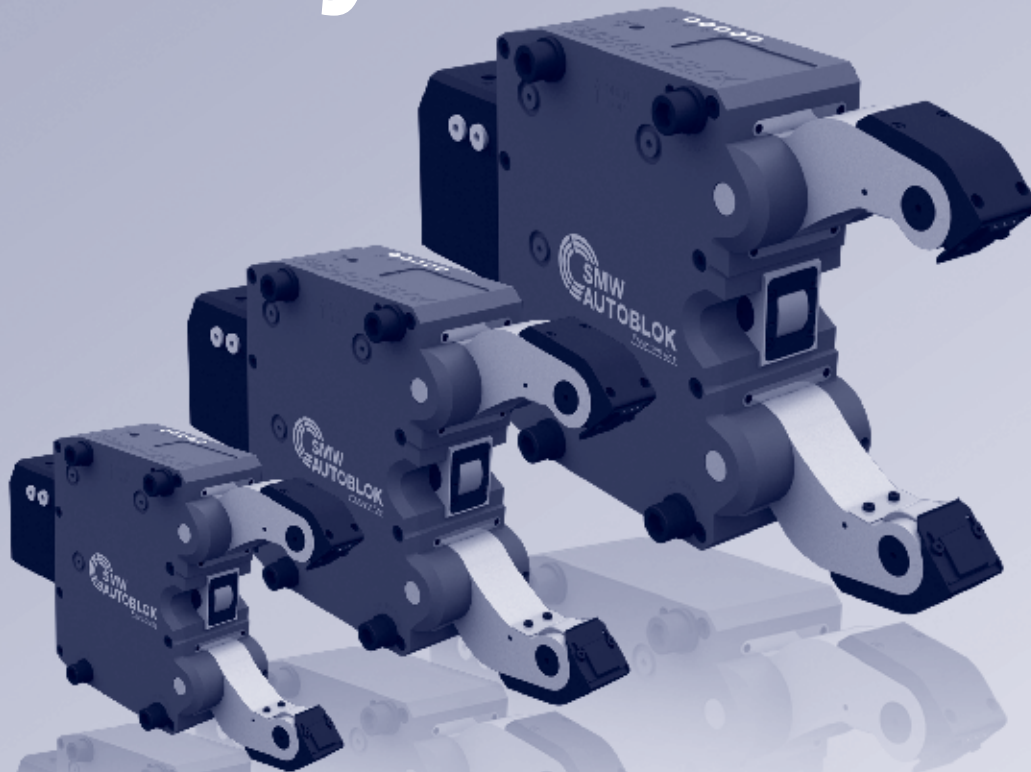


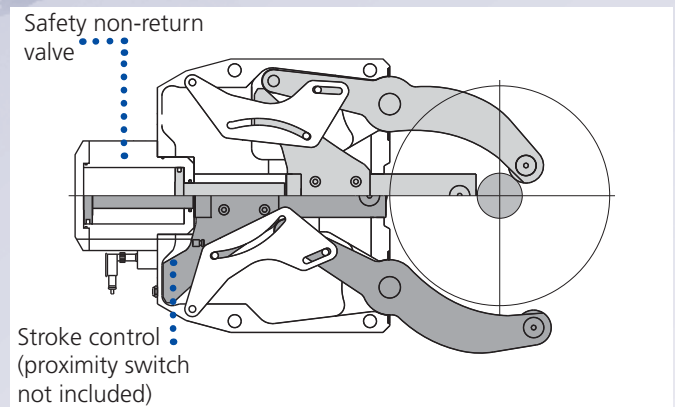
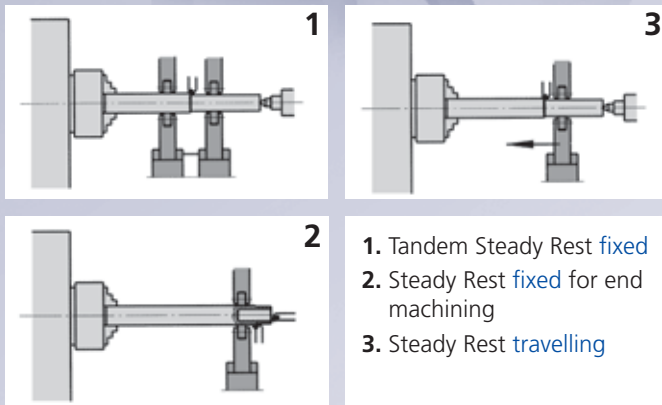
SMW-AUTOBLOK

worldwide leader

in Steady Rests



Fixed or travelling application

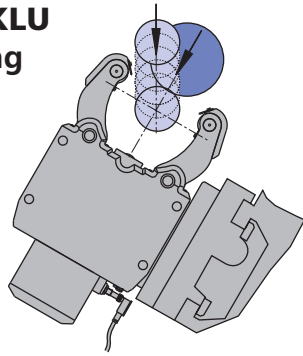


Features included in standard range

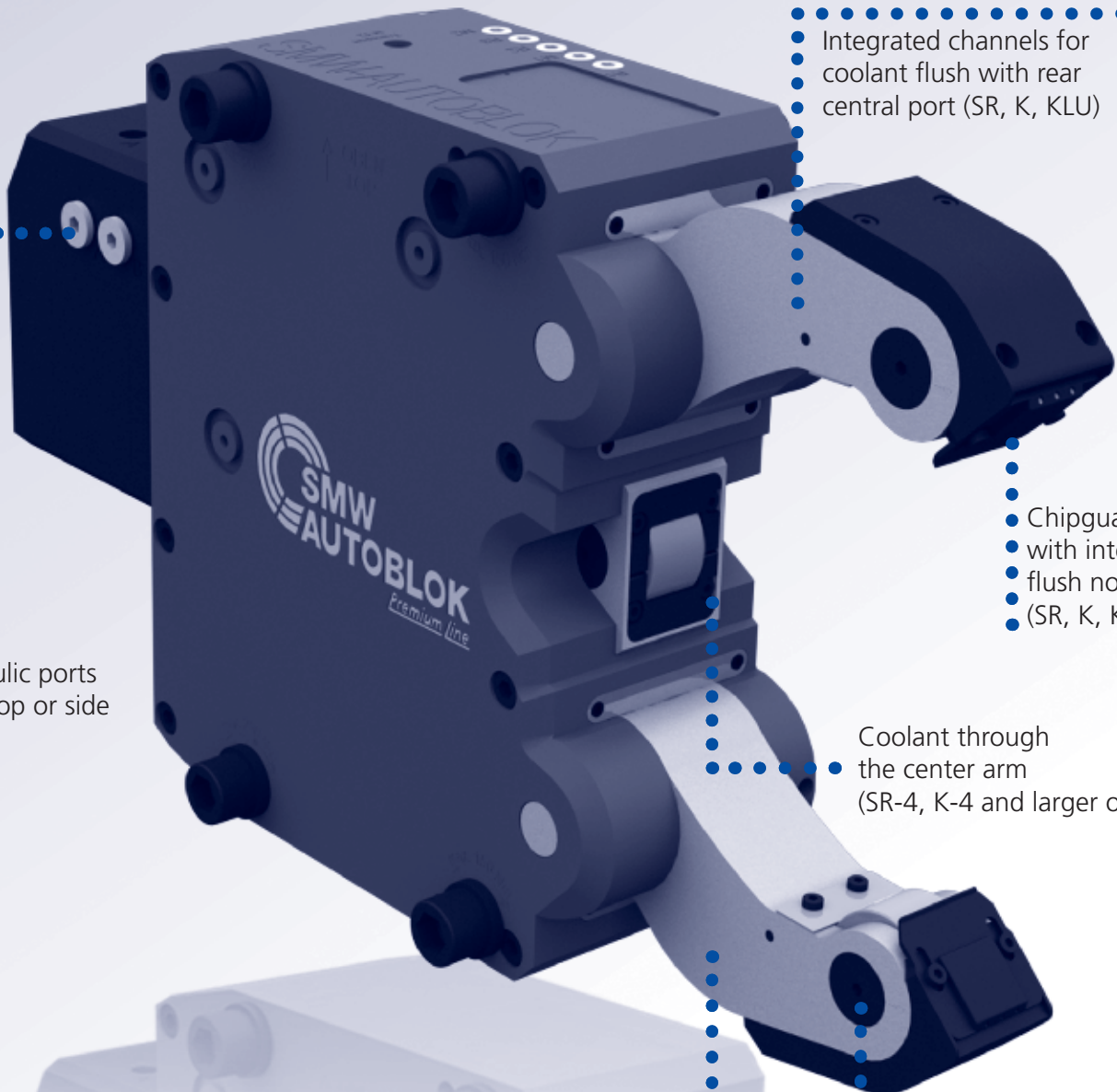
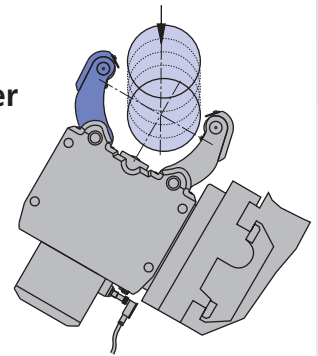
Steady Rest type	Standard Line		Premium Line			
	SLU-X, SLUA-X	SLU-B, SLUA-B	SR	SRA	K, KA	KLU
Steady Rest size	1 - 5.1	3 - 6	1 - 6	2 - 6	3 - 7.1	215 - 540
Sealed body	■		■	■	■	■
Safety valve	■	■	■	■	■	■
Stroke control (open position)	■	■	■	■	■	■
1 set swarf guard 3-piece	■	■				
1 set swarf guard with 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

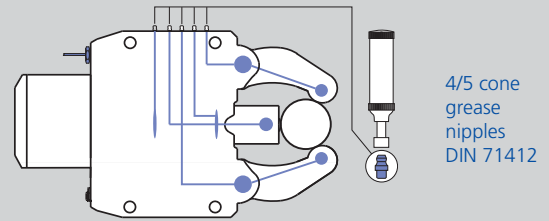
KLU
K

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)



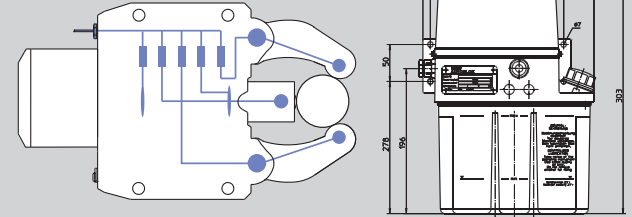
Option of central oil lubrication (Z)

- 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"



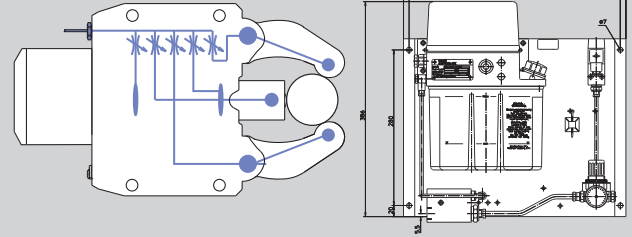
Option of central lubrication oil + air (OLD)

- 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"

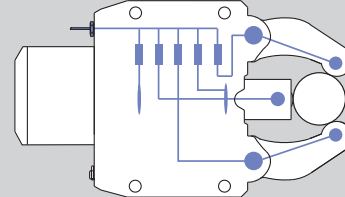


Option of central grease lubrication (F)

- 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)

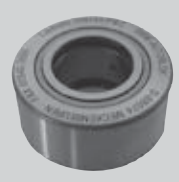
Centralized lubrication G 1/8"



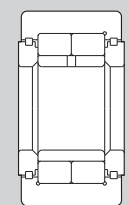
Option of rollers

- 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.

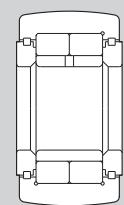
Original SMW-AUTOBLOK roller



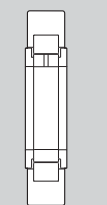
cylindrical



spherical



narrow



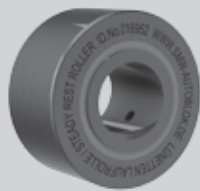
Rollers (all types)

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

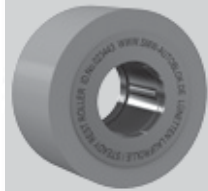
Available optional materials:

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

Rollers steel

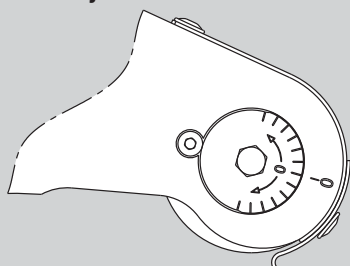


Rollers synthetic material

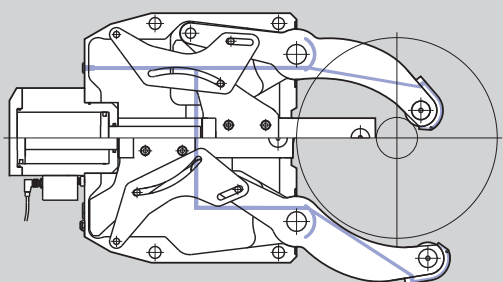


Rollers carbide

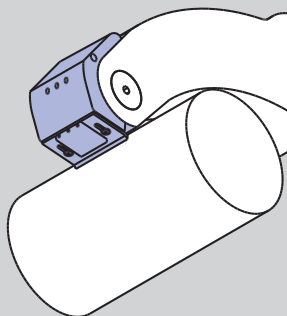


Eccentric fine adjustment**Option fine adjustment of center line**

- 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)**

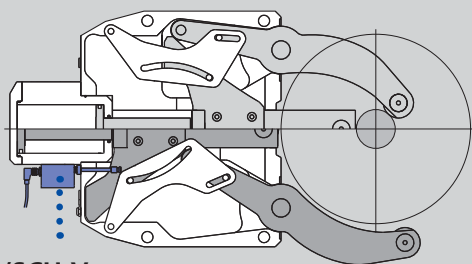
- Built-in channels to feed coolant or air from a central connecting port to the Steady Rest arms.
- Basic equipment for SR/K/KLU steady rests
- From size SR-4 / K4 and larger with coolant through the center arm

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

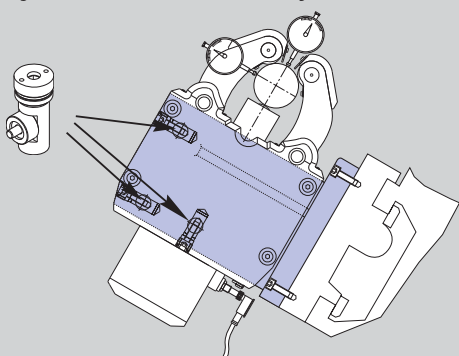
- Keeps roller clamping area free from chips
- The patented double flush nozzles keep front and rear of the wiper area clean.

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

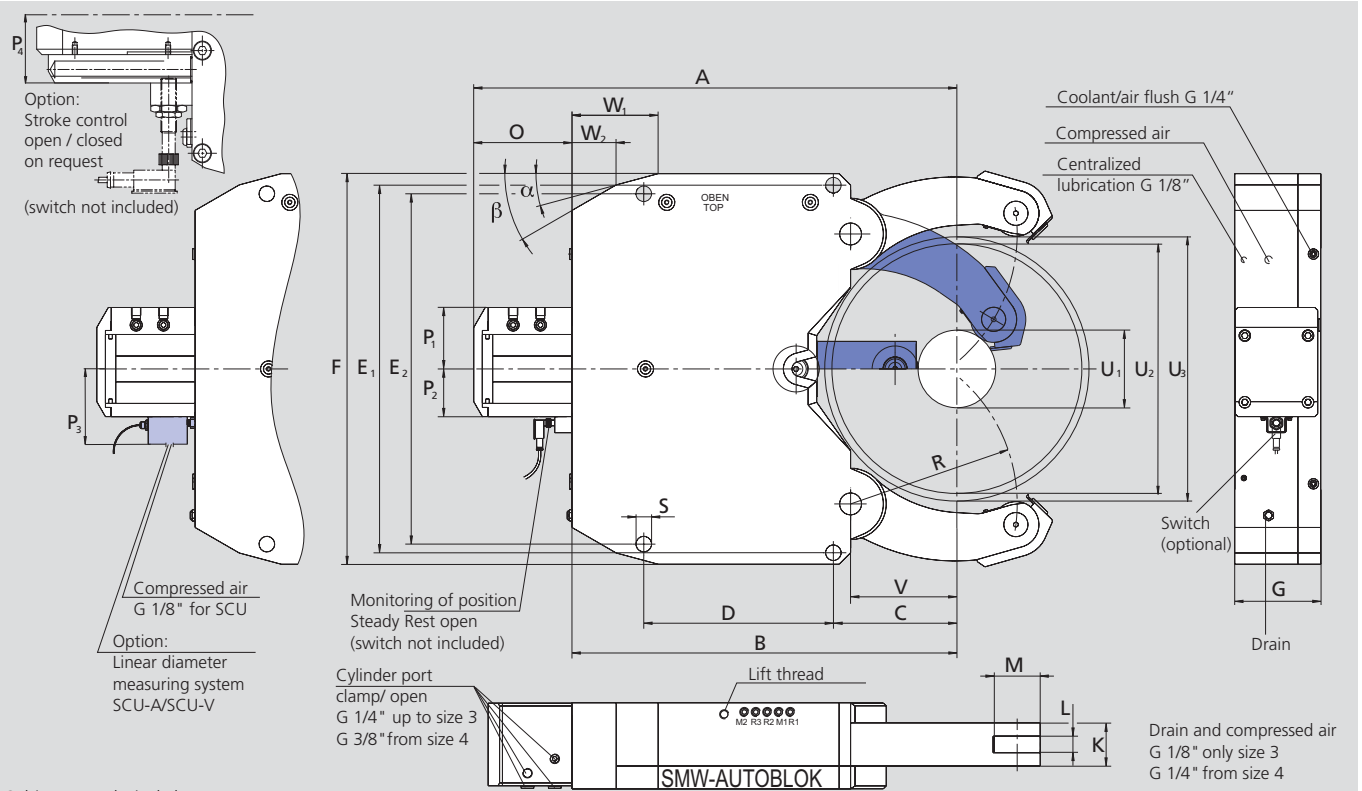
**SCU-A/SCU-V
diameter measuring system****SCU-A/SCU-V****Option linear diameter measuring system
SCU-A/SCU-V**

- 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.

- Sealed body
- Integrated coolant flush
- Stroke control unit or proximity switches



Subject to technical changes
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type		K 3	K 4	K 4.1	K 5	K 5.1	K 6	K 6.1
Centering range with coolant chip guard	U ₁	65	52	90	80	100	135	215
	U ₂	235	280	330	390	410	460	510
Max. axial clearing diameter	U ₃	242	285	331	404	424	464	512
	A	443	582	612	753	763	816	815.5
	B	355	460	490	607	617	670	680
	C	150	168	198	230	240	215	245
	D	140	180	180	240	240	330	300
	E ₁	312	360	360	445	445	640	640
	E ₂	312	360	360	445	445	610	610
	F	345	400	400	485	485	680	680
	G	105	125	125	150	150	150	150
	K	45	60	60	75	75	75	75
Width of rollers	L	25	25	25	29	29	29	29
Diameter of rollers	M	47	52	52	62	62	80	80
	O	88	122	122	146	146	146	135.5
	P ₁	92	91	91	97	97	107	107
	P ₂	62	67	67	73	73	83	83
	P ₃	111	116	116	122	122	132	132
	P ₄	-	91	91	97	97	107	107
	R	155	200	228	265	275	290	310
	S	18	23	23	23	23	27	27
	V	115	140	170	195	205	185	215
	W ₁	50	110	110	130	130	150	155
	α	15°	15°	15°	15°	15°	15°	20°
	W ₂	10	59.8	59.8	50.6	50.6	77	87.1
	β	30°	30°	30°	30°	30°	30°	30°
Piston area*	cm ²	38.5	63	63	78	78	113	113
Operating pressure min./max.	bar	8/80	8/70	8/70	8/80	8/80	8/80	8/80
Max. clamping force/roller	daN	1000	1500	1500	2000	2000	3000	3000
Centering accuracy within the whole range	mm	0.05	0.06	0.06	0.07	0.07	0.07	0.07
Repeatability accuracy	mm	0.007	0.007	0.007	0.01	0.01	0.01	0.01
Max. roller surface speed	m/min	725	715	715	600	600	560	560
Weight approx.	kg	64	114	116	209	209	335	330

* Cylinders differing from standard available on request

- Ordering review
- Accessories and wearing parts

K Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)***

Steady Rest size		3	4	4.1	5	5.1	6	6.1
K-M manual lubrication	Id. No.	127251	129901	129121	127485	127559	127491	127497
K-Z central lubrication	Id. No.	127252	129900	129120	127484	127558	127490	127496
K-OLD central lubrication oil + air	Id. No.	127253	129902	129122	127486	127560	127492	127498
K-F central grease lubrication	Id. No.	220200	129903	129400	221815	221100	on request	on request

K Steady Rest with stroke control via linear stroke control SCU-A, output 4–20 mA














Steady Rest size		3	4	4.1	5	5.1	6	6.1
K-M manual lubrication	Id. No.	127266	221401	221409	124981	124984	124987	124990
K-Z central lubrication	Id. No.	127265	221400	221408	124980	124983	124986	124989
K-OLD central lubrication oil + air	Id. No.	127267	221402	221410	124982	124985	124988	124991
K-F central grease lubrication	Id. No.	on request	221403	221411	on request	on request	on request	on request

K Steady Rest with stroke control via linear stroke control SCU-V, output 1–10 V

Steady Rest size		3	4	4.1	5	5.1	6	6.1
K-M manual lubrication	Id. No.	127269	221405	221413	125120	125123	125126	125129
K-Z central lubrication	Id. No.	127268	221404	221412	125119	125122	125125	125128
K-OLD central lubrication oil + air	Id. No.	127270	221406	221414	125121	125124	125127	125130
K-F central grease lubrication	Id. No.	on request	221407	221415	on request	on request	on request	on request

Type K

◆ denotes wearing parts, recommended stock items

Steady Rest size		3	4	4.1	5	5.1	6	6.1
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		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
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest) manual/central lubrication		127240	128474	128474	125612	125612	124894	124894
Inductive limit switch		087926	087926	087926	087926	087926	087926	087926
Swarf guard coolant/air with wiper		124024	125797	125797	125816	125816	125837	125837
Wiper for swarf guard coolant/air	 ◆	124026	126904	126904	126888	126888	126694	126694
Roller stripper for middle piece	 ◆	198950	200151	200151	196200	196200	196201	196201
Rollers, cylindrical design	 ◆	016951	016953	016953	018345	018345	026594	026594
Rollers spherical design	 ◆	018433	018443	018443	019545	019545	121302	121302
Rollers synthetic material	 ◆	023443	023672	023672	023650	023650	on request	on request
Roller stripper (2-pieces) for middle piece with roller synthetic material	 ◆	204212	204214	204214	204216	204216	-	-
Rollers carbide	 ◆	129225	220918	220918	222038	222038	on request	on request
Adjustment device 1 set = 3 pcs.		200178	200179	200179	200179	200179	200179	200179

* When placing an order, please advise voltage

** On request 110 V available

*** Stroke control open / closed on request

SLU-X®
SLU-B

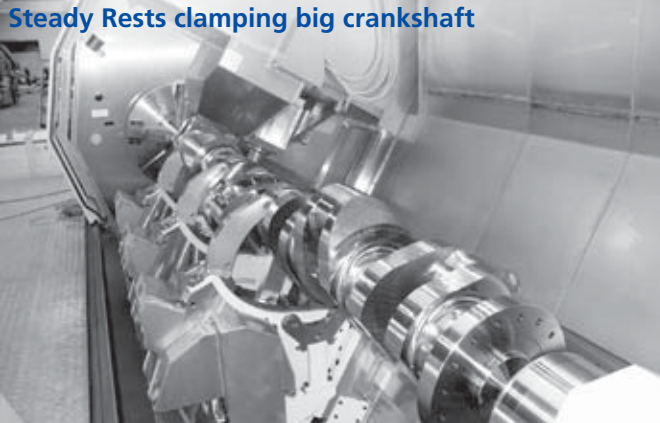
SLUA®-X
SLUA®-B

SR®
SRA

KLU
K

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

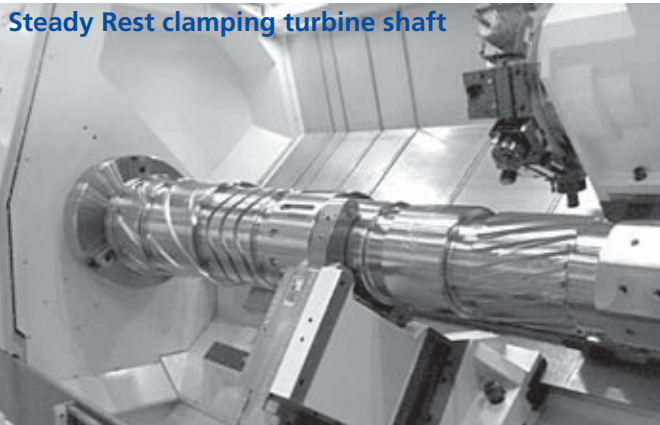
Steady Rests clamping big crankshaft



Steady Rests clamping big crankshaft



Steady Rest clamping turbine shaft



Steady Rest clamping special shaft



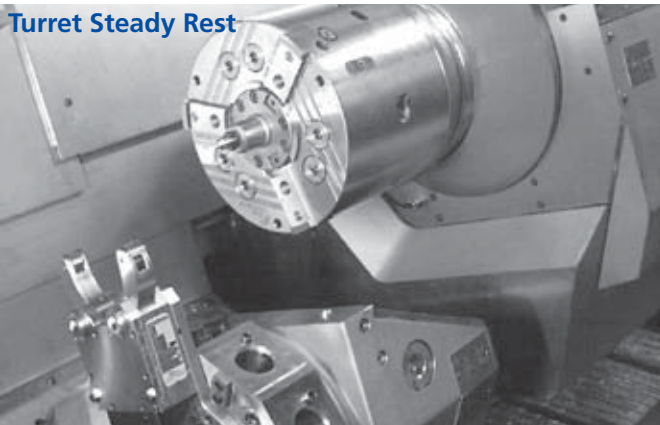
Steady Rest clamping train axle



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



Turret Steady Rest



Steady Rest clamping aircraft shaft

