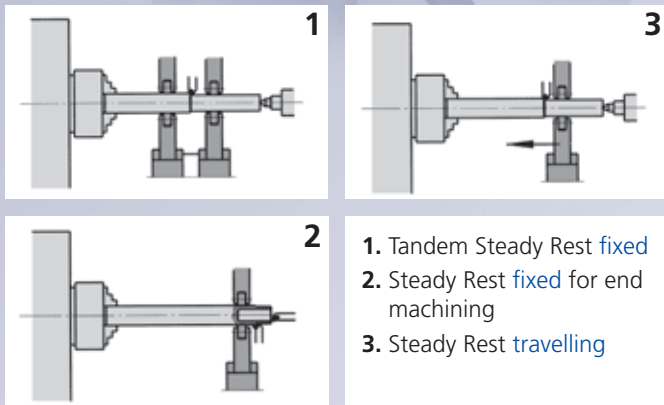
SMW-AUTOBLOK

worldwide leader

in Steady Rests



Fixed or travelling application

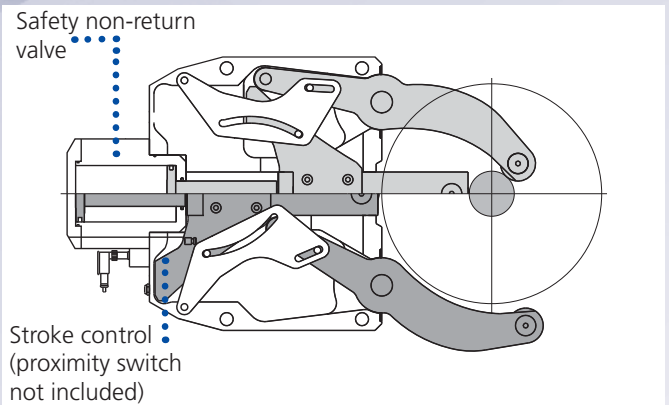


1

3

2

1. Tandem Steady Rest **fixed**
2. Steady Rest **fixed** for end machining
3. Steady Rest **travelling**

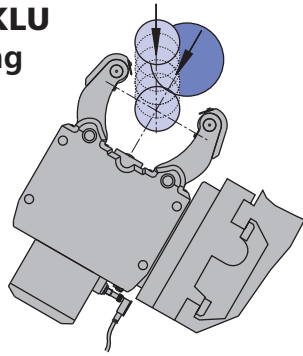


Features included in standard range

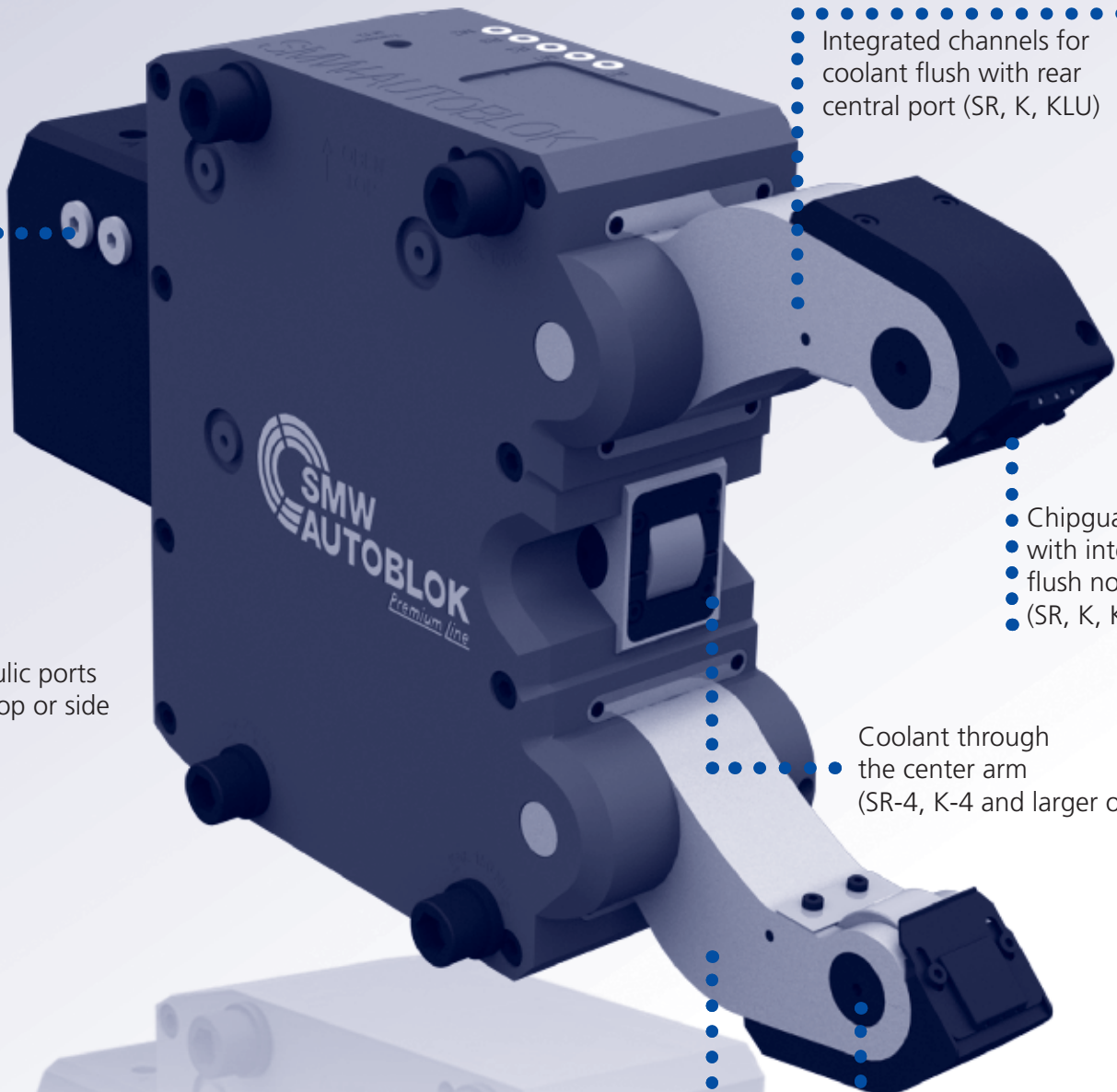
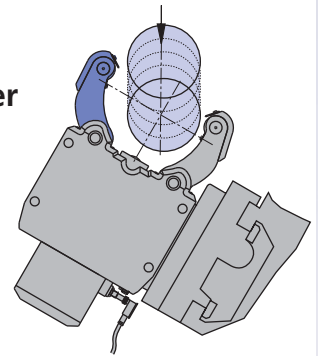
Steady Rest type	Standard Line		Premium Line			
	SLU-X, SLUA-X	SLU-B, SLUA-B	SR	SRA	K, KA	KLU
Steady Rest size	1 - 5.1	3 - 6	1 - 6	2 - 6	3 - 7.1	215 - 540
Sealed body	■		■	■	■	■
Safety valve	■	■	■	■	■	■
Stroke control (open position)	■	■	■	■	■	■
1 set swarf guard 3-piece	■	■				
1 set swarf guard with integrated coolant flush			■	■	■	■
1 set cylindrical rollers	■	■	■	■	■	■
Port for compressed air	■	■	■	■	■	■
Port for coolant through arms incl. chipguard			■	■	■	■

SLU-X® / SR® / K / KLU

SLU-X/SR/K/KLU
large clamping
range



SLUA-X/SRA
additional
pivoting upper
arm
for automatic
vertical loading
(worldwide
patented)



Integrated channels for
coolant flush with rear
central port (SR, K, KLU)

Hydraulic ports
from top or side

Chipguard
with integrated
flush nozzle
(SR, K, KLU)

Coolant through
the center arm
(SR-4, K-4 and larger only)

**Patented mechanism
for opening the arms of the
Steady Rest without
springs and free from wear.
(worldwide patented)**

Arms and centerpiece
hardened
(SLU-X, SR, K, KLU)

Easy change of rollers
without loose parts

SLU-X®
SLU-B

SLUA®-X
SLUA®-B

SR®
SRA

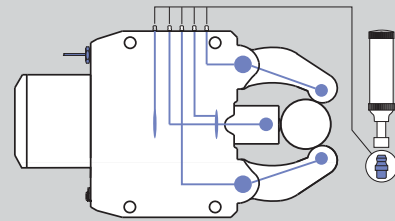
KLU
K

Equipment

Option of manual lubrication (M)

- Low cost solution for medium working conditions and low build up of swarf.
- The lubrication points and rollers are supplied with lubrication grease via the grease nipples and the grease gun.
- Lubrication intervals depending on the working conditions normally every 4 to 8 operating hours.
- Grease: KPE 2R-20 DIN 51502

Manual lubrication (M)



4/5 cone grease nipples
DIN 71412

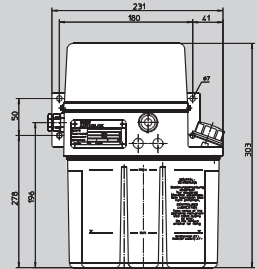
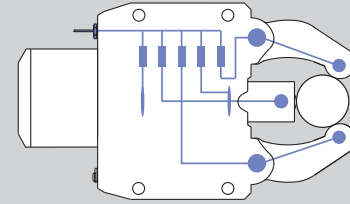
Option of central oil lubrication (Z)

- For heavy working conditions and high build up of swarf
- For travelling Steady Rest applications.
- The use of our separate complete lubrication unit with timer control is recommended.
- Lubricating intervals 5 - 20 min
- Min./max. operating pressure 10 to 45 bar.
- Oil: Viscosity of 46 mm²/s (viscosity class ISO)

Central lubrication (Z)

Lubrication unit oil
Id. No. 088707

Centralized lubrication G 1/8"



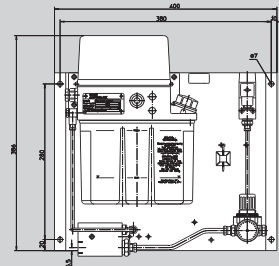
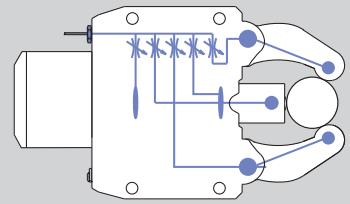
Option of central lubrication oil + air (OLD)

- For heaviest cutting conditions with high built up of swarf, dust or coolant.
- The SMW-AUTOBLOK oil + air unit for lubrication with built-in timer control is mandatory.
- This unit injects oil for lubrication into the air hose in adjustable intervals (2 -12 min.).
- The permanent air flow (min. 3 bar) feeds the oil to the rollers and keeps them clean.
- Oil: Viscosity of 46 mm²/s (viscosity class ISO)

Oil + air lubrication (OLD)

Lubrication unit oil + air
Id. No. 088708

Centralized lubrication G 1/8"

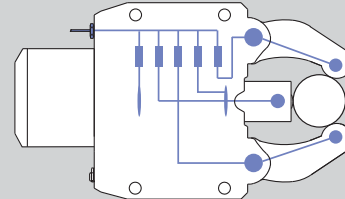


Option of central grease lubrication (F)

- For machines with central grease lubrication
- For application and intervals please follow the instruction of the machine maker.
- Min./max. operating pressure 30 to 45 bar.
- Grease: NLGI class 0 or 1

Central grease lubrication (F)

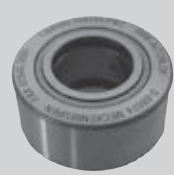
Centralized lubrication G 1/8"



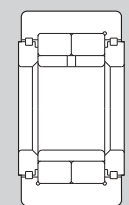
Option of rollers

- SMW-AUTOBLOK rollers (precision class P05) specially developed for our Steady Rests.
- Special sealing ensures highest precision and service life.
- Standard equipment: 1 set of cylindrical rollers.
- Option: Spherical rollers (for travelling Steady Rests), synthetic material rollers, carbide rollers.

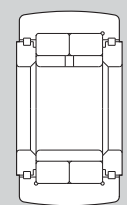
Original
SMW-AUTOBLOK
roller



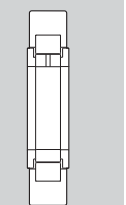
cylindrical



spherical



narrow



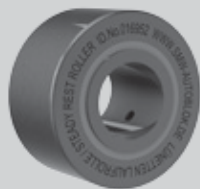
Rollers (all types)

- Rollers steel (standard): Surface of workpiece not hardened

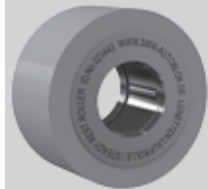
Available optional materials:

- Rollers synthetic material: Surface of workpiece polished or chrome plated
- Rollers carbide: Surface of workpiece hardened

Rollers
steel

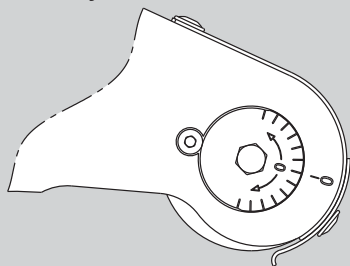


Rollers synthetic
material

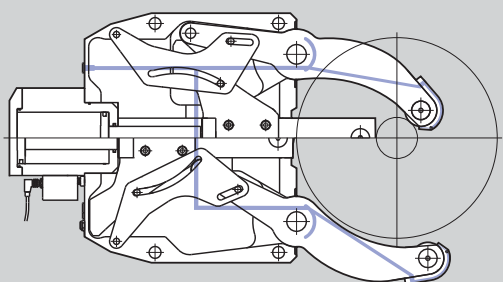


Rollers
carbide

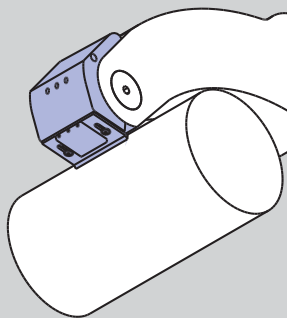


Eccentric fine adjustment**Option fine adjustment of center line**

- Eccentric roller pins on the two Steady Rest arms allow a quick fine adjustment of the center line.
- This avoids to unlock and adjust the entire Steady Rest on the bracket for small adjusting movements.
- Adjustment of open steady rest only!

Coolant/air feed**Coolant/air feed (SR/K/KLU only)**

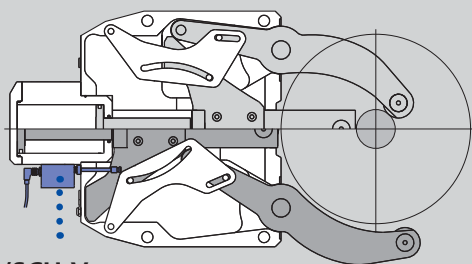
- Built-in channels to feed coolant or air from a central connecting port to the Steady Rest arms.
- Basic equipment for SR/K/KLU steady rests
- From size SR-4 / K4 and larger with coolant through the center arm

Chipguard coolant/air**Patented coolant/air chipguard with integrated flush nozzles (SR/K/KLU only)**

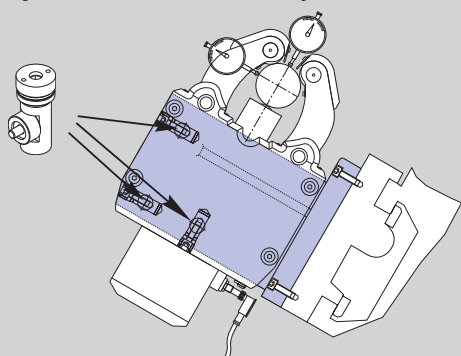
- Keeps roller clamping area free from chips
- The patented double flush nozzles keep front and rear of the wiper area clean.

Only for steady rests with coolant / air feed.**Benefit:**

- Constant centering accuracy
- No damage of workpiece and rollers caused by chips/swarf
- Less roller consumption = less costs

**SCU-A/SCU-V
diameter measuring system****SCU-A/SCU-V****Option linear diameter measuring system
SCU-A/SCU-V**

- The position of the clamping arms is monitored by the linear measuring system SCU-A/SCU-V.
- Avoids collision with workpieces, turret, loader etc.
- Reduced cycle time due to position controlled opening of the arms to the requested opening only.
- SCU-A: In: 24 V Out: 4 – 20 mA
- SCU-V: In: 24 V Out: 0 – 10 V

Steady Rest bracket with adjustment device**Steady Rest bracket**

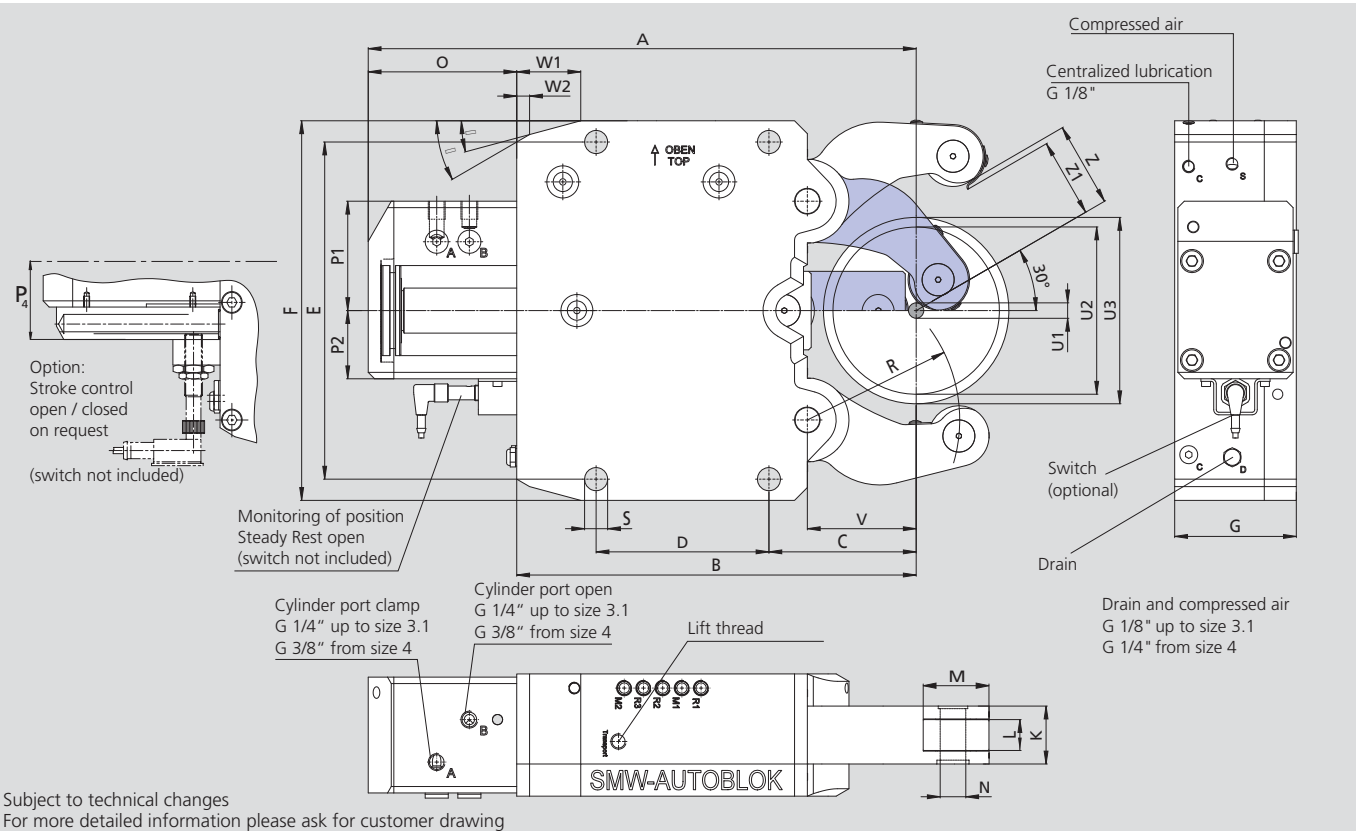
- A perfect bracket is very important for the function/precision of the Steady Rest.
- Fast and easy adjustment can be done with the SMW-AUTOBLOK adjustment device integrated into the bracket.
- SMW-AUTOBLOK supplies the correct bracket for all applications as a turnkey solution.

SLUA®-X

Self-centering Steady Rests
Standard Line

Additional pivoting upper arm for vertical loading

- Sealed body
- Stroke control for end position open (switch not included)



SMW-AUTOBLOK Type		SLUA-X	SLUA-X	SLUA-X	SLUA-X	SLUA-X	SLUA-X
Size		1	2	3	3.1	4	5
Centering range without chip guard	U1	6	8	12	22	30	45
	U2	55	80	130	150	220	268
Vertical loading without chip guard	Z	28	41	66	76	111	135
Max. axial clearing diameter	U3	75	99	158	168	253	295
Centering range with chip guard	U1	8	11	14	20	30	45
	U2	55	80	130	150	220	268
Vertical loading with chip guard	Z1	24	37.3	61.5	71.4	105.9	129.7
	A	214.5	277	428	436	603	697
	B	149	195	312	320	448	510
	C	52	70	115	123	146	178
	D	66	85	135	135	240	270
	E	140	170	262	262	365	400
	F	160	195	295	295	405	440
	G	63	75	95	95	110	145
	K	28	35	45	45	60	75
Width of rollers	L	15	19	25	25	25	29
Diameter of rollers	M	24	35	47	47	52	62
Diameter of roller pins	N	8	15	20	20	25	30
	O	65.5	82	116	116	155	187
	P1	53	63	85	85	91	97
	P2	29	40	53	53	61	63
	P4	40	61	74	74	82	84
	R	55	74	119	124	172	209
	S	11	14	18	18	23	23
	V	37	51	85	93	128	160
	W1	20	30	50	50	58	62
	W2	5	11.2	10	10	18.3	19.1
	α	15°	15°	15°	15°	15°	18°
	β	45°	30°	30°	30°	40°	40°
Piston area*	cm ²	7	19.6	38.5	38.5	63.6	78.5
Operation pressure min./max.	bar	6/70	8/70	8/80	8/80	8/70	8/80
Max. clamping force/roller	daN	165	450	1000	1000	1500	2000
Centering accuracy within the whole range	mm	0.02	0.02	0.04	0.04	0.05	0.06
Repeatability accuracy	mm	0.005	0.005	0.007	0.007	0.007	0.01
Max. roller surface speed	m/min	800	800	725	725	715	600
Weight approx.	kg	8	17	50	51	103	168

* On request cylinder differing from standard available
Subject to technical changes!

SLU-X[®]
SLU-B

SLUA[®]-X
SLUA[®]-B

■ Ordering review

SLU-X Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)*

Steady Rest size		1	2	3	3.1	3.2	4	5	5.1	6
SLU-X-M manual lubrication	Id. No.	127563	129001	129018	129196	129234	129141	129278	129291	-
SLU-X-Z central lubrication oil	Id. No.	127562	129000	129020	129195	129235	129140	129280	129292	-
SLU-X-OLD central lubrication oil & air	Id. No.	127564	129002	129019	129197	129236	129142	129279	129293	-
SLU-X-F central grease lubrication	Id. No.	129761	129762	129763	129764	129765	129766	129767	129768	-

* Stroke control open / closed on request

SLU Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)

Steady Rest size		1	2	3	3.1	3.2	4	5	5.1	6
SLU-B-M manual lubrication	Id. No.	-	-	029865	029866	-	029867	029868	029909	029869
SLU-B-Z central lubrication oil	Id. No.	-	-	029855	029856	123929	029857	029858	029908	029859
SLU-B-Z-OLD central lubrication oil & air	Id. No.	-	-	029875	029876	-	029877	029878	029910	029879

SLUA-X Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)*

Steady Rest size		1	2	3	3.1	3.2	4	5	5.1	6
SLUA-X-M manual lubrication	Id. No.	127569	221744	221761	221771	-	221801	221821	-	-
SLUA-X-Z central lubrication oil	Id. No.	127568	221745	221760	221770	-	221800	221820	-	-
SLUA-X-OLD central lubrication oil & air	Id. No.	127570	221746	221762	221772	-	221802	221822	-	-
SLUA-X-F central grease lubrication	Id. No.	221757	221747	221763	221773	-	221803	221823	-	-

* Stroke control open / closed on request

SLUA-B Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)

Steady Rest size		1	2	3	3.1	3.2	4	5	5.1	6
SLUA-B-M manual lubrication	Id. No.	-	-	029870	029871	-	029872	029873	-	029874
SLUA-B-Z central lubrication oil	Id. No.	-	-	029860	029861	-	029862	029863	-	029864
SLUA-B-Z-OLD central lubrication oil & air	Id. No.	-	-	029880	029881	-	029882	029883	-	029884

- Ordering review
- Accessories and wearing parts

SLU-X[®]
SLU-B

SLUA[®]-X
SLUA[®]-B

Accessories and wearing parts

Type SLU-X, SLU-B, SLUA-X, SLUA-B

◆ denotes wearing parts, recommended stock items

Steady Rest size		1	2	3	3.1	3.2	4	5	5.1	6
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil & air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest) (SLU-B / SLUA-B)		-	026120	018437	018437	018437	018444	018450	018450	026595
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest) (SLU-X / SLUA-X)		-	127237	127240	127240	127240	128474	128584	128584	-
Inductive limit switch		087926	087926	087926	087926	087926	087926	087926	087926	087926
Swarf guard 3-pieces (SLU-B / SLUA-B)	◆	-	026116	026117	026117	026117	026118	026119	026119	026597
Swarf guard 3-pieces (SLU-X / SLUA-X)	◆	126171	026116	026117	026117	026117	026118	026119	026119	-
Roller stripper (2-pieces) for middle piece (SLU-B / SLUA-B)	◆	029795	029796	029797	029797	029797	029798	029799	029799	029800
Roller stripper (2-pieces) for middle piece (SLU-X / SLUA-X)	◆	200155	200154	198950	198950	198950	196199	196200	196200	-
Rollers cylindrical design (SLU-B / SLUA-B)	◆	023122	016952	016951	016951	016951	016953	018345	018345	026594
Rollers cylindrical design (SLU-X / SLUA-X)	◆	-	016952	016951	016951	016951	016953	018345	018345	-
Rollers spherical design (SLU-B / SLUA-B)	◆	-	017658	018433	018433	018433	018443	019545	019545	121302
Rollers spherical design (SLU-X / SLUA-X)	◆	028738	017658	018433	018433	018433	018443	019545	019545	-
Rollers synthetic material	◆	on request	029451	023443	023443	023443	023672	023650	023650	on request
Roller stripper (2-pieces) for middle piece with roller synthetic material (SLU-X / SLUA-X)	◆	-	204211	204212	204212	204212	204213	204215	204215	-
Rollers carbide	◆	on request	129223	129225	129225	129225	220918	222038	222038	on request
Adjustment device 1 set = 3 pieces		-	-	200178	200178	200178	200179	200179	200179	200179

* When placing an order please advise voltage

** On request 110 V available

SLU-X®
SLU-B

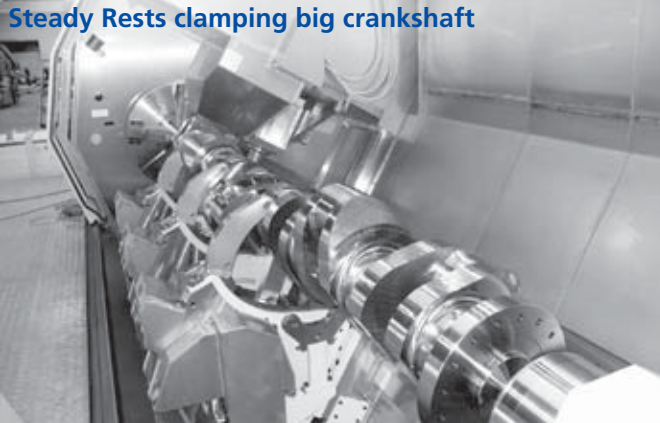
SLUA®-X
SLUA®-B

SR®
SRA

KLU
K

Our additional program:
■ Special Steady Rests
■ Turret Steady Rests
■ Crankshaft Steady Rests
■ Grinding Steady Rests

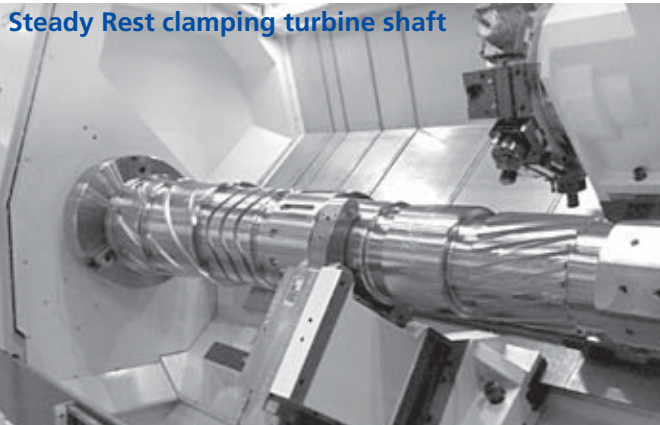
Steady Rests clamping big crankshaft



Steady Rests clamping big crankshaft



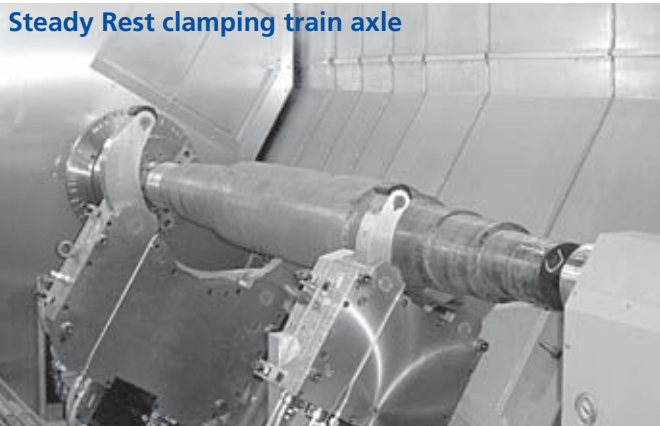
Steady Rest clamping turbine shaft



Steady Rest clamping special shaft



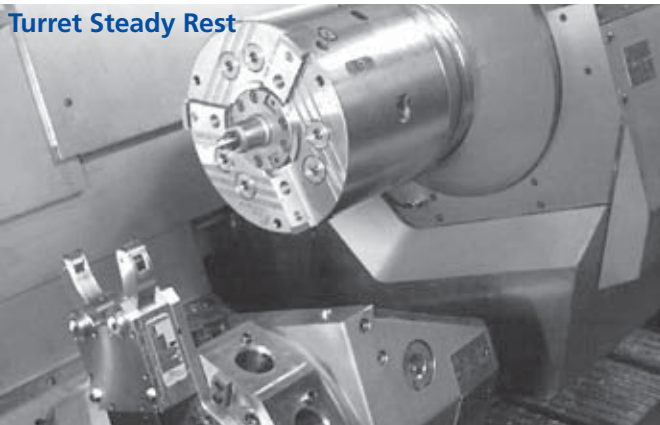
Steady Rest clamping train axle



Steady Rest with diamond pads clamping input shaft in hard turning/grinding operation



Turret Steady Rest



Steady Rest clamping aircraft shaft

