

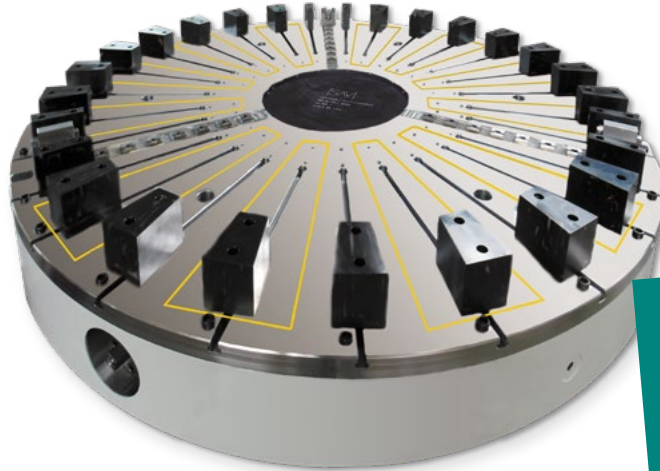
SAV 244.76

COMBINED CIRCULAR CHUCKS

Radial pole pitch and integrated jaw chuck



Combination of magnetic and mechanical workholding



The innovative combination of magnetic workholding with a centring chuck – a complete system solution from a single source

ADVANTAGES

- Reproducible centring
- Reliable process
- Option for combining first and second chucking
- Compact design (height from 170 mm)

DESIGN OF MAGNET SYSTEM

- Combination/hybrid magnet chuck type SAV 224.76 with electro permanent magnetic principle, magnet system with amplified design, holding forces on inducible area up to 170 N/cm²
- Full metal pole plate with brass insulation and T-slots as per DIN 650-10^{H10} for mounting fixed and movable pole raisers
- 8 mm wear layer on the pole plate, can be replaced after many years of use and wear
- On request with heavy-duty power connector integrated into the circumference and as a quick-release coupling

RATED HOLDING FORCE

170 N/cm², controllable with control unit

RATED VOLTAGE, RECOMMENDED

360 V IMP

DESIGN EXAMPLE FOR CENTRING CHUCK

- Power chuck SAV 260.20
- Centring accuracy of the chuck: 0.02 mm, centring range from: 450 – 1200 mm, magnetic chucking range from: 500 – 1100 mm
- Chuck equipped with brushed long-size base jaws, a chucking range of 500 – 1200 mm can be centred without gaps
- Holding force of the chuck: 180 kN at 210 Nm
- Travel per jaw: 9.6 mm
- Actuation of the jaw unlocking on the centring chuck with a control rod
- Spindle with precision bearing and sealing

SPECIAL FEATURE

- Resistant to emulsions as per IP 65
- Can be controlled with machine spindle using rotary transmitter
- Control with demagnetising cycle and eight holding force levels for pre-selection
- System with potential-free switching to the enable signals, complete integration into the machine controller possible; plug-in version with parking station for connector check and enable

mm	Pair	Qty.	mm	kg	A	
Diameter	Pole pairs	No. of jaws	Height	Active diameter	Weight	Control max. pul. Current
500	6	3	170	250 - 464	260.0	30
600	9	3	170	300 - 564	378.0	30
800	9	3	170	300 - 764	670.0	30
1000	12	6	180	450 - 950	1100.0	60
1200	12	6	180	450 - 1150	1600.0	60x2
1400	12	6	180	450 - 1350	2180.0	60x2
1600	12	6	180	500 - 1430	3160.0	60x2
1800	18	6	180	600 - 1750	4000.0	60x2

Other designs upon request, force actuation possible upon clarification of spindle integration.

ORDERING EXAMPLE

Designation SAV no. - diameter x pole pairs - no. of jaws - magnet voltage
 Combined circular chuck SAV 244.76 - 1800 x 18 - 6 - 360 V