

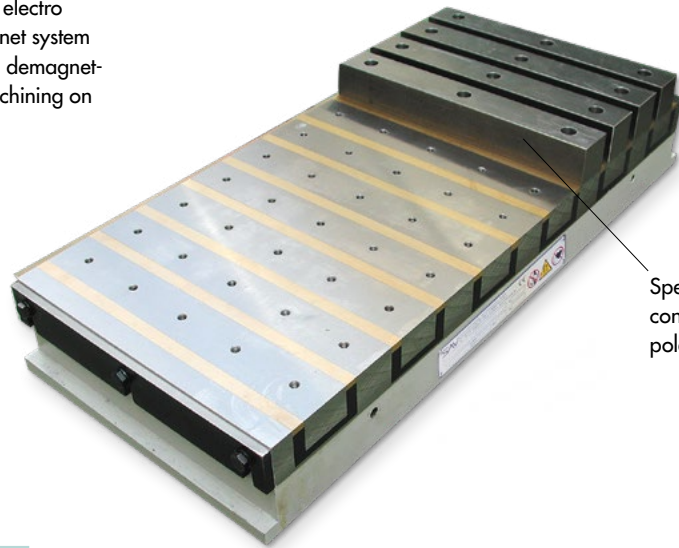
SAV 243.77

ELECTRO PERMANENT MAGNETIC CHUCKS

With transverse pole pitch $P = 27.5, 55, 85$ mm



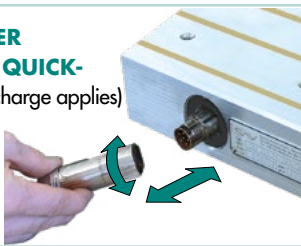
Milling magnet with holding forces in the high-end range. The workholding system with NdFeB high-energy magnets was optimised to the state of the art in magnet technology. The electro permanent magnetic switching of the AlNiCo/NdFeB magnet system generates extremely high holding forces. Magnetising and demagnetising are achieved with short current pulses. For heavy machining on non-hardened and low alloy workpieces.



Special design with continuous transverse pole bars

HEAVY-DUTY POWER CONNECTOR WITH QUICK-RELEASE Optional (surcharge applies)

Easy handling of the plug-in connection



DESIGN

- Optimised high-energy magnet system
- Holding forces in the physically possible maximum range
- The magnet system with great depth action bridges even larger air gaps
- Complete surface magnetically active, no "dead zones"
- 8 mm wear layer on the pole plate
- Solid monoblock design
- "True" N/S pole spacing
- Electro permanent magnetic system for absolute safety in case of power failure
- Pole gap with brass, wear-protected
- Optionally with tapped hole drilling template (M) for any top tooling
- Pole pitch 85 mm can optionally also be supplied with T-slots (T) as per DIN 650-10H10

RATED HOLDING FORCE

195 N/cm² on inducible steel surface
 110 N/cm² with $P = 27.5$ mm pole pitch
 150 N/cm² with $P = 55$ mm pole pitch
 170 N/cm² with $P = 85$ mm pole pitch
 controllable with control unit using holding force coding switch

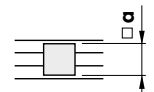
RATED VOLTAGE, RECOMMENDED

360 V IMP

APPLICATION

For heavy milling with high level of material removal. Ideal for use on pallet changing systems.

- For workpieces up to min. thickness x :
 8 mm with $P = 27.5$ mm
 18 mm with $P = 55$ mm
 38 mm with $P = 85$ mm
- For flat workpieces min. a :
 45 mm x 45 mm with $P = 27.5$ mm
 95 mm x 95 mm with $P = 55$ mm
 150 mm x 150 mm with $P = 85$ mm



SCOPE OF DELIVERY

- 3 m connecting cable on right short side, rear
- On request with water-tight heavy-duty power connector
- Larger magnetic chucks are provided with lifting lugs for transport
- Control and hand remote unit not in the scope of delivery
- Clamps

SAV 243.77 - 27.5

Narrow pole pitch

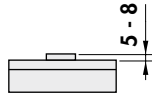
RATED HOLDING FORCE

110 N/cm²

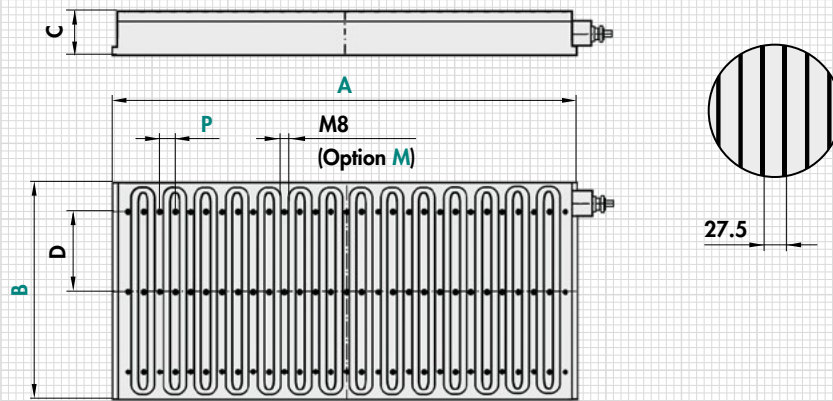
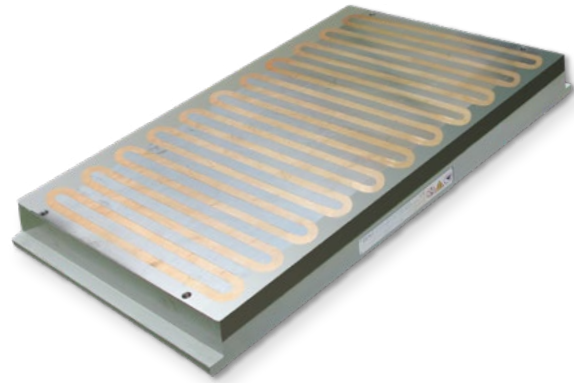
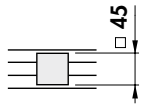
APPLICATION

Milling of thin plates

- For workpieces:
Min. thickness = 5 – 8 mm



- For workpieces:
Min. size = 45 x 45 mm



mm					daN	Qty.			kg	A
A	B	C ₋₁ ⁰	D	P	Rated holding force fully applied	Number of threads per pole row M	Number of pole rows M	Number of threads version M	Weight	Control max. pul. Current
410	200	80	100	27.5	9,020	2	15	30	46.0	30
520	200	80	100	27.5	11,440	2	19	38	58.0	30
630	200	80	100	27.5	13,860	2	23	46	71.0	30
520	300	80	100	27.5	17,160	3	19	57	87.0	60
630	300	80	100	27.5	20,790	3	23	69	107.0	60
800	300	80	100	27.5	26,400	3	29	87	135.0	60
630	400	80	150	27.5	27,720	3	23	69	143.0	60x2
800	400	80	150	27.5	35,200	3	29	87	180.0	60x2
1015	400	80	150	27.5	44,660	3	37	111	228.0	60x2
800	500	80	200	27.5	44,000	3	29	87	225.0	60x2
1015	500	80	200	27.5	55,825	3	37	111	285.0	60x2
1180	500	80	200	27.5	64,300	3	43	129	331.0	60x3

ORDERING EXAMPLE

Designation SAV no. - A x B - pole pitch - rated voltage - option
 Electro permanent magnetic chuck SAV 243.77 - 1180 x 500 - 27,5 - 360 V - M

SAV 243.77 - 55

Universal pole pitch

RATED HOLDING FORCE

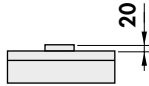
150 N/cm²

APPLICATION

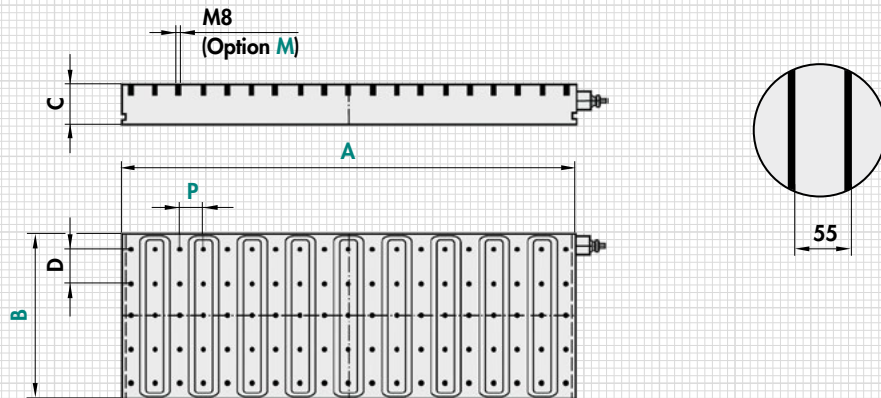
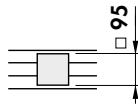
For heavy milling.



- For workpieces:
Min. thickness = 20 mm



- For workpieces:
Min. size = 95 x 95 mm



mm					daN	Qty.			kg	A
A	B	C ⁰ ₋₁	D	P	Rated holding force fully applied	Number of threads per pole row M	Number of pole rows M	Number of threads version M	Weight	Control max. pul. Current
480	300	97	60	55	21,600	4	9	36	94.0	30
590	300	97	60	55	26,550	4	11	44	116.0	30
810	300	97	60	55	36,450	4	15	60	159.0	30
1030	300	97	60	55	46,350	4	19	76	202.0	30
1140	300	97	60	55	51,300	4	23	92	224.0	60
810	400	97	80	55	48,600	5	15	75	212.0	30
1030	400	97	80	55	61,800	5	19	95	270.0	60
1140	400	97	80	55	68,400	5	23	115	299.0	60
1580	400	97	80	55	94,900	5	29	145	414.0	60
2020	400	97	80	55	121,200	5	37	185	529.0	60x2
1030	500	97	70	55	77,250	7	19	133	337.0	60
1140	500	97	70	55	85,500	7	23	161	373.0	60
1580	500	97	70	55	118,500	7	29	203	517.0	60x2
2020	500	97	70	55	151,500	7	37	259	661.0	60x2

ORDERING EXAMPLE

Designation SAV no. - A x B - P - rated voltage - option
 Electro permanent magnetic chuck SAV 243.77 - 1580 x 500 - 55 - 360 V - M

SAV 243.77 - 85

Large transverse pole pitch

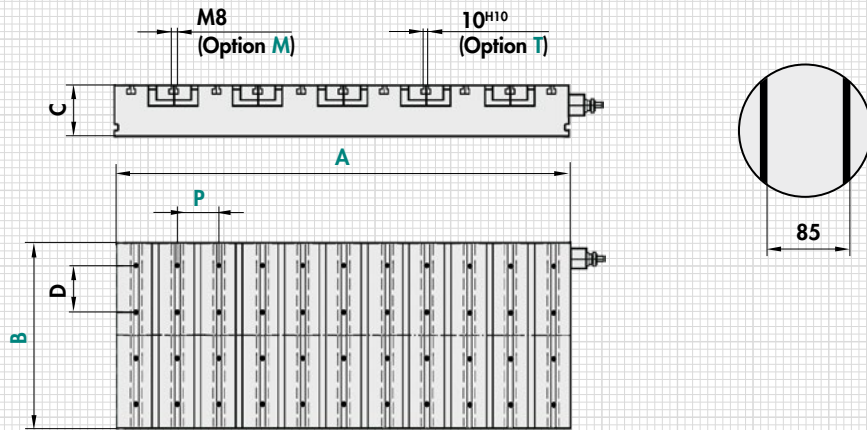
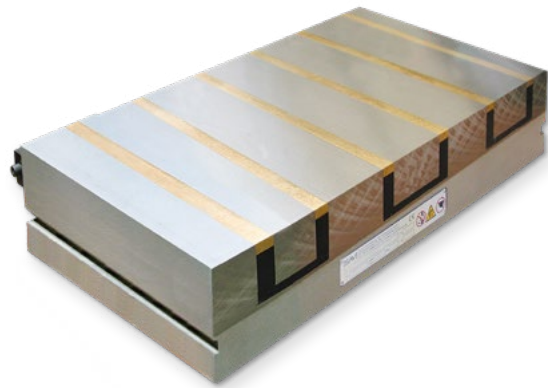
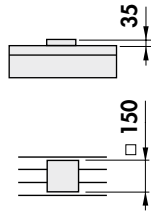
RATED HOLDING FORCE

170 N/cm²

APPLICATION

For heavy milling of very large and heavy workpieces. For large air gaps.

- For workpieces:
Min. thickness = 35 mm
- For workpieces:
Min. size = 150 x 150 mm



mm					daN	Qty.			kg	A
A	B	C ₁ ⁰	D	P	Rated holding force fully applied	Number of threads per pole row M	Number of pole rows M	Number of threads version M	Weight	Control max. pul. Current
580	300	110	90	85	29,500	3	7	21	129.0	30
750	300	110	90	85	38,250	3	9	27	167.0	30
750	400	100	90	85	51,000	4	9	36	203.0	60
1090	400	100	90	85	74,120	4	13	52	294.0	60
1430	400	100	90	85	97,240	4	17	68	386.0	60
1600	400	100	90	85	108,800	4	19	76	432.0	60
750	500	110	90	85	63,750	5	9	45	278.0	60
1090	500	110	90	85	92,650	5	13	65	405.0	60
1430	500	110	90	85	121,550	5	17	85	531.0	60
1600	500	110	90	85	136,000	5	19	95	594.0	60x2
1090	600	110	90	85	111,180	6	13	78	486.0	60
1430	600	110	90	85	145,860	6	17	102	637.0	60x2
1600	600	110	90	85	163,200	6	19	114	713.0	60x2

ORDERING EXAMPLE

Designation SAV no. - A x B - P - rated voltage - option
 Electro permanent magnetic chuck SAV 243.77 - 1600 x 600 - 85 - 360 V - T