

The electro magnetic circular chucks feature high holding forces. Radial T-slots can be machined into the pole plate for universal use or for use of pole shoes.



DESIGN

- Solid pole plate
- The radial pole positioning is particularly suitable for using pole shoes. This prerequisite is absolutely required for the runout of the tool or the grinding wheel in case of 3-sides machining. Version with T-slot (T) as per DIN 650-10^{H10} are available for this.
- 8 mm wear layer on the pole plate
- Protection rating IP 65
- 100 % duty cycle
- Suitable for connecting to the SAV 876.10 control unit
- Available with flange on request (see SAV 248.90 to 248.94).

RATED HOLDING FORCE

120 N/cm², controllable with control unit using holding force coding switch

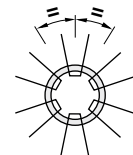
RATED VOLTAGE, RECOMMENDED

24 V DC up to and including 90 W power
110 V DC for all other sizes

APPLICATION

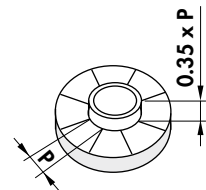
For grinding of cylindrical and ring-shaped workpieces on carousel-type internal and external grinding machines. Also suitable for turning with shape and position tolerances of 0.01 to 0.02 mm.

- Same pole pitch on the circumference, therefore suitable for ring-shaped workpieces

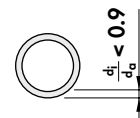


- For workpieces up to min. width equivalent to 35 % pole pitch on the pitch circle diameter

$$P = \frac{\pi}{4} \cdot \frac{d_i + d_a}{P_p} ; B_{WKPC} > 0.35 \times P$$

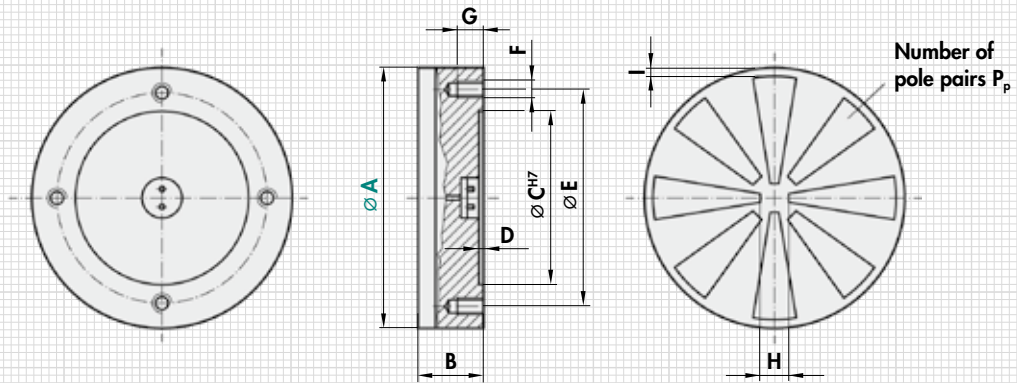


- Also for thin rings



SCOPE OF DELIVERY

- Larger round magnets are provided with threads for transport
- Standard version without T-slots and pole shoes
- Standard electrical connection centrally on the rear side using terminals
- Optionally available with integrated flat slip ring assembly for diameters from 1000 mm
- Control and hand remote unit not in the scope of delivery



mm									Pair	W	kg	Type	
A	B ⁰⁻¹	C	D	E	F	G	H	I	P _p	Power	Weight	Control	
100	90	60	3	80	M8 (3x)	12	30	10	3	16	4.0	E 1	
150	90	90	3	120	M10 (3x)	14	30	10	3	30	9.0	E 1	
200	90	110	3	140	M10 (4x)	14	40	10	4	48	18.0	E 1	
250	90	140	3	170	M12 (4x)	16	50	10	4	66	29.0	E 1	
300	90	160	3	190	M12 (4x)	16	60	10	6	90	42.0	E 1	
400	90	210	4	250	M12 (6x)	16	70	15	6	150	76.0	E 4	
500	90	280	4	320	M12 (6x)	16	100	15	8	190	120.0	E 4	
600	100	350	4	390	M16 (6x)	18	100	15	8	265	195.0	E 4	
700	100	400	4	450	M16 (6x)	18	120	15	8	350	265.0	E 4	
800	100	450	4	500	M16 (6x)	18	150	18	12	440	365.0	E 4	
1000	100	550	4	620	M16 (8x)	18	200	18	12	660	550.0	E 4	
1200	110		Rear side upon agreement					300	25	18	960	990.0	E 5
1400	110		Rear side upon agreement					300	25	18	1100	1350.0	E 5
1500	120		Rear side upon agreement					300	25	18	1440	1550.0	E 5
1600	120		Rear side upon agreement					300	25	18	1630	1760.0	E 5

* On versions with T-slots, the height increases by 10 mm

Larger diameters, e.g. 5.5 m, available on request.

RECOMMENDED CONTROL AND CONTROL UNIT

Type	Control	Hand remote unit
E 1	SAV 876.10-S-T-24/7/230	SAV 876.02-SE3
E 4	SAV 876.10-S-O-110/6/230	SAV 876.02-SE3
E 5	SAV 876.10-S-O-110/16/230	SAV 876.02-SE3

Installation control units as per page 34.

ORDERING EXAMPLE

Designation SAV no. - A - version - rated voltage
 Electro magnetic circular chuck SAV 244.40 - 800 - T - 110 V