**Electro-Permanent Magnetic Circular Chuck**

**SAV 244.72**

With concentric pole arrangement

These circular magnets with concentric magnetic poles permit the clamping of several workpieces outside the central region. The strong magnetic field is distributed evenly over the entire surface.

**Nominal holding force:**

- $P = 4.5 \text{ mm}$: $80 \text{ N/cm}^2$
- $P = 9.0 \text{ mm}$: $100 \text{ N/cm}^2$
- $P = 18.0 \text{ mm}$: $110 \text{ N/cm}^2$

Adjustable by control unit with encoded switch

**Nominal operating voltage:**

- $210 \text{ V DC}$ up to $500 \text{ mm}$ diameter
- $360 \text{ V DC}$ above $500 \text{ mm}$ diameter

**Features:**

- Gap free construction of pole plate
- Evenly distributed, strong magnetic field
- Solid constructed pole plate
- Switching off through demagnetizing cycle
- Electro-permanent system, guaranteeing safe operation during power failure
- High precision due to fine grid pole-plate-to-body connection
- Pole separation with brass in-lays for optimal wear behaviour
- Pole plate exchangeable
- Pole plate wearing limit $8 \text{ mm}$
- Sealed to IP 65
- Suitable for use with control unit type 876.10 (see chapter 04)
- Available with adapter flange on request (SAV 248.90 to 248.94, see chapter 06)

**Use:**

- For circular grinding
- Uniform holding force distribution due to concentric pole arrangement; therefore suitable for thin and flat workpieces (e.g. saw blades)
- Multiple workpiece operation on segments possible
- For workpieces with min. thickness $= x$:
  - $2 \text{ mm at } P = 4.5 \text{ mm}$
  - $4 \text{ mm at } P = 9.0 \text{ mm}$
  - $8 \text{ mm at } P = 18.0 \text{ mm}$
- For flat workpieces with min. dimensions $45 \text{ mm} \times 45 \text{ mm}$

**Scope of supply:**

- Lifting bolts for transportation on larger models.
- Terminals for electrical connection in middle of backside in standard execution.
- Optional with integrated slip ring body for the bigger diameters.
**Electro-Permanent Magnetic Circular Chuck**

SAV 244.72

With concentric pole arrangement

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**Ordering example:**

**Ordering key:**

Name  
SAV-No. - A x P - Operating voltage

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**Dimensions in mm**

<table>
<thead>
<tr>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>I</th>
<th>P</th>
<th>Weight in kg</th>
<th>Chuck voltage in Vdc</th>
<th>Control unit max. current in A</th>
<th>Suitable control unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>300</td>
<td>105</td>
<td>160</td>
<td>3</td>
<td>190</td>
<td>M12 (4x)</td>
<td>16</td>
<td>76</td>
<td>16</td>
<td>4.5</td>
<td>52</td>
<td>210</td>
<td>30</td>
<td>876.10</td>
</tr>
<tr>
<td>400</td>
<td>105</td>
<td>210</td>
<td>4</td>
<td>250</td>
<td>M12 (6x)</td>
<td>16</td>
<td>90</td>
<td>21</td>
<td>9</td>
<td>89</td>
<td>210</td>
<td>30</td>
<td>876.10</td>
</tr>
<tr>
<td>500</td>
<td>105</td>
<td>280</td>
<td>4</td>
<td>320</td>
<td>M12 (6x)</td>
<td>16</td>
<td>96</td>
<td>21</td>
<td>9</td>
<td>141</td>
<td>210</td>
<td>30</td>
<td>876.10</td>
</tr>
<tr>
<td>600</td>
<td>105</td>
<td>350</td>
<td>4</td>
<td>390</td>
<td>M12 (6x)</td>
<td>18</td>
<td>80</td>
<td>21</td>
<td>9</td>
<td>204</td>
<td>360</td>
<td>30</td>
<td>876.10</td>
</tr>
<tr>
<td>700</td>
<td>105</td>
<td>400</td>
<td>4</td>
<td>450</td>
<td>M12 (6x)</td>
<td>18</td>
<td>96</td>
<td>21</td>
<td>9</td>
<td>278</td>
<td>360</td>
<td>30</td>
<td>876.10</td>
</tr>
<tr>
<td>800</td>
<td>105</td>
<td>450</td>
<td>4</td>
<td>500</td>
<td>M16 (6x)</td>
<td>18</td>
<td>96</td>
<td>22</td>
<td>9</td>
<td>383</td>
<td>360</td>
<td>30</td>
<td>876.10</td>
</tr>
<tr>
<td>1000</td>
<td>105</td>
<td>550</td>
<td>4</td>
<td>620</td>
<td>M16 (8x)</td>
<td>18</td>
<td>96</td>
<td>22</td>
<td>9</td>
<td>578</td>
<td>360</td>
<td>60</td>
<td>876.10</td>
</tr>
</tbody>
</table>

| 400 | 105 | 210 | 4 | 250 | M12 (6x) | 16 | 92 | 21 | 18 | 990 | 360 | 60 x 2 | 876.10 |
| 500 | 105 | 280 | 4 | 320 | M12 (6x) | 16 | 92 | 21 | 18 | 1350 | 360 | 60 x 2 | 876.10 |
| 600 | 105 | 350 | 4 | 390 | M12 (6x) | 18 | 70 | 21 | 18 | 204 | 360 | 30 | 876.10 |
| 700 | 105 | 400 | 4 | 450 | M12 (6x) | 18 | 92 | 21 | 18 | 278 | 360 | 30 | 876.10 |
| 800 | 105 | 450 | 4 | 500 | M16 (6x) | 18 | 92 | 22 | 18 | 383 | 360 | 30 | 876.10 |
| 1000 | 105 | 550 | 4 | 620 | M16 (8x) | 18 | 92 | 22 | 18 | 578 | 360 | 60 | 876.10 |

| 1200 | 125 | Rear detail as required | 22 | 80 | 23 | 9 | 990 | 360 | 60 x 2 | 876.10 |
| 1400 | 125 | Rear detail as required | 22 | 166 | 26 | 9 | 1350 | 360 | 60 x 2 | 876.10 |
| 1500 | 125 | Rear detail as required | 22 | 166 | 26 | 9 | 1550 | 360 | 60 x 2 | 876.10 |
| 1600 | 125 | Rear detail as required | 22 | 166 | 26 | 9 | 1765 | 360 | 60 x 2 | 876.10 |

Larger sizes on request. Please refer to SAV 876.03 to SAV 876.10 (see chapter 04), for details regarding suitable control units, based on the power rating.

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Chapter 3 | 73