

**SAV 242.90**

**PERMANENT MAGNETIC VERTICAL CHUCKS**

With fine transverse pole pitch  $P = 1.9 \text{ mm}$ , for horizontal machining



**APPLICATION**

Primarily for horizontal machining of workpieces.

**DESIGN**

Upright chuck made of St 52-3. Supplied with permanent magnetic chuck SAV 243.01. Pole divisions made of 0.5 mm brass/1.4 mm steel. The upright chuck can also be manufactured with other controllable permanent magnetic, electromagnet or electro permanent magnetic chucks. Clamping grooves (N).

**TECHNICAL DATA**

- Parallelism and angularity: 0.005/100 mm
- Rated holding force: 90 N/cm<sup>2</sup>
- Magnetic field height: 6 mm
- Wear layer of the pole plate: 8 mm



mm					kg
A	B	C	D	E	Weight
250	150	190	30	156	38.0
350	150	190	30	156	52.0
400	200	240	30	175	75.0
500	200	240	30	175	93.5

**ORDERING EXAMPLE**

Designation	SAV no. - A
Permanent magnetic vertical chuck	SAV 242.90 - 500

**SAV 242.91**

**PERMANENT MAGNETIC CHUCK TOWERS**

Chuck towers, precision-milled



**APPLICATION**

For horizontal milling and drilling processes.

**DESIGN**

Chuck tower made of St 52-3, precision-milled. With 4 permanent magnetic chucks SAV 243.11, amplified high-energy system, 15 mm pole pitch, fastening holes as required.

**TECHNICAL DATA**

- Perpendicularity: 0.03/1000 mm
- Parallelism: 0.04/1000 mm
- Rated holding force: 150 N/cm<sup>2</sup>
- Magnetic field height: 12 mm
- Wear layer of the pole plate: 5 mm



mm						kg
A	B	C	D	E	F	Weight
300	150	415	320	200	455	183.0
500	200	620	400	256	660	395.0
600	300	660	500	356	700	616.0

**ORDERING EXAMPLE**

Designation	SAV no. - A x B
Permanent magnetic chuck tower	SAV 242.91 - 600 x 300