

- Fine adjustment of the center
- Retractable Steady Rest arms



Application/customer benefits

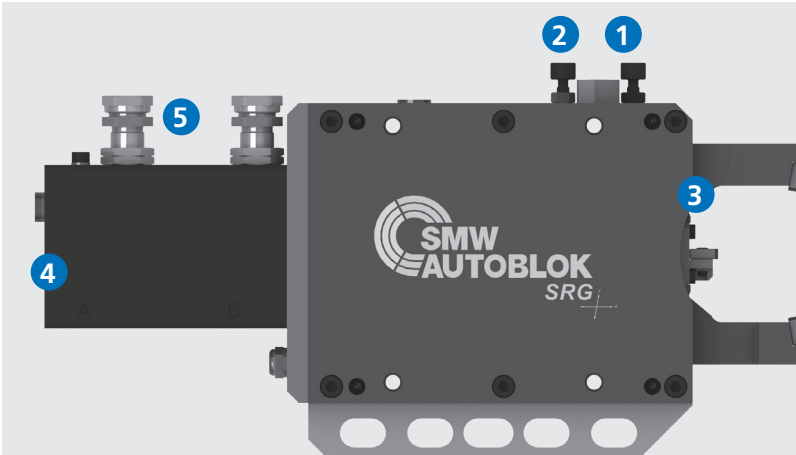
- Support of shaft type workpieces on grinding machines
- Particularly suitable for the machining of crankshafts and camshafts
- Rapid set up of the Steady Rest to the grinding center with the sensitive fine adjustment of the grinding center
- Suitable for follow down grinding
- Retractable Steady Rest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

Standard equipment

Basic grinding Steady Rest SRG

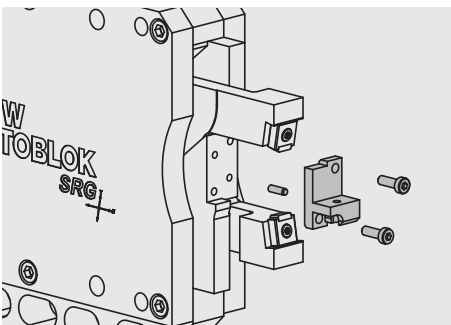
(Padholder for the middle piece, clamping kit and pad kits are not scope of delivery. For these parts please see the overview for the configurations below)

Technical details



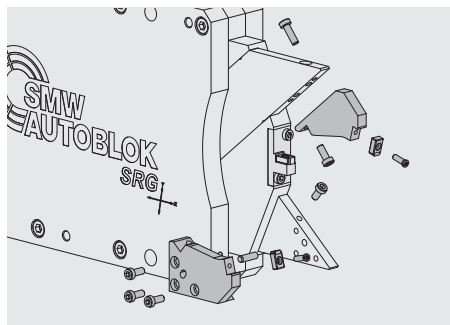
1. Horizontal fine adjustment of the grinding center.
2. Vertical fine adjustment of the grinding center.
3. Retractable Steady Rest arms.
4. Port for compressed air against dust and coolant.
5. Monitoring of end positions with proximity switches (switches not included).

Overview Configuration



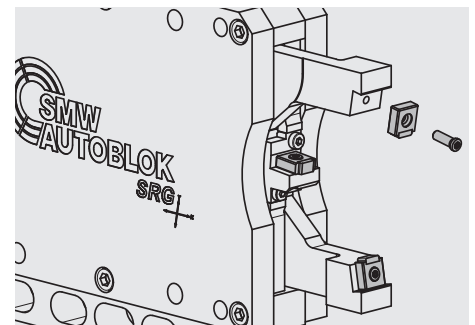
Select padholder for the middle piece (SRG 1, 1S, 2)

- 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.

- Fine adjustment of the center
- Retractable Steady Rest arms

Overview clamping range

Type	Clamping range in mm																Page
SRG 0.8	3 - 18																431
SRG 1			20 - 35														432
SRG 1 S			20 - 35														433
SRG 2				30 - 60													434
SRG 2 F																	435
I Kit	12 - 28																
II Kit			28 - 44														
III Kit					44 - 60												
SRG 3 F																	436
I Kit	10 - 30																
II Kit			30 - 50														
III Kit					50 - 70												
IV Kit							70 - 90										437-365
SRG 4 F SRG 4.1 FS SRG-B 4 F																	
I Kit			22 - 35														
II Kit				35 - 48													
III Kit					48 - 61												
IV Kit						61 - 74											
V Kit							74 - 87										
VI Kit								87 - 100									
SRG 5 F SRG-B 5 F																	366-367
I Kit						48 - 70											
II Kit								70 - 92									
III Kit									92 - 114								
IV Kit										114 - 136							368
SRG 5.1 FS																	
I Kit										96 - 102							
II Kit											102 - 108						
III Kit												108 - 114					
IV Kit													114 - 120				
V Kit														120 - 126			
	0	10	20	30	40	50	60	70	80	90	100	110	120	130	140		

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.

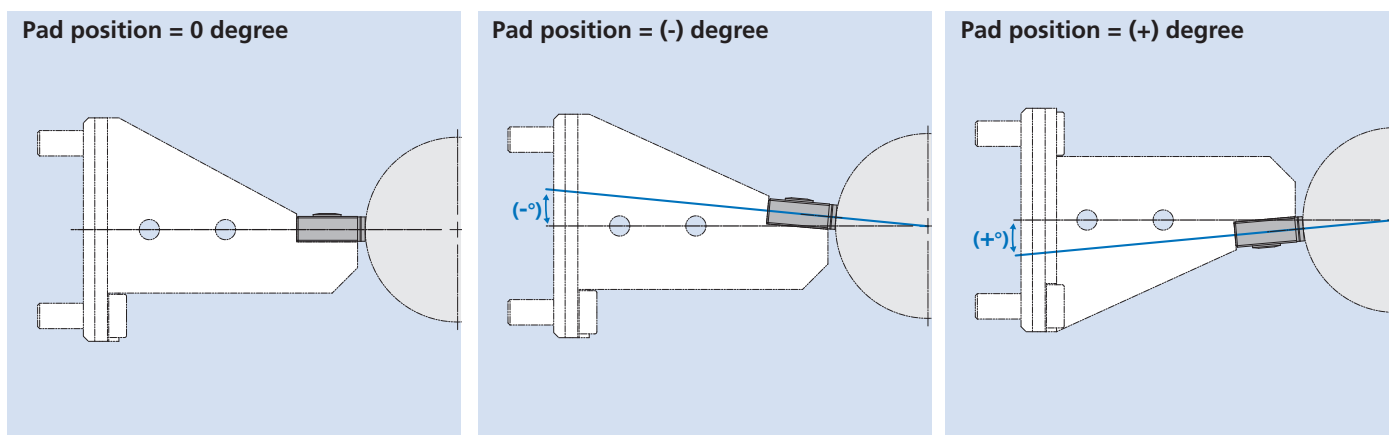
** Consisting of padholder for the middle piece and the nests for the arms incl. mounting material.

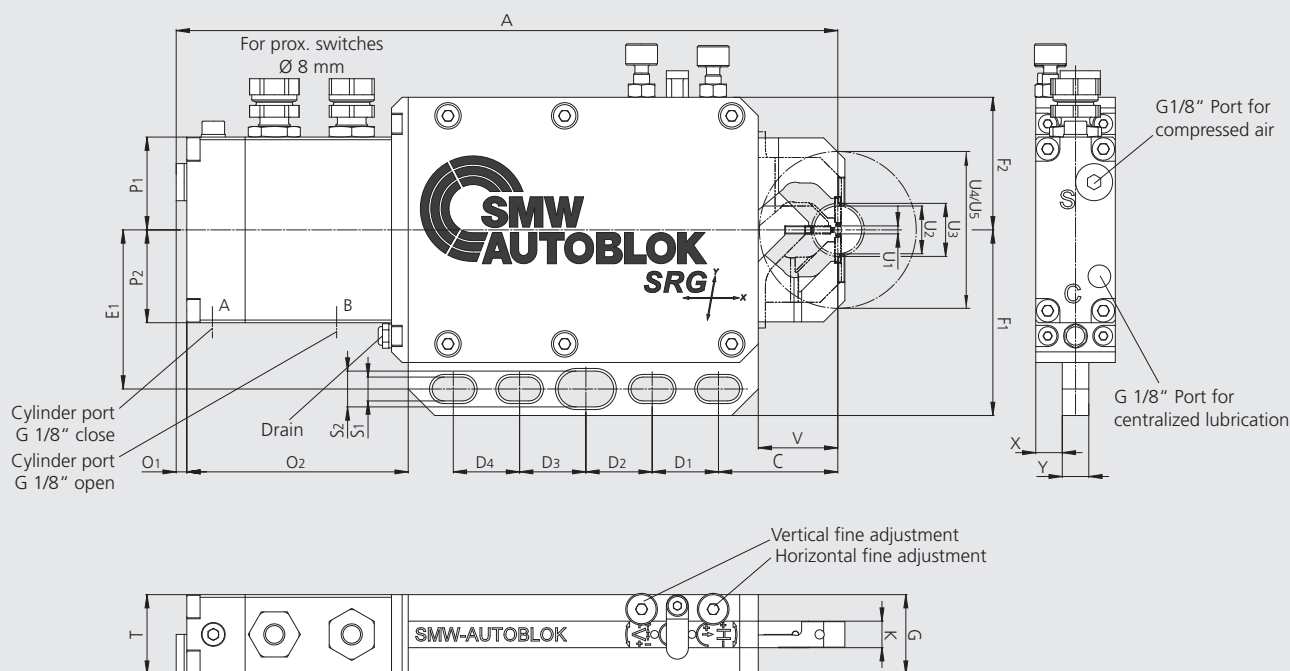
*** Clamping range -5 mm.

**** Padholder middle piece pivoting for contact angle.

SRG-B Side mounted cylinder.

Pad position middle piece / contact angle





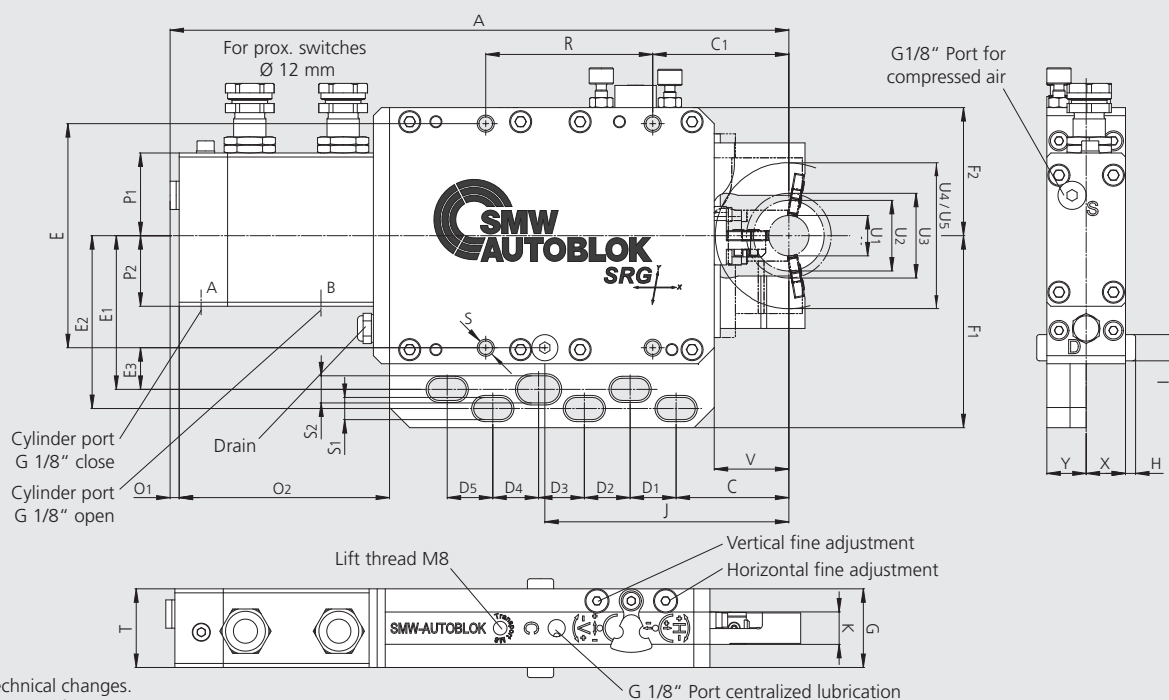
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			SRG 0.8
Id. No.			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		cm ²	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

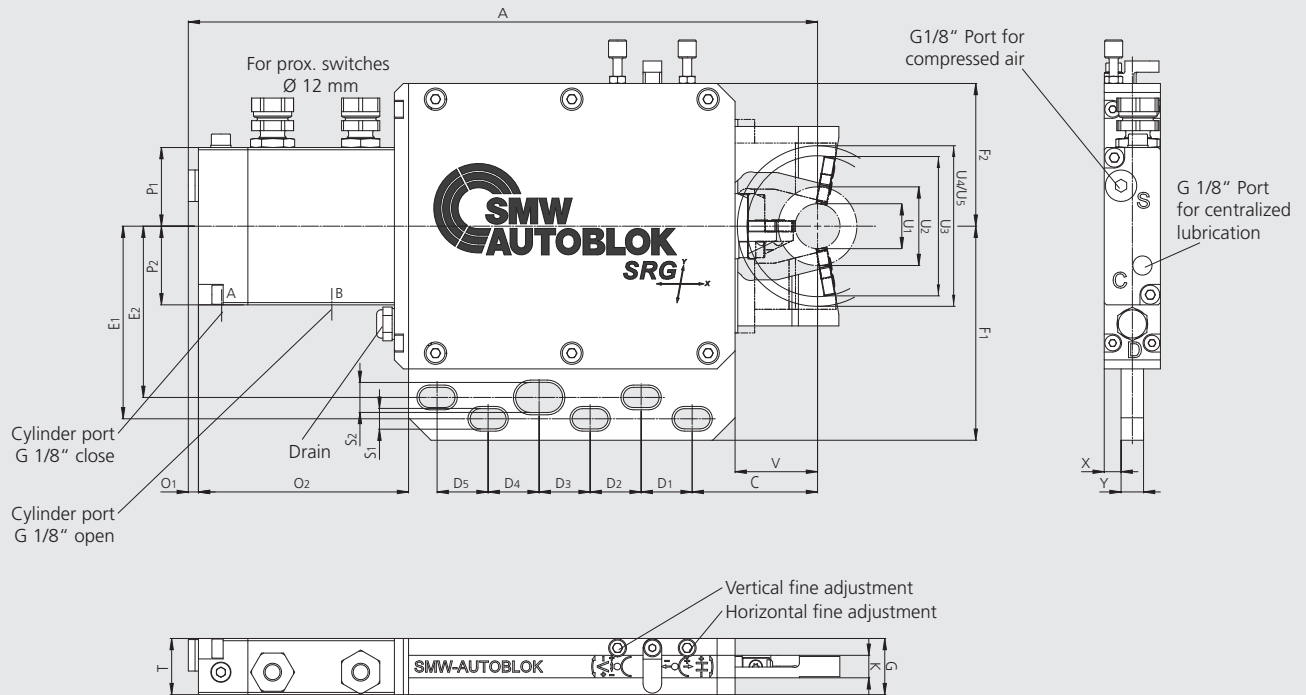
■ Dimensions and technical data



Subject to technical changes.

For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		SRG 1	
Id. No.		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		cm ²	7.07
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	±0.001
Weight		kg	8.5



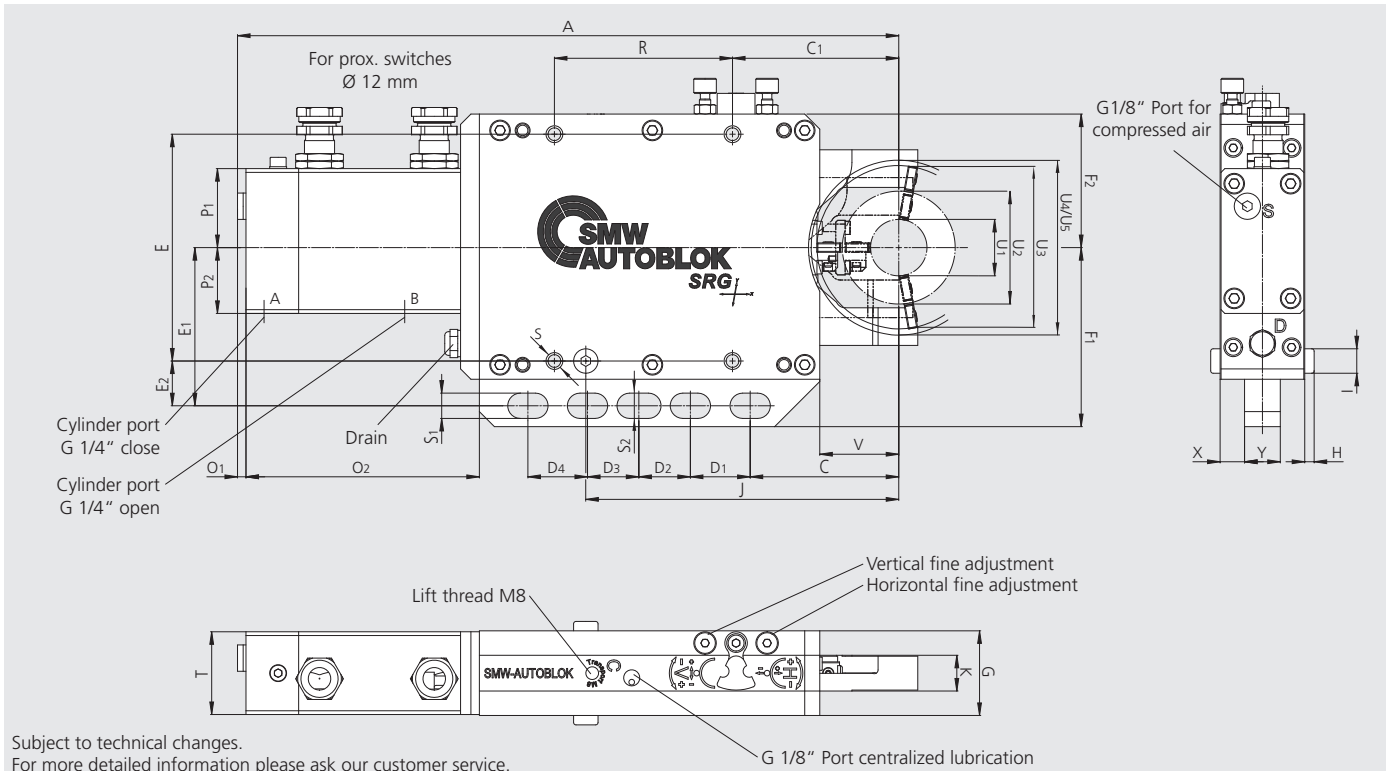
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		SRG 1 S	
Id. No.		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		cm ²	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

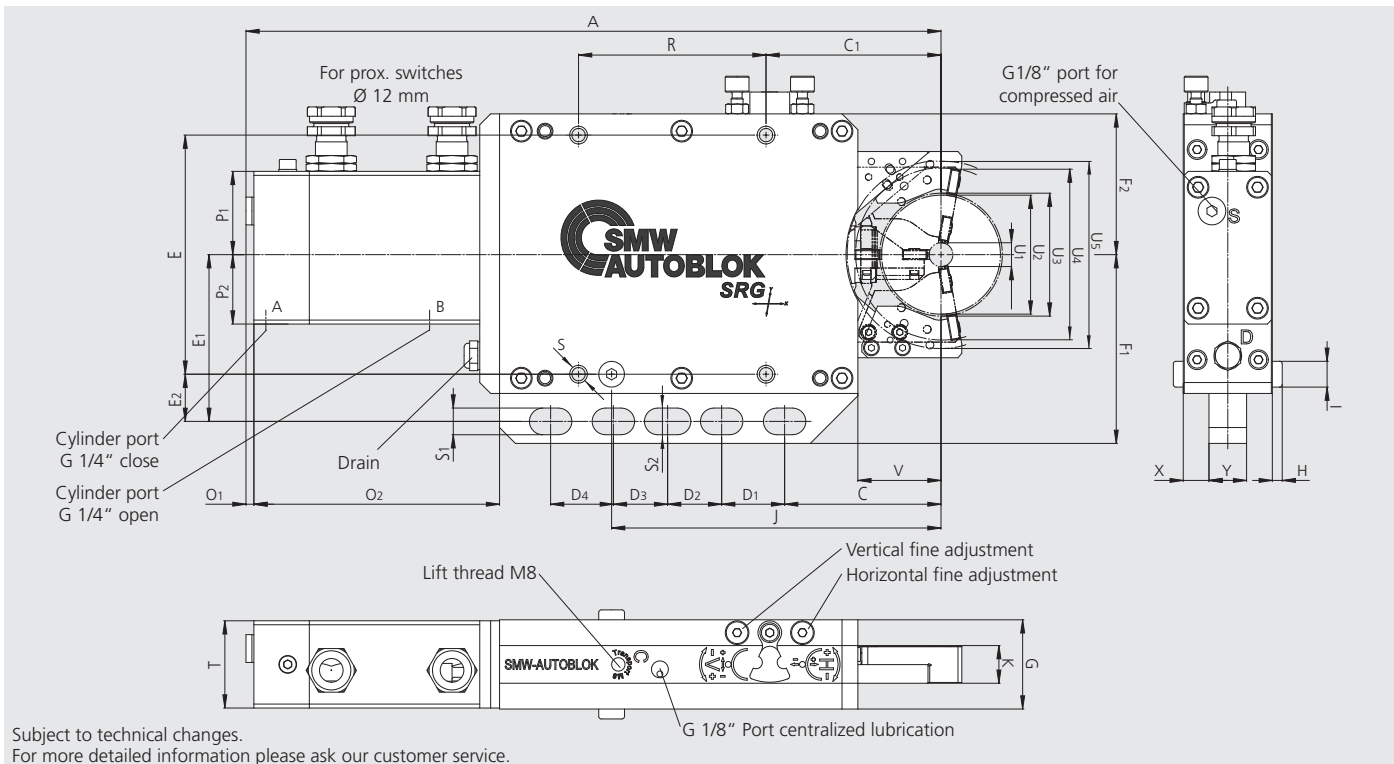
■ Dimensions and technical data



Subject to technical changes.

For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			SRG 2
Id. No.			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		cm ²	7.07
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	±0.001
Weight		kg	11.8



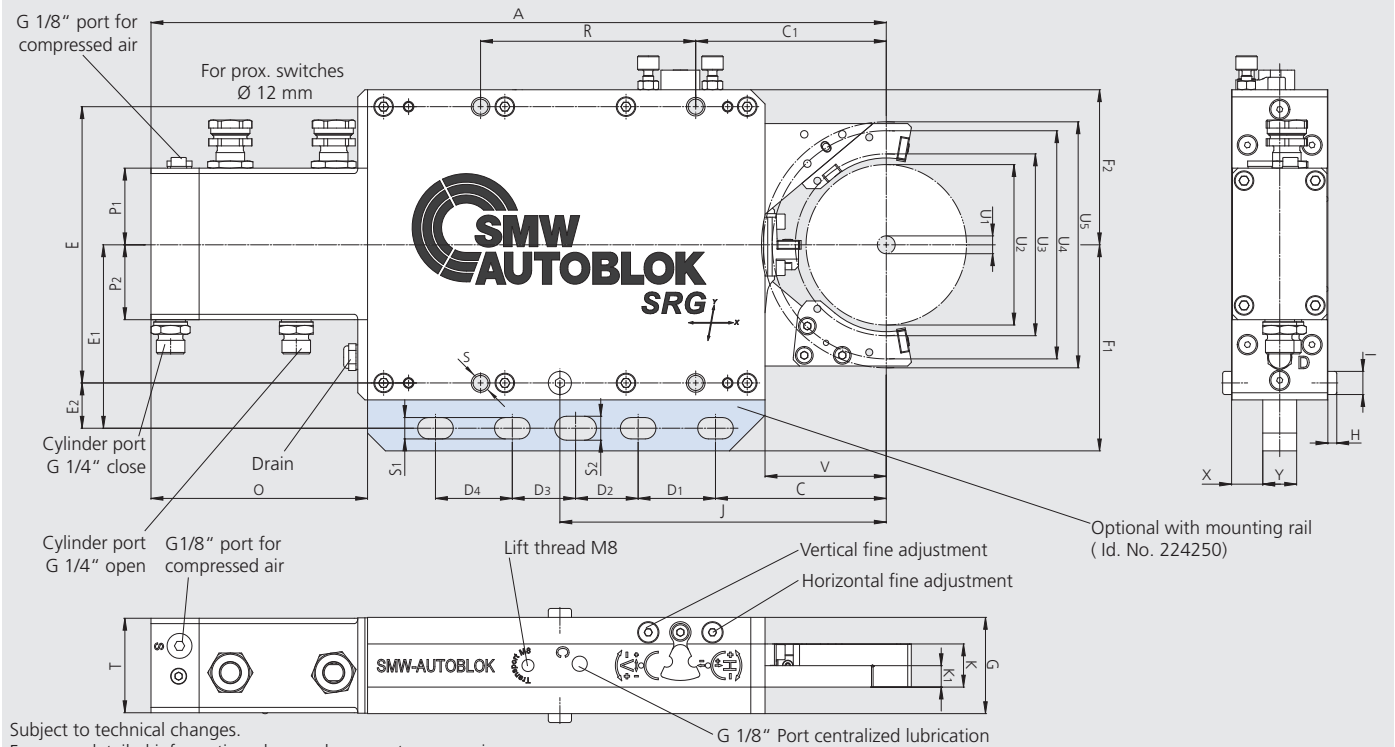
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		SRG 2 F			
Id. No.		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		cm ²		7.07	
Operating pressure max.		bar		45	
Working pressure		bar		15-30	
Repeatability accuracy		mm		±0.001	
Weight		kg		11.2	

SRG 3 F

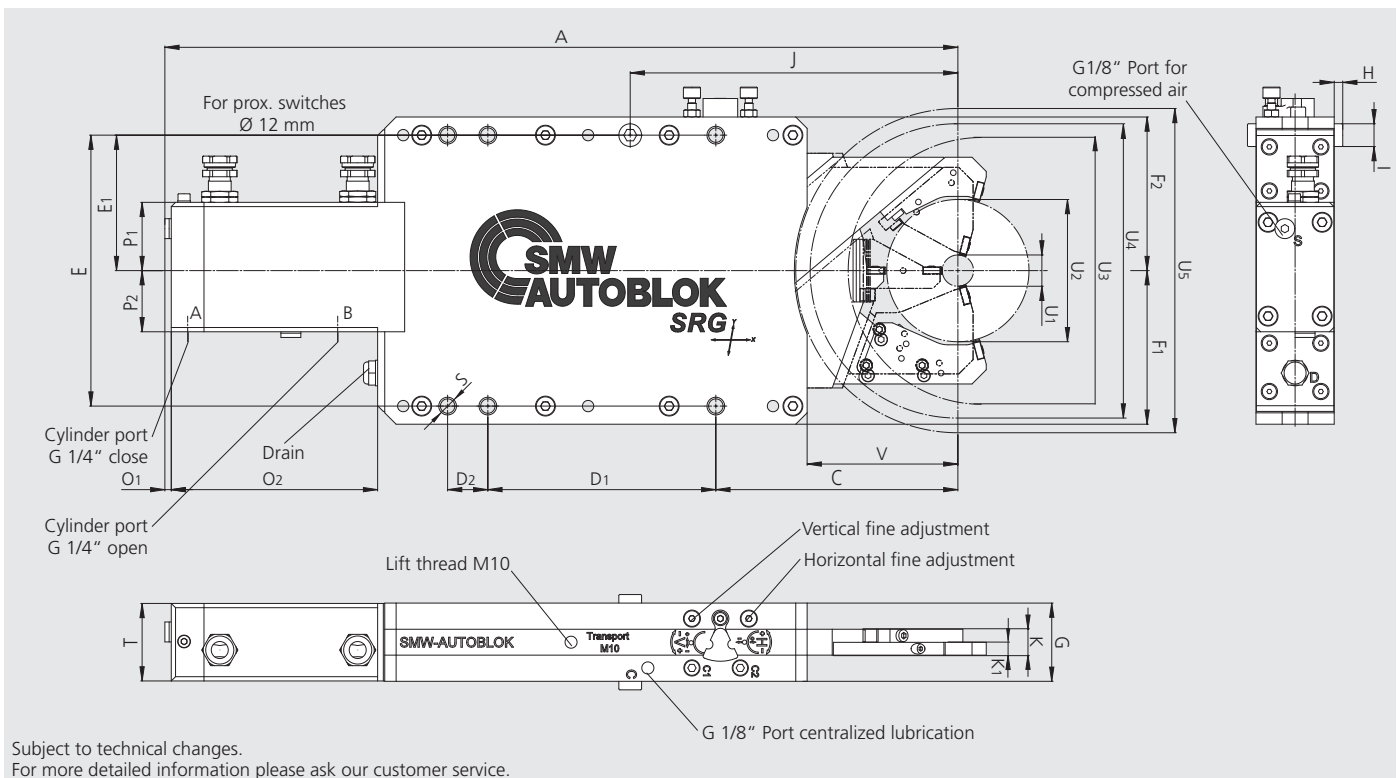
Grinding Steady Rests

■ Dimensions and technical data



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

SMW-AUTOBLOK Type			SRG 3 F			
Id. No.			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		cm ²	12.56			
Operating pressure max.		bar	45			
Working pressure		bar	10 - 30			
Repeatability accuracy		mm	±0.001			
Weight		kg	19.1			



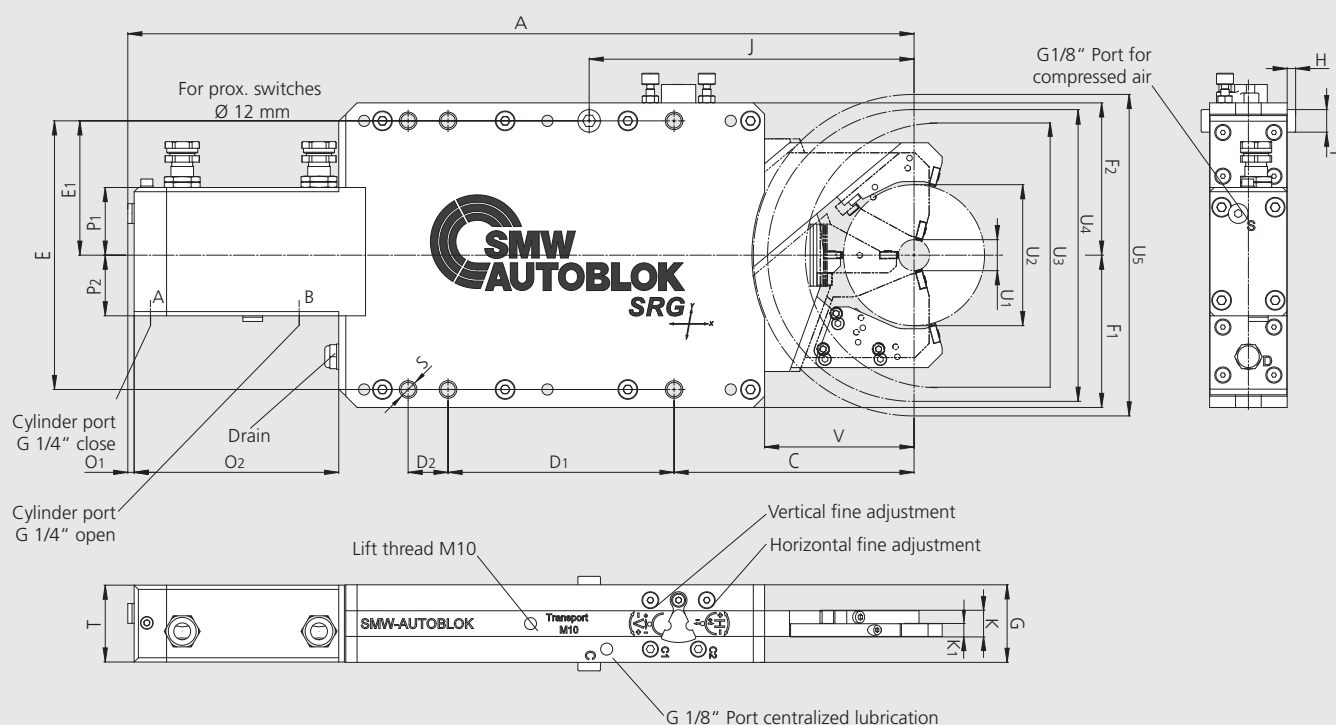
Subject to technical changes.
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SMW-AUTOBLOK Type			SRG 4 F					
Id. No.			221930					
Clamping kit			I	II	III	IV	V	VI
Min. clamping diameter	U1	mm	22	35	48	61	74	87
Max. clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady 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		cm ²	12.56					
Operating pressure max.		bar	30					
Working pressure		bar	7 - 25					
Repeatability accuracy		mm	±0.001					
Weight		kg	30					

SRG 4.1 FS

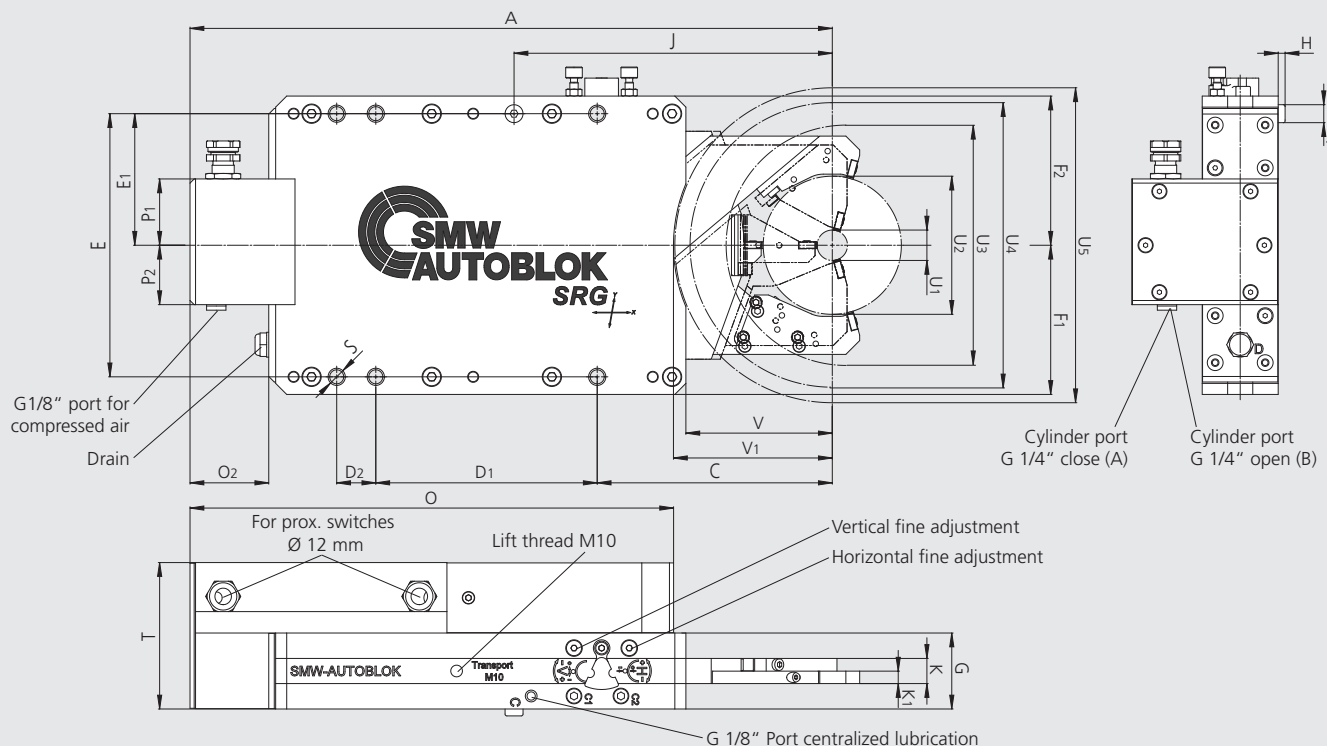
Grinding Steady Rests

■ Dimensions and technical data



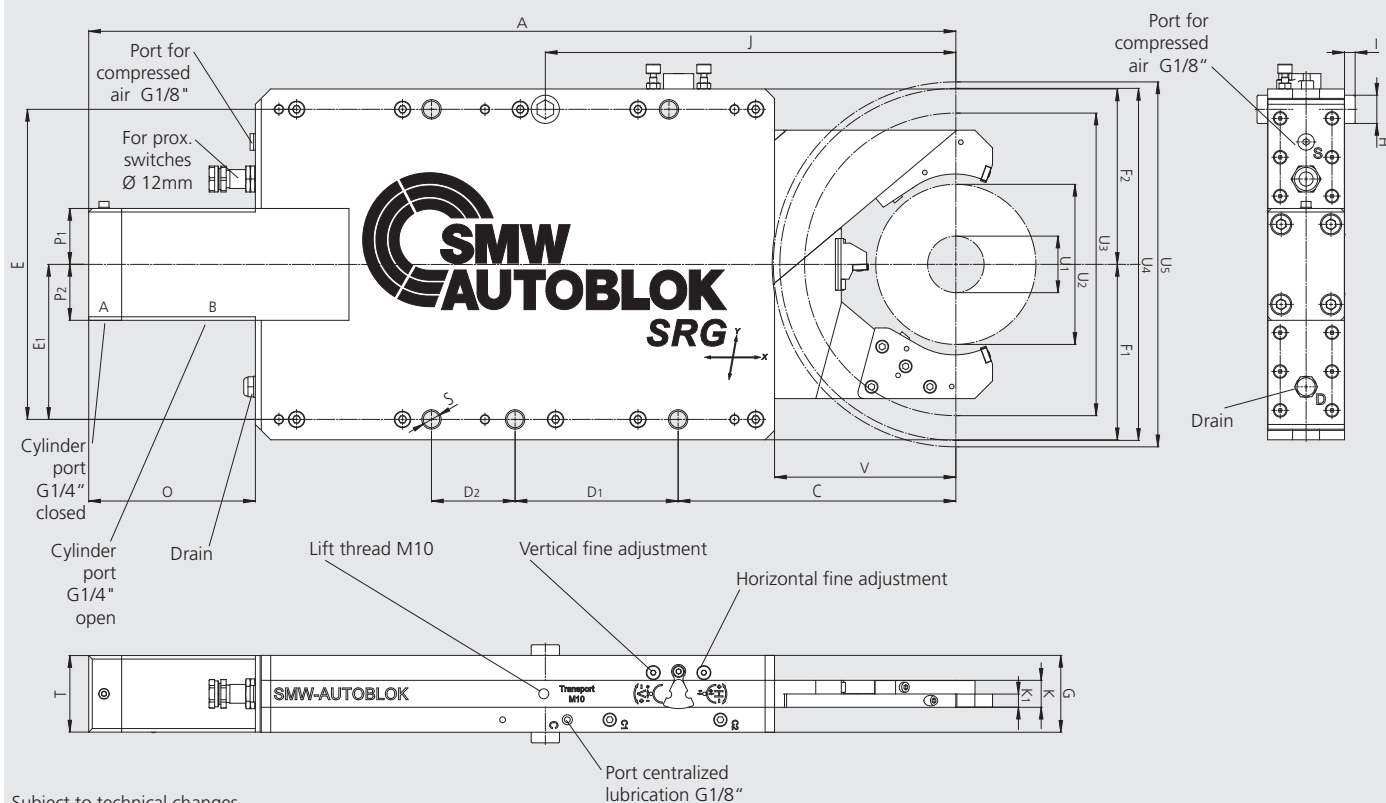
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		SRG 4.1 FS						
Id. No.		222410						
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	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					
Cylinder stroke		mm	126					
Piston area		cm ²	12.56					
Operating pressure max.		bar	35					
Working pressure		bar	8 - 28					
Repeatability accuracy		mm	±0.001					
Weight		kg	26.5					



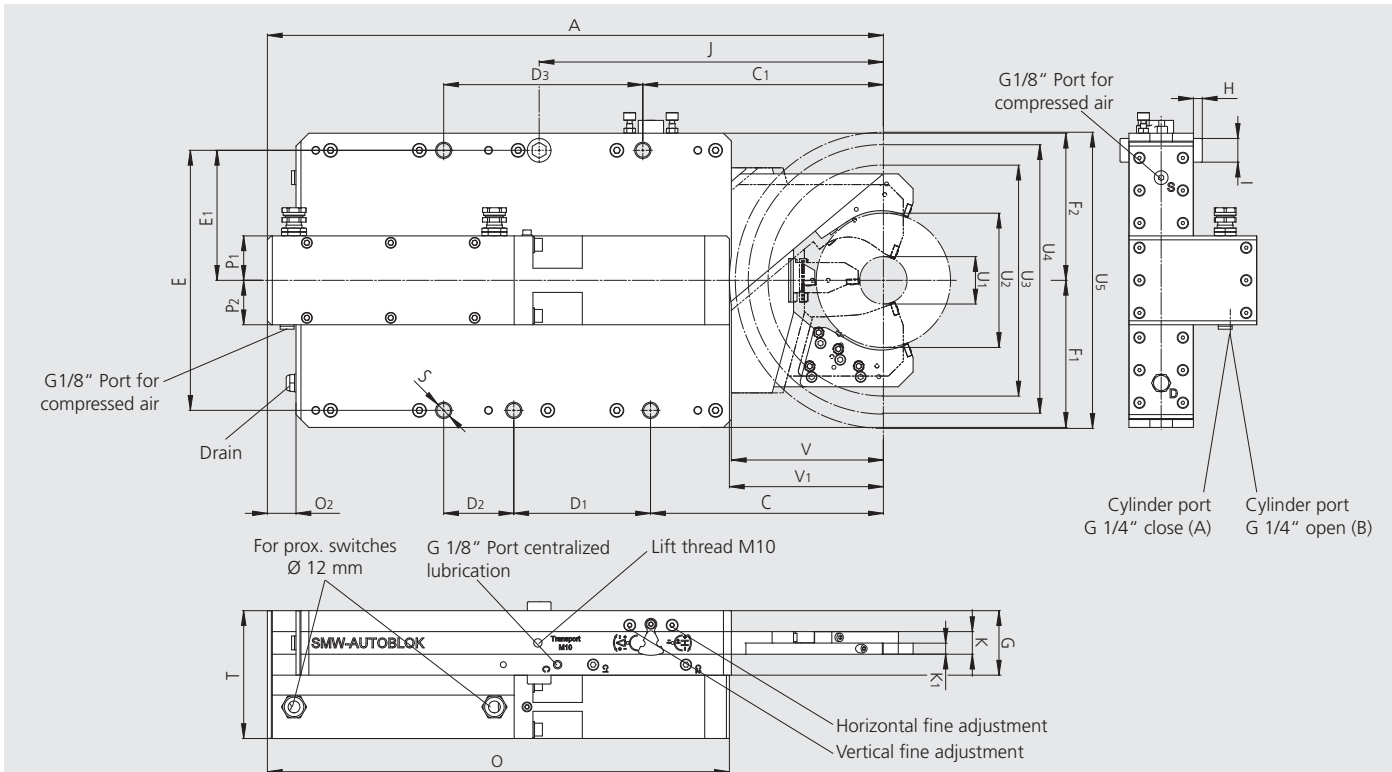
Subject to technical changes.
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SMW-AUTOBLOK Type			SRG-B 4 F					
Id. No.			223140					
Clamping kit			I	II	III	IV	V	VI
Min. clamping diameter	U1	mm	22	35	48	61	74	87
Max. clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady open)	U3	mm	206	204	200	196	194	190
Max. axial clearance diameter (steady open)	U4	mm	218	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		cm ²	10.02					
Operating pressure max.		bar	35					
Working pressure		bar	10-30					
Repeatability accuracy		mm	±0.001					
Weight		kg	37.8					



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

SMW-AUTOBLOK Type			SRG 5 F			
Id. No.			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		cm ²	19.63			
Operating pressure max.		bar	30			
Working pressure		bar	7-25			
Repeatability accuracy		mm	±0.002			
Weight		kg	62.6			



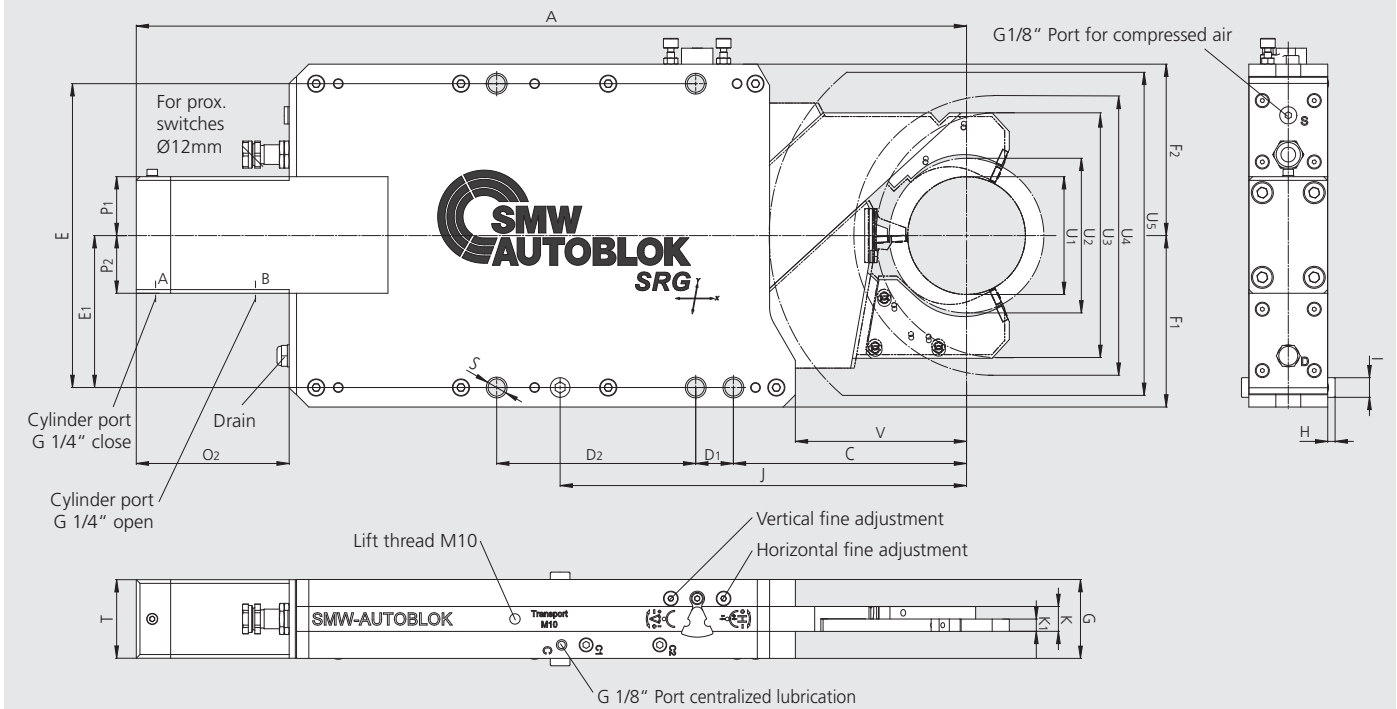
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			SRG-B 5 F			
Id. No.			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		cm ²	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		SRG 5.1 FS					
Id. No.		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		cm ²	19.63				
Operating pressure max.		bar	23				
Working pressure		bar	8 - 18.5				
Repeatability accuracy		mm	±0.002				
Weight		kg	54.8				