

## ELECTRO-PERMANENT MAGNETIC CIRCULAR CHUCK



SAV 244.71

Enhanced magnetic system with radial pole arrangement and exceptional holding force

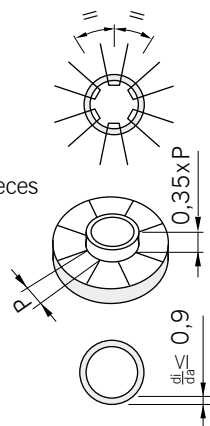
This new design of circular magnet, using high-energy magnetic materials, provides extremely high holding forces. Magnetization and demagnetization through a short electric direct current pulse. The homogeneous nature and precision of this circular magnet makes it suitable for turning hardened steels as well as general heavy cutting.



### Use:

Turning of hardened steel and heavy cutting of small to large workpieces. Also for highest precision grinding.

- for turning and hard turning
- equal pole pitch within circle range; therefore very suitable for circular and ring-shaped workpieces
- the minimum workpiece height is 35% of the pole pitch at the given circle segment
- also for thin rings



### Nominal holding force:

170 N/cm<sup>2</sup>, adjustable by control unit with encoded switch.

### Nominal operating voltage:

360 V

### Features:

- evenly distributed strong magnetic field
- solid constructed pole plate
- switching off through demagnetizing cycle

- electro-permanent magnetic 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
- radial pole arrangement, especially suitable for the use of pole raisers. This is absolutely essential for the runout of the tool or the grinding wheel at three side operation. Therefore available with T-slots (T) according DIN 650-10H10 on request.
- pole plate wearing limit 8mm
- sealed to IP 65
- suitable for use with control unit type 876.10
- available with adapter flange on request (SAV 248.90 to 248.94, see chapter 01)

### Scope of supply:

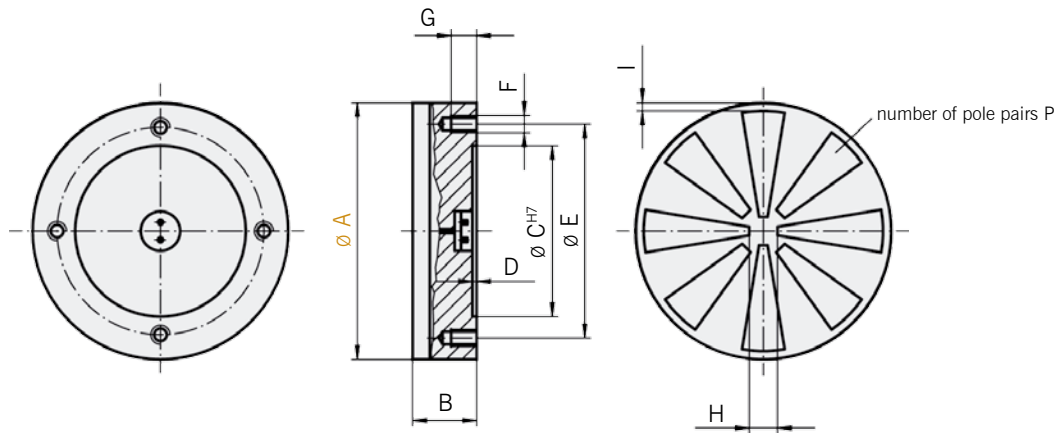
- Lifting bolts for transportation on larger models.
- T-slots and pole extensions not included as standard.
- Terminals for electrical connection in middle of back side in standard execution.
- Optional with integrated slip ring body for the bigger diameters.
- With industrial watertight plug-in type connector on request.



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Dimensions in mm										Weight in kg	Chuck voltage in V	Type of control	
A	B <sup>0*</sup>	C	D	E	F	G	H	I	P				
200	100	110	3	140	M10 (4x)	14	45	10	4	24,0	360	EP 1	
250	100	140	3	170	M12 (4x)	16	45	10	4	39,0	360	EP 1	
300	100	160	3	190	M12 (4x)	16	60	10	6	54,0	360	EP 1	
400	100	210	4	250	M12 (6x)	16	70	15	6	85,0	360	EP 1	
500	110	280	4	320	M12 (6x)	16	100	15	8	150,0	360	EP 1	
600	110	350	4	390	M16 (6x)	18	100	15	8	210,0	360	EP 1	
700	110	400	4	450	M16 (6x)	18	120	15	8	280,0	360	EP 1	
800	110	450	4	500	M16 (6x)	18	150	18	12	380,0	360	EP 1	
1000	125	550	4	620	M16 (8x)	18	200	18	12	680,0	360	EP 2	
1200	125			Rear detail as required				300	25	18	975,0	360	EP 3
1400	135			Rear detail as required				300	25	18	1600,0	360	EP 3
1500	135			Rear detail as required				300	25	18	1850,0	360	EP 3
1600	135			Rear detail as required				300	25	18	2105,0	360	EP 3

Bigger sizes up to A = 5,5 m available on request. Please refer to SAV 876.10, for details regarding suitable control units, based on the power rating.

\* For execution with T-slots, the height increases with 10 mm.

## Industrial plug with quick-lock action

optional at a surcharge

Easy to use plug connection



## Recommended controller and control unit:

Typ	Control unit	Hand-held control unit
EP 2	SAV 876.12-S-O-360/30/400	SAV 876.02-SE3
EP 3	SAV 876.12-S-O-360/60/400	SAV 876.02-SE3
EP 5	SAV 876.12-S-O-360/60x2/400	SAV 876.02-SE3

For built-in or combination control unit see page 88.

## Ordering example:

Electro permanent magnetic circular chuck SAV 244.71 - 1600 - T - 360 V  
 Ordering key SAV - No. - A - Execution - Nom. voltage

## Ordering example control unit:

Electronic polarity-reversing control unit SAV 876.12 - S-O-360/60x2/400  
 Hand-held control unit SAV 876.02 - SE3  
 Ordering key SAV - No.