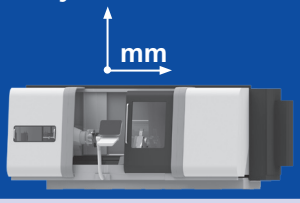
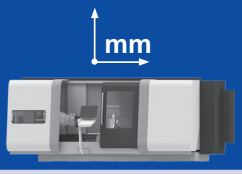
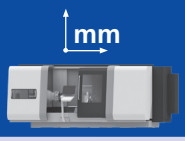
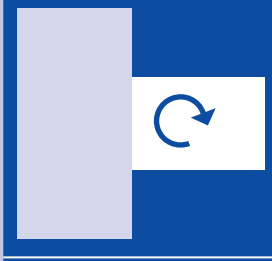
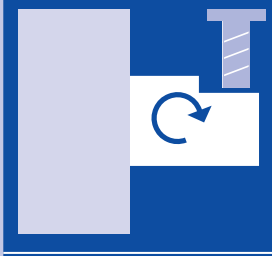
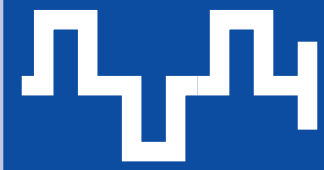
SMW AUTOBLOK

SELF-CENTERING STEADY RESTS

for turning, milling and grinding

www.smw-autoblok.de

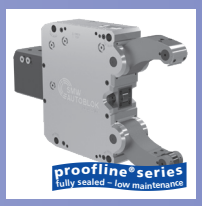
A Steady Rest for every machine and application

Large clamping range in machine with... / Steady Rest characteristics	... unrestricted mounting space for the steady rest. 	... restricted mounting space for the steady rest. 	... very restricted mounting space for the steady rest. 
Turning 	■ SLU-X ■ SLU	□ SLU-X ■ SLUB □ SLU ■ K □ RX	□ SLUB □ K ■ RX
Turning and milling 	□ SLU-X □ SLU ■ SR | SR-CL	□ SLU-X □ SLUB □ SR | SR-CL ■ K □ RX	□ SLUB □ K ■ RX
Cam and crankshaft 	■ KLU	□ KLU	
Heavy duty	■ SR | SR-CL □ K □ KA	□ SR | SR-CL □ K ■ KA	
Grinding	■ SRG □ SRG-B	□ SRG ■ SRG-B	□ SRG-B

This matrix is a recommendation only. It may vary for special applications.

■ first choice □ second choice

Self-centering Steady Rests for turning and grinding

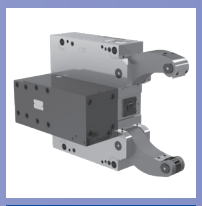


Page 4

SLU-X®

Self-centering Steady Rest
Standard Line

- Fully sealed body
- Monitoring Steady Rest open via proximity switch
- Special sizes on request



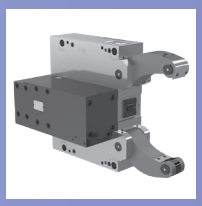
Page 10

SLUB

Self-centering Steady Rest
Standard Line

Extra compact with side mounted cylinder

- Monitoring open/closed via proximity switch
- Special sizes on request



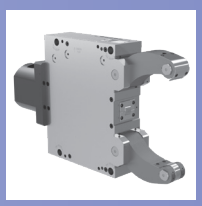
Page 12

SLUB-A

Self-centering Steady Rest
Standard Line

Extra compact with side mounted cylinder and additional pivoting upper arm for automatic vertical loading

- Monitoring open/closed via proximity switch
- Special sizes on request

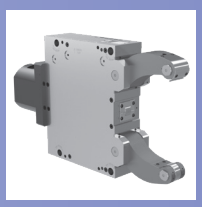


Page 14

SLU

Self-centering Steady Rest
Basic Line

- Large clamping range
- Monitoring open/closed via proximity switch
- Hardened arms



Page 16

SLU-A

Self-centering Steady Rest
Basic Line

Pivoting upper arm for automatic vertical loading

- Large clamping range
- Monitoring open/closed via proximity switch
- Hardened arms

Page 18

SR®

Self-centering Steady Rest
Premium Line

- Fully sealed body
- Integrated coolant/air flush
- Diameter measuring system or monitoring open via proximity switches
- Special sizes on request

Page 20

SRA

Self-centering Steady Rest
Premium Line

Additional pivoting upper arm for automatic vertical loading

- Fully sealed body
- Integrated coolant/air flush
- Diameter measuring system or monitoring open via proximity switches
- Special sizes on request

Page 22

SR-CL

Self-centering Steady Rest
Premium Line – with fine adjustment

- Integrated fine adjustment of the center line
- Sealed body
- Integrated coolant/air flush
- Diameter measuring system or monitoring open via proximity switches

Page 24

K

Self-centering Steady Rest
Premium Line

- Compact design
- Sealed body
- Integrated coolant/air flush
- Diameter measuring system or monitoring open via proximity switches
- Special sizes on request

Page 26

KA

Self-centering Steady Rest
Premium Line

- Compact design
- Sealed body
- Integrated coolant/air flush
- Double guided center arm to carry heavy loads
- Excenter fine adjustment on the outer arms
- Special sizes on request

Page 28

KLU / KLU-A

Self-centering Steady Rest
Premium Line

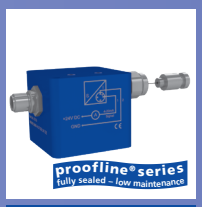
- Narrow arms for crankshafts
- Sealed body
- Integrated coolant/air flush
- Diameter measuring system or monitoring open via proximity switches
- Special sizes on request

Page 30

RX

Self-centering Steady Rest
Premium Line

- Extra compact design
- Patented double cam system
- Sealed body
- Integrated coolant/air flush
- Monitoring steady rest open via proximity switch
- Special sizes on request

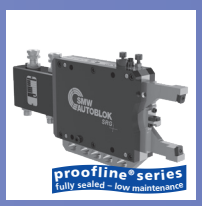


Page 32

SCU

Linear stroke control unit

- For SMW-AUTOBLOK steady rests
- Linear monitoring of the complete clamping stroke – Avoids collision with the tools
- Time saving by only partial opening of the steady
- Protection class IP 66, Output signal 4-20 mA or 0-10 V, Electrical power supply 24 VDC
- **proofline®** = fully sealed – low maintenance



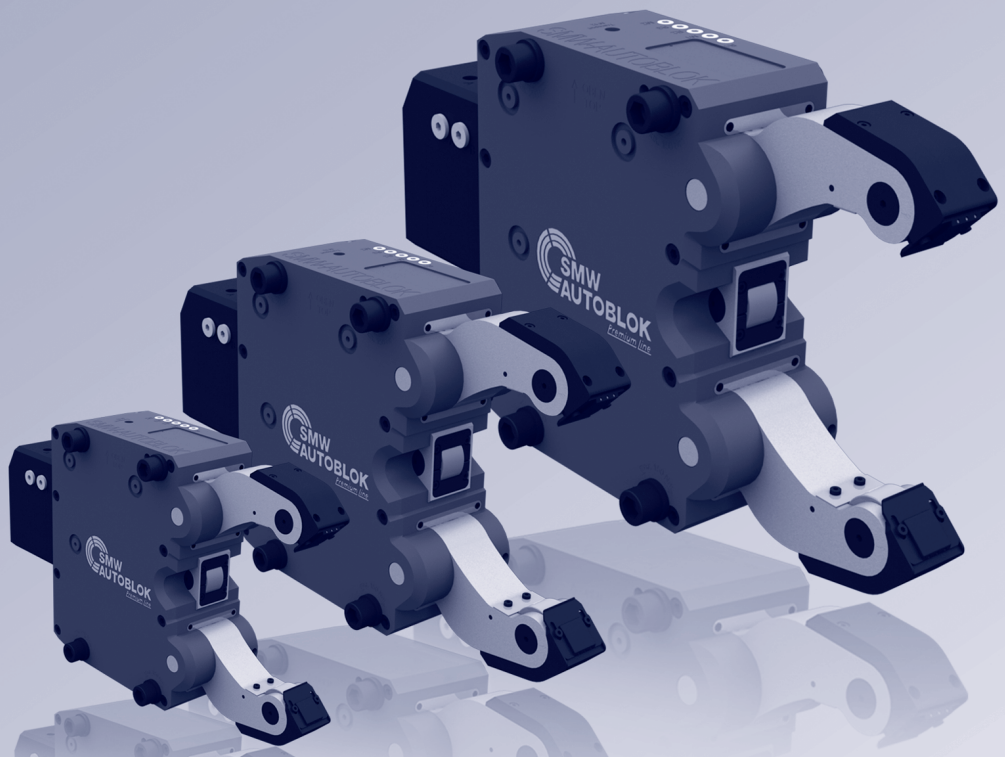
Page 34

SRG/ SRG-B

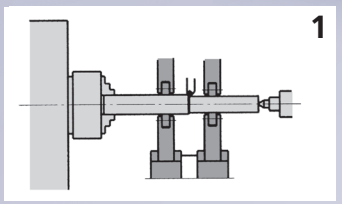
Grinding Steady Rest
with fine adjustment of the center

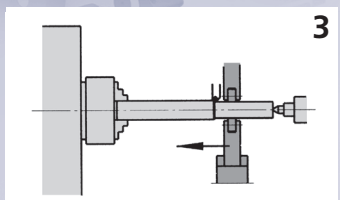
- Horizontal and vertical fine adjustment of the grinding center
- Retractable Steady Rest arms
- Port for compressed air against dust and coolant
- Monitoring via proximity switches
- Ideal for follow down grinding

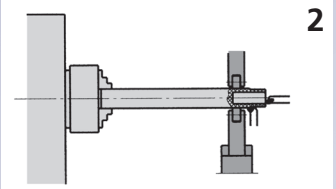
SMW-AUTOBLOK worldwide leader in Steady Rests



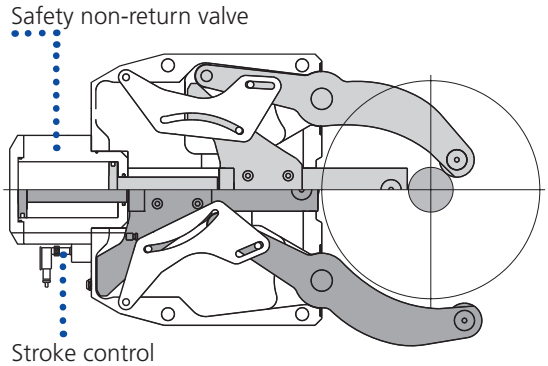
Fixed or travelling application







1. Tandem Steady Rest fixed
2. Steady Rest fixed for end machining
3. Steady Rest travelling

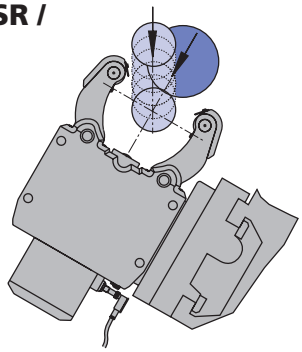


Features included in standard range

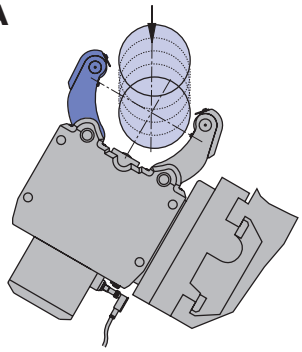
Steady Rest Type	Standard Line		Basic Line	Premium Line					
	SLU-X	SLUB, SLUB-A	SLU, SLU-A	SR	SRA	SR-CL	K, KA	KLU, KLU-A	RX
Steady Rest Size	1 - 5.1	3 - 6	1 - 6	2 - 6	2 - 6	4 - 6	3 - 7.1	215 - 540	5 - 6.1
Sealed body	■			■	■	■	■	■	■
Safety valve	■	■	■	■	■	■	■	■	■
Stroke control (proximity switch not included)	■	■	■	■	■	■	■	■	■
1 set swarf guard 3-piece	■	■	■						
1 set swarf guard with integrated coolant flush				■	■	■	■	■	■
1 set cylindrical rollers	■	■	■	■	■	■	■	■	■
Port for compressed air	■	■	■	■	■	■	■	■	■
Port for coolant through arms incl. chipguard				■	■	■	■	■	■
Toolbox	■	■		■	■	■	■	■	■

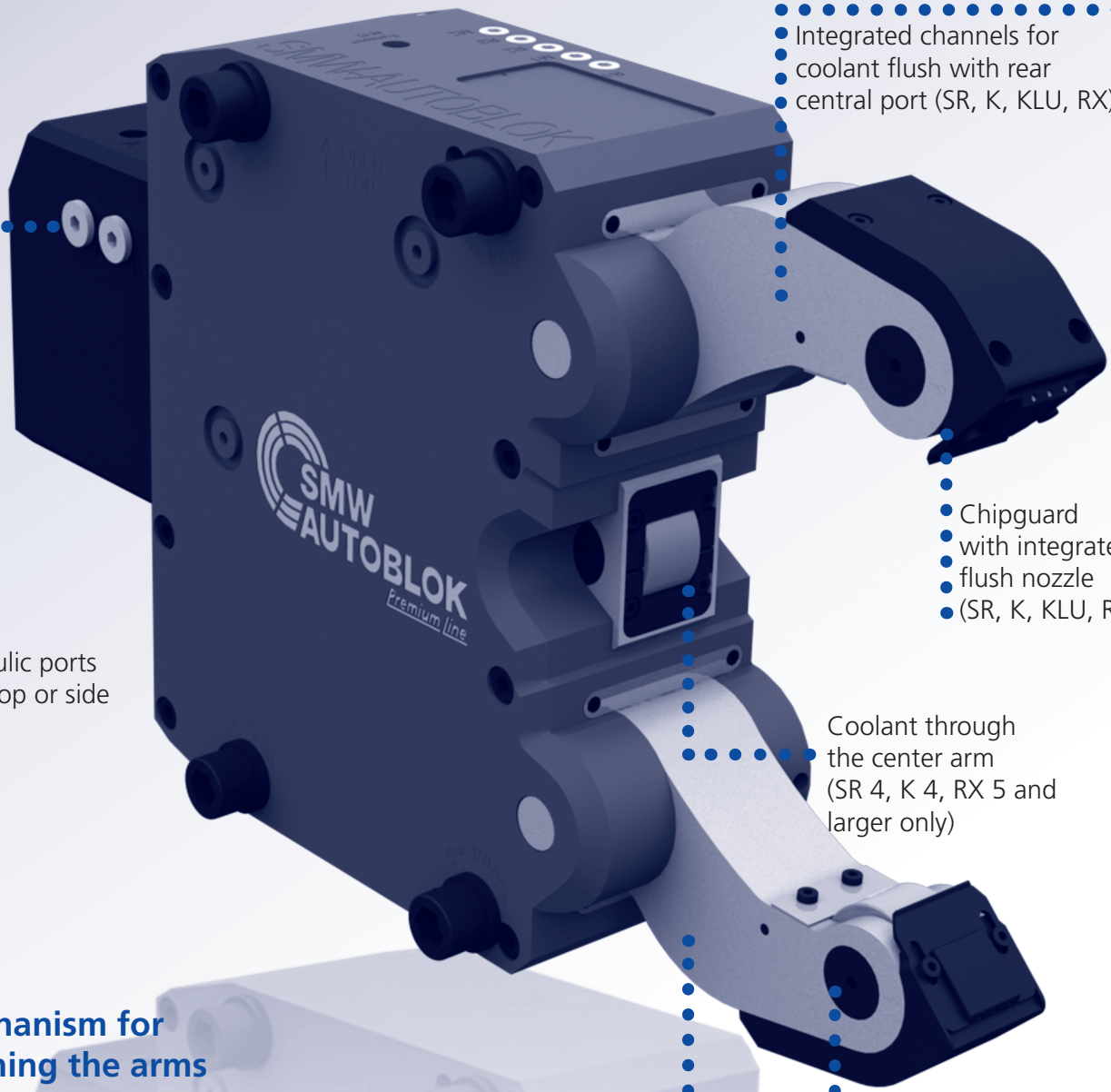
SLU-X® · SR® · K · KLU · RX

SLU-X / SLU / SR / K / KLU / RX
large clamping range



SLU-A / SRA / KLU-A / KA
additional pivoting upper arm
for automatic vertical loading





Integrated channels for coolant flush with rear central port (SR, K, KLU, RX)

Chipguard with integrated flush nozzle (SR, K, KLU, RX)

Hydraulic ports from top or side

Coolant through the center arm (SR 4, K 4, RX 5 and larger only)

Mechanism for opening the arms of the Steady Rest without springs and free from wear.

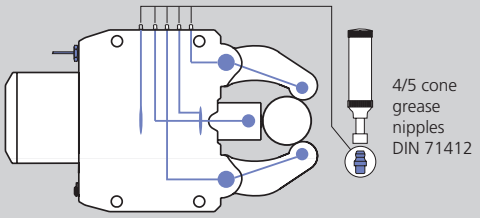
Arms and centerpiece hardened (SLU-X, SR, K, KLU, RX)

Easy change of rollers without loose parts

Option of manual lubrication (M) (all types)

- Low cost solution for medium working conditions and low build up of swarf.
- The lubrication points and rollers are supplied with lubrication grease via the grease nipples and the grease gun.
- Lubrication intervals depending on the working conditions normally every 4 to 8 operating hours.
- Grease: KPE 2R-20 DIN 51502.

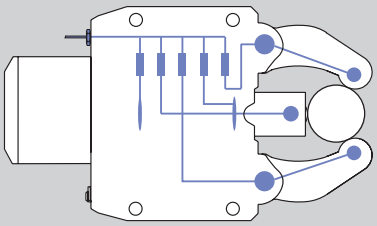
Manual lubrication (M)



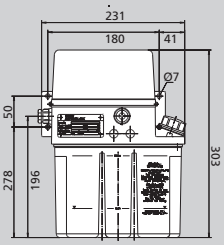
Option of central oil lubrication (Z) (all types)

- For heavy working conditions and high build up of swarf.
- For travelling Steady Rest applications.
- The use of our separate complete lubrication unit with timer control is recommended.
- Lubricating intervals 5 - 20 min.
- Min. / max. operating pressure 10 / 45 bar.
- Oil: Viscosity of 46 mm² / s (viscosity class ISO).

Central lubrication oil (Z)
Centralized lubrication G 1/8"



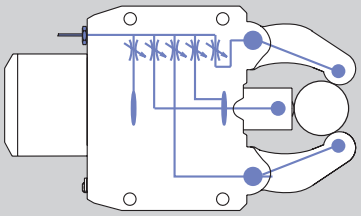
Lubrication unit oil
Id. No. 088707



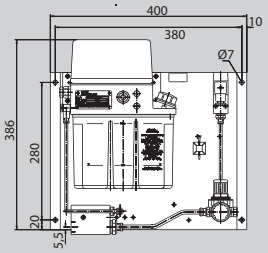
Option of central lubrication oil + air (OLD) (all types)

- For heaviest cutting conditions with high built up of swarf, dust or coolant.
- The SMW-AUTOBLOK oil + air unit for lubrication with built-in timer control is mandatory.
- This unit injects oil for lubrication into the air hose in adjustable intervals (1 - 4 min.).
- The permanent air flow (min. 3 bar) feeds the oil to the rollers and keeps them clean.
- Oil: Viscosity of 46 mm² / s (viscosity class ISO).

Oil + air lubrication (OLD)
Centralized lubrication G 1/8"



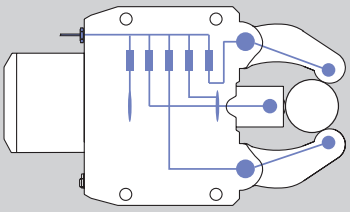
Lubrication unit oil + air
Id. No. 088708



Option of central grease lubrication (F) (not SLU / SLU-A / SLUB / SLUB-A)

- For machines with central grease lubrication.
- For application and intervals please follow the instruction of the machine maker.
- Min. / max. operating pressure 30 / 45 bar.
- Grease: NLGI class 0 or 1.

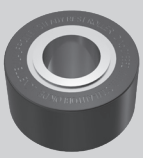
Central grease lubrication (F)
Centralized lubrication G 1/8"



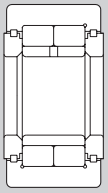
Option of rollers (all types)

- SMW-AUTOBLOK rollers (precision class P05) specially developed for our Steady Rests.
- Special sealing ensures highest precision and service life.
- Standard equipment: 1 set of cylindrical rollers.
- Option: Spherical rollers (for travelling Steady Rests), synthetic material rollers, carbide rollers.

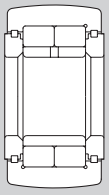
Original SMW-AUTOBLOK roller



cylindrical



spherical



narrow

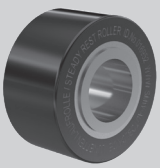
Rollers (all types)

- Rollers steel (standard): Surface of workpiece not hardened.

Available optional materials:

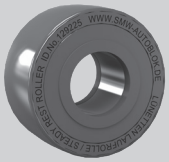
- Rollers synthetic material: Surface of workpiece polished or chrome plated.
- Rollers carbide: Surface of workpiece hardened.

Rollers steel

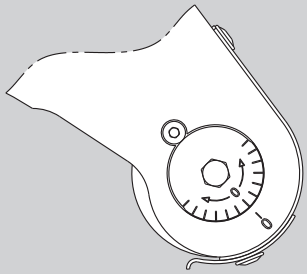


Rollers synthetic material

Rollers carbide



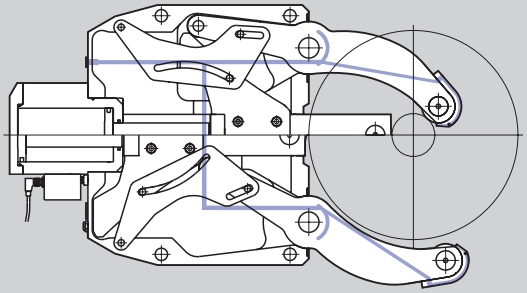
Eccentric fine adjustment



Option fine adjustment of center line
(all types)

- Eccentric roller pins on the two Steady Rest arms allow a quick fine adjustment of the center line.
- Therefore no need to unlock and adjust the entire Steady Rest on the bracket for small adjusting movements.
- Adjustment of open Steady Rest only!

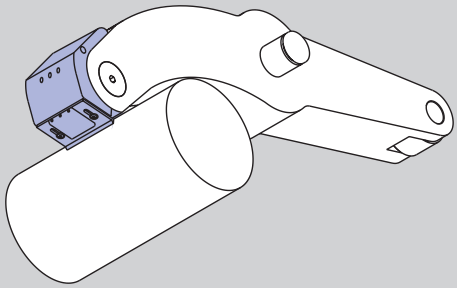
Coolant / air feed



Coolant / air feed (SR / K / KLU / RX only)

- Built-in channels to feed coolant or air from a central connecting port to the Steady Rest arms.
- Basic equipment for SR / K / KLU / RX Steady Rests.
- From size SR-4 / K4 and larger with coolant through the center arm.

Chipguard coolant / air



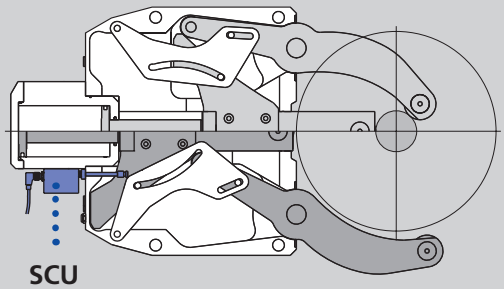
Patented coolant / air chipguard with integrated flush nozzles (SR / K / KLU / RX only)

- Keeps roller clamping area free from chips.
- The patented double flush nozzles keep front and rear of the wiper area clean.

Only for Steady Rests with coolant / air feed
Benefit:

- Constant centering accuracy.
- No damage of workpiece and rollers caused by chips / swarf.
- Less roller consumption = less costs.

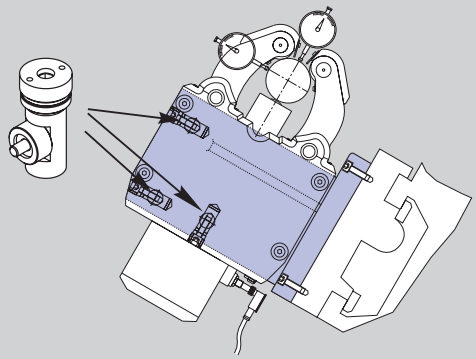
SCU
diameter measuring system



Option linear diameter measuring system SCU (not SLU, SLUB, SLU-A, SLUB-A)

- The position of the clamping arms is monitored by the linear measuring system SCU.
- Avoids collision with workpieces, turret, loader etc.
- Reduced cycle time due to position controlled opening of the arms to the requested opening only.
- Power supply SCU: In: 24 V Out: 4 - 20 mA

Steady Rest bracket with adjustment device



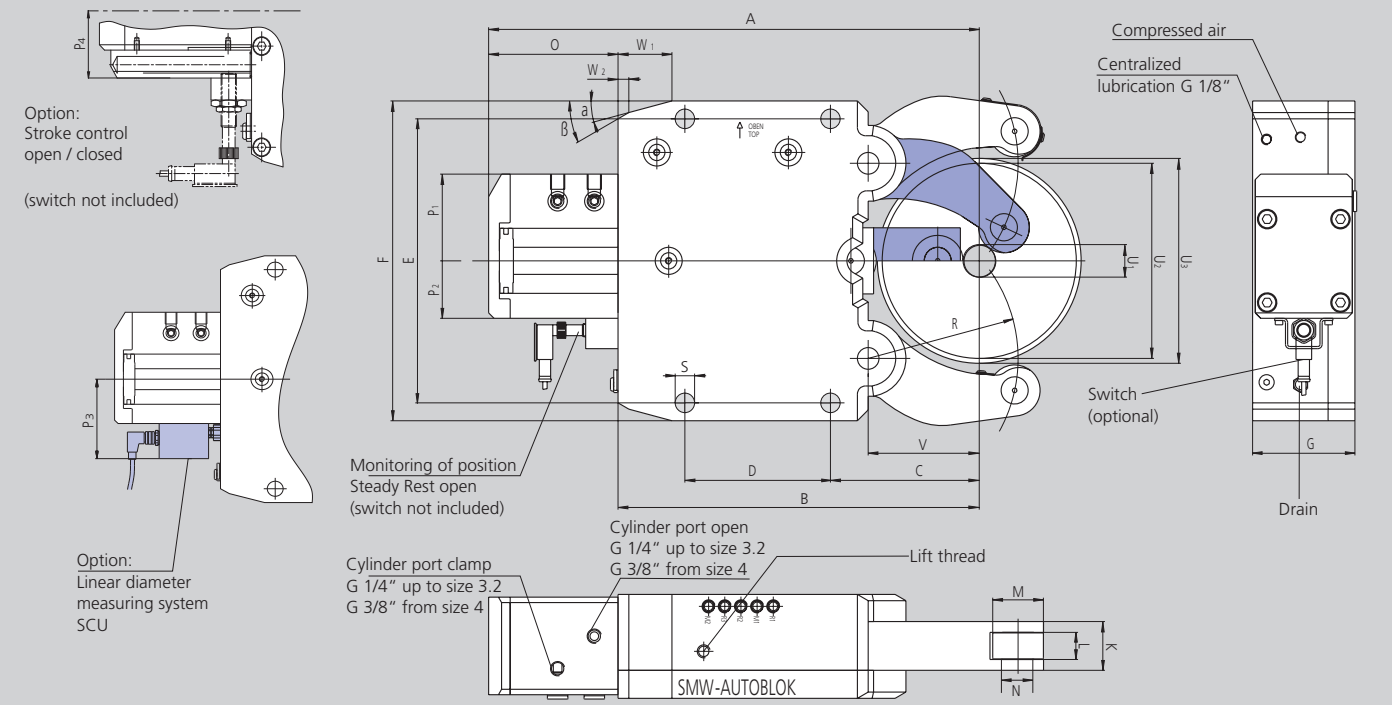
Steady Rest bracket

- A suitable bracket is very important for the function / precision of the Steady Rest.
- Fast and easy adjustment can be done with the SMW-AUTOBLOK **adjustment device** integrated into the bracket.
- SMW-AUTOBLOK supplies the correct bracket for all applications as a turnkey solution.

SLU-X®

Self-centering Steady Rests
Standard line

- **Sealed body**
- **Stroke control for end position open (switch not included)**



Subject to technical changes.
For more detailed information please ask for customer drawing.

Drain and compressed air
G 1/8" up to size 3.2
G 1/4" from size 4

SMW-AUTOBLOK Type Size		SLU-X 1	SLU-X 2	SLU-X 3	SLU-X 3.1	SLU-X 3.2	SLU-X 4	SLU-X 5	SLU-X 5.1
Centering range without chip guard	**U_1**	**6**	**8**	**12**	**20**	**50**	**30**	**45**	**85**
	U_2	**70**	**101**	**152**	**165**	**200**	**245**	**310**	**350**
Max. axial clearing dia.	**U_3**	**75**	**106**	**164**	**172**	**202**	**253**	**320**	**352**
Centering range with chip guard 3-piece	**U_1**	**8**	**12**	**14**	**20**	**50**	**30**	**45**	**85**
	U_2	**70**	**101**	**152**	**165**	**200**	**245**	**310**	**350**
	A	214.5	277	428	436	455	603	697	717
	B	149	195	312	320	335	448	510	530
	C	52	70	115	123	138	146	178	198
	D	66	85	135	135	135	240	270	270
	E	140	170	262	262	262	365	400	400
	F	160	195	295	295	295	405	440	440
	G	63	75	95	95	95	110	145	145
	K	28	35	45	45	45	60	75	75
Width of rollers	L	15	19	25	25	25	25	29	29
Diameter of rollers	M	24	35	47	47	47	52	62	62
Diameter of roller pins	N	8	15	20	20	20	25	30	30
	O	65.5	82	116	116	120	155	187	187
	P_1	53	63	85	85	85	91	97	97
	P_2	29	40	53	53	53	61	63	63
	P_3	-	82	95	95	95	103	105	105
	P_4	40	61	74	74	74	82	84	84
	R	55	74	119	124	139	172	209	229
	S	11	14	18	18	18	23	23	23
	V	37	51	85	93	103	128	160	180
	W_1	20	30	50	50	50	58	62	62
	W_2	5	11.2	10	10	10	18.3	19.1	19.1
	α	15°	15°	15°	15°	15°	15°	18°	18°
	β	45°	30°	30°	30°	30°	40°	40°	40°
Piston area*	cm^2	7	19.6	38.5	38.5	38.5	63.6	78.5	78.5
Operation pressure min. / max.	bar	6 / 70	8 / 70	8 / 80	8 / 80	8 / 80	8 / 70	8 / 80	8 / 80
Max. clamping force / roller	daN	165	450	1000	1000	1000	1500	2000	2000
Centering accuracy within the whole range	mm	0.02	0.02	0.04	0.04	0.04	0.05	0.06	0.06
Repeatability accuracy	mm	0.005	0.005	0.007	0.007	0.007	0.007	0.01	0.01
Max. roller surface speed	m/min	800	800	725	725	725	715	600	600
Weight approx.	kg	8	17	50	51	59	103	168	170

* Cylinders differing from standard available on request.
Subject to technical changes!

SLU-X®

Self-centering Steady Rests
Standard line

SLU-X Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)									
Steady Rest size		**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**
SLU-X-M Manual lubrication	Id. No.	127563	129001	129018	129196	129234	129141	129278	129291
SLU-X-Z Central lubrication oil	Id. No.	127562	129000	129020	129195	129235	129140	129280	129292
SLU-X-OLD Central lubrication oil + air	Id. No.	127564	129002	129019	129197	129236	129142	129279	129293
SLU-X-F Central grease lubrication	Id. No.	129761	129762	129763	129764	129765	129766	129767	129768

SLU-X Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)									
Steady Rest size		**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**
SLU-X-M Manual lubrication	Id. No.	126155	222390	221912	223890	222400	on request	on request	on request
SLU-X-Z Central lubrication oil	Id. No.	126154	221116	221151	221152	221153	221154	221155	221156
SLU-X-OLD Central lubrication oil + air	Id. No.	126156	227175	221913	227586	on request	on request	on request	on request
SLU-X-F Central grease lubrication	Id. No.	on request	on request	221914	225348	225349	on request	on request	on request

SLU-X Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA									
Steady Rest size		**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**
SLU-X-Z Central lubrication oil	Id. No.	-	225830	225831	225832	225833	222513	222183	225834

SLU-X Steady Rest with stroke control via linear stroke control SCU, output 0 - 10 V									
Steady Rest size		**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**
SLU-X-Z Central lubrication oil	Id. No.	-	on request	on request	on request	on request	on request	on request	on request

Type SLU-X

♦ means wearing parts, recommended stock items

Steady Rest size	**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**	088707	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil & air lubrication Container 2.7 l, 220 V *,**	088708	088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)	-	127237	127240	127240	127240	128474	128584	128584
Inductive limit switch	087926	087926	087926	087926	087926	087926	087926	087926
Swarf guard 3-pieces ♦	126171	026116	026117	026117	026117	026118	026119	026119
Spring loaded chip-guard*** ♦	226668	025760	025759	025759	025759	025758	025757	025757
Roller pin with collar*** ♦	226656	225317	221112	221112	221112	204052	125824	125824
Roller stripper (2-pieces) for middle piece ♦	200155	200154	198950	198950	198950	196199	196200	196200
Rollers cylindrical design ♦	023122	016952	016951	016951	016951	016953	018345	018345
Rollers spherical design ♦	028738	017658	018433	018433	018433	018443	019545	019545
Rollers synthetic material**** ♦	225135	029451	023443	023443	023443	023672	023650	023650
Roller stripper (2-pieces) for middle piece with roller synthetic material ♦	-	204211	204212	204212	204212	204213	204215	204215
Rollers carbide ♦	224747	129223	129225	129225	129225	220918	222038	222038
Adjustment device 1 set = 3 pieces	-	-	200178	200178	200178	200179	200179	200179

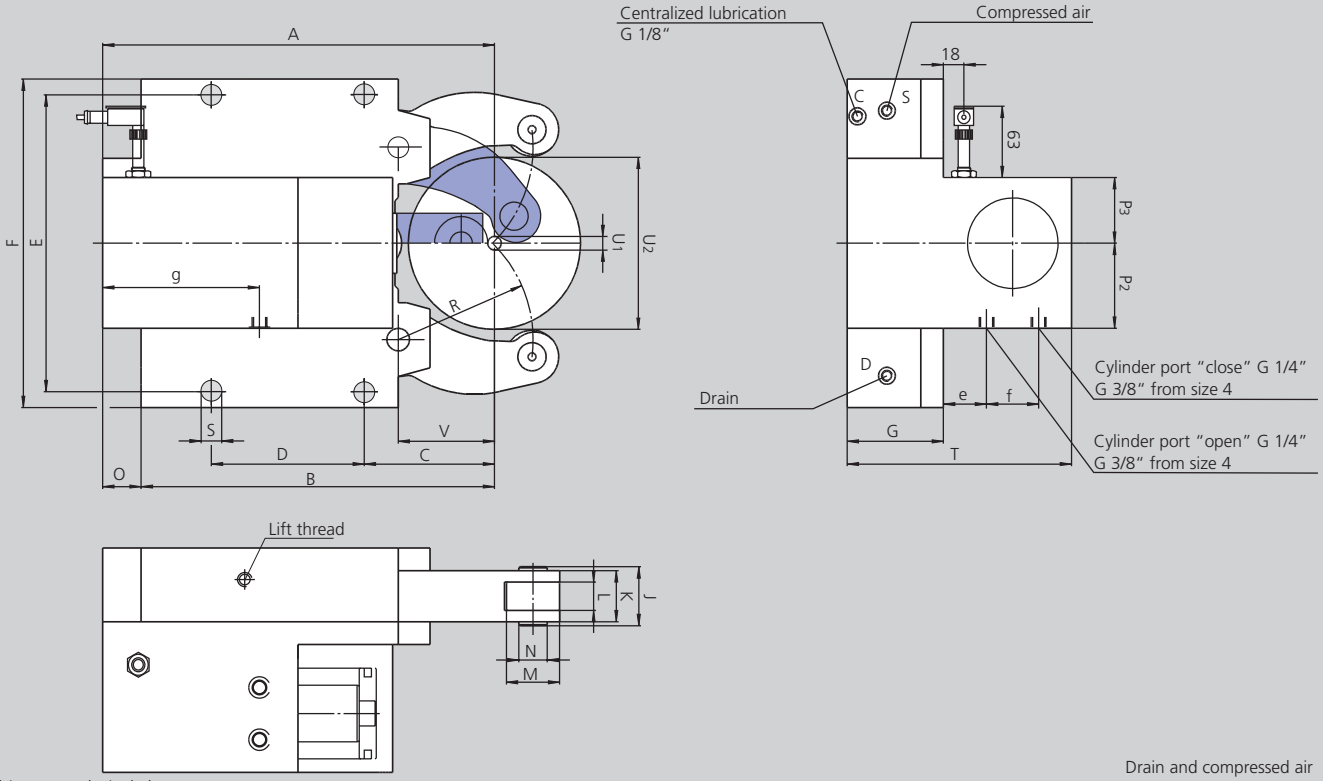
* When placing an order please advise voltage.
** On request 110 V available.
*** Use of spring located chip-guard only possible in combination with roller pin with collar.
**** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SLUB

Self-centering Steady Rests
Standard line

Extra compact with side mounted cylinder

- **Monitoring open / closed via proximity switch**
- **Special sizes on request**



Subject to technical changes.
For more detailed information please ask for customer service.

Drain and compressed air
G 1/8" up to size 3.2
G 1/4" from size 4

SMW-AUTOBLOK Type Size		SLUB 3	SLUB 3.1	SLUB 3.2	SLUB 4	SLUB 5	SLUB 5.1	SLUB 6
Centering range without chip guard	**U_1**	**12**	**20**	**50**	**35**	**50**	**90**	**125**
	U_2	**152**	**165**	**200**	**245**	**310**	**350**	**460**
Centering range with chip guard 3-piece	U_1	14	20	50	35	50	90	125
	U_2	152	165	200	245	310	350	460
	A	346	354	372.5	480	612.5	632.5	800
	B	312	320	335	448	510	530	709
	C	115	123	138	146	178	198	215
	D	135	135	135	240	270	270	330
	E	262	262	262	365	400	400	610 / 640
	F	290	290	290	400	440	440	680
	G	85	85	85	110	145	145	145
	J	52	52	52	67	83	83	83
	K	45	45	45	60	75	75	75
Width of rollers	L	25	25	25	25	29	29	29
Diameter of rollers	M	47	47	47	52	62	62	80
Diameter of collars	N	25	25	25	32	36	36	42
	O	34	34	37.5	32	102.5	102.5	91
	P_2	75	75	75	68	85	85	100
	P_3	58	58	58	68	85	85	85
	R	119	124	139	172	209	229	290
	S	18	18	18	23	23	23	27
	T	198	198	198	243.5	325	325	350
	V	85	93	103	128	160	180	175
	e	38	38	38	38.5	79.5	79.5	74.5
	f	46	46	46	66	66	66	96
	g	138.5	138.5	138.5	190	261	215	334.5
Piston area*	cm^2	50	50	50	78	78	78	132
Operation pressure min. / max.	bar	8 / 60	8 / 60	8 / 60	8 / 60	8 / 80	8 / 80	8 / 70
Max. clamping force / roller	daN	1000	1000	1000	1500	2000	2000	3000
Centering accuracy within the whole range	mm	0.04	0.04	0.04	0.05	0.06	0.06	0.06
Repeatability accuracy	mm	0.007	0.007	0.007	0.007	0.01	0.01	0.01
Max. roller surface speed	m/min.	725	725	725	715	600	600	560
Weight approx.	kg	45	46	48	106	175	178	483

* On request cylinder differing from standard available.
Subject to technical changes!

SLUB Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)								
Steady Rest size		**3**	**3.1**	**3.2**	**4**	**5**	**5.1**	**6**
SLUB-M Manual lubrication	Id. No.	029865	029866	227695	029867	029868	029909	029869
SLUB-Z Central lubrication oil	Id. No.	029855	029856	123929	029857	029858	029908	029859
SLUB-OLD Central lubrication oil + air	Id. No.	029875	029876	228024	029877	029878	029910	029879

Type SLUB

♦ **means wearing parts, recommended stock items**

Steady Rest size		**3**	**3.1**	**3.2**	**4**	**5**	**5.1**	**6**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil & air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)		018437	018437	018437	018444	018450	018450	026595
Inductive limit switch		087926	087926	087926	087926	087926	087926	087926
Swarf guard (3-pieces)	♦	026117	026117	026117	026118	026119	026119	026597
Roller stripper (2-pieces) for middle piece	♦	029797	029797	029797	029798	029799	029799	029800
Rollers cylindrical design	♦	016951	016951	016951	016953	018345	018345	026594
Rollers spherical design	♦	018433	018433	018433	018443	019545	019545	121302
Rollers synthetic material***	♦	023443	023443	023443	023672	023650	023650	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material	♦	029797	029797	029797	205400	029799	029799	-
Rollers carbide	♦	129225	129225	129225	220918	222038	222038	on request
Adjustment device 1 set = 3 pieces		200178	200178	200178	200179	200179	200179	200179

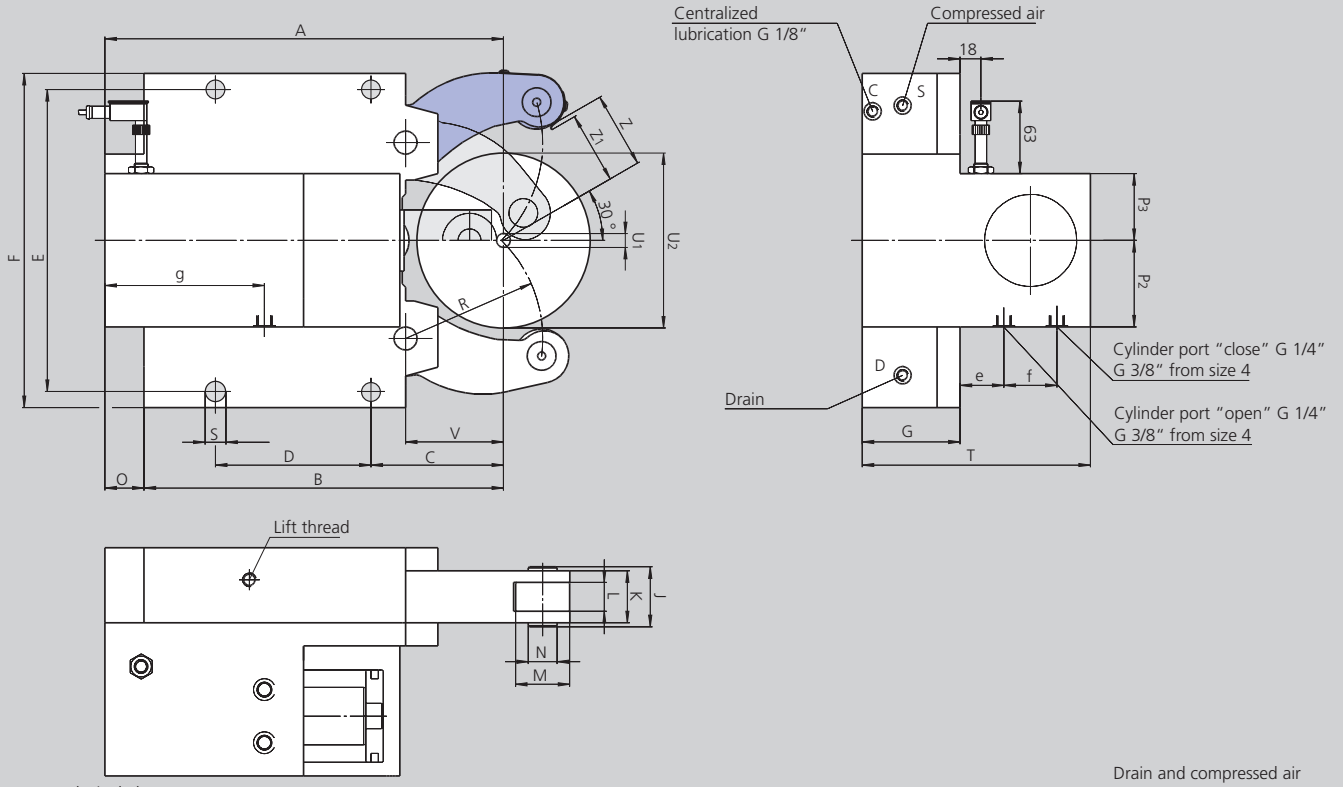
* When placing an order please advise voltage.
** On request 110 V available.
*** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SLUB-A

Self-centering Steady Rests
Standard line

Extra compact with side mounted cylinder
Additional pivoting upper arm for vertical loading

- **Monitoring open / closed via proximity switch**
- **Special sizes on request**



Subject to technical changes.
For more detailed information please ask our customer service.

Drain and compressed air
G 1/8" up to size 3.1
G 1/4" from size 4

SMW-AUTOBLOK Type Size		SLUB-A 3	SLUB-A 3.1	SLUB-A 4	SLUB-A 5	SLUB-A 6
Centering range without chip guard	**U_1**	**12**	**22**	**35**	**50**	**160**
	U_2	**130**	**150**	**220**	**268**	**460****
Centering range with chip guard 3-piece	U_1	14	22	35	50	160
	U_2	130	150	220	268	460**
Vertical loading without chip guard	**Z**	**66**	**76**	**111**	**135**	**230****
Vertical loading with chip guard	**Z_1**	**62**	**72**	**106.5**	**130**	**225****
	A	346	354	480	600.5	800
	B	312	320	448	510	709
	C	115	123	146	178	215
	D	135	135	240	270	330
	E	262	262	365	400	610 / 640
	F	290	290	400	440	680
	G	85	85	110	145	145
	J	52	52	67	83	83
	K	45	45	60	75	75
Width of rollers	L	25	25	25	29	29
Diameter of rollers	M	47	47	52	62	80
Diameter of collars	N	25	25	32	36	42
	O	34	34	32	90.5	91
	P_2	75	75	68	85	87
	P_3	58	58	85	85	104
	R	119	124	172	209	290
	S	18	18	23	23	27
	T	198	198	243.5	325	350
	V	85	93	128	160	175
	e	38	38	38.5	79.5	74.5
	f	46	46	66	66	96
	g	138.5	138.5	188	210	230
Piston area*	cm^2	50	50	78	78	132
Operating pressure min. / max.	bar	8 / 60	8 / 60	8 / 60	8 / 80	8 / 70
Max. clamping force / roller	daN	1000	1000	1500	2000	3000
Centering accuracy within the whole range	mm	0.04	0.04	0.05	0.06	0.06
Repeatability accuracy	mm	0.007	0.007	0.007	0.01	0.01
Max. roller surface speed	m/min	725	725	715	600	560
Weight approx.	kg	45	46	106	175	483

* On request cylinder differing from standard available.
** SLUB-A-6: Loading diameter U2 = 460 only under 19° installation.

SLUB-A Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)						
Steady Rest size		**3**	**3.1**	**4**	**5**	**6**
SLUB-A-M Manual lubrication	Id. No.	029870	029871	029872	029873	029874
SLUB-A-Z Central lubrication oil	Id. No.	029860	029861	029862	029863	029864
SLUB-A-OLD Central lubrication oil + air	Id. No.	029880	029881	029882	029883	029884

Type SLUB-A

♦ means wearing parts, recommended stock items

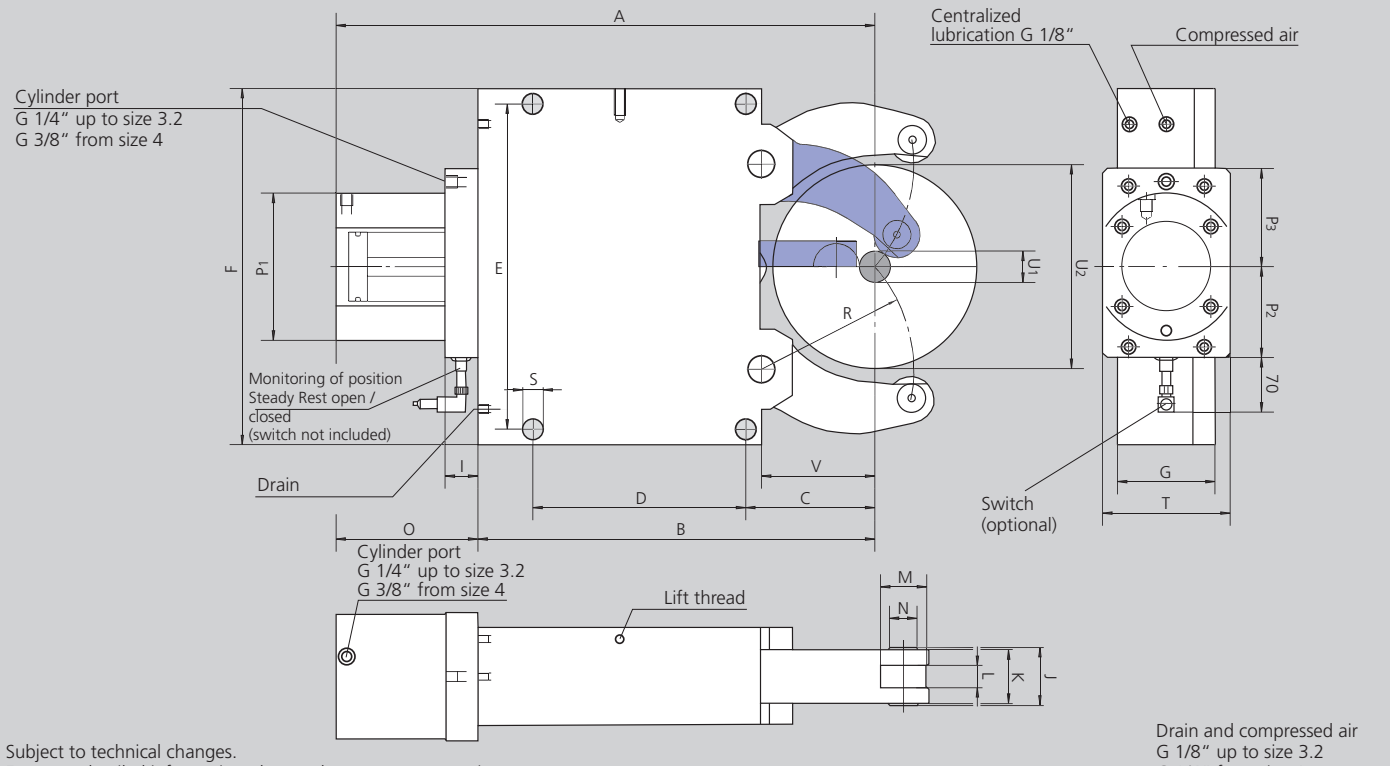
Steady Rest size		**3**	**3.1**	**4**	**5**	**6**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707	088707
Compact lubrication system for oil & air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)		018437	018437	018444	018450	026595
Inductive limit switch		087926	087926	087926	087926	087926
Swarf guard (3-pieces)	♦	026117	026117	026118	026119	026597
Roller stripper (2-pieces) for middle piece	♦	029797	029797	029798	029799	029800
Rollers cylindrical design	♦	016951	016951	016953	018345	026594
Rollers spherical design	♦	018433	018433	018443	019545	121302
Rollers synthetic material***	♦	023443	023443	023672	023650	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material	♦	029797	029797	205400	029799	-
Rollers carbide	♦	129225	129225	220918	222038	on request
Adjustment device 1 set = 3 pieces		200178	200178	200179	200179	200179

* When placing an order please advise voltage.
** On request 110 V available.
*** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SLU

Self-centering Steady Rests
Basic line

- **Large clamping range**
- **Monitoring open / closed via proximity switch**
- **Hardened arms**



Subject to technical changes.
For more detailed information please ask our customer service.

Drain and compressed air
G 1/8“ up to size 3.2
G 1/4“ from size 4

SMW-AUTOBLOK Type Size		SLU 1	SLU 2	SLU 3	SLU 3.1	SLU 3.2	SLU 4	SLU 5	SLU 5.1	SLU 6
Centering range without chip guard	U_1	4	8	12	20	50	30	45	85	125
	U_2	64	101	152	165	200	245	310	350	460
Centering range with chip guard 3-piece	U_1	8	12	14	20	50	30	45	85	125
	U_2	64	101	152	165	200	245	310	350	460
	A	207	279.5	429	437	455	608	697.5	717.5	944.5
	B	137	195	312	320	335	448	510	530	709
	C	51	70	115	123	138	146	178	198	215
	D	64	85	135	135	135	240	270	270	330
	E	118	170	262	262	262	365	400	400	610 / 640
	F	132	190	290	290	290	400	440	440	680
	G	55	70	85	85	85	110	145	145	145
	I	33	33	37	37	37	37	37	37	37
	J	26	42	52	52	52	67	83	83	83
	K	20	35	45	45	45	60	75	75	75
Width of rollers	L	12	19	25	25	25	25	29	29	29
Diameter of rollers	M	19	35	47	47	47	52	62	62	80
Diameter of collars	N	6	21	25	25	25	32	36	36	42
	O	70	84.5	117	117	120	160	187.5	187.5	235.5
	P_1	84	102	137	137	137	165	165	165	190
	P_2	66	72	90	90	90	102	102	102	115
	P_3	66	75	100	100	100	110	110	110	130
	R	50.5	74	119	124	139	172	209	229	290
	S	11	14	18	18	18	23	23	23	27
	T	70	70	100	100	100	144	144	144	158
	V	37	52	85	93	103	128	160	180	175
Piston area	cm^2	7	19.6	50	50	50	78	78	78	132
Operation pressure min. / max.	bar	6 / 50	8 / 70	8 / 60	8 / 60	8 / 60	8 / 60	8 / 80	8 / 80	8 / 70
Max. clamping force / roller	daN	100	450	1000	1000	1000	1500	2000	2000	3000
Centering accuracy within the whole range	mm	0.02	0.02	0.04	0.04	0.04	0.05	0.06	0.06	0.06
Repeatability accuracy	mm	0.005	0.005	0.007	0.007	0.007	0.007	0.01	0.01	0.01
Max. roller surface speed	m/min	800	800	725	725	725	715	600	600	560
Weight approx.	kg	6	14	39	40	43	92	152	155	420

SLU Steady Rest (including 1 set of SMW-AUTOBLOK cylindrical rollers)										
Steady Rest size		**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**	**6**
SLU-M Manual lubrication	Id. No.	025804	025805	025806	025807	120689	122186	122416	122469	026586
SLU-Z Central lubrication oil	Id. No.	025457	025402	025401	025406	120690	122185	122415	122468	026492
SLU-OLD Central lubrication oil + air	Id. No.	027649	027650	027651	027652	120691	122187	122417	122470	027655

Type SLU

♦ **means wearing parts, recommended stock items**

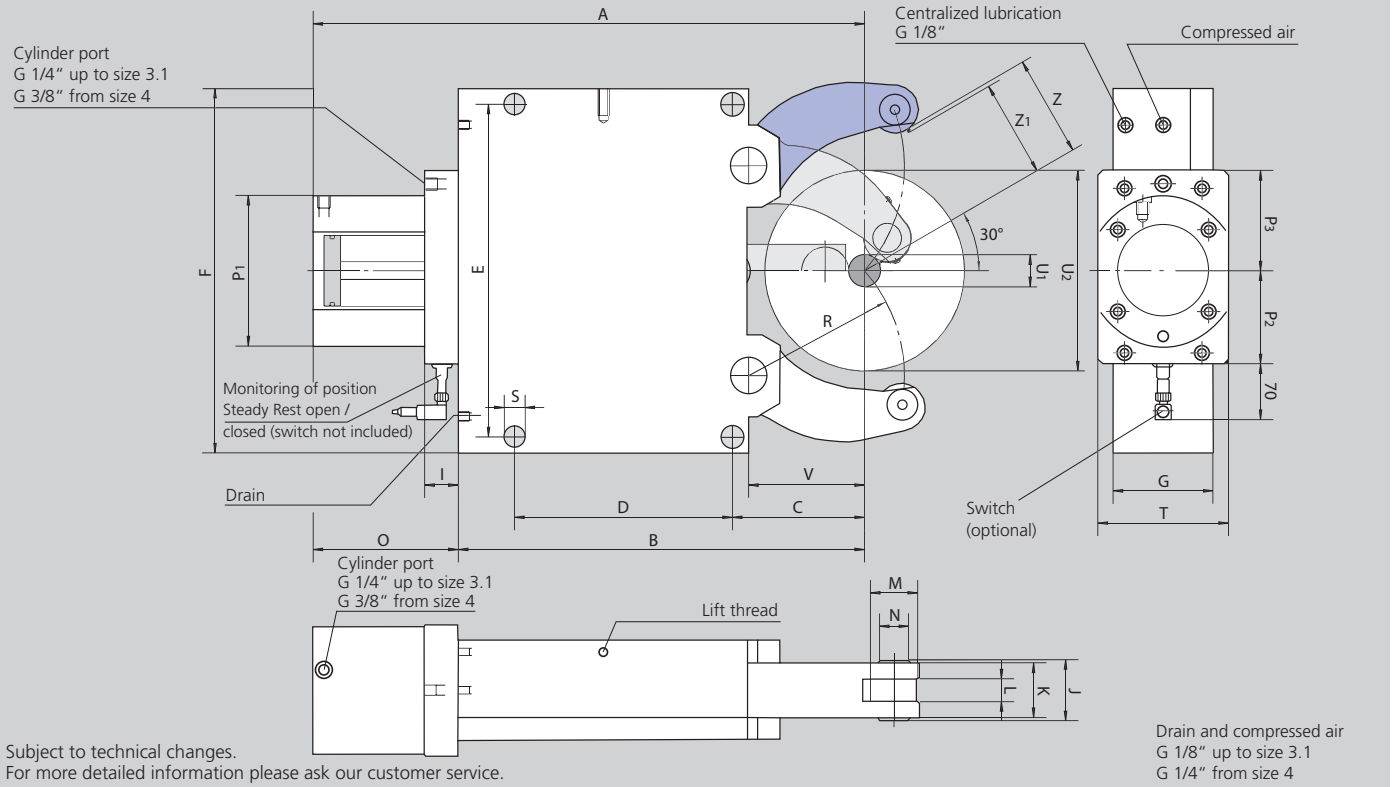
Steady Rest size	**1**	**2**	**3**	**3.1**	**3.2**	**4**	**5**	**5.1**	**6**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**	088707	088707	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**	088708	088708	088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)	-	026120	018437	018437	018437	018444	018450	018450	026595
Inductive limit switch	087926	087926	087926	087926	087926	087926	087926	087926	087926
Swarf guard (3-pieces) ♦	026115	026116	026117	026117	026117	026118	026119	026119	026597
Spring loaded chip guard ♦	025781	025760	025759	025759	025759	025758	025757	025757	026596
Roller stripper (2-pieces) for middle piece ♦	029795	029796	029797	029797	029797	029798	029799	029799	029800
Rollers cylindrical design ♦	017869	016952	016951	016951	016951	016953	018345	018345	026594
Rollers spherical design ♦	016900	017658	018433	018433	018433	018443	019545	019545	121302
Rollers synthetic material*** ♦	024409	029451	023443	023443	023443	023672	023650	023650	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material ♦	029795	197520	029797	029797	029797	205400	029799	029799	-
Rollers carbide ♦	128794	129223	129225	129225	129225	220918	222038	222038	on request
Adjustment device 1 set = 3 pieces	-	-	200178	200178	200178	200179	200179	200179	200179

* When placing an order please advise voltage.
** On request 110 V available.
*** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SLU-A

Self-centering Steady Rests
Basic line

- **Additional pivoting upper arm**
- **Monitoring of position Steady Rest open and closed**
- **Hardened arms**



Subject to technical changes.
For more detailed information please ask our customer service.

Drain and compressed air
G 1/8" up to size 3.1
G 1/4" from size 4

SMW-AUTOBLOK Type Size		SLU-A 1	SLU-A 2	SLU-A 3	SLU-A 3.1	SLU-A 4	SLU-A 5	SLU-A 6
Centering range without chip guard	U_1	4	8	12	22	30	45	160
	U_2	52	80	130	150	220	268	460 *
Centering range with chip guard 3-piece	U_1	8	12	14	22	30	50	160
	U_2	52	80	130	150	220	268	460
	Z	26.5	41	66	76	111	135	230 *
	Z_1	24	34	62	72	106.5	130	225 *
	A	207	279.5	429	437	608	697.5	944.5
	B	137	195	312	320	448	510	709
	C	51	70	115	123	146	178	215
	D	64	85	135	135	240	270	330
	E	118	170	262	262	365	400	610 / 640
	F	132	190	290	290	400	440	680
	G	55	70	85	85	110	145	145
	I	33	33	37	37	37	37	37
	J	26	42	52	52	67	83	83
	K	20	35	45	45	60	75	75
Width of rollers	L	12	19	25	25	25	29	29
Diameter of rollers	M	19	35	47	47	52	62	80
Diameter of collars	N	6	21	25	25	32	36	42
	O	70	84.5	117	117	160	187.5	235.5
	P_1	84	102	137	137	165	165	190
	P_2	66	72	90	90	102	102	115
	P_3	66	75	100	100	110	110	130
	R	50.5	74	119	124	172	209	290
	S	11	14	18	18	23	23	27
	T	70	70	100	100	144	144	158
	V	37	52	85	93	128	160	175
Piston area	cm^2	7	19.6	50	50	78	78	132
Operation pressure min. / max.	bar	6 / 50	8 / 70	8 / 60	8 / 60	8 / 60	8 / 80	8 / 70
Max. clamping force / roller	daN	100	450	1000	1000	1500	2000	3000
Centering accuracy within the whole range	mm	0.02	0.02	0.04	0.04	0.05	0.06	0.06
Repeatability accuracy	mm	0.005	0.005	0.007	0.007	0.007	0.01	0.01
Max. roller surface speed	m/min	800	800	725	725	715	600	560
Weight approx.	kg	6	14	39	40	92	152	420

* SLU-A 6: loading diameter U2 = 460 only under 19° installation.

SLU-A

Self-centering Steady Rests
Basic line

SLU-A Steady Rest (including 1 set of SMW-AUTOBLOK cylindrical rollers)								
Steady Rest size		**1**	**2**	**3**	**3.1**	**4**	**5**	**6**
SLU-A-M Manual lubrication	Id. No.	024458	024459	024460	024461	122546	024463	026591
SLU-A-Z Central lubrication oil	Id. No.	024482	024483	024673	024674	122545	024485	026593
SLU-A-OLD Central lubrication oil + air	Id. No.	027656	027657	027658	027659	122547	027661	027662

Type SLU-A

♦ means wearing parts, recommended stock items

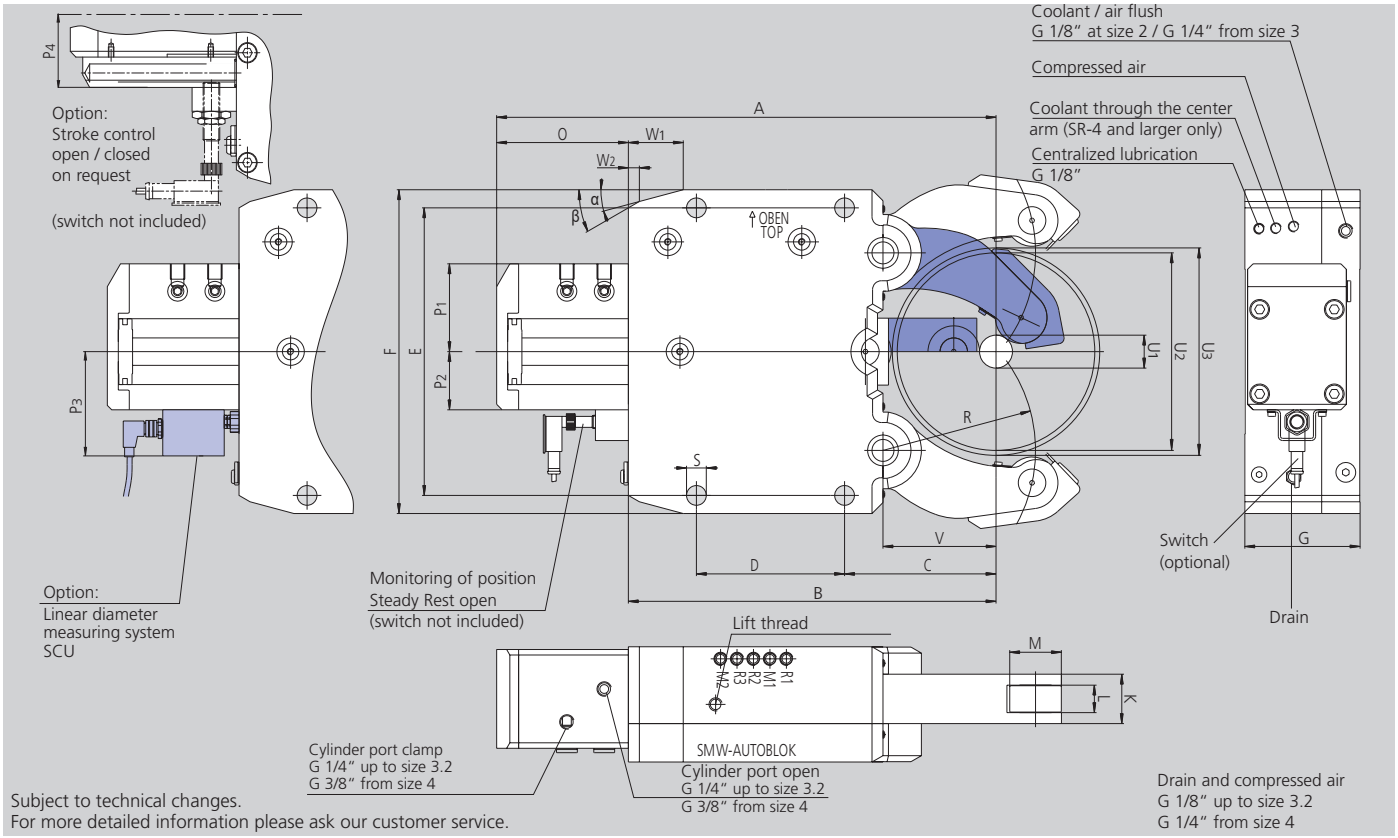
Steady Rest size	**1**	**2**	**3**	**3.1**	**4**	**5**	**6**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**	088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)	-	026120	018437	018437	018444	018450	026595
Inductive limit switch	087926	087926	087926	087926	087926	087926	087926
Swarf guard (3-pieces) ♦	026115	026116	026117	026117	026118	026119	026597
Spring loaded chip guard ♦	025781	025760	025759	025759	025758	025757	026596
Roller stripper (2-pieces) for middle piece ♦	029795	029796	029797	029797	029798	029799	029800
Rollers cylindrical design ♦	017869	016952	016951	016951	016953	018345	026594
Rollers spherical design ♦	016900	017658	018433	018433	018443	019545	121302
Rollers synthetic material*** ♦	024409	029451	023443	023443	023672	023650	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material ♦	029795	197520	029797	029797	205400	029799	-
Rollers carbide ♦	128794	129223	129225	129225	220918	222038	on request
Adjustment device 1 set = 3 pieces	-	-	200178	200178	200179	200179	200179

* When placing an order please advise voltage.
** On request 110 V available.
*** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SR®

Self-centering Steady Rests
Premium line

- **Sealed body**
- **Integrated coolant flush**
- **Chip guard with coolant nozzles**
- **Stroke control unit or proximity switch for end position open**



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Size		SR 2	SR 3	SR 3.1	SR 3.2	SR 4	SR 5	SR 5.1	SR 6
Centering range with coolant chip guard	U_1	20 (8*)	28 (12*)	25 (20*)	50	30	45	85	125
	U_2	101 (92**)	152	165	200	245	310	350	460
Max. axial clearing diameter	U_3	106	162	172	202	253	320	352	466
	A	277	428	436	455	603	697	717	953.5
	B	195	312	320	335	448	510	530	715
	C	70	115	123	138	146	178	198	215
	D	85	135	135	135	240	270	270	330
	E	170	262	262	262	365	400	400	610 / 640
	F	195	295	295	295	405	440	440	680
	G	75	105	105	105	125	150	150	175
	K	35	45	45	45	60	75	75	85
Width of rollers	L	19	25	25	25	25	29	29	32
Diameter of rollers	M	35	47	47	47	52	62	62	90
	O	82	116	116	120	155	187	187	238.5
	P_1	63	85	85	85	91	97	97	122
	P_2	40	53	53	53	61	63	63	88
	P_3	82	95	95	95	103	105	105	130
	P_4	61	74	74	74	82	84	84	109
	R	74	119	124	139	172	209	229	290
	S	14	18	18	18	23	23	23	27
	V	51	85	93	103	128	160	180	190
	W_1	30	50	50	50	58	62	62	100
	W_2	11.2	10	10	10	18.3	19.1	19.1	22
	α	15°	15°	15°	15°	15°	18°	18°	10°
	β	30°	30°	30°	30°	40°	40°	40°	50°
Piston area***	cm²	19.6	38.5	38.5	38.5	63.6	78.5	78.5	176.7
Operating pressure min. / max.	bar	8 / 70	8 / 80	8 / 80	8 / 80	8 / 70	8 / 80	8 / 80	8 / 75
Max. clamping force / roller	daN	450	1000	1000	1000	1500	2000	2000	4500
Centering accuracy within the whole range	mm	0.02	0.04	0.04	0.04	0.05	0.06	0.06	0.06
Repeatability accuracy	mm	0.005	0.007	0.007	0.007	0.007	0.01	0.01	0.01
Max. roller surface speed	m/min	800	725	725	725	715	600	600	560
Weight approx.	kg	14	56	57	59	117	174	178	436

* The Steady Rest can be modified to this clamping range (see instruction manual page 24) if the coolant chip guard is not used.
** Can be loaded axially. Radial loading with chip guard Ø 92, without chip guard Ø 101.
*** Cylinder sizes different from standard available on request.

SR Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)***									
Steady Rest size		2	3	3.1	3.2	4	5	5.1	6
SR-M Manual lubrication	Id. No.	128161	128167	128184	127511	127001	128001	128039	128426
SR-Z Central lubrication oil	Id. No.	128160	128166	128185	127510	127000	128000	128038	128425
SR-OLD Central lubrication oil + air	Id. No.	128162	128168	128186	127512	127002	128002	128040	128427
SR-F Central grease lubrication	Id. No.	225568	on request	222282	227176	on request	227600	on request	on request

SR Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA									
Steady Rest size		2	3	3.1	3.2	4	5	5.1	6
SR-M Manual lubrication	Id. No.	on request	128169	128187	126559	127017	128017	128046	128451
SR-Z Central lubrication oil	Id. No.	220432	128170	128188	126560	127016	128016	128045	128450
SR-OLD Central lubrication oil + air	Id. No.	on request	128171	128189	126561	127018	128018	128047	128452
SR-F Central grease lubrication	Id. No.	on request	on request	on request	on request	on request	on request	on request	on request

SR Steady Rest with stroke control via linear stroke control SCU, output 0 - 10 V									
Steady Rest size		2	3	3.1	3.2	4	5	5.1	6
SR-M Manual lubrication	Id. No.	on request	128172	128190	126563	127022	128021	128049	128453
SR-Z Central lubrication oil	Id. No.	220434	128173	128191	126564	127021	128020	128048	128454
SR-OLD Central lubrication oil + air	Id. No.	on request	128174	128192	126565	127023	128022	128050	128455
SR-F Central grease lubrication	Id. No.	on request	on request	on request	on request	on request	on request	on request	on request

Type SR

♦ means wearing parts, recommended stock items

Steady Rest size		2	3	3.1	3.2	4	5	5.1	6
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pieces per Steady Rest)		127237	127240	127240	127240	128474	128584	128584	128585
Inductive limit switch		087926	087926	087926	087926	087926	087926	087926	087926
Swarf guard coolant / air with wiper		128106	124024	124024	124024	125797	125816	125816	128442
Wiper for swarf guard coolant / air ♦		128108	124026	124026	124026	126904	126888	126888	128444
Swarf guard (3-pieces) ♦		026116	026117	026117	-	-	-	-	-
Roller stripper (2-pieces) for middle piece ♦		200154	198950	198950	198950	200151	200152	200152	200153
Roller cylindrical design ♦		016952	016951	016951	016951	016953	018345	018345	028971
Roller spherical design ♦		017658	018433	018433	018433	018443	019545	019545	129825
Roller synthetic material**** ♦		029451	023443	023443	023443	023672	023650	023650	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material ♦		204211	204212	204212	204212	204214	204216	204216	-
Roller carbide ♦		129223	129225	129225	129225	220918	222038	222038	on request
Adjustment device 1 set = 3 pieces		-	200178	200178	200178	200179	200179	200179	200179

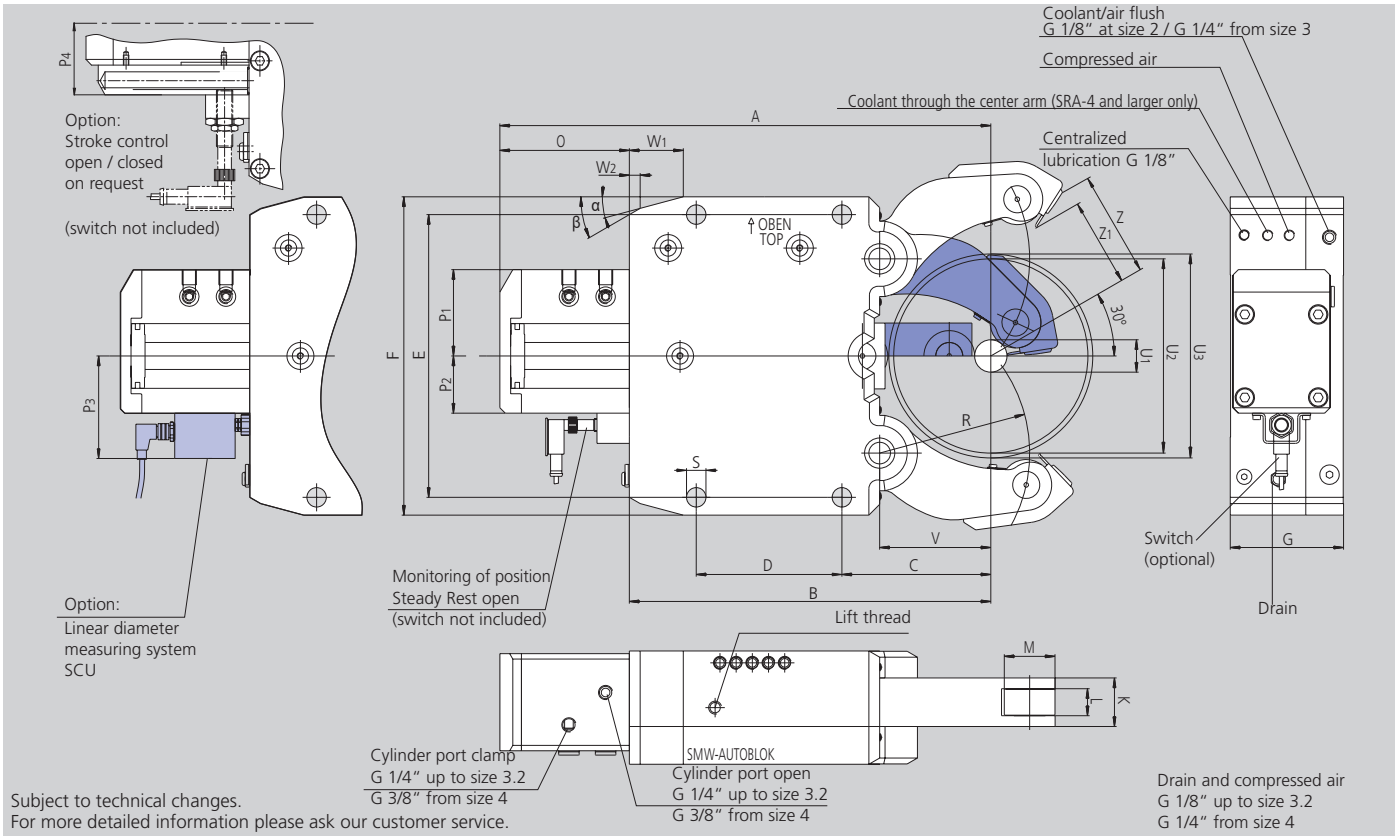
* When placing an order, please advise voltage.
** On request 110 V available.
*** Stroke control open / closed on request.
**** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SRA

Self-centering Steady Rests
Premium line

Additional pivoting upper arm for vertical loading

- Sealed body
- Integrated coolant flush
- Chip guard with coolant nozzles
- Stroke control unit or proximity switch for end position open



SMW-AUTOBLOK Type Size		SRA 2	SRA 3	SRA 3.1	SRA 4	SRA 5	SRA 6
Centering range with coolant chip guard	U_1	20 (8*)	28 (12*)	25 (22*)	30	45	175
	U_2	80	130	150	220	268	460
Max. axial clearing diameter	U_3	99	162	168	253	295	466
Vertical loading with chip guard	Z1	35	58	68	103	121	215**
Vertical loading without chip guard	Z	41	66	76	111	135	231
	A	277	428	436	603	697	953.5
	B	195	312	320	448	510	715
	C	70	115	123	146	178	215
	D	85	135	135	240	270	330
	E	170	262	262	365	400	680
	F	195	295	295	405	440	610 / 640
	G	75	105	105	125	150	175
	K	35	45	45	60	75	85
	L	19	25	25	25	29	32
Width of rollers	M	35	47	47	52	62	90
Diameter of rollers	O	82	116	116	155	187	238.5
	P_1	63	85	85	91	97	122
	P_2	40	53	53	61	63	88
	P_3	82	95	95	103	105	130
	P_4	61	74	74	82	84	109
	R	74	119	124	172	209	290
	S	14	18	18	23	23	27
	V	51	85	93	128	160	190
	W_1	30	50	50	58	62	100
	W_2	11.2	10	10	18.3	19.1	22
	α	15°	15°	15°	15°	18°	10°
	β	30°	30°	30°	40°	40°	50°
Piston area***	cm²	19.6	38.5	38.5	63.6	78.5	176.7
Operating pressure min. / max.	bar	70	80	80	70	80	75
Max. clamping force / roller	daN	450	1000	1000	1500	2000	4500
Centering accuracy within the whole range	mm	0.02	0.04	0.04	0.05	0.06	0.06
Repeatability accuracy	mm	0.005	0.007	0.007	0.007	0.01	0.01
Max. roller surface speed	m/min	800	725	725	715	600	560
Weight approx.	kg	14	56	57	117	174	436

* The Steady Rest can be modified to this clamping range (see instruction manual page 24) if the coolant chip guard is not used.
** SRA-6: Loading diameter only under 19° installation.
*** Cylinder sizes different from standard available on request.

SRA Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)***							
Steady Rest size		**2**	**3**	**3.1**	**4**	**5**	**6**
SRA-M Manual lubrication	Id. No.	128163	128175	128193	127025	128025	128457
SRA-Z Central lubrication oil	Id. No.	128164	128176	128194	127024	128024	128456
SRA-OLD Central lubrication oil + air	Id. No.	128165	128177	128195	127026	128026	128458
SRA-F Central grease lubrication	Id. No.	227453	226444	on request	on request	on request	on request

SRA Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA							
Steady Rest size		**2**	**3**	**3.1**	**4**	**5**	**6**
SRA-M Manual lubrication	Id. No.	227454	128178	128196	127031	128031	128467
SRA-Z Central lubrication oil	Id. No.	on request	128179	128197	127030	128030	128468
SRA-OLD Central lubrication oil + air	Id. No.	on request	128180	128198	127032	128032	128469
SRA-F Central grease lubrication	Id. No.	227455	on request	on request	on request	on request	on request

SRA Steady Rest with stroke control via linear stroke control SCU, output 0 - 10 V							
Steady Rest size		**2**	**3**	**3.1**	**4**	**5**	**6**
SRA-M Manual lubrication	Id. No.	227456	128181	128199	127034	128035	128471
SRA-Z Central lubrication oil	Id. No.	on request	128182	128200	127033	128034	128470
SRA-OLD Central lubrication oil + air	Id. No.	on request	128183	128201	127035	128036	128472
SRA-F Central grease lubrication	Id. No.	227457	on request	on request	on request	on request	on request

Type SRA

♦ means wearing parts, recommended stock items

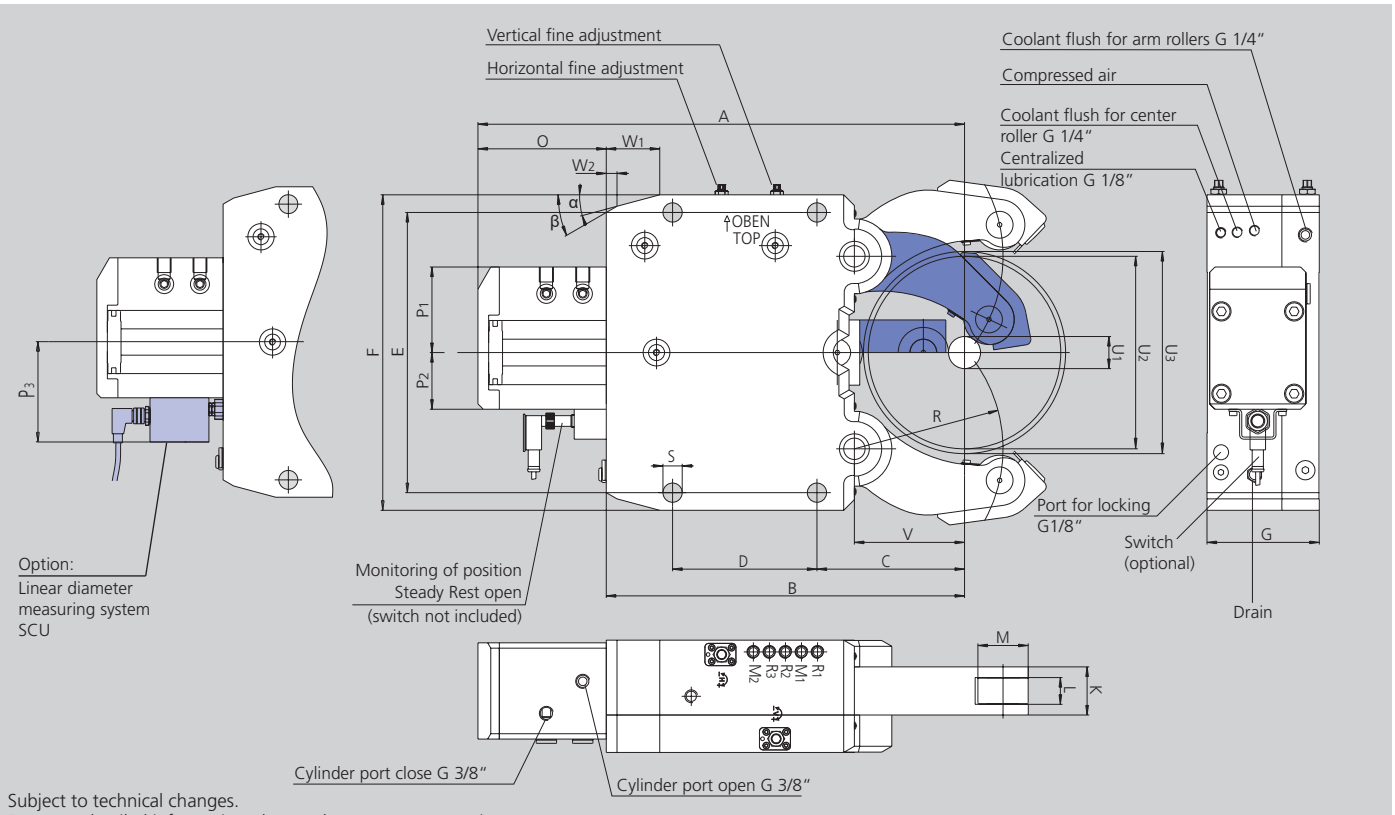
Steady Rest size	**2**	**3**	**3.1**	**4**	**5**	**6**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pieces per Steady Rest)	127237	127240	127240	128474	128584	128585
Inductive limit switch	087926	087926	087926	087926	087926	087926
Swarf guard coolant / air with wiper	128106	124024	124024	125797	125816	128442
♦ Wiper for swarf guard coolant / air	128108	124026	124026	126904	126888	128444
♦ Swarf guard (3-pieces)	026116	026117	026117	-	-	-
♦ Roller stripper (2-pieces) for middle piece	200154	198950	198950	200151	200152	200153
♦ Roller cylindrical design	016952	016951	016951	016953	018345	028971
♦ Roller spherical design	017658	018433	018433	018443	019545	129825
♦ Roller synthetic material****	029451	023443	023443	023672	023650	227357
♦ Roller stripper (2-pieces) for middle piece with roller synthetic material	204211	204212	204212	204214	204216	-
♦ Roller carbide	129223	129225	129225	220918	222038	on request
Adjustment device 1 set = 3 pieces	-	200178	200178	200179	200179	200179

* When placing an order, please advise voltage.
** On request 110 V available.
*** Stroke control open / closed on request.
**** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SR-CL

Self-centering Steady Rests
Premium line – with fine adjustment

- **With fine adjustment of the clamped workpiece**
- **Sealed body**
- **Integrated coolant flush**
- **Chip guard with coolant nozzles**



Subject to technical changes.
For more detailed information please ask our customer service.

Drain and compressed air G 1/4"

SMW-AUTOBLOK Type Size		SR-CL 4	SR-CL 5	SR-CL 5.1	SR-CL 6
Id. No.		**222070**	**222071**	**222072**	**222073**
Centering range with coolant chip guard	U_1	30	45	85	125
	U_2	245	310	350	460
Max. axial clearing diameter	U_3	253	320	352	466
Horizontal adjustment range	mm	± 0.3	± 0.4	± 0.4	± 0.5
Vertical adjustment range	mm	± 0.3	± 0.4	± 0.4	± 0.5
	A	603	697	717	953.5
	B	448	510	530	715
	C	146	178	198	215
	D	240	270	270	330
	E	365	400	400	610
	F	405	440	440	680
	G	130	160	160	180
	K	60	75	75	85
Width of rollers	L	25	29	29	32
Diameter of rollers	M	52	62	62	90
	O	155	187	187	238.5
	P_1	91	97	97	122
	P_2	61	63	63	88
	P_3	103	105	105	130
	R	172	209	229	290
	S	23	23	23	27
	V	128	160	180	190
	W_1	58	62	62	22
	W_2	18.3	19.1	19.1	100
	α	15°	18°	18°	10°
	β	40°	40°	40°	50°
Piston area	cm²	63.6	78.5	78.5	176.7
Operating pressure min. / max.	bar	8/70	8/80	8/80	8/75
Max. clamping force / roller	daN	1500	2000	2000	4500
Centering accuracy within the whole range	mm	0.05	0.06	0.06	0.06
Repeatability accuracy	mm	0.007	0.01	0.01	0.01
Max. roller surface speed	m/min	715	600	600	560
Weight approx.	kg	121	178	182	441

SR-CL

Self-centering Steady Rests
Premium line – with fine adjustment

SR-CL Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)					
Steady Rest size		**4**	**5**	**5.1**	**6**
SR-CL-M Manual lubrication	Id. No.	on request	on request	on request	on request
SR-CL-Z Central lubrication oil	Id. No.	222070	222071	222072	222073
SR-CL-OLD Central lubrication oil + air	Id. No.	on request	on request	on request	on request
SR-CL-F Central grease lubrication	Id. No.	on request	on request	on request	on request

SR-CL Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA					
Steady Rest size		**4**	**5**	**5.1**	**6**
SR-CL-M Manual lubrication	Id. No.	on request	on request	on request	on request
SR-CL-Z Central lubrication oil	Id. No.	on request	on request	on request	on request
SR-CL-OLD Central lubrication oil + air	Id. No.	on request	on request	on request	on request
SR-CL-F Central grease lubrication	Id. No.	on request	on request	on request	on request

SR-CL Steady Rest with stroke control via linear stroke control SCU, output 0 - 10 V					
Steady Rest size		**4**	**5**	**5.1**	**6**
SR-CL-M Manual lubrication	Id. No.	on request	on request	on request	on request
SR-CL-Z Central lubrication oil	Id. No.	on request	on request	on request	on request
SR-CL-OLD Central lubrication oil + air	Id. No.	on request	on request	on request	on request
SR-CL-F Central grease lubrication	Id. No.	on request	on request	on request	on request

Type SR-CL

♦ means wearing parts, recommended stock items

Steady Rest size		4	5	5.1	6
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708
Inductive limit switch		087926	087926	087926	087926
Swarf guard coolant / air with wiper		222594	222596	222596	221976
Wiper for swarf guard coolant/air	♦	222595	222597	222597	221699
Roller stripper (2-pieces) for middle piece	♦	200151	200152	200152	200153
Roller cylindrical design	♦	016953	018345	018345	028971
Roller spherical design	♦	018443	019545	019545	129825
Roller synthetic material***	♦	023672	023650	023650	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material	♦	204214	204216	204216	-
Roller carbide	♦	220918	222038	222038	on request
Adjustment device 1 set = 3 pieces		200179	200179	200179	200179

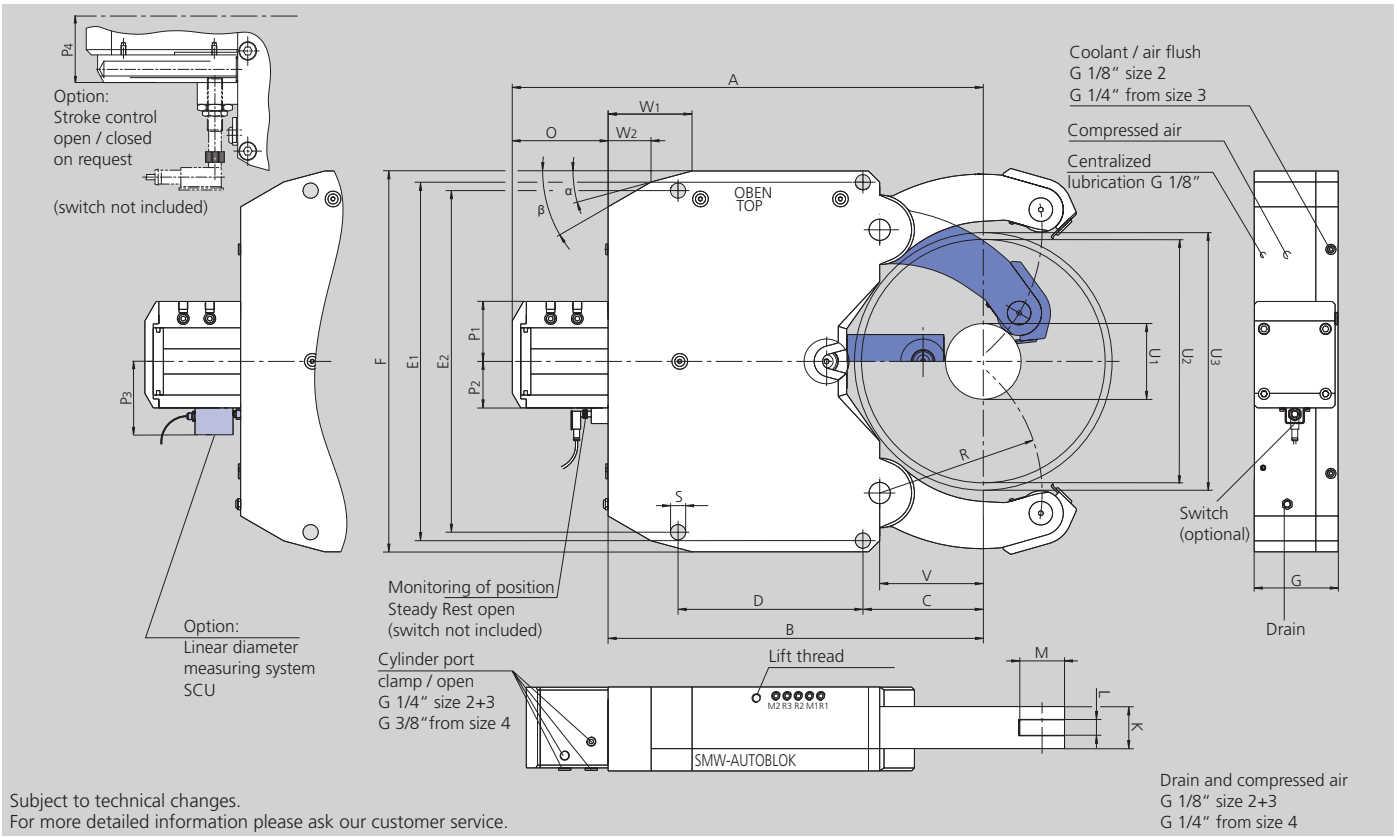
* When placing an order, please advise voltage.
** On request 110 V available.
*** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

K

Self-centering Steady Rests
Premium line

Compact design

- Sealed body
- Chip guard with coolant nozzles
- Stroke control unit or proximity switches



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Size		K 2	K 3	K 4	K 4.1	K 5	K 5.1	K 6	K 6.1
Centering range with coolant chip guard	U1	25	65	52	90	80	100	135	215
	U2	180	235	280	330	390	410	460	510
Max. axial clearing diameter	U3	188	242	285	331	404	424	464	512
	A	400	443	582	612	753	763	816	815.5
	B	305	355	460	490	607	617	670	680
	C	120	150	168	198	230	240	215	245
	D	120	140	180	180	240	240	330	300
	E1	270	312	360	360	445	445	640	640
	E2	270	312	360	360	445	445	610	610
	F	295	345	400	400	485	485	680	680
	G	75	105	125	125	150	150	150	150
	K	35	45	60	60	75	75	75	75
Width of rollers	L	19	25	25	25	29	29	29	29
Diameter of rollers	M	35	47	52	52	62	62	80	80
	O	95	88	122	122	146	146	146	135.5
	P1	63	92	91	91	97	97	107	107
	P2	40	62	67	67	73	73	83	83
	P3	82	104	109	109	115	115	125	125
	P4	-	-	91	91	97	97	107	107
	R	124	155	200	228	265	275	290	310
	S	14	18	23	23	23	23	27	27
	V	90	115	140	170	195	205	185	215
	W1	50	50	110	110	130	130	150	155
	α	10	15°	15°	15°	15°	15°	15°	20°
	W2	26.1	10	59.8	59.8	50.6	50.6	77	87.1
	β	35°	30°	30°	30°	30°	30°	30°	30°
Piston area*	cm²	19.6	38.5	63	63	78	78	113	113
Operating pressure min. / max.	bar	8 / 70	8 / 80	8 / 70	8 / 70	8 / 80	8 / 80	8 / 80	8 / 80
Max. clamping force / roller	daN	450	1000	1500	1500	2000	2000	3000	3000
Centering accuracy w. the whole range	mm	0.03	0.05	0.06	0.06	0.07	0.07	0.07	0.07
Repeatability accuracy	mm	0.005	0.007	0.007	0.007	0.01	0.01	0.01	0.01
Max. roller surface speed	m/min	800	725	715	715	600	600	560	560
Weight approx.	kg	52	64	114	116	209	209	335	330

* Cylinders differing from standard available on request.

K Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)***									
Steady Rest size		2	3	4	4.1	5	5.1	6	6.1
K-M Manual lubrication	Id. No.	223566	127251	129901	129121	127485	127559	127491	127497
K-Z Central lubrication oil	Id. No.	223565	127252	129900	129120	127484	127558	127490	127496
K-OLD Central lubrication oil + air	Id. No.	223567	127253	129902	129122	127486	127560	127492	127498
K-F Central grease lubrication	Id. No.	223568	220200	129903	129400	221815	221100	223494	223495

K Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA									
Steady Rest size		2	3	4	4.1	5	5.1	6	6.1
K-M Manual lubrication	Id. No.	on request	127266	221401	221409	124981	124984	124987	124990
K-Z Central lubrication oil	Id. No.	on request	127265	221400	221408	124980	124983	124986	124989
K-OLD Central lubrication oil + air	Id. No.	on request	127267	221402	221410	124982	124985	124988	124991
K-F Central grease lubrication	Id. No.	on request	on request	221403	221411	on request	on request	on request	on request

K Steady Rest with stroke control via linear stroke control SCU, output 0 - 10 V									
Steady Rest size		2	3	4	4.1	5	5.1	6	6.1
K-M Manual lubrication	Id. No.	on request	127269	221405	221413	125120	125123	125126	125129
K-Z Central lubrication oil	Id. No.	on request	127268	221404	221412	125119	125122	125125	125128
K-OLD Central lubrication oil + air	Id. No.	on request	127270	221406	221414	125121	125124	125127	125130
K-F Central grease lubrication	Id. No.	on request	on request	221407	221415	on request	on request	on request	on request

Type K

♦ means wearing parts, recommended stock items

Steady Rest size			2	3	4	4.1	5	5.1	6	6.1
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**			088707	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**			088708	088708	088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)			127237	127240	128474	128474	125612	125612	124894	124894
Inductive limit switch			087926	087926	087926	087926	087926	087926	087926	087926
Swarf guard coolant / air with wiper			128106	124024	125797	125797	125816	125816	125837	125837
Wiper for swarf guard coolant / air		♦	128108	124026	126904	126904	126888	126888	126694	126694
Roller stripper for middle piece (2 pieces)		♦	200154	198950	200151	200151	200152	200152	203268	203268
Roller cylindrical design		♦	016952	016951	016953	016953	018345	018345	026594	026594
Roller spherical design		♦	017658	018433	018443	018443	019545	019545	121302	121302
Roller synthetic material ****		♦	029451	023443	023672	023672	023650	023650	227357	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material		♦	204211	204212	204214	204214	204216	204216	-	-
Roller carbide		♦	129223	129225	220918	220918	222038	222038	on request	on request
Adjustment device 1 set = 3 pcs.			200178	200178	200179	200179	200179	200179	200179	200179

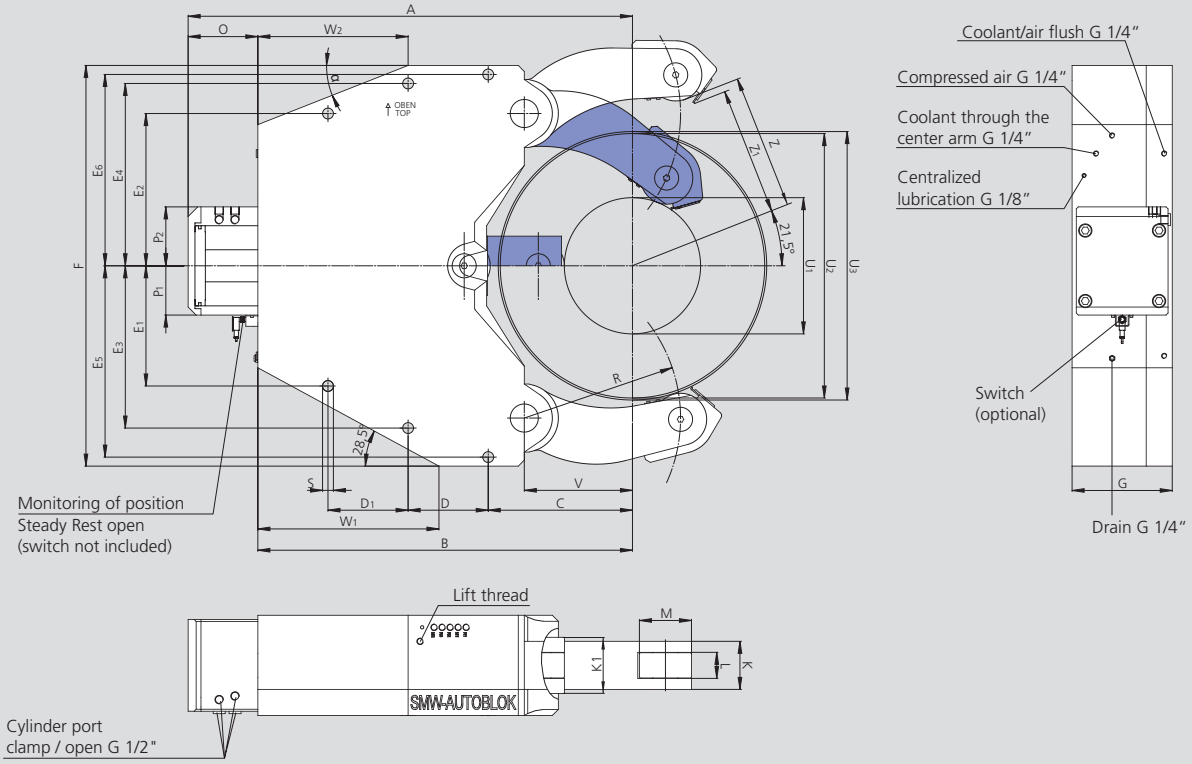
* When placing an order, please advise voltage.
** On request 110 V available.
*** Stroke control open / closed on request.
**** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

KA

Self-centering Steady Rests
Premium line

Additional pivoting upper arm for vertical loading

- Compact design, sealed body
- Chip guard with coolant nozzles
- Double guided center arm to carry heavy loads
- Excenter fine adjustment on the outer arms



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		KA 7	KA 7.1
Centering range with coolant chip guard	U_1	340	650
	U_2	660	910
Max. axial clearing diameter	U_3	670	916
Vertical loading without chip guard	Z	347.6	472
Vertical loading with chip guard	Z1	330.7	456
	A	1109	1165
	B	935	1015
	C	360	450
	D	210	220
	D_1	210	220
	E_1	300	240
	E_2	380	320
	E_3	405	365
	E_4	455	415
	E_5	477.5	477.5
	E_6	477.5	477.5
	F	1000	1000
	G	250	250
Width of outer arms	K	120	120
Width of center arm	K_1	140	140
Width of rollers	L	65	65
Diameter of rollers	M	130	130
	O	174	150
	P_1	123	123
	P_2	147	147
	R	390	530
	S	27	27
	V	270	390
	W_1	452	522
	W_2	375	485
	α	21.5°	22°
Piston area	cm^2	314	314
Operating pressure max.	bar	80	80
Max. clamping force / roller	daN	8500	8500
Centering accuracy within the whole range	mm	0.08	0.08
Repeatability accuracy	mm	0.03	0.03
Max. roller surface speed	m/min	560	560
Weight approx.	kg	975	896

KA Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)***			
Steady Rest size		**KA 7**	**KA 7.1**
KA-M Manual lubrication	Id. No.	222901	222951
KA-Z Central lubrication oil	Id. No.	222900	222950
KA-OLD Central lubrication oil + air	Id. No.	222902	222952
KA-F Central grease lubrication	Id. No.	222903	222953

Type KA

♦ **means wearing parts, recommended stock items**

Steady Rest size		KA 7	KA 7.1
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**		088708	088708
Inductive limit switch		087926	087926
Swarf guard coolant / air with wiper		222944	222944
Wiper for swarf guard coolant / air ♦		222994	222994
Roller stripper for middle piece ♦		202358	202358
Rollers cylindrical design ♦		028525	028525
Adjustment device 1 set = 3 pcs.		205696	205696

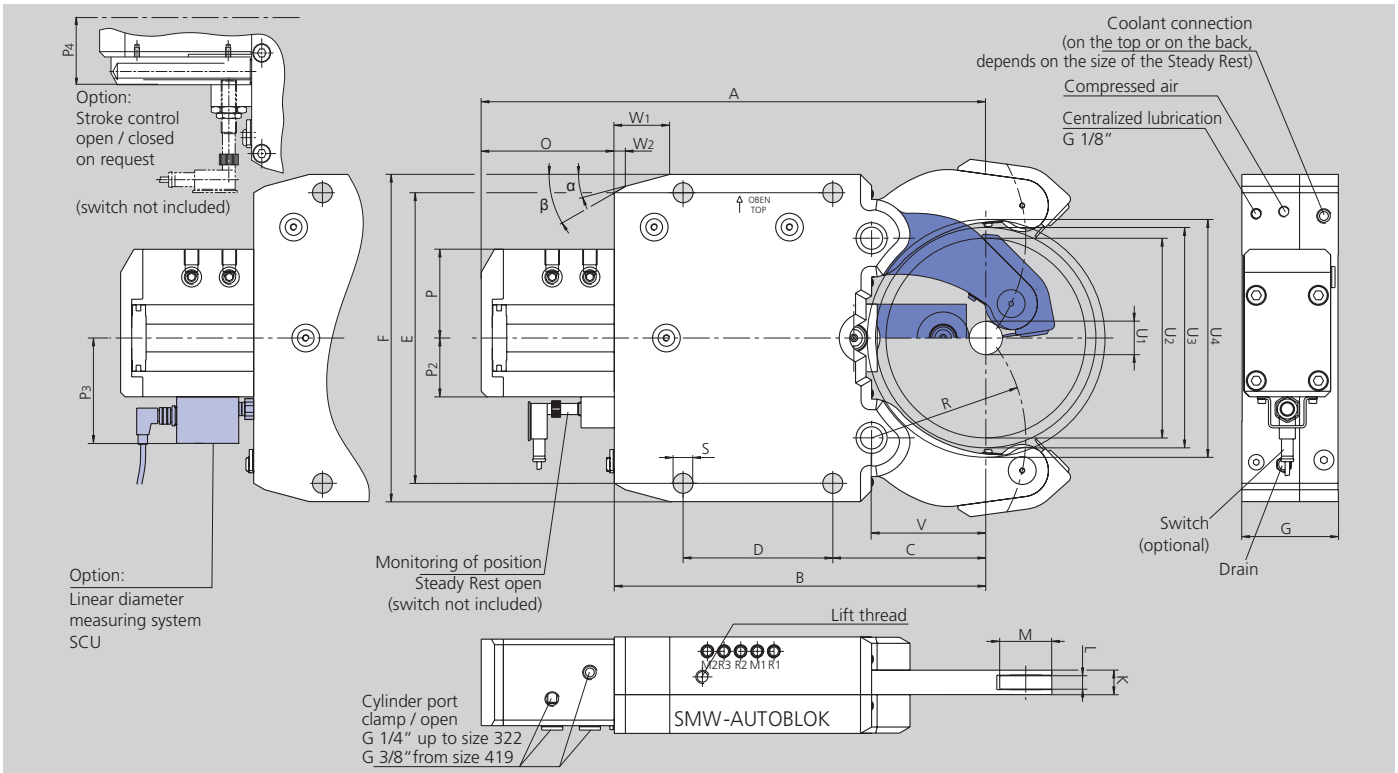
* When placing an order, please advise voltage.
** On request 110 V available.
*** Stroke control open / closed on request.

KLU / KLU-A

Self-centering Steady Rests
Premium line

Narrow arms for crankshafts

- Sealed body
- Chip guard with coolant nozzles
- Stroke control unit or proximity switches



Subject to technical changes.
For more detailed information please ask our customer service.

Drain and compressed air
G 1/8" only size 322
G 1/4" from size 419

SMW-AUTOBLOK Type / Size		KLU 215	KLU 218	KLU 222	KLU 318	KLU 322	KLU 419	KLU 422	KLU 429	KLU-A 530	KLU-A 540
Centering range with coolant chip guard	U_1	20 (12*)	20 (12*)	20 (12*)	30	30	30	30	30	70	70
	U_2	101 (92**)	101 (92**)	101 (92**)	180	180	245	245	245	293	293
Max. axial clearing diameter	U_3	106	106	106	189	189	253	253	253	330	330
Max. interference diameter	U_4	116	116	116	215	215	282	282	282	370	370
	A	275	275	275	455	455	602	602	602	703	703
	B	195	195	195	335	335	448	448	448	530	530
	C	70	70	70	138	138	146	146	146	198	198
	D	85	85	85	135	135	240	240	240	270	270
	E	170	170	170	262	262	365	365	365	400	400
	F	195	195	195	295	295	405	405	405	440	440
	G	59	62	66	83	87	89	92	99	105	115
	K	15	18	22	18	22	19	22	29	30	40
Width of rollers	L	8	10	13	10	13	10	13	16	16	20
Diameter of rollers	M	35	35	35	47	47	52	52	52	62	62
	O	80	80	80	120	120	154	154	154	173	173
	P_1	58	58	58	80	80	80	80	80	88	88
	P_2	40	40	40	53	53	53	53	53	59	59
	P_3	-	-	-	95	95	95	95	95	101	101
	P_4	61	61	61	74	74	74	74	74	80	80
	R	74	74	74	139	139	172	172	172	229	229
	S	14	14	14	18	18	23	23	23	23	23
	V	51	51	51	103	103	128	128	128	180	180
	W_1	30	30	30	50	50	58	58	58	62	62
	W_2	11.2	11.2	11.2	10	10	18.3	18.3	18.3	19	19
	α	15°	15°	15°	15°	15°	15°	15°	15°	18°	18°
	β	30°	30°	30°	30°	30°	40°	40°	40°	40°	40°
Piston area***	cm²	12.5	12.5	12.5	28.3	28.3	28.3	28.3	28.3	50.2	50.2
Operation pressure min. / max.	bar	8 / 50	8 / 65	8 / 80	8 / 60	8 / 75	8 / 70	8 / 80	8 / 80	8 / 70	8 / 80
Max. clamping force / roller	daN	210	270	335	565	700	660	750	750	1170	1340
Centering accuracy within the whole range	mm	0.03	0.03	0.03	0.05	0.05	0.06	0.06	0.06	0.07	0.07
Repeatability accuracy	mm	0.007	0.007	0.007	0.007	0.007	0.01	0.01	0.01	0.01	0.01
Max. roller surface speed	m/min	750	750	750	715	715	700	700	700	700	700
Weight approx.	kg	14	15	16	33	36	70	74	85	100	125

* The Steady Rest can be modified to this clamping range (see instruction manual page 24) if the coolant chip guard is not used.
** Can be loaded axially. Radial loading with chip guard Ø 92, without chip guard Ø 101.
*** Cylinder sizes different from standard available on request.

KLU / KLU-A

Self-centering Steady Rests
Premium line

KLU Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)***											
Steady Rest size		**215**	**218**	**222**	**318**	**322**	**419**	**422**	**429**	**530**	**540**
KLU-Z Central lubrication oil	Id. No.	128280	128282	128284	127528	127530	127534	127536	127538	127542	127544
KLU-OLD Central lubrication oil + air	Id. No.	128281	128283	128285	127529	127531	127535	127537	127539	127543	127545
KLU-F Central grease lubrication	Id. No.	on request	on request	on request	on request	on request	on request	on request	on request	on request	on request

KLU Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA											
Steady Rest size		**215**	**218**	**222**	**318**	**322**	**419**	**422**	**429**	**530**	**540**
KLU-Z Central lubrication oil	Id. No.	-	-	-	125637	125655	125365	125398	125421	125988	126050
KLU-OLD Central lubrication oil + air	Id. No.	-	-	-	125638	125656	125366	125399	125422	125989	126051
KLU-F Central grease lubrication	Id. No.	-	-	-	on request	on request	226246	on request	on request	on request	on request

KLU Steady Rest with stroke control via linear stroke control SCU, output 0 - 10 V											
Steady Rest size		**215**	**218**	**222**	**318**	**322**	**419**	**422**	**429**	**530**	**540**
KLU-Z Central lubrication oil	Id. No.	-	-	-	125640	125657	125369	125400	125423	125992	126052
KLU-OLD Central lubrication oil + air	Id. No.	-	-	-	125641	125658	125370	125401	125424	125993	126053
KLU-F Central grease lubrication	Id. No.	-	-	-	on request	on request	on request	on request	on request	on request	on request

Type KLU

♦ denotes wearing parts, recommended stock items

Steady Rest size		**215**	**218**	**222**	**318**	**322**	**419**	**422**	**429**	**530**	**540**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707	088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708	088708	088708	088708	088708	088708	088708
Inductive limit switch		087926	087926	087926	087926	087926	087926	087926	087926	087926	087926
Swarf guard coolant / air with wiper		128270	128273	128276	125633	125652	125360	125394	125417	127036	126046
Wiper for swarf guard coolant / air ♦		128272	128275	128278	126905	126906	126907	126906	126908	126909	126910
Swarf guard 3-pcs. ♦		125906	126055	126058	-	-	-	-	-	-	-
Roller stripper for middle piece ♦		197995	197996	197997	197998	197999	198000	198001	198002	198003	198004
Roller cylindrical design ♦		122794	020062	020759	017861	002411	017676	084766	019541	125964	019612
Adjustment device 1 set = 3 pcs.		-	-	-	200178	200178	200179	200179	200179	200179	200179

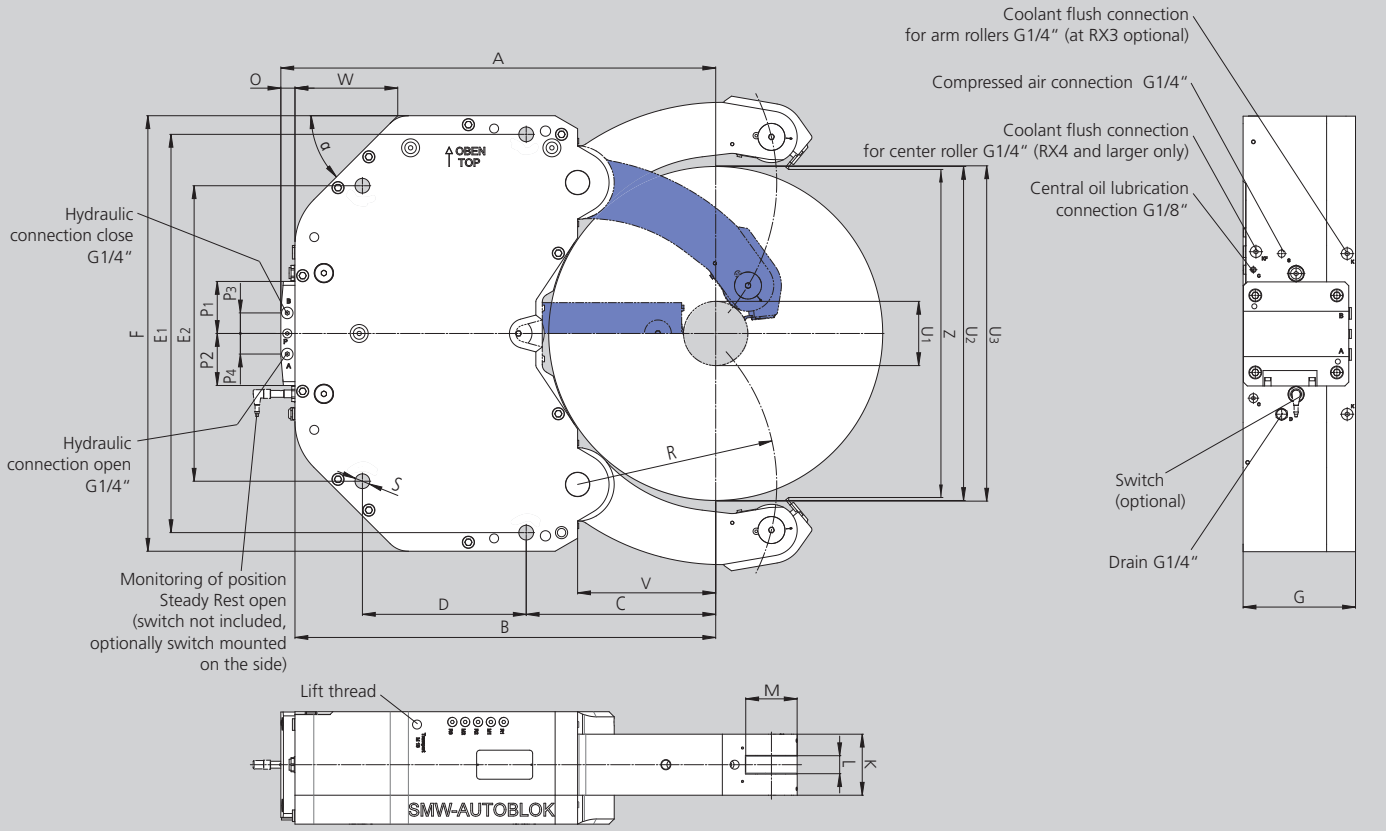
* When placing an order, please advise voltage.
** On request 110 V available.
*** Stroke control open / closed on request.

RX

Self-centering Steady Rests
Premium line

Extra compact Steady Rest

- Integrated cylinder
- Sealed body
- Chip guard with coolant nozzles
- Stroke control with proximity switch



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Size		RX 3	RX 4	RX 5	RX 6	RX 6.1
Centering range with coolant chip guard	U1	20	35	75	100	250
Max. clamping diameter*	U2	270	340	430	520	685
Max. axial clearing diameter	U3	275	345	432	522	687
	A	430	504	599	677	792
	B	408	482	577	655	770
	C	140	170	225	295	370
	D	170	220	235	255	290
	E1	400	460	490	620	720
	E2	340	360	360	460	520
	F	440	500	530	678	760
	G	150	155	165	175	175
	K	75	80	85	95	95
Width of rollers	L	25	25	29	29	29
Diameter of rollers	M	47	52	62	80	80
	O	22	22	22	22	22
	P1	81	81	81	81	81
	P2	81	81	81	81	81
	P3	30	30	30	30	30
	P4	30	30	30	30	30
	R	164	210	270	310	395
	S	18	23	23	23	23
	V	118	148	200	215	285
	W	108	121	175	160	197 / 45.6
With coolant flush / without coolant flush	Z	270 / 279	332.8	432	510.6	682
	α	45°	45°	38°	45°	40° / 60°
Piston area	cm²	12.56	12.56	12.56	19.63	19.63
Operating pressure min. / max. „close" **	bar	10 / 60	10 / 50	10 / 65	10 / 60	10 / 60
Operating pressure min. / max. „open" **	bar	20 / 60	20 / 50	20 / 65	20 / 60	20 / 60
Max. clamping force / roller	daN	1000	1500	2000	3000	3000
Centering accuracy over the whole range	mm	0.08	0.1	0.1	0.1	0.1
Repeatability accuracy	mm	0.007	0.01	0.01	0.01	0.01
Max. roller surface speed	m/min	725	715	600	560	560
Weight approx.	kg	120	152	190	295	325

* Can be loaded axially. Radial loading is possible, without chip guard.

** 240 bar in the cylinder created by the pressure booster (ratio 1:4 RX3). 375 / 485 / 450 bar in the cylinder created by the pressure booster (ratio 1:7.5 RX4-6.1). In case a lower pressure for the function „Steady Rest close" is needed, two independent pressure regulators for open and close have to be installed.

RX Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)							
Steady Rest size		**3**	**3** (incl. flush)	**4**	**5**	**6**	**6.1**
RX-M Manual lubrication	Id. No.	on request	227773	227370	226501	226975	on request
RX-Z Central lubrication oil	Id. No.	224670	224690	224700	224200	224140	224220
RX-OLD Central lubrication oil + air	Id. No.	227570	on request	on request	on request	227310	on request
RX-F Central grease lubrication	Id. No.	on request	227234	227235	227332	226900	on request

RX Steady Rest with stroke control via linear stroke control SCU, output 4 - 20 mA							
Steady Rest size		**3**	**3** (incl. flush)	**4**	**5**	**6**	**6.1**
RX-M Manual lubrication	Id. No.	on request	on request	on request	on request	on request	on request
RX-Z Central lubrication oil	Id. No.	227961	227962	on request	228045	on request	227311
RX-OLD Central lubrication oil + air	Id. No.	on request	on request	on request	on request	on request	on request
RX-F Central grease lubrication	Id. No.	on request	on request	on request	on request	on request	on request

RX Steady Rest with stroke control via linear stroke control SCU, output 0 - 10V							
Steady Rest size		**3**	**3** (incl. flush)	**4**	**5**	**6**	**6.1**
RX-M Manual lubrication	Id. No.	on request	on request	on request	on request	on request	on request
RX-Z Central lubrication oil	Id. No.	224946	227980	on request	225925	227766	on request
RX-OLD Central lubrication oil + air	Id. No.	on request	on request	on request	on request	on request	on request
RX-F Central grease lubrication	Id. No.	on request	on request	on request	on request	on request	on request

Type RX

♦ means wearing parts, recommended stock items

Steady Rest size		**3**	**3** (incl. flush)	**4**	**5**	**6**	**6.1**
Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**		088707	088707	088707	088707	088707	088707
Compact lubrication system for oil + air lubrication Container 2.7 l, 220 V *,**		088708	088708	088708	088708	088708	088708
Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest)		224665	224665	224694	224193	224196	224196
Inductive limit switch		087926	087926	087926	087926	087926	087926
Swarf guard (3-pieces)	♦	026117	-	-	-	-	-
Swarf guard coolant / air with wiper		-	224697	125797	125816	125837	125837
Wiper for swarf guard coolant / air	♦	-	124026	126904	126888	126694	126694
Roller stripper for middle piece (2-pieces)	♦	198950	198950	200151	200152	203268	203268
Roller cylindrical design	♦	016951	016951	016953	018345	026594	026594
Roller spherical design	♦	018433	018433	018443	019545	121302	121302
Roller synthetic material ***	♦	023443	023443	023672	023650	227357	227357
Roller stripper (2-pieces) for middle piece with roller synthetic material	♦	204212	204212	204214	204216	-	-
Roller carbide	♦	129225	129225	220918	222038	on request	on request
Adjustment device 1 set = 3 pcs.		200178	200178	200179	200179	200179	200179

* When placing an order, please advise voltage.
** On request 110 V available.
*** Attention: Reduced clamping force! Please refer to the clamping force value marked on the roller.

SCU

Linear stroke control unit for Steady Rests

- Completely sealed, protection class IP 66
- Output signal 4-20 mA or 0-10 V

proofline® series
fully sealed – low maintenance

Application/customer benefits

- For SMW-AUTOBLOK Steady Rests
- Linear monitoring of the complete clamping stroke avoids collision with the tools, which is an added safety feature
- Time saving by only partial opening the Steady Rest (with corresponding hydraulic power unit)

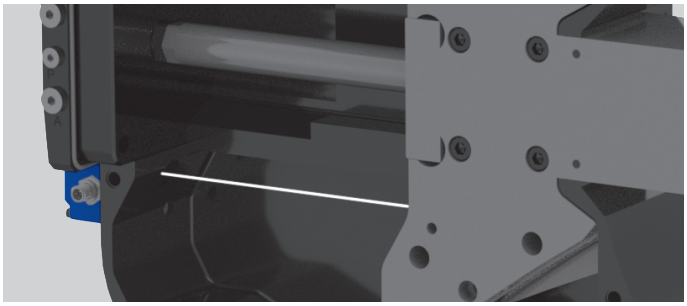
Technical features

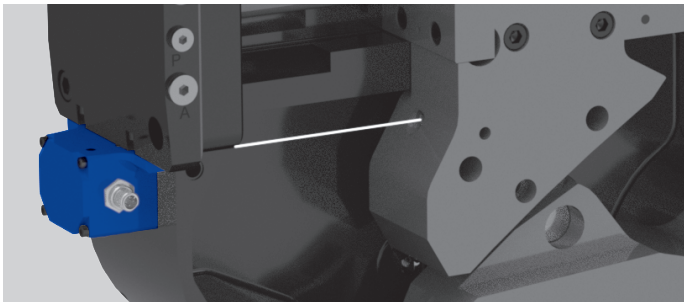
- Protection class IP 66
- Output signal 4 - 20 mA or 0 - 10 V
- Electrical power supply 24 VDC
- **proofline®** = fully sealed – low maintenance

Accessories

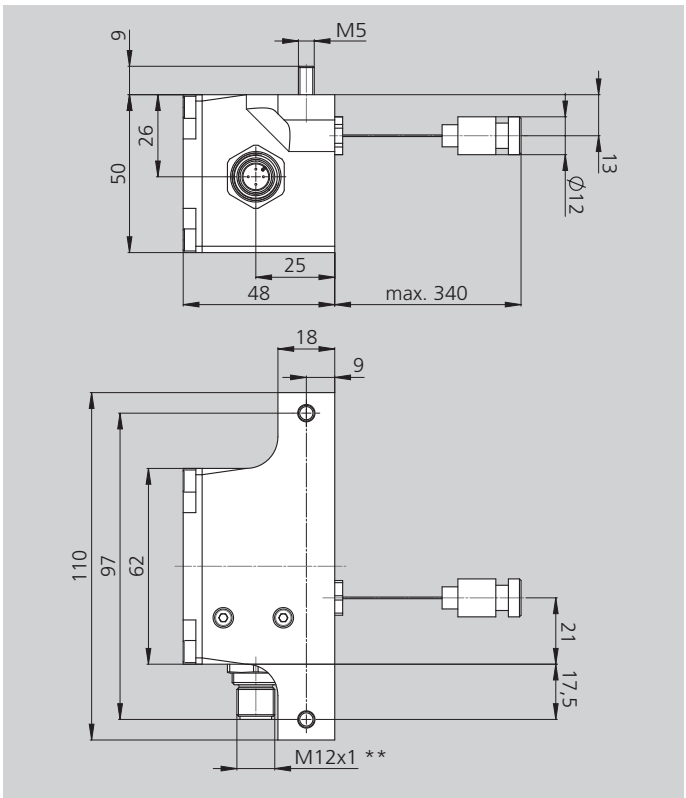
Sensor connection cable see LPS 4.0
(Plug M12 x 1 4-pin) see general catalog page 329

Installation and Position

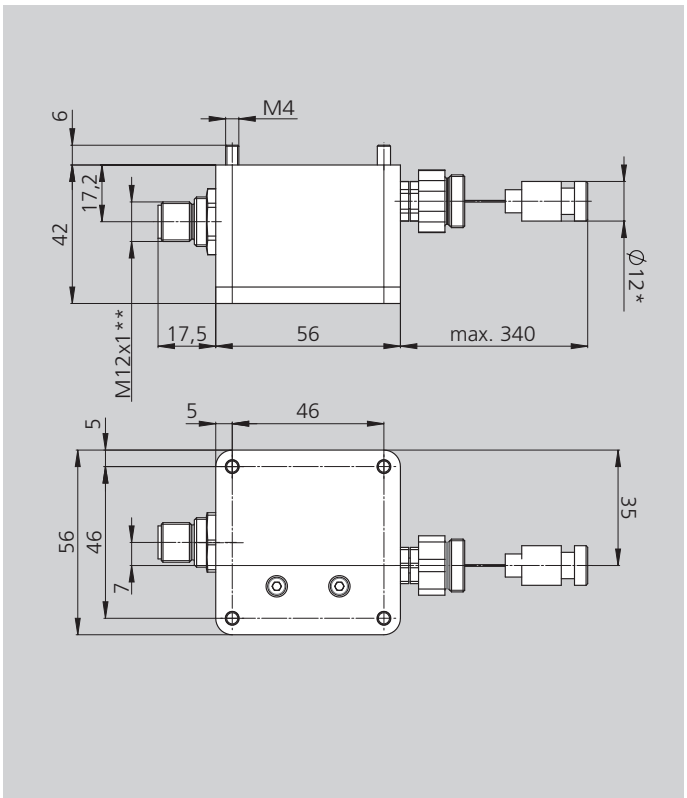




Technical data for Steady Rests type RX
SCU, output 4 - 20 mA: Id. No. 224244
SCU, output 0 - 10 V: Id. No. 225924



Technical data for other Steady Rest types
SCU, output 4 - 20 mA: Id. No. 225440
SCU, output 0 - 10 V: Id. No. 226122



Note for both SCU types: It is about a two-wire system. The measuring current is simultaneously acting to feed the transformer.
Subject to technical changes. For more detailed information please ask our customer service.

* For mounting Steady Rests type KLU: Ø 8 mm.

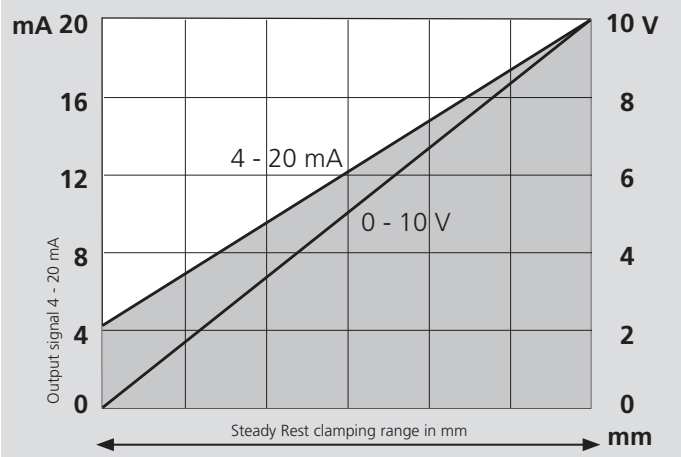
** Connector 4-pin.

Linear stroke control unit for Steady Rests

SCU

- Completely sealed, protection class IP 66
- Output signal 4 - 20 mA or 0 - 10 V

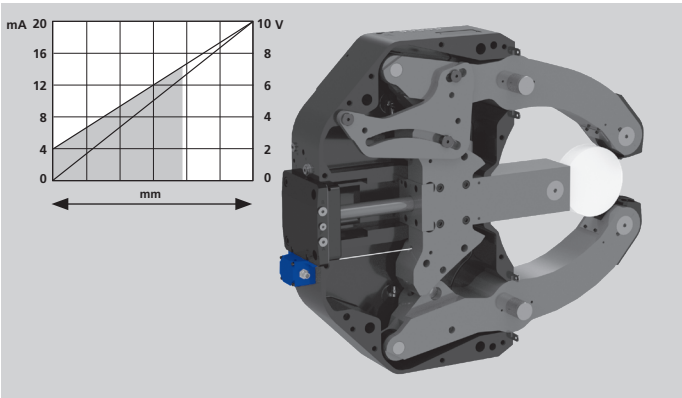
Linear stroke control unit SCU

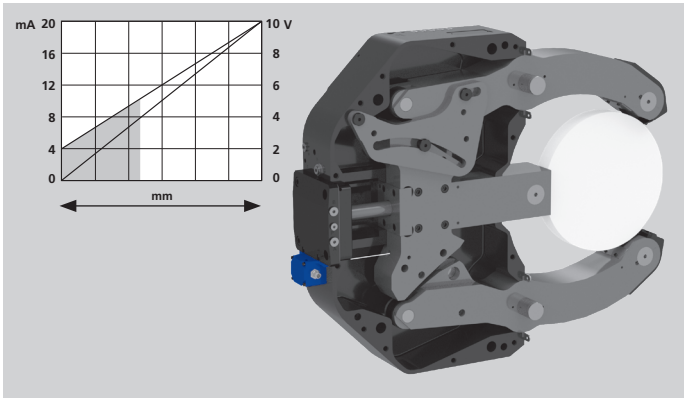


The linear stroke control unit type SCU provides a linear output signal between min. 4 mA and max. 20 mA depending on the Steady Rest clamping range.
This allows to detect any position of the Steady Rest, and thus of the Steady Rest arms, safely.

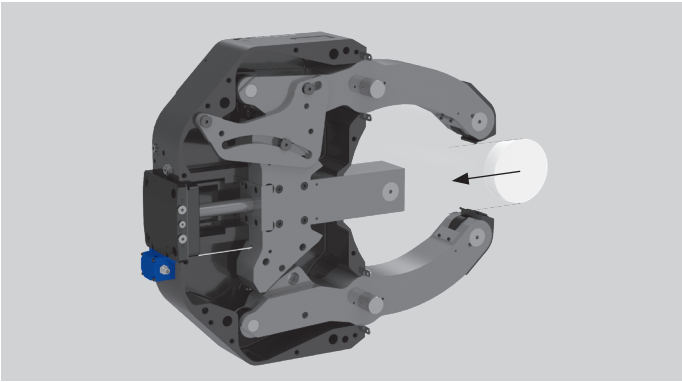
- Time saving by only partial opening the Steady Rest (with corresponding hydraulic power unit).
- Collision protection by evaluation of the output signal of the machine control.

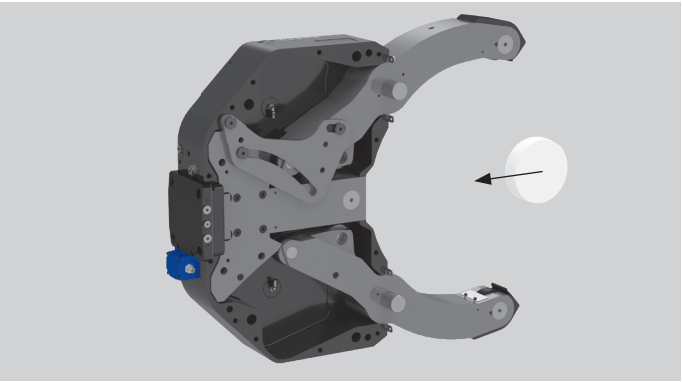
Output signal depending on the Steady Rest clamping range



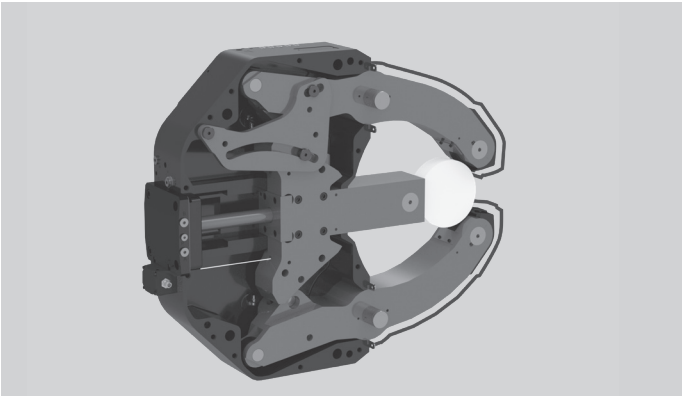


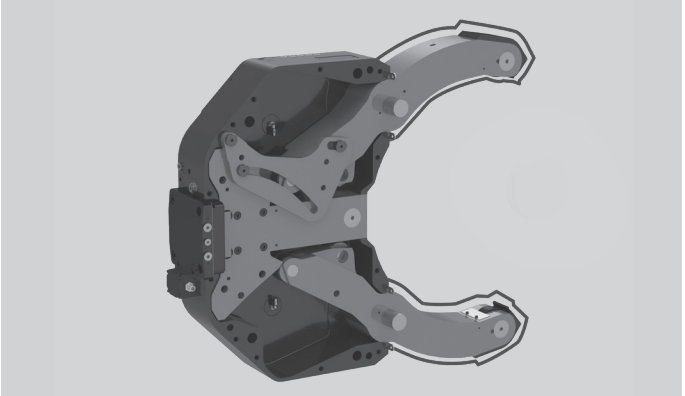
Time saving by only partial opening of the Steady Rest





Collision protection by evaluation of the output signal





SRG / SRG-B

Grinding Steady Rests

Grinding Steady Rest

■ Fine adjustment of the center
■ Retractable Steady Rest arms

Application/customer benefits

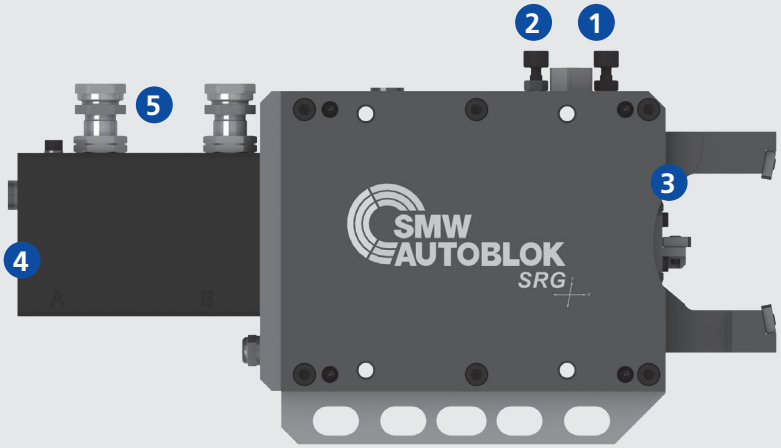
- Support of shaft type workpieces on grinding machines
- Particularly suitable for the machining of crankshafts and camshafts
- Rapid set up of the Steady Rest to the grinding center with the sensitive fine adjustment of the grinding center
- Suitable for follow down grinding
- Retractable Steady Rest arms for autoloading of workpieces
- Monitoring of end positions for process safety

Standard equipment

Basic grinding Steady Rest SRG

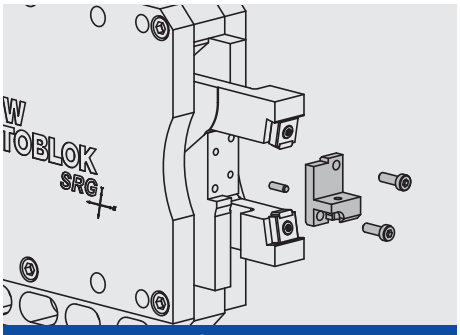
(Padholder for the middle piece, clamping kit and pad kits are not scope of delivery. For these parts please see the overview for the configurations below)

Technical details



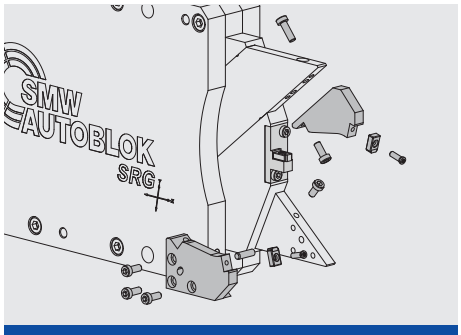
1. Horizontal fine adjustment of the grinding center.
2. Vertical fine adjustment of the grinding center.
3. Retractable Steady Rest arms.
4. Port for compressed air against dust and coolant.
5. Monitoring of end positions with proximity switches (switches not included).

Overview Configuration



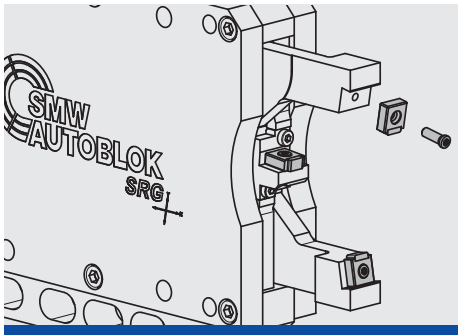
Select padholder for the middle piece* (SRG 1, 1S, 2)

- Consisting of padholder middle piece (incl. mounting material).
- 3 versions available: 0 degree, ± 5 degree, ± 7 degree.
- Can be rotated by 180 degrees.



Select clamping kit (SRG 2F, 3F, 4F, 5F, 5.1FS | SRG-B 4F, 5F)**

- Consisting of 2 nests for the arms and 1 padholder for the middle piece (incl. mounting material).
- The different clamping ranges can be covered with different clamping kits.

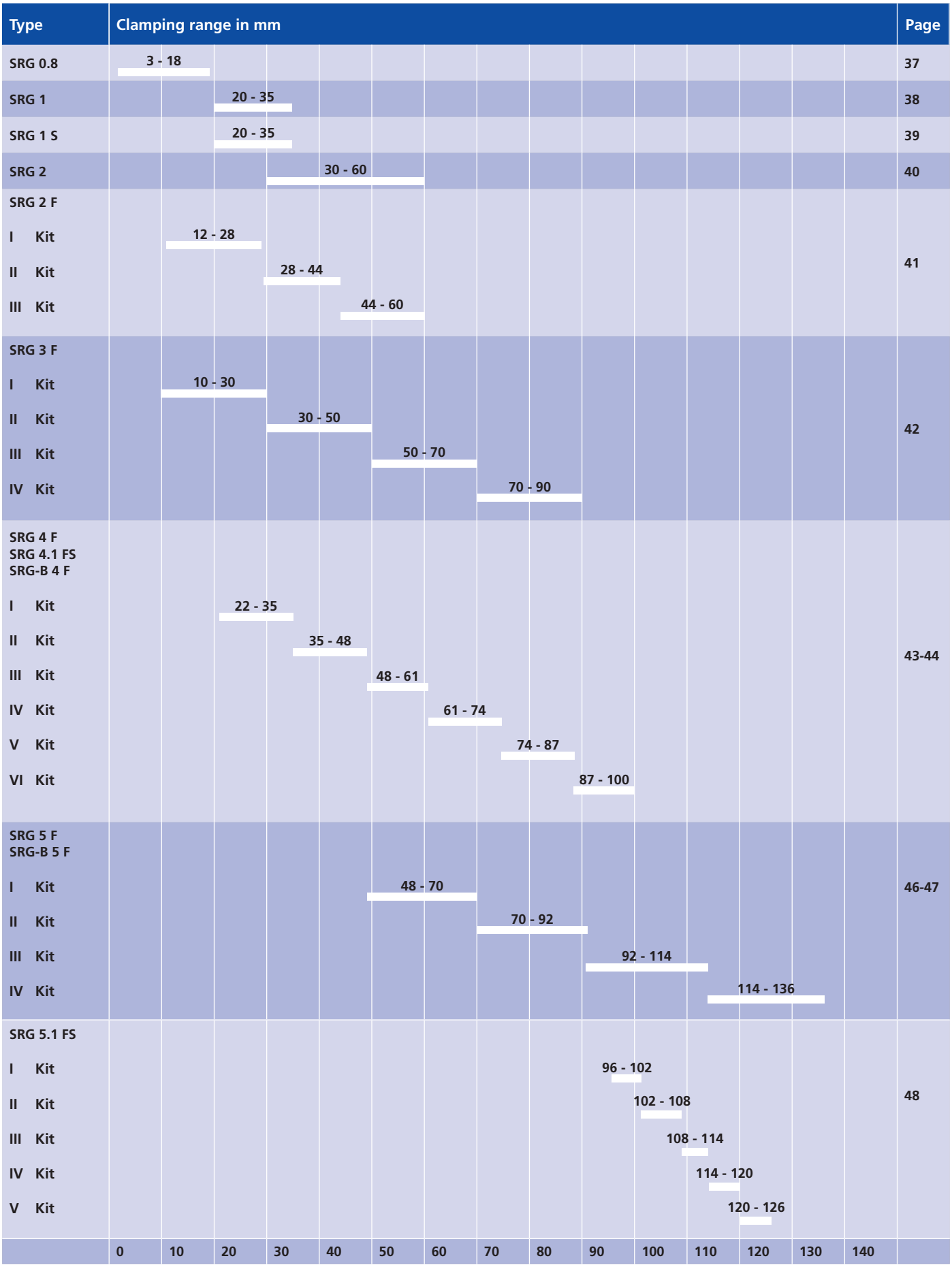


Select Pad kit***

- Consisting of 3 pads incl. 3 mounting screws.
- Standard for clamping range as shown on the Steady Rest.
- Special pad kit for shifting of the clamping range -5 mm available.

* Consisting of padholder for the middle piece incl. mounting material.
** Consisting of padholder for the middle piece and the nests for the arms incl. mounting material.
*** Consisting of 3 pads and 3 mounting bolts.

Overview clamping range



SRG / SRG-B

Grinding Steady Rests

Ordering review

SMW-AUTOBLOK type Basic Steady Rest		SRG 0.8 223250	SRG 1 221175	SRG 1 S 223060	SRG 2 221871
Clamping range	mm	**3-18**	**20-35**	**20-35**	**30-60**
Padholder 0 degree*	Id. No.	-	203977	205191	203985
Padholder ± 5 degree*	Id. No.	-	203978	205196	203986
Padholder ± 7 degree*	Id. No.	-	203979	205197	203987
Pad Kit Standard	Id. No.	205439	203976	204161	203976
Pad Kit Special * **	Id. No.	-	203939	-	203939
Working pressure	bar	20-50	15-30	20-50	15-30
Follow down grinding		Yes	Yes	Yes	Yes
Dosing element kit	Id. No.	224379 (0.03 cm³)	224360 (0.1 cm³)	224379	224360

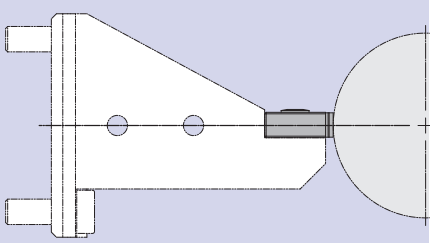
SMW-AUTOBLOK type Basic Steady Rest		SRG 2 F 222260			SRG 3 F 224450				SRG 4 F 221930			SRG-B 4 F 223140		
Clamping range	mm	**12-60****			**10-90****				**22-100**					
Clamping kit		**I**	**II**	**III**	**I**	**II**	**III**	**IV**	**I**	**II**	**III**	**IV**	**V**	**VI**
Clamping range	mm	**12-28**	**28-44**	**44-60**	**10-30**	**30-50**	**50-70**	**70-90**	**22-35**	**35-48**	**48-61**	**61-74**	**74-87**	**87-100**
Clamping kit 0 degree**	Id. No.	204383	204382	204381	224298	224297	224296	224295	205000	205001	205002	205003	205004	205005
Clamping kit ±2 degree**	Id. No.	-	-	-	-	-	-	-	205006	205007	205008	205009	205010	205011
Clamping kit ±3 degree**	Id. No.	-	-	-	-	-	-	-	-	-	-	-	-	-
Clamping kit ±5 degree**	Id. No.	206349	206348	206347	224302	224301	224300	224299	224453	224454	224455	224456	224457	224458
Clamping kit ±7 degree**	Id. No.	206346	206345	206344	224306	224305	224304	224303	224459	224460	224461	224462	224463	224464
Pad Kit Standard	Id. No.	203976			203976				204161					
Pad Kit Special***	Id. No.	203939			203939				-					
Working pressure	bar	15-30			10-30				7-25					
Follow down grinding		Yes			Yes				Yes					
Dosing element kit	Id. No.	224360			224360				-			-		

SMW-AUTOBLOK type Basic Steady Rest		SRG 4.1 FS 222410						SRG 5 F 223774		SRG-B 5 F 222530		SRG 5.1 FS 222665				
Clamping range	mm	**22-100**						**48-136**				**96-126**				
Clamping kit		**I**	**II**	**III**	**IV**	**V**	**VI**	**I**	**II**	**III**	**IV**	**I**	**II**	**III**	**IV**	**V**
Clamping range	mm	**22-35**	**35-48**	**48-61**	**61-74**	**74-87**	**87-100**	**48-70**	**70-92**	**92-114**	**114-136**	**96-102**	**102-108**	**108-114**	**114-120**	**120-126**
Clamping kit 0 degree**	Id. No.							-	-	-	-	-	-	-	-	-
Clamping kit ±2 degree**	Id. No.	204719	204720	204721	204722	204723	204724	205018	205019	205020	205021	-	-	-	-	-
Clamping kit ±3 degree**	Id. No.							-	-	-	-	205200	205201	205202	205203	205204
Clamping kit ±5 degree**	Id. No.											-	-	-	-	-
Clamping kit ±7 degree**	Id. No.											-	-	-	-	-
Pad Kit Standard	Id. No.	205228						204161				204161				
Pad Kit Special***	Id. No.							-				-				
Working pressure	bar							10-30				7-25				
Follow down grinding		Yes						Yes				Yes				

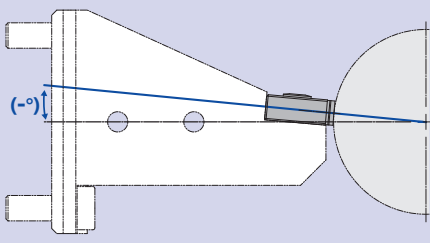
* Consisting of padholder for the middle piece incl. mounting material.
** Consisting of padholder for the middle piece and the nests for the arms incl. mounting material.
*** Clamping range -5 mm.
**** Padholder middle piece pivoting for contact angle.
SRG-B Side mounted cylinder.

Pad position middle piece / contact angle

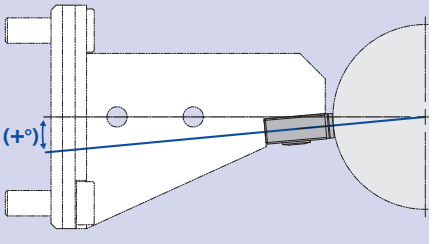
Pad position = 0 degree

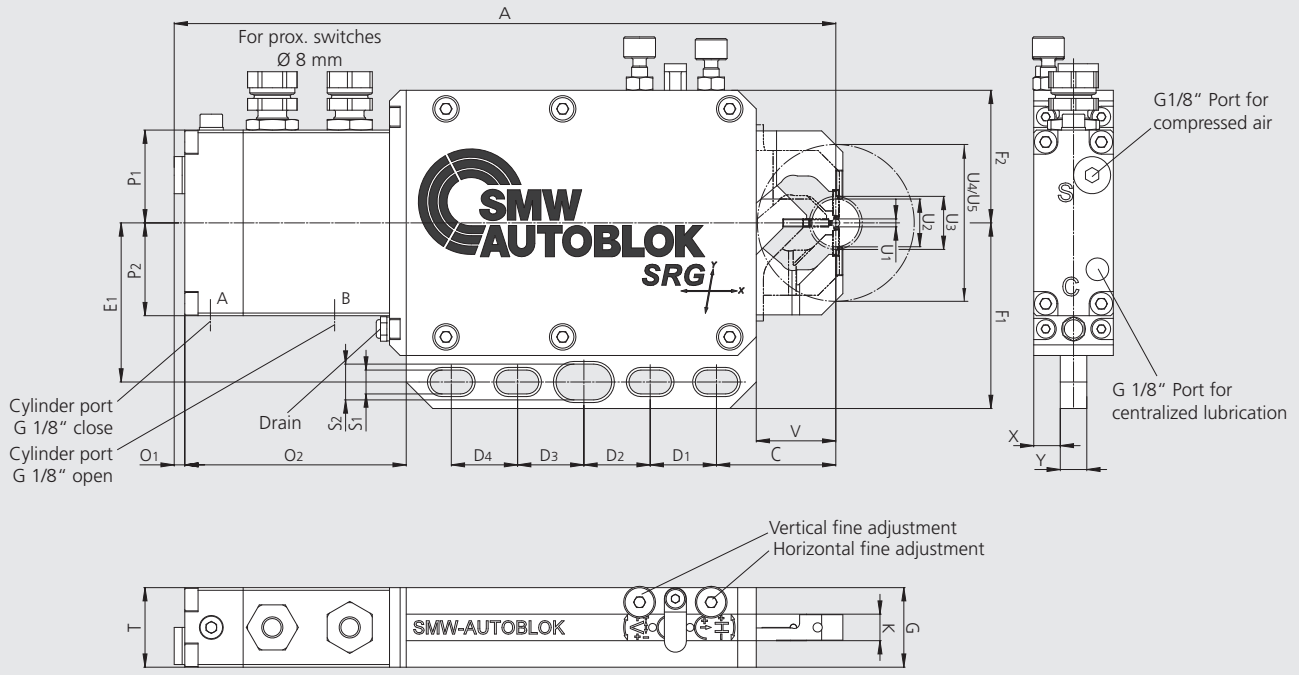


Pad position = (-) degree



Pad position = (+) degree





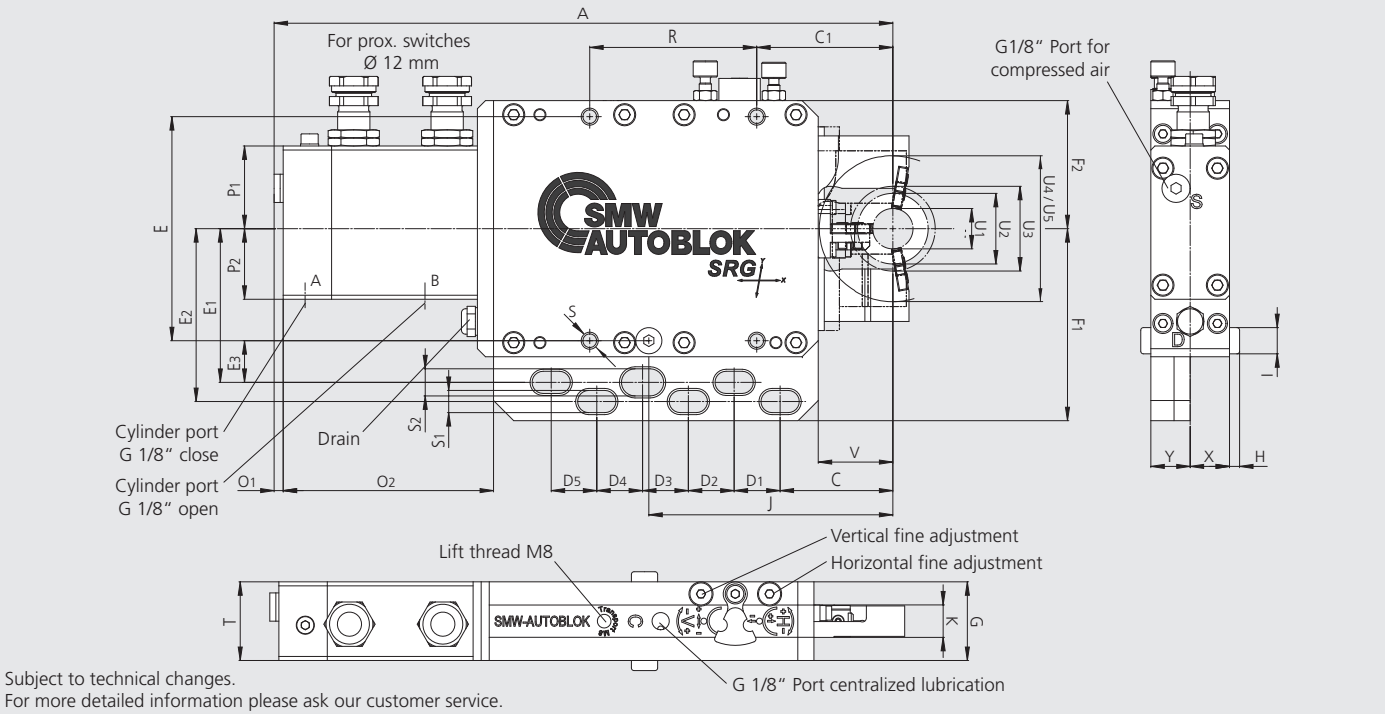
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 0.8 223250
Min. clamping diameter	U1	mm	3
Max. clamping diameter	U2	mm	18
Max. loading diameter (vertical, steady open)	U3	mm	58
Max. axial clearance diameter (steady open)	U4	mm	58
Max. swing diameter	U5	mm	58
Horizontal adjustment range		mm	±0.05
Vertical adjustment range		mm	±0.05
	A	mm	249.5
	C	mm	45
	D1	mm	25
	D2	mm	25
	D3	mm	25
	D4	mm	25
	E1	mm	60
	F1	mm	70
	F2	mm	50
	G	mm	30
	K	mm	10
	O1	mm	4
	O2	mm	83.5
	P1	mm	35
	P2	mm	35
	S1	mm	9 (4x)
	S2	mm	13.46 (1x)
	T	mm	30
	V	mm	30
	X	mm	10
	Y	mm	10
Cylinder stroke		mm	43
Piston area		cm²	3.14
Operating pressure max.		bar	50
Working pressure		bar	20 - 50
Repeatability accuracy		mm	±0.001
Weight		kg	4.3

SRG 1

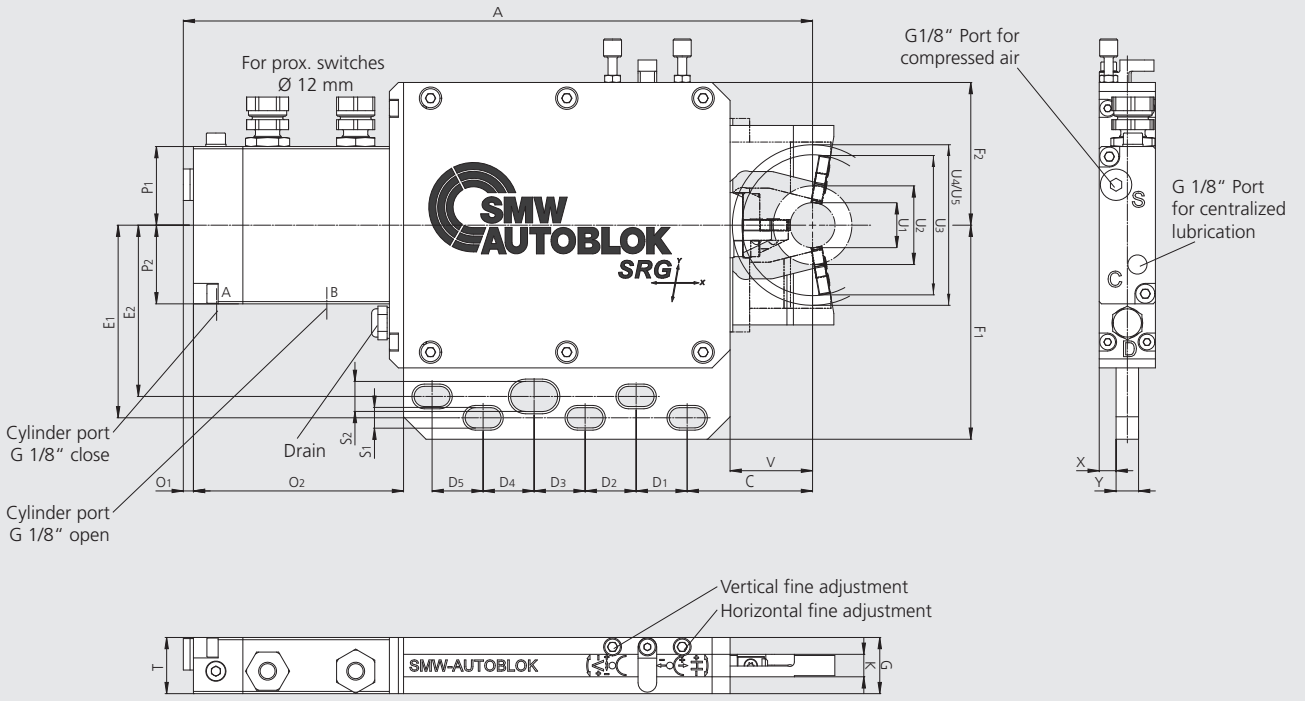
Grinding Steady Rests

Dimensions and technical data



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 1 221175
Min. clamping diameter	U1	mm	20
Max. clamping diameter	U2	mm	35
Max. loading diameter (vertical, steady open)	U3	mm	72
Max. axial clearance diameter (steady open)	U4	mm	72
Max. swing diameter	U5	mm	72
Horizontal adjustment range		mm	±0.20
Vertical adjustment range		mm	±0.10
	A	mm	306.8
	C	mm	55.9
	C1	mm	67.5
	D1	mm	22.8
	D2	mm	22.7
	D3	mm	22.7
	D4	mm	22.7
	D5	mm	22.6
	E	mm	111.1
	E1	mm	76.2
	E2	mm	85.7
	E3	mm	20.65
	F1	mm	95.2
	F2	mm	63.5
	G	mm	39
	H	mm	5
	I	mm	13
	J	mm	121
	K	mm	16.1
	O1	mm	4.5
	O2	mm	104.3
	P1	mm	41
	P2	mm	35
	R	mm	82.8
	S	mm	M8 (4x)
	S1	mm	11 (5x)
	S2	mm	13.46 (1x)
	T	mm	39
	V	mm	37
	X	mm	19.5
	Y	mm	19.5
Cylinder stroke		mm	73.4
Piston area		cm²	7.07
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	±0.001
Weight		kg	8.5



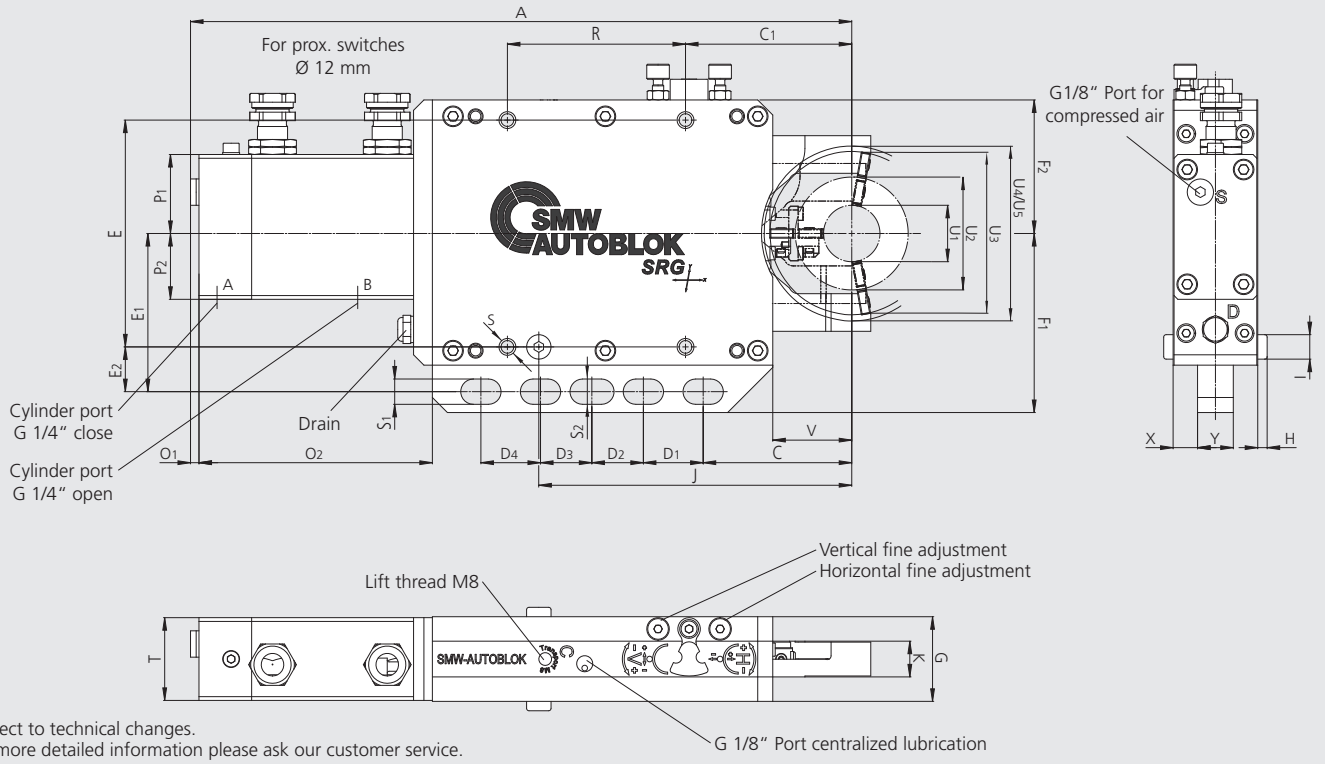
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 1 S 223060
Min. clamping diameter	U1	mm	20
Max. clamping diameter	U2	mm	35
Max. loading diameter (vertical, steady open)	U3	mm	62
Max. axial clearance diameter (steady open)	U4	mm	72
Max. swing diameter	U5	mm	72
Horizontal adjustment range		mm	±0.20
Vertical adjustment range		mm	±0.10
	A	mm	280
	C	mm	55.8
	D1	mm	22.7
	D2	mm	22.7
	D3	mm	22.7
	D4	mm	22.7
	D5	mm	22.7
	E1	mm	85.7
	E2	mm	76.2
	F1	mm	95.25
	F2	mm	63.5
	G	mm	25
	K	mm	10
	O1	mm	4.5
	O2	mm	93.5
	P1	mm	35
	P2	mm	35
	S1	mm	9 (5x)
	S2	mm	13.46 (1x)
	T	mm	25
	V	mm	36.7
	X	mm	7.5
	Y	mm	10
Cylinder stroke		mm	53
Piston area		cm²	2.01
Operating pressure max.		bar	50
Working pressure		bar	20-50
Repeatability accuracy		mm	±0.001
Weight		kg	4.8

SRG 2

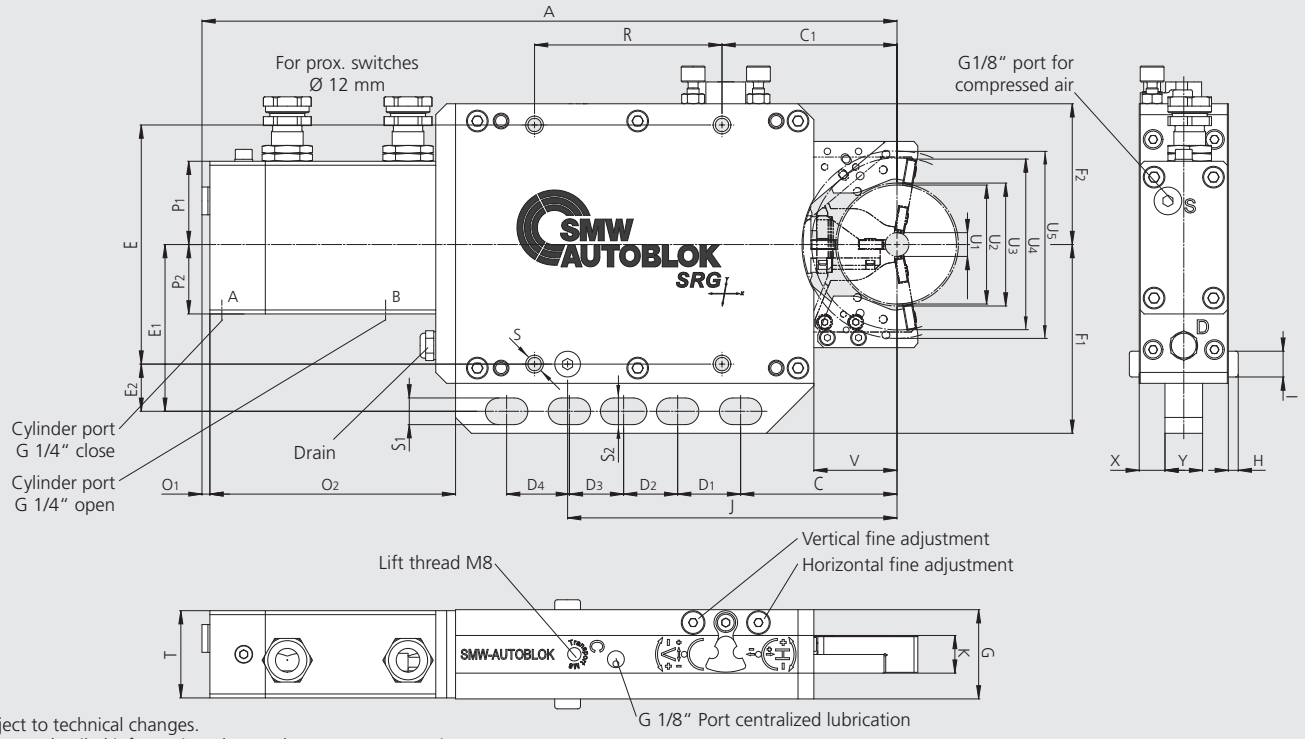
Grinding Steady Rests

Dimensions and technical data



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 2 221871
Min. clamping diameter	U1	mm	30
Max. clamping diameter	U2	mm	60
Max. loading diameter (vertical, steady open)	U3	mm	82
Max. axial clearance diameter (steady open)	U4	mm	95
Max. swing diameter	U5	mm	95
Horizontal adjustment range		mm	±0.20
Vertical adjustment range		mm	±0.14
	A	mm	351.6
	C	mm	79
	C1	mm	88.4
	D1	mm	31.8
	D2	mm	27.4
	D3	mm	27.3
	D4	mm	31.7
	E	mm	120.6
	E1	mm	84.1
	E2	mm	23.8
	F1	mm	95.2
	F2	mm	71
	G	mm	45
	H	mm	5
	I	mm	13
	J	mm	166.4
	K	mm	19
	O1	mm	4.5
	O2	mm	124.1
	P1	mm	42
	P2	mm	35
	R	mm	94.7
	S	mm	M8 (4x)
	S1	mm	12.5 (4x)
	S2	mm	13.46 (1x)
	T	mm	44
	V	mm	42
	X	mm	13
	Y	mm	19
Cylinder stroke		mm	73.4
Piston area		cm²	7.07
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	±0.001
Weight		kg	11.8



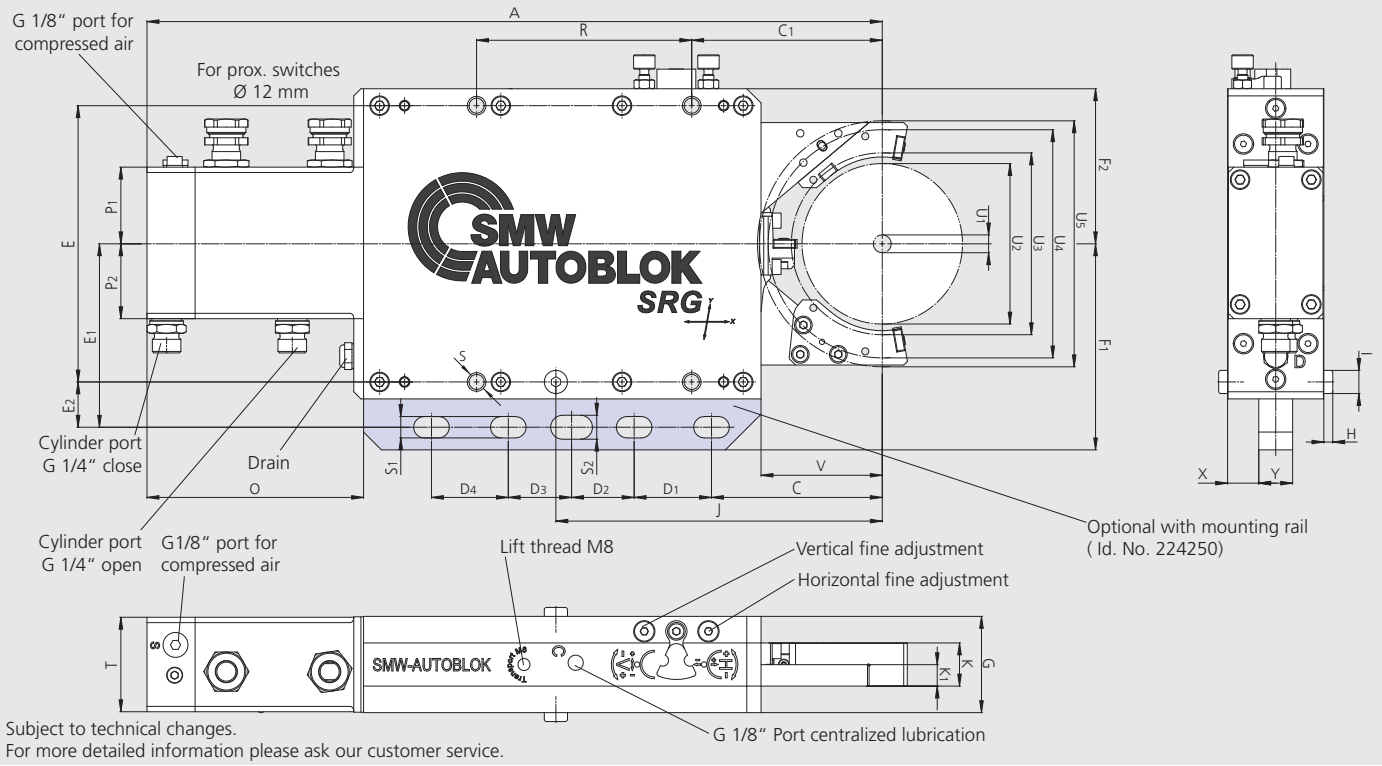
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 2 F 222260		
Clamping kit			**I**	**II**	**III**
Min. clamping diameter	U1	mm	12	28	44
Max. clamping diameter	U2	mm	28	44	60
Max. loading diameter (vertical, steady open)	U3	mm	82	82	82
Max. axial clearance diameter (steady open)	U4	mm	94	94	94
Max. swing diameter	U5	mm		94	
Horizontal adjustment range		mm	±0.20		
Vertical adjustment range		mm	±0.14		
	A	mm	351.1		
	C	mm	79		
	C1	mm	88.4		
	D1	mm	31.8		
	D2	mm	27.3		
	D3	mm	27.4		
	D4	mm	31.7		
	E	mm	120.6		
	E1	mm	84.1		
	E2	mm	23.8		
	F1	mm	95.2		
	F2	mm	71		
	G	mm	45		
	H	mm	5		
	I	mm	13		
	J	mm	166.4		
	K	mm	19		
	O1	mm	4.5		
	O2	mm	124.1		
	P1	mm	42		
	P2	mm	35		
	R	mm	94.7		
	S	mm	M8 (4x)		
	S1	mm	12.5 (4x)		
	S2	mm	13.46 (1x)		
	T	mm	44		
	V	mm	42		
	X	mm	13		
	Y	mm	19		
Cylinder stroke		mm	66.4		
Piston area		cm²	7.07		
Operating pressure max.		bar	45		
Working pressure		bar	15-30		
Repeatability accuracy		mm	±0.001		
Weight		kg	11.2		

SRG 3 F

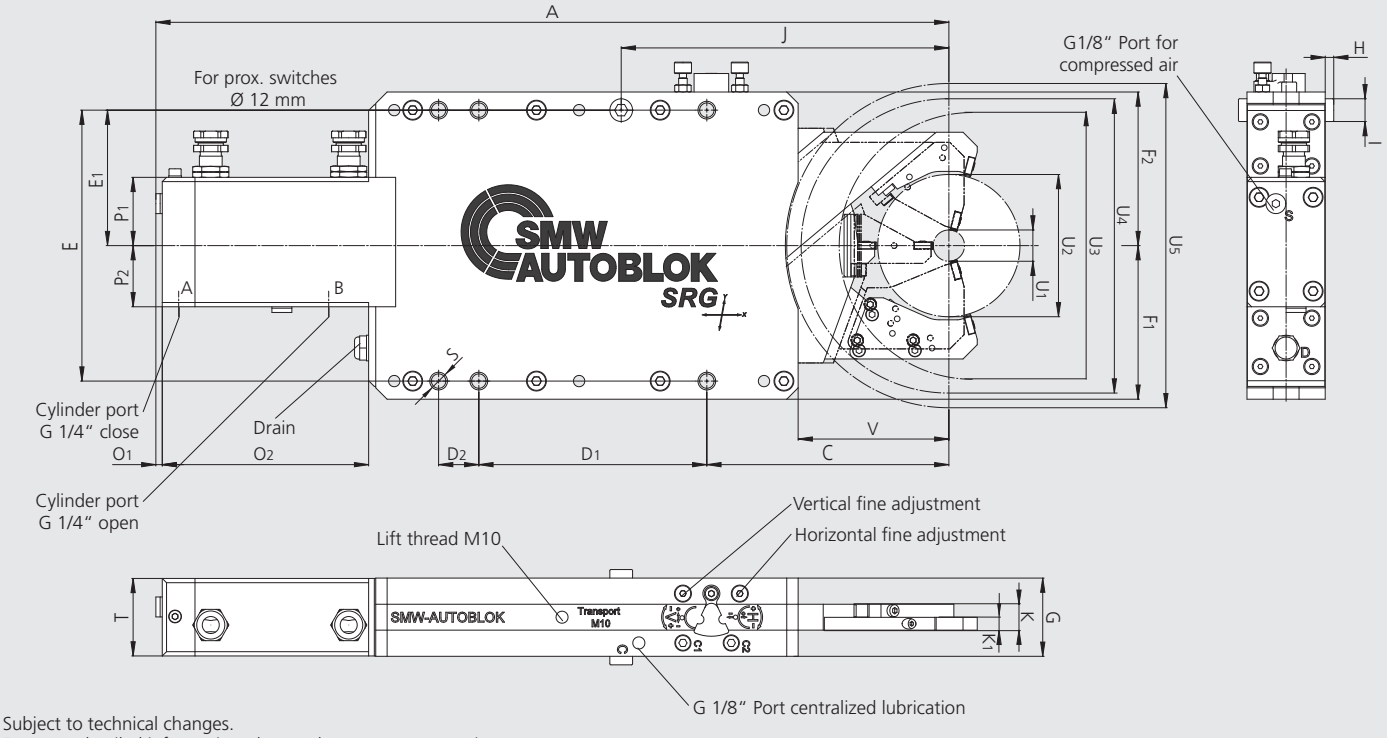
Grinding Steady Rests

Dimensions and technical data



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 3 F 224450			
Clamping kit			**I**	**II**	**III**	**IV**
Min. clamping diameter	U1	mm	10	30	50	70
Max. clamping diameter	U2	mm	30	50	70	90
Max. loading diameter (vertical, steady open)	U3	mm	111	110	106	102
Max. axial clearance diameter (steady open)	U4	mm	125	129	135	138
Max. swing diameter	U5	mm	138			
Horizontal adjustment range		mm	±0.20			
Vertical adjustment range		mm	±0.15			
	A	mm	412.5			
	C	mm	95.8			
	C1	mm	106.9			
	D1	mm	43.4			
	D2	mm	35.1			
	D3	mm	35.5			
	D4	mm	43.1			
	E	mm	155			
	E1	mm	102.9			
	E2	mm	25.4			
	F1	mm	115.6			
	F2	mm	87			
	G	mm	54			
	H	mm	5			
	I	mm	13			
	J	mm	183.1			
	K	mm	24			
	K1	mm	12			
	O	mm	121.5			
	P1	mm	43			
	P2	mm	42			
	R	mm	120.7			
	S	mm	M10 (4x)			
	S1	mm	13.46			
	S2	mm	13.46			
	T	mm	53			
	V	mm	68			
	X	mm	17.5			
	Y	mm	19			
Cylinder stroke		mm	79.8			
Piston area		cm²	12.56			
Operating pressure max.		bar	45			
Working pressure		bar	10 - 30			
Repeatability accuracy		mm	±0.001			
Weight		kg	19.1			



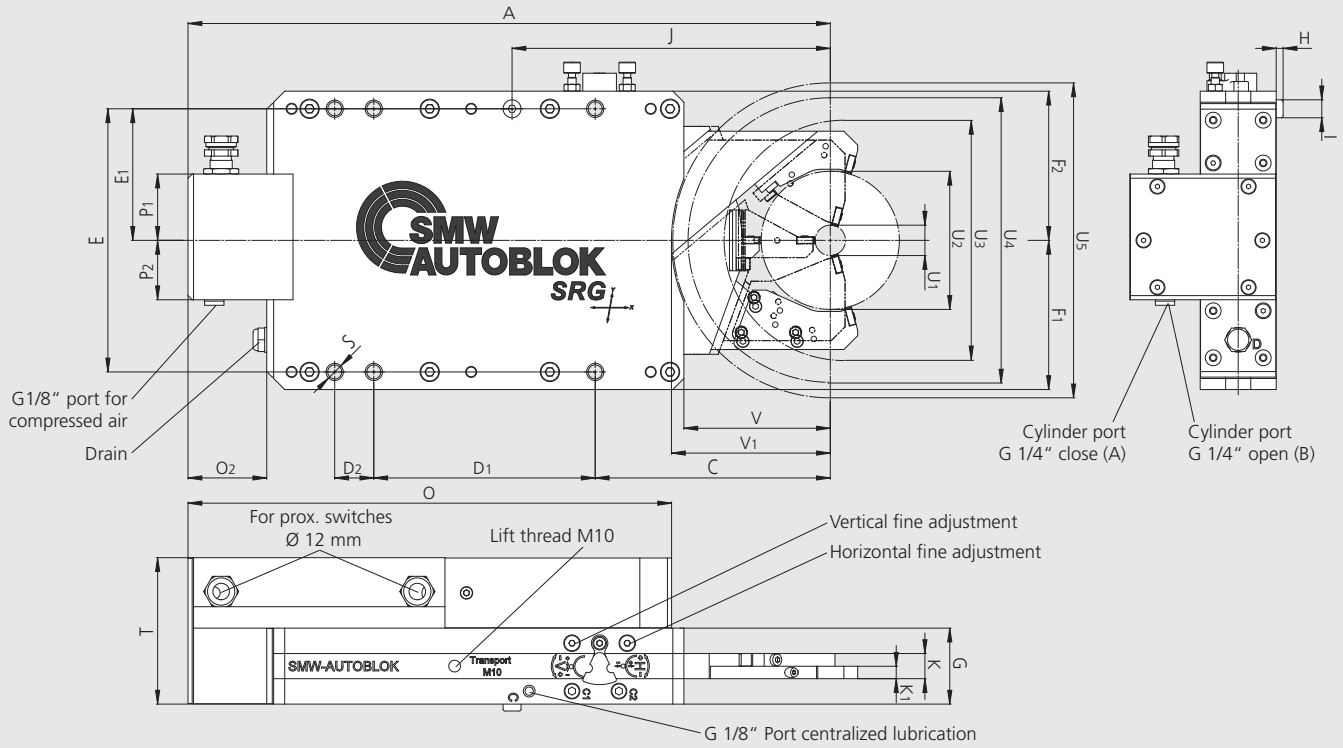
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 4 F 221930					
Clamping kit			**I**	**II**	**III**	**IV**	**V**	**VI**
Min. clamping diameter	U1	mm	22	35	48	61	74	87
Max. clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady open)	U3	mm	206	204	200	196	194	190
Max. axial clearance diameter (steady open)	U4	mm	218	219	219	220	222	224
Max. swing diameter	U5	mm	228					
Horizontal adjustment range		mm	±0.20					
Vertical adjustment range		mm	±0.14					
	A	mm	557.6					
	C	mm	170.2					
	D1	mm	160.3					
	D2	mm	28.3					
	E	mm	190.5					
	E1	mm	95.25					
	F1	mm	108					
	F2	mm	108					
	G	mm	55					
	H	mm	6					
	I	mm	16					
	J	mm	230.4					
	K	mm	18.2					
	K1	mm	9					
	O1	mm	4.5					
	O2	mm	145.1					
	P1	mm	48					
	P2	mm	43					
	S	mm	M12 (6x)					
	T	mm	54.5					
	V	mm	106					
Cylinder stroke		mm	127.2					
Piston area		cm²	12.56					
Operating pressure max.		bar	30					
Working pressure		bar	7 - 25					
Repeatability accuracy		mm	±0.001					
Weight		kg	30					

SRG-B 4 F

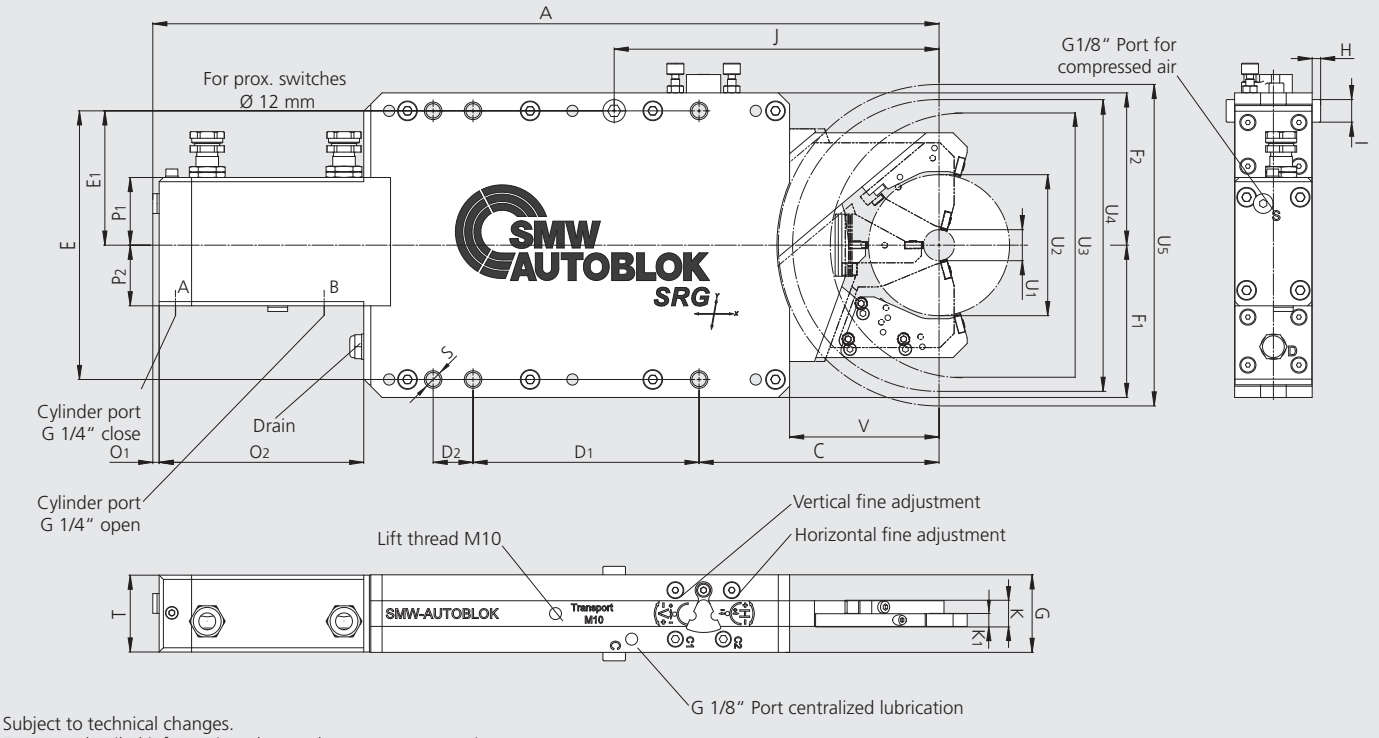
Grinding Steady Rests

Dimensions and technical data



Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG-B 4 F 223140					
Clamping kit			**I**	**II**	**III**	**IV**	**V**	**VI**
Minimum clamping diameter	U1	mm	22	35	48	61	74	87
Maximum clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady open)	U3	mm	206	204	200	196	194	190
Max. axial clearance diameter (steady open)	U4	mm	218	218	218	220	222	224
Max. swing diameter	U5	mm	228					
Horizontal adjustment range		mm	±0.20					
Vertical adjustment range		mm	±0.14					
	A	mm	465					
	C	mm	170.2					
	D1	mm	160.3					
	D2	mm	28.3					
	E	mm	190.5					
	E1	mm	95.25					
	F1	mm	108					
	F2	mm	108					
	G	mm	55					
	H	mm	5					
	I	mm	13					
	J	mm	230.4					
	K	mm	18.2					
	K1	mm	9					
	O	mm	350.1					
	O2	mm	57					
	P1	mm	48					
	P2	mm	43					
	S	mm	M12 (6x)					
	T	mm	106					
	V	mm	106					
	V1	mm	115					
Cylinder stroke		mm	127.2					
Piston area		cm²	10.02					
Operating pressure max.		bar	35					
Working pressure		bar	10-30					
Repeatability accuracy		mm	±0.001					
Mass		kg	37.8					



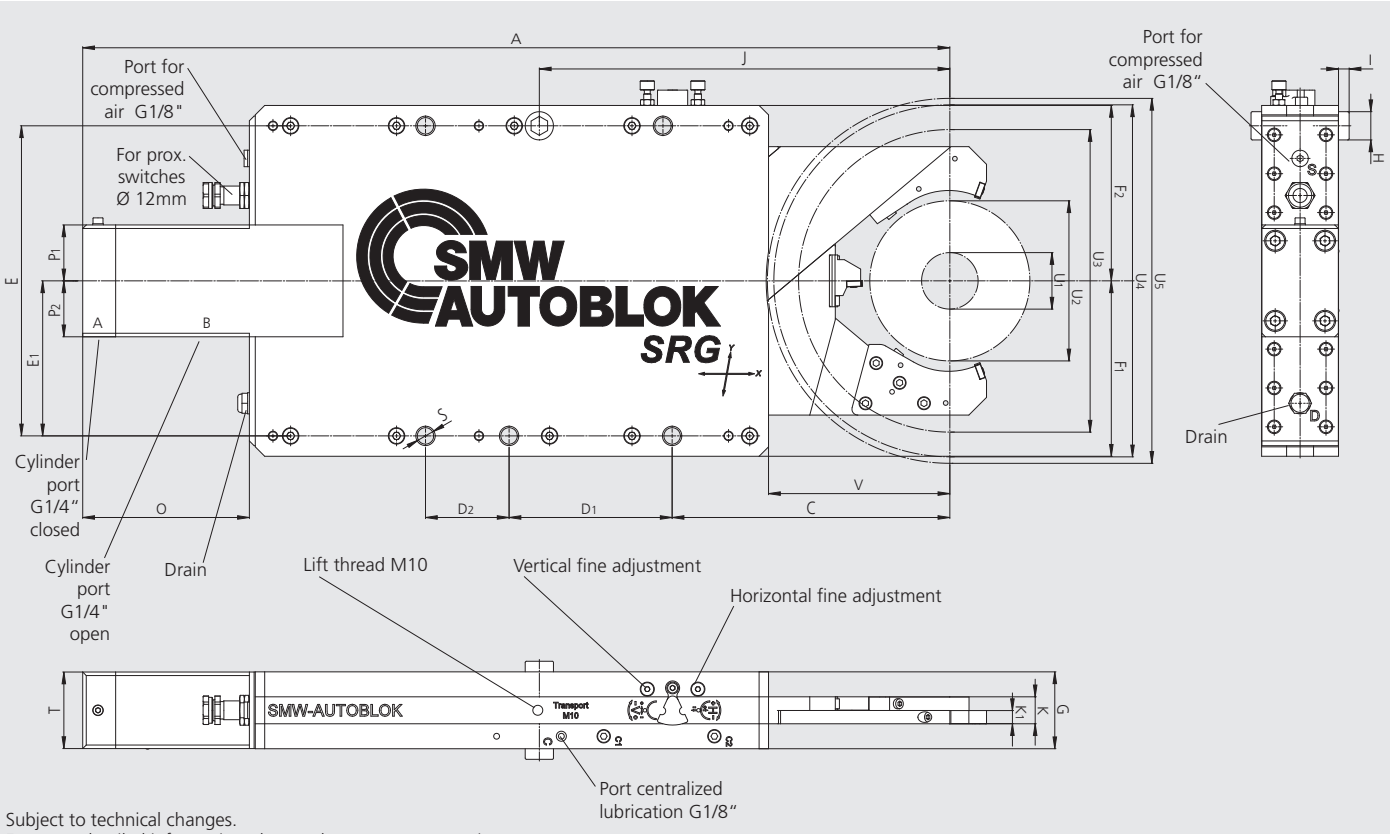
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 4.1 FS 222410					
Clamping kit			**I**	**II**	**III**	**IV**	**V**	**VI**
Minimum clamping diameter	U1	mm	22	35	48	61	74	87
Maximum clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady open)	U3	mm	206	201	197	195	190	189
Max. axial clearance diameter (steady open)	U4	mm	216	216	217	218	220	223
Max. swing diameter	U5	mm	250					
Horizontal adjustment range		mm	±0.22					
Vertical adjustment range		mm	±0.175					
	A	mm	565.5					
	C	mm	161.7					
	D1	mm	170.8					
	E	mm	190.5					
	E1	mm	95.25					
	F1	mm	108					
	F2	mm	108					
	G	mm	50.3					
	H	mm	6					
	I	mm	16					
	J	mm	230.8					
	K	mm	15.3					
	K1	mm	7.4					
	O1	mm	4.5					
	O2	mm	135					
	P1	mm	47					
	P2	mm	43					
	S	mm	M12 (6x)					
	T	mm	49.3					
	V	mm	114					
Piston area		cm²	12.56					
Operating pressure max.		bar	35					
Working pressure		bar	8-28					
Repeatability accuracy		mm	±0.001					
Mass		kg	26.5					

SRG 5 F

Grinding Steady Rests

Dimensions and technical data

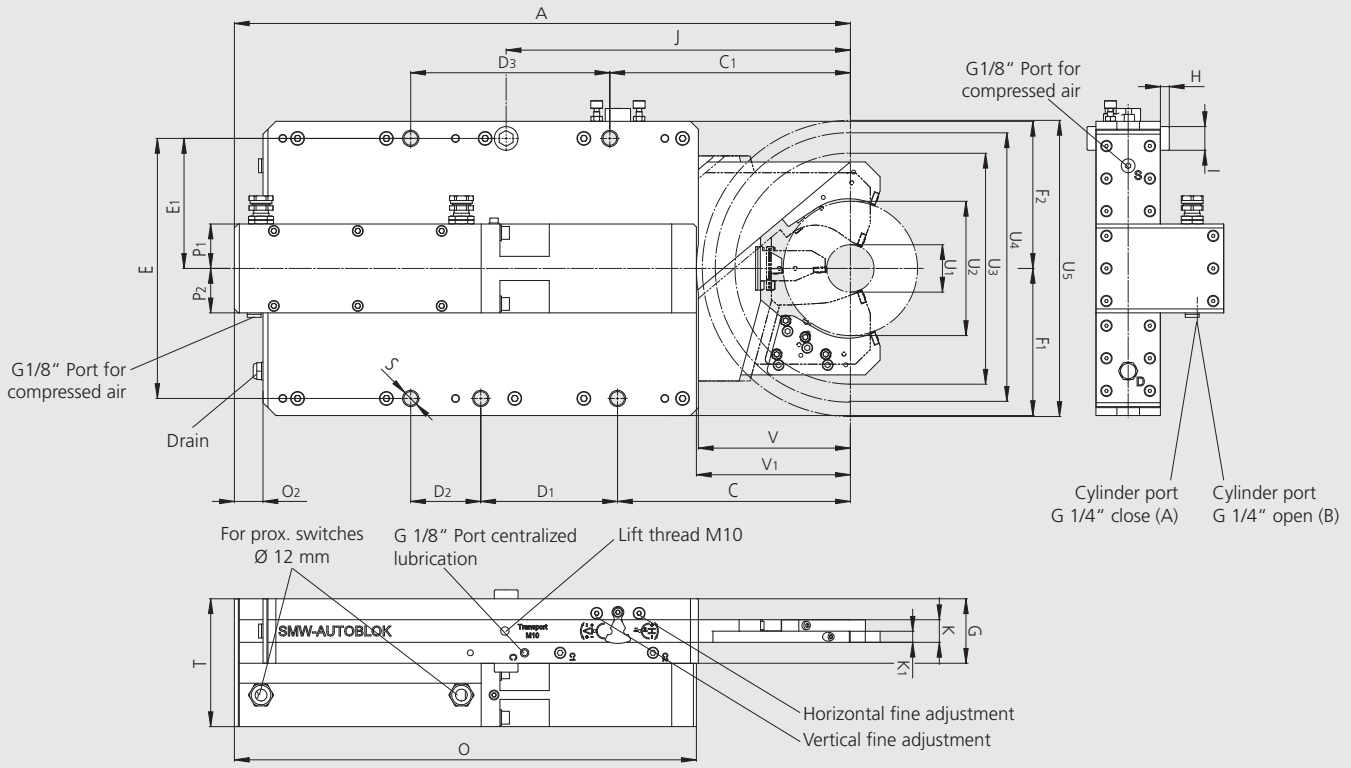


Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 5 F 223774			
Clamping kit			**I**	**II**	**III**	**IV**
Min. clamping diameter	U1	mm	48	70	92	114
Max. clamping diameter	U2	mm	70	92	114	136
Max. loading diameter (vertical, steady open)	U3	mm	273	267	263	257
Max. axial clearance diameter (steady open)	U4	mm	298	298	298	299
Max. swing diameter	U5	mm	310			
Horizontal adjustment range		mm	±0.20			
Vertical adjustment range		mm	±0.14			
	A	mm	736.6			
	C	mm	235.9			
	D1	mm	138.5			
	D2	mm	71			
	E	mm	263.4			
	E1	mm	131.7			
	F1	mm	149			
	F2	mm	149			
	G	mm	65.3			
	H	mm	24			
	I	mm	9			
	J	mm	348.7			
	K	mm	22.9			
	K1	mm	11.3			
	O	mm	141.6			
	P1	mm	47.5			
	P2	mm	47.5			
	S	mm	14			
	T	mm	65			
	V	mm	154			
Cylinder stroke		mm	179			
Piston area		cm²	19.63			
Operating pressure max.		bar	30			
Working pressure		bar	7-25			
Repeatability accuracy		mm	±0.002			
Weight		kg	62.6			

SRG-B 5 F

Grinding Steady Rests



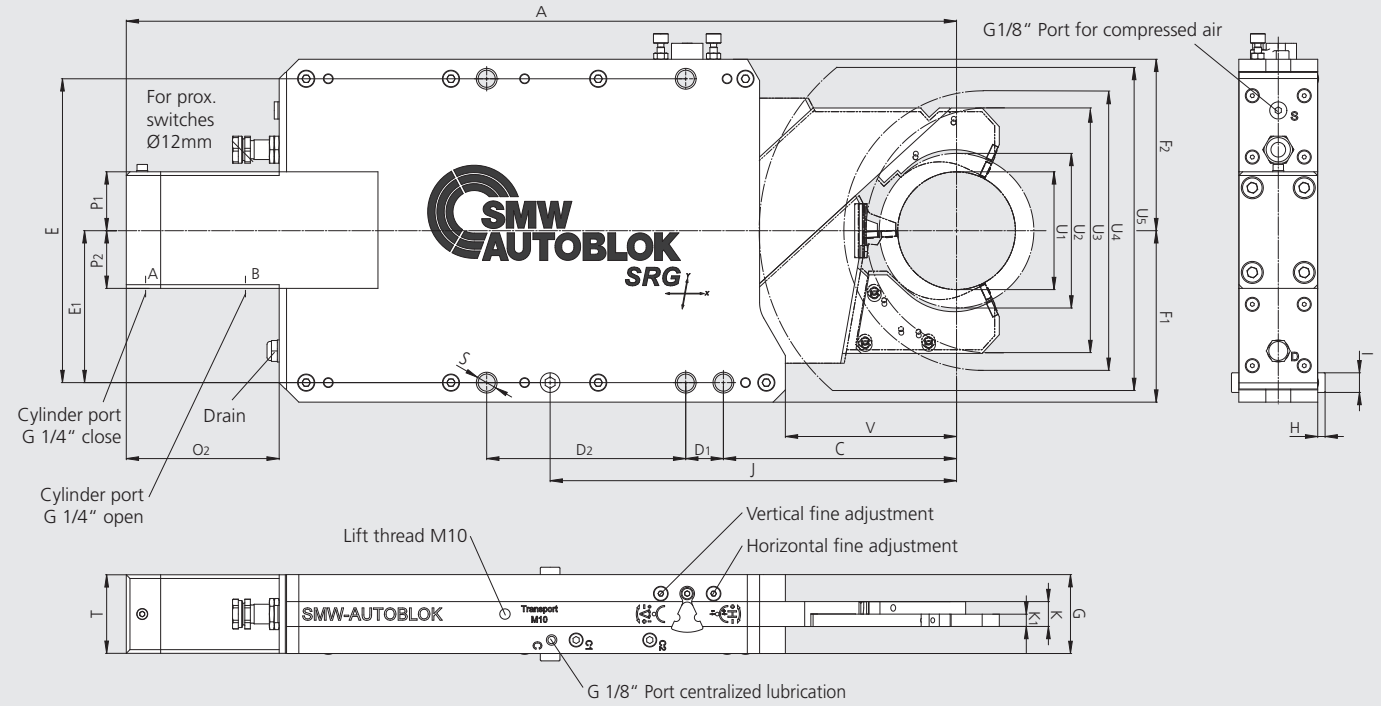
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG-B 5 F 222530			
Clamping kit			**I**	**II**	**III**	**IV**
Min. clamping diameter	U1	mm	48	70	92	114
Max. clamping diameter	U2	mm	70	92	114	136
Max. loading diameter (vertical, steady open)	U3	mm	273	267	263	257
Max. axial clearance diameter (steady open)	U4	mm	298	298	298	299
Max. swing diameter	U5	mm	310			
Horizontal adjustment range		mm	± 0.20			
Vertical adjustment range		mm	± 0.14			
	A	mm	624			
	C	mm	235.9			
	C1	mm	243.7			
	D1	mm	138.5			
	D2	mm	71			
	D3	mm	201.7			
	E	mm	263.4			
	E1	mm	131.7			
	F1	mm	149			
	F2	mm	149			
	G	mm	65.3			
	H	mm	9			
	I	mm	24			
	J	mm	348.7			
	K	mm	22.9			
	K1	mm	11.1			
	O	mm	468			
	O2	mm	29			
	P1	mm	45			
	P2	mm	45			
	S	mm	M16 (5x)			
	T	mm	129.5			
	V	mm	154			
	V1	mm	156			
Cylinder stroke		mm	179			
Piston area		cm²	16.49			
Operating pressure max.		bar	35			
Working pressure		bar	10-30			
Repeatability accuracy		mm	±0.002			
Weight		kg	76.4			

SRG 5.1 FS

Grinding Steady Rests

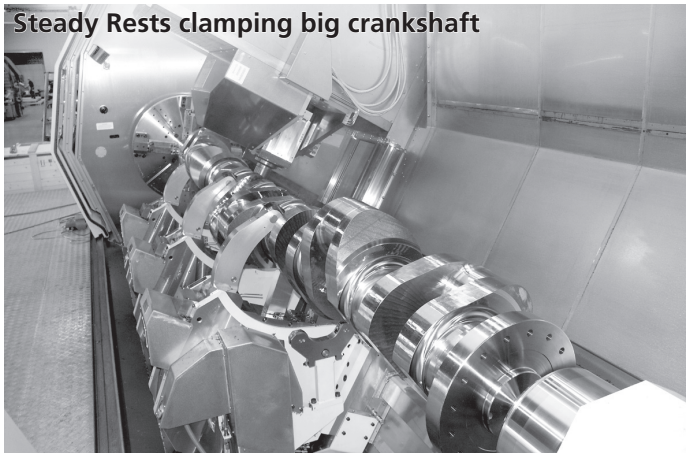
Dimensions and technical data



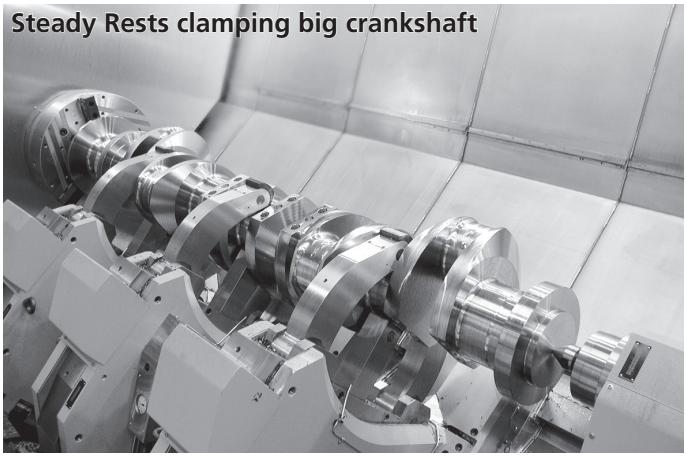
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 5.1 FS 222665				
Clamping kit			**I**	**II**	**III**	**IV**	**V**
Min. clamping diameter	U1	mm	96	102	108	114	120
Max. clamping diameter	U2	mm	102	108	114	120	126
Max. loading diameter (vertical, steady open)	U3	mm	236	234	232	229	228
Max. axial clearance diameter (steady open)	U4	mm	272	272	272	272	272
Max. swing diameter	U5	mm	320				
Horizontal adjustment range		mm	±0.22				
Vertical adjustment range		mm	±0.17				
	A	mm	676.6				
	C	mm	190				
	D1	mm	30.7				
	D2	mm	162.2				
	E	mm	247.6				
	E1	mm	123.8				
	F1	mm	139.7				
	F2	mm	139.7				
	G	mm	64.3				
	H	mm	6				
	I	mm	16				
	J	mm	331.2				
	K	mm	20.25				
	K1	mm	10				
	O2	mm	124.6				
	P1	mm	48				
	P2	mm	47				
	S	mm	17 (5x)				
	T	mm	64				
	V	mm	139.5				
Cylinder stroke		mm	167.1				
Piston area		cm²	19.63				
Operating pressure max.		bar	23				
Working pressure		bar	8 - 18.5				
Repeatability accuracy		mm	±0.002				
Weight		kg	54.8				

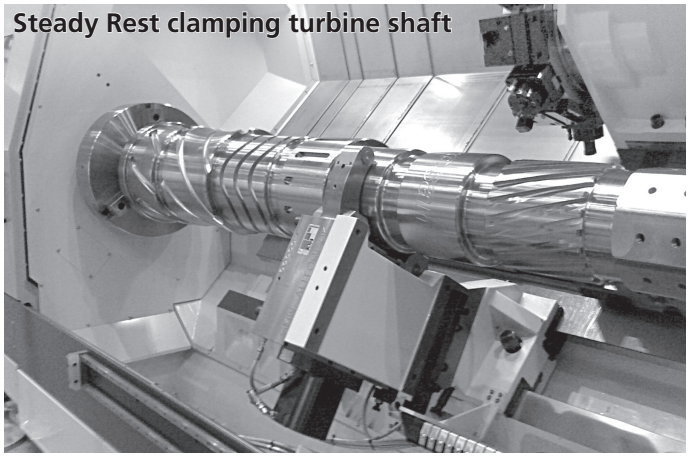
SLU-X® SLU-B	SLUA® SLUA®-B	SR® / -CL SRA	KLU / -A K	Our additional program: ■ Special Steady Rests ■ Turret Steady Rests ■ Crankshaft Steady Rests ■ Grinding Steady Rests



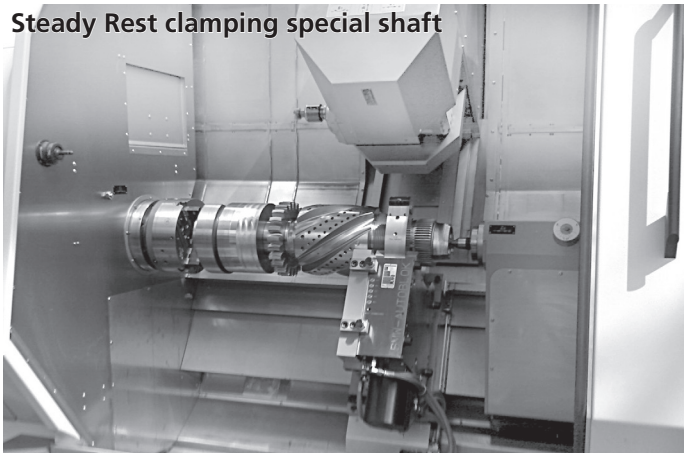
Steady Rests clamping big crankshaft



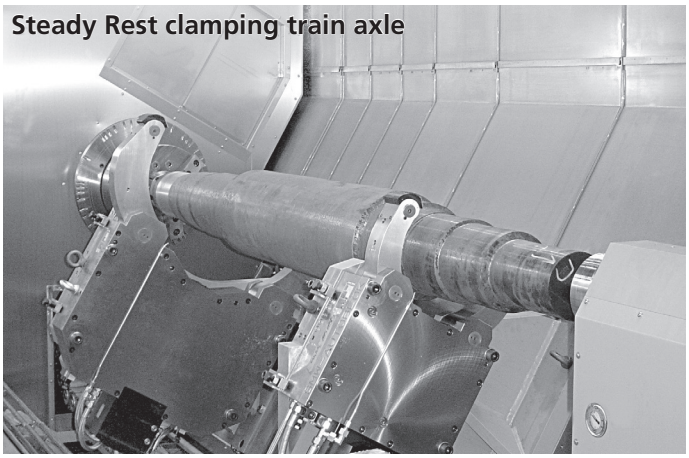
Steady Rests clamping big crankshaft



Steady Rest clamping turbine shaft

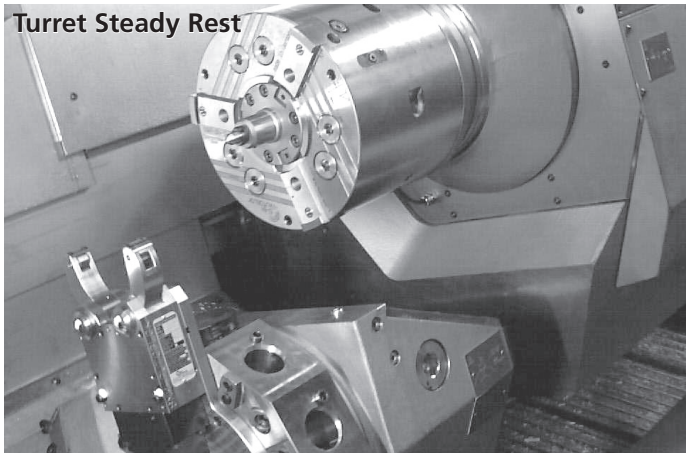


Steady Rest clamping special shaft

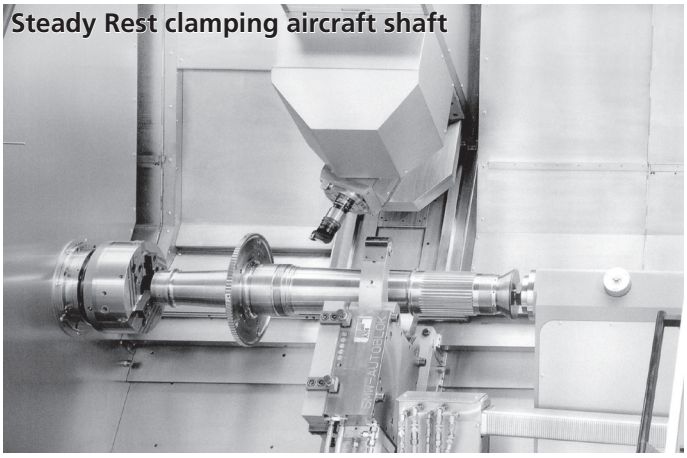


Steady Rest clamping train axle

Steady Rest with diamond pads clamping input shaft in hard turning / grinding operation



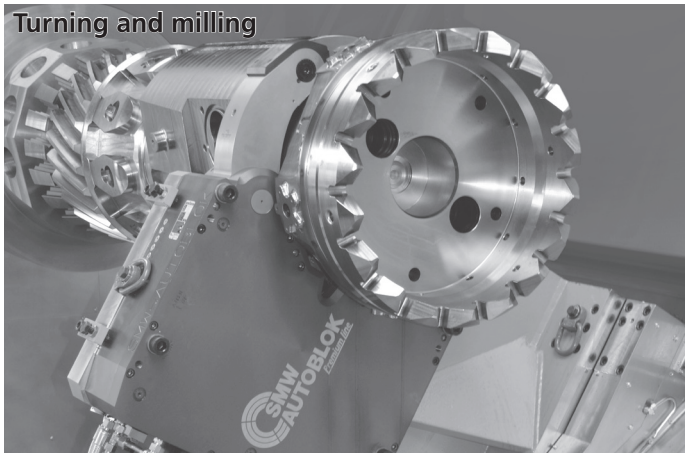
Turret Steady Rest



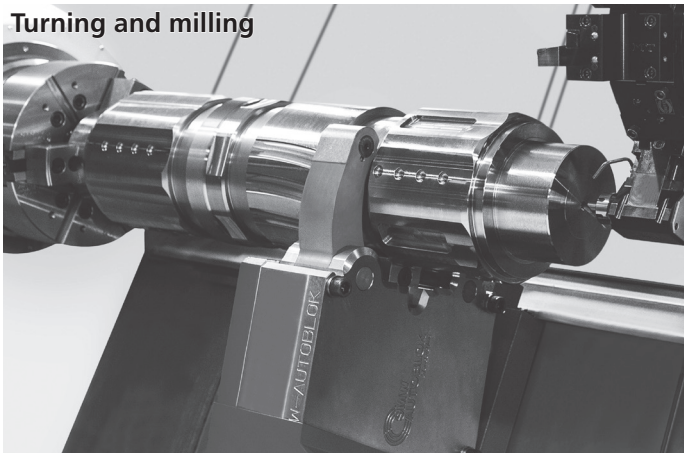
Steady Rest clamping aircraft shaft

Application Examples

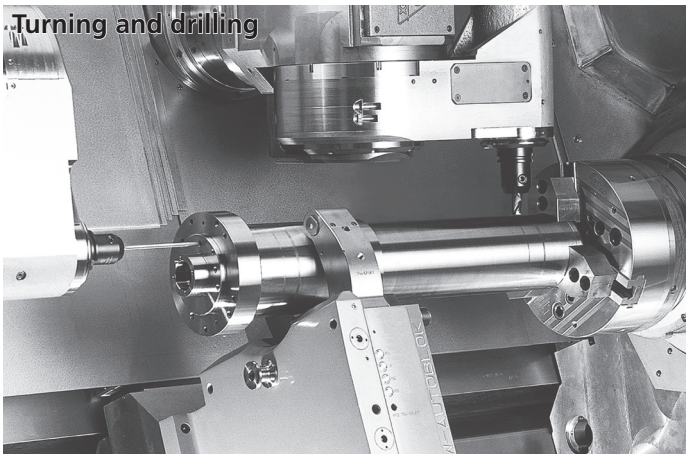
Turning and milling



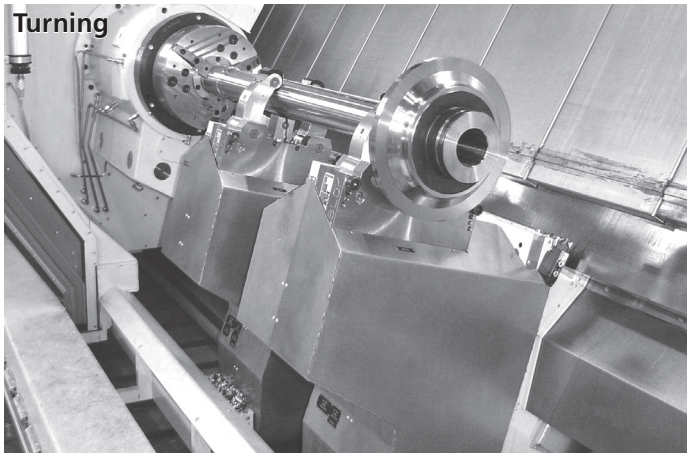
Turning and milling



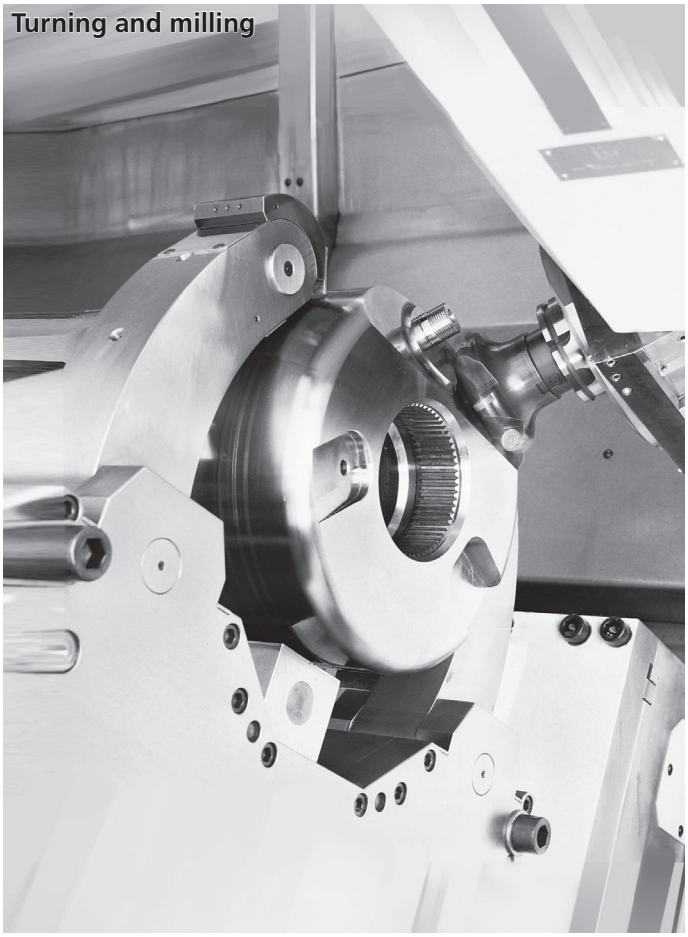
Turning and drilling



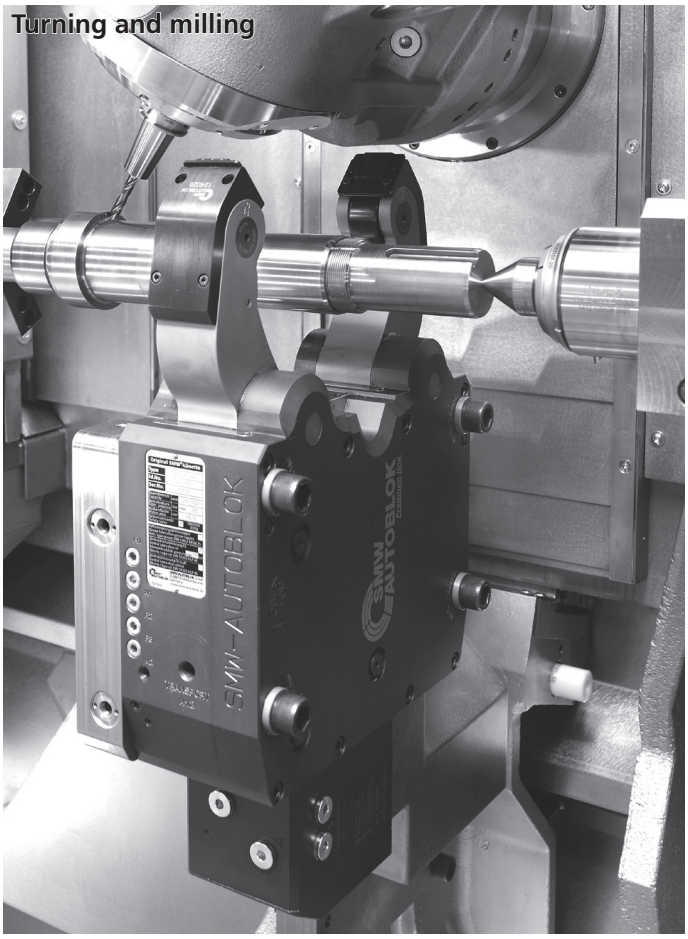
Turning



Turning and milling



Turning and milling



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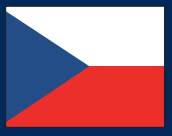

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