

# **HIGH PRECISE GRINDING STEADY REST SRG**

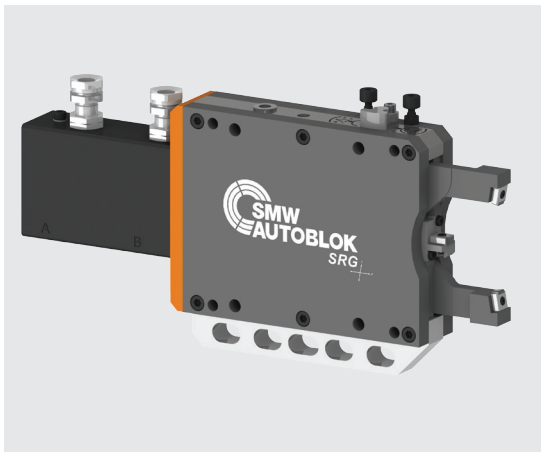
from the market leader in Steady Rests



Video  
Technical data  
[smw-autoblok.de/srg](http://smw-autoblok.de/srg)



## New grinding Steady Rest with fine adjustment of the center



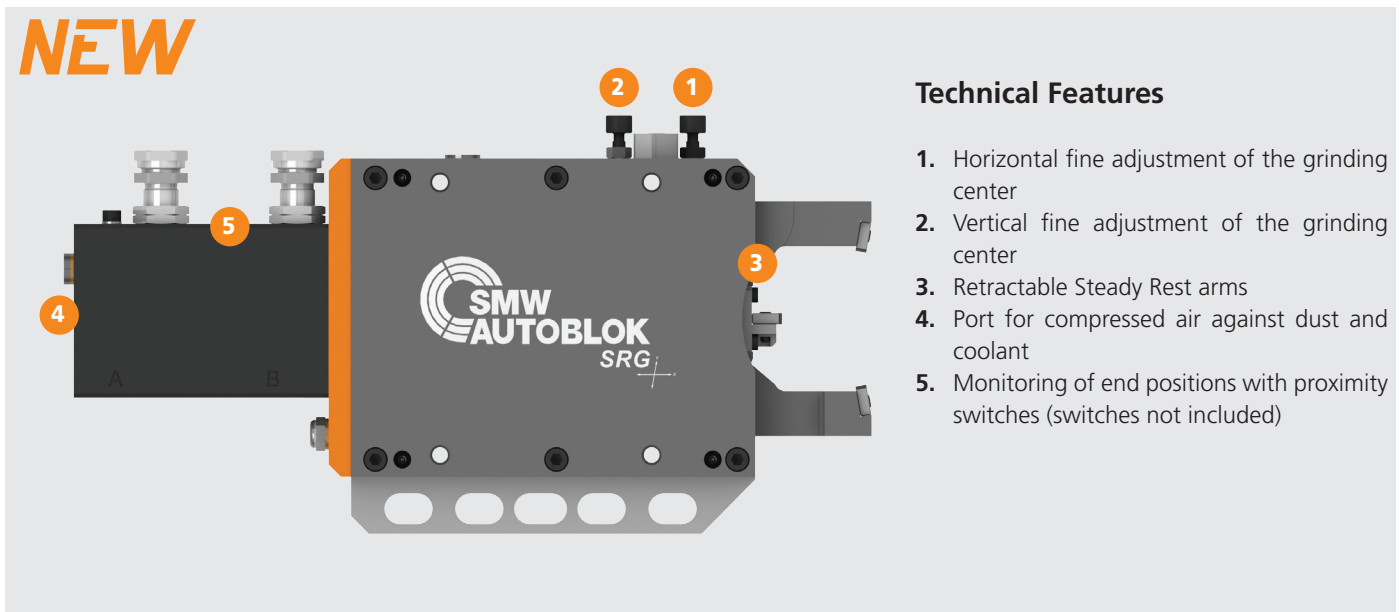
### Application/customer benefits

- 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 fine adjustment
- Suitable for Follow down grinding

### Scope of delivery

- Basic Grinding Steady Rest SRG
- Delivery in transport box

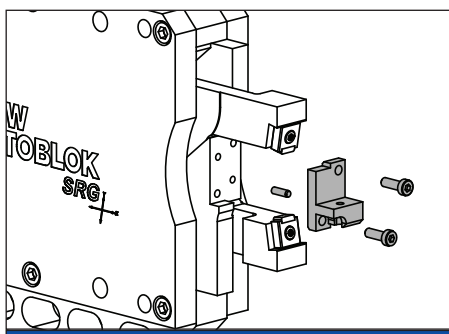
(Padholder for the middle piece, Clamping Kit and Pad Kits are not scope of delivery. See therefor the overview for the configurations below.)



### Technical Features

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)

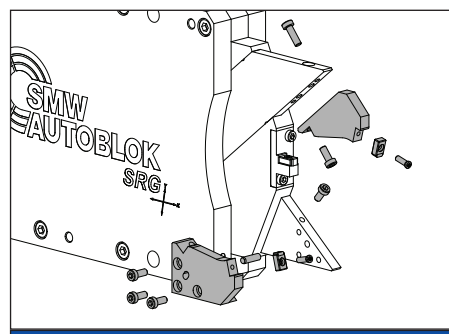
### Overview Configuration



Select padholder for the middle piece (SRG 1 and 2)

#### Padholder for the middle piece (\*)

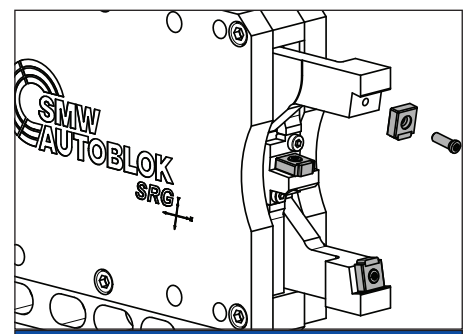
- Consisting of padholder middle piece (incl. mounting material)
- 3 versions available:  
0 degree,  $\pm 5$  degree,  $\pm 7$  degree
- Can be rotated by 180 degrees



Select clamping kit (SRG 2.1 and 4)

#### Clamping Kit for the arms (\*\*)

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



Select Pad Kit

#### Pad Kit (\*\*\*)

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

\* 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



SMW-AUTOBLOK Type Basic Steady Rest	Id. No.	SRG 0.8 223250	SRG 1 221175	SRG 1 S 223060	SRG 2 221871	SRG 2 F 222260
Clamping range	mm	<b>3-18</b>	<b>20-35</b>	<b>20-35</b>	<b>30-60</b>	<b>12-60</b>
Padholder 0 degree	Id. No.		203977*	205191*	203985*	
Padholder ± 5 degree	Id. No.		203978*	205196*	203986*	
Padholder ± 7 degree	Id. No.		203979*	205197*	203987*	
Clamping kit						I II III
Clamping range	mm					<b>12-28 28-44 44-60</b>
Clamping kit 0 degree	Id. No.					204383** 204382** 204381**
Clamping kit -2 degree	Id. No.					
Pad Kit Standard	Id. No.	205439	203976	204161	203976	203976
Pad Kit Special***	Id. No.		203939		203939	203939
Working pressure	bar	20-50	15-30	20-50	15-30	15-30
Follow down grinding		Yes	Yes	Yes		Yes

SMW-AUTOBLOK Type Basic Steady Rest	Id. No.	SRG 4 F 221930						SRG 5.1 FS 222665				
Clamping range	mm	<b>22-100</b>						<b>96-126</b>				
Clamping kit		I	II	III	IV	V	VI	I	II	III	IV	V
Clamping range	mm	<b>22-35</b>	<b>35-48</b>	<b>48-61</b>	<b>61-74</b>	<b>74-87</b>	<b>87-100</b>	<b>96-102</b>	<b>102-108</b>	<b>108-114</b>	<b>114-120</b>	<b>120-126</b>
Clamping kit 0 degree	Id. No.	205000**	205001**	205002**	205003**	205004**	205005**					
Clamping kit -2 degree	Id. No.	205006**	205007**	205008**	205009**	205010**	205011**					
Clamping kit -3 degree	Id. No.							205200**	205201**	205202**	205203**	205204**
Pad Kit Standard	Id. No.	204161						204161				
Pad Kit Special***	Id. No.											
Working pressure	bar	7-25						8-18.5				
Follow down grinding		Yes						Yes				

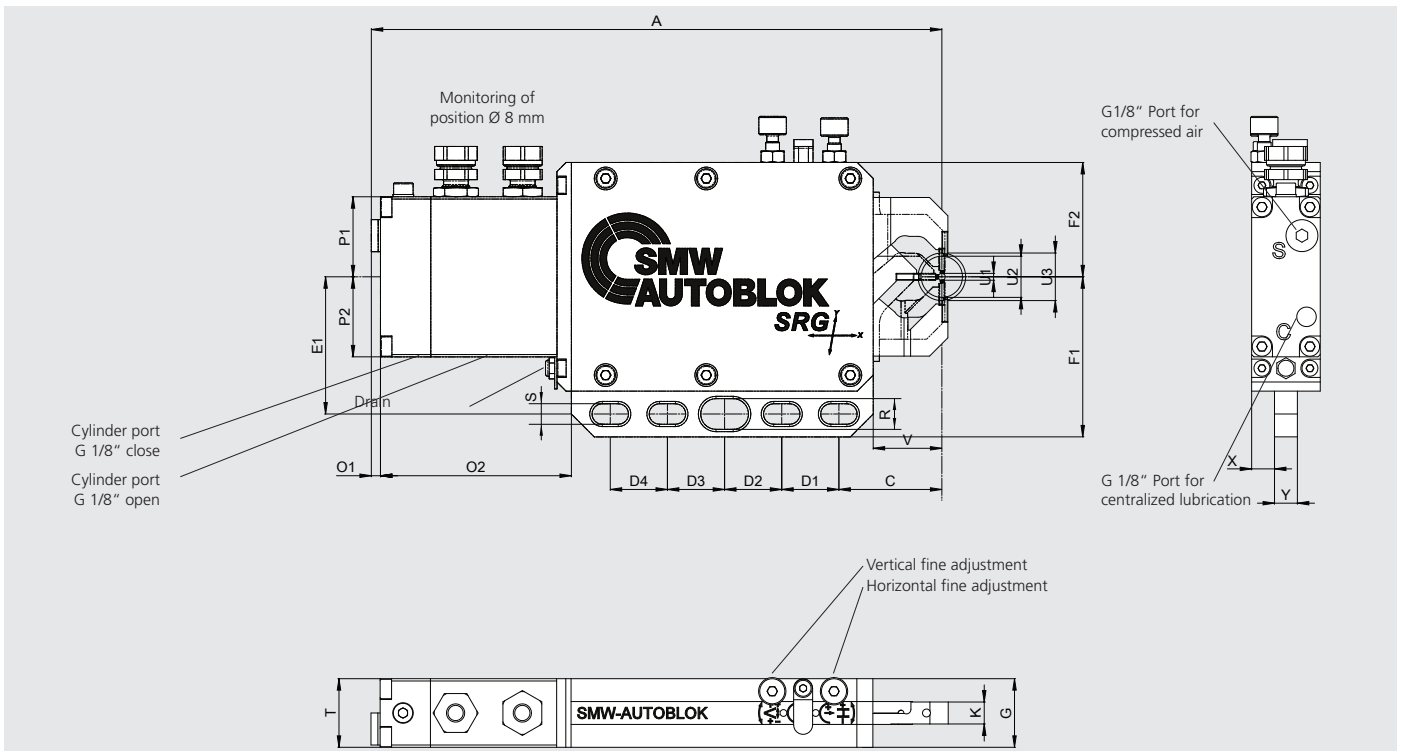
SMW-AUTOBLOK Type Basic Steady Rest	Id. No.	SRG-B 4 F 223140						SRG-B 5 F 222530			
Clamping range	mm	<b>22-100</b>						<b>48-136</b>			
Clamping kit		I	II	III	IV	V	VI	I	II	III	IV
Clamping range	mm	<b>22-35</b>	<b>35-48</b>	<b>48-61</b>	<b>61-74</b>	<b>74-87</b>	<b>87-100</b>	<b>48-70</b>	<b>70-92</b>	<b>92-114</b>	<b>114-136</b>
Clamping kit 0 degree	Id. No.	205000**	205001**	205002**	205003**	205004**	205005**	205018**	205019**	205020**	202021**
Clamping kit -2 degree	Id. No.	205006**	205007**	205008**	205009**	205010**	205011**				
Clamping kit -3 degree	Id. No.										
Pad Kit Standard	Id. No.	204161						204161			
Pad Kit Special***	Id. No.										
Working pressure	bar	10-30						10-30			
Follow down grinding		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
- SRG-B Side mounted cylinder

# SRG 0.8

Grinding Steady Rest

Dimensions and technical data



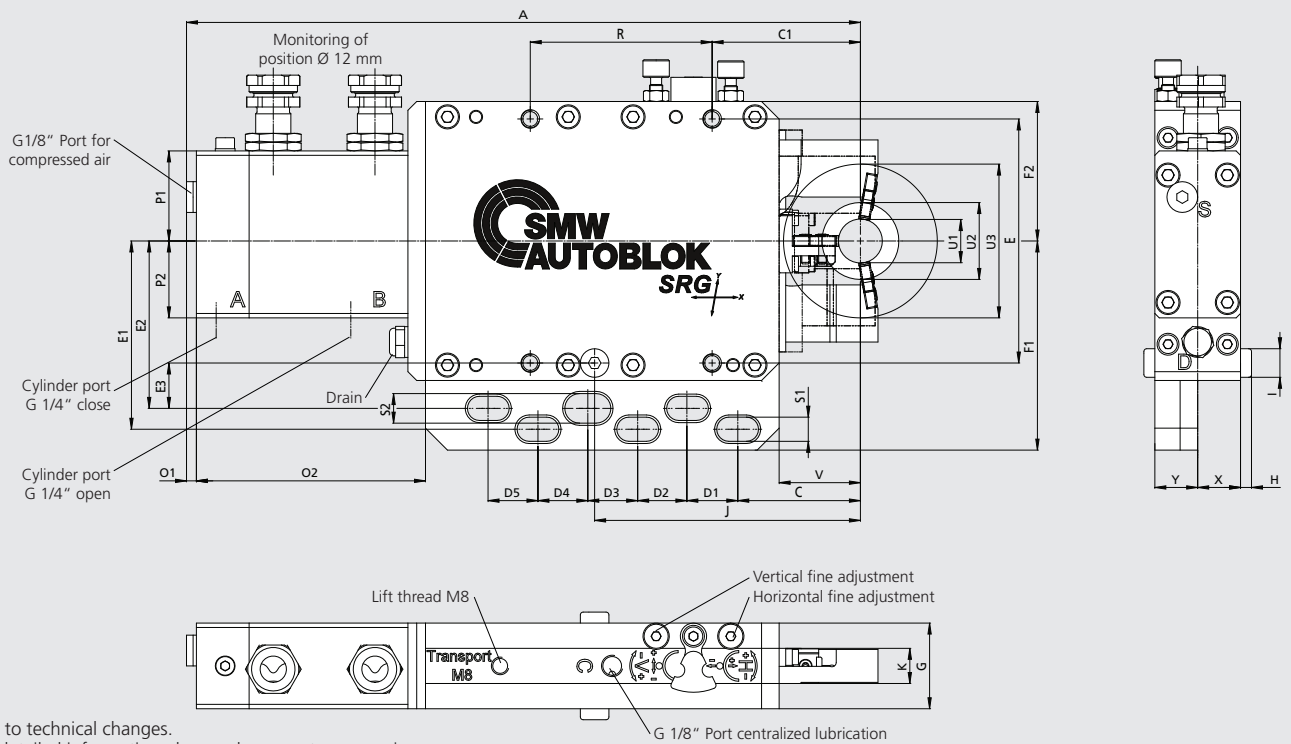
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 0.8 223250
Minimum clamping diameter	U1	mm	3
Maximum clamping diameter	U2	mm	18
Clear for part loading	U3	mm	20
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
	R	mm	13.46
	S	mm	9
	T	mm	30
	V	mm	30
	X	mm	10
	Y	mm	10
Cylinder stroke		mm	43
Piston area		cm <sup>2</sup>	3.14
Operating pressure max.		bar	50
Working pressure		bar	20-50
Repeatability accuracy		mm	0.001
Mass		kg	4.3

# SRG 1

## Dimensions and technical data

## Grinding Steady Rest



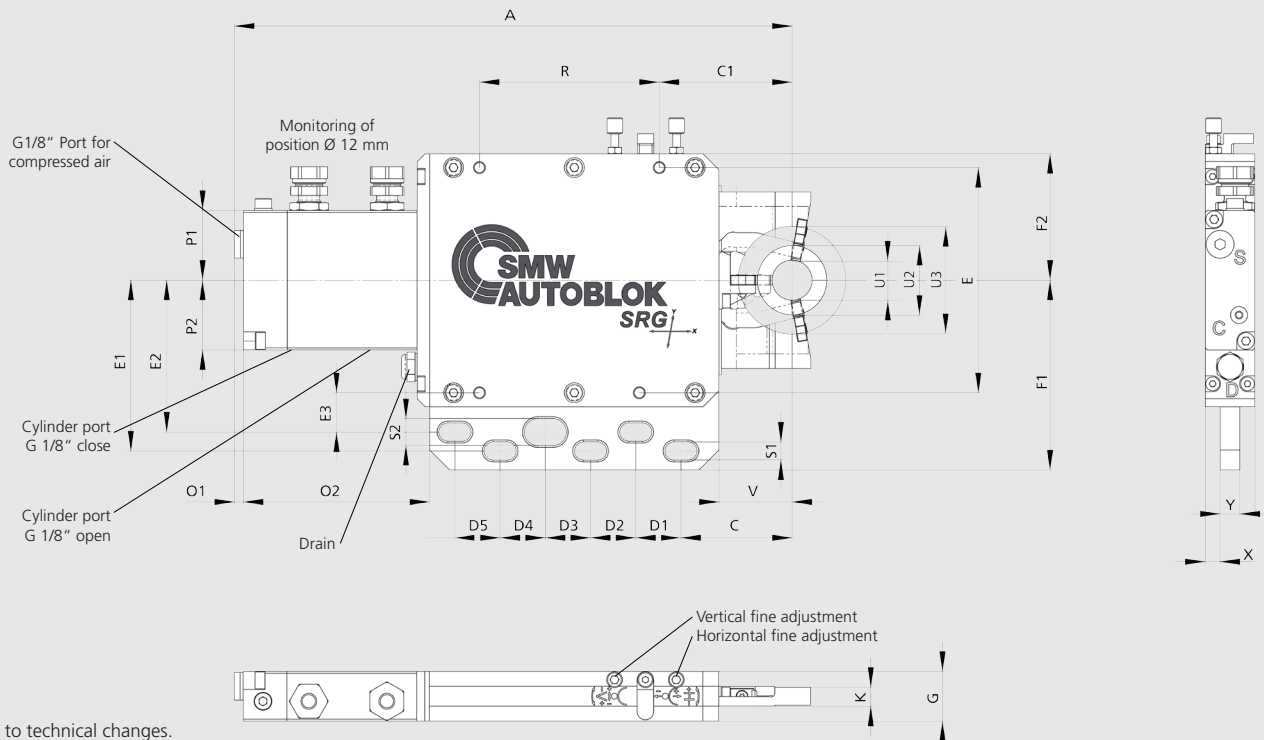
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 1 221175
Minimum clamping diameter	U1	mm	20
Maximum clamping diameter	U2	mm	35
Clear for part loading	U3	mm	42
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	20.7
	F1	mm	95.2
	F2	mm	63.5
	G	mm	39
	H	mm	5
	I	mm	13
	J	mm	121.2
	K	mm	16
	O1	mm	4.5
	O2	mm	104.3
	P1	mm	41
	P2	mm	35
	R	mm	82.8
	S1	mm	11
	S2	mm	13.5
	T	mm	39
	V	mm	37
	X	mm	19.5
	Y	mm	19.5
Cylinder stroke		mm	69.9
Piston area		cm <sup>2</sup>	6.38
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	0.001
Mass		kg	8.7

# SRG 1 S

Grinding Steady Rest

Dimensions and technical data



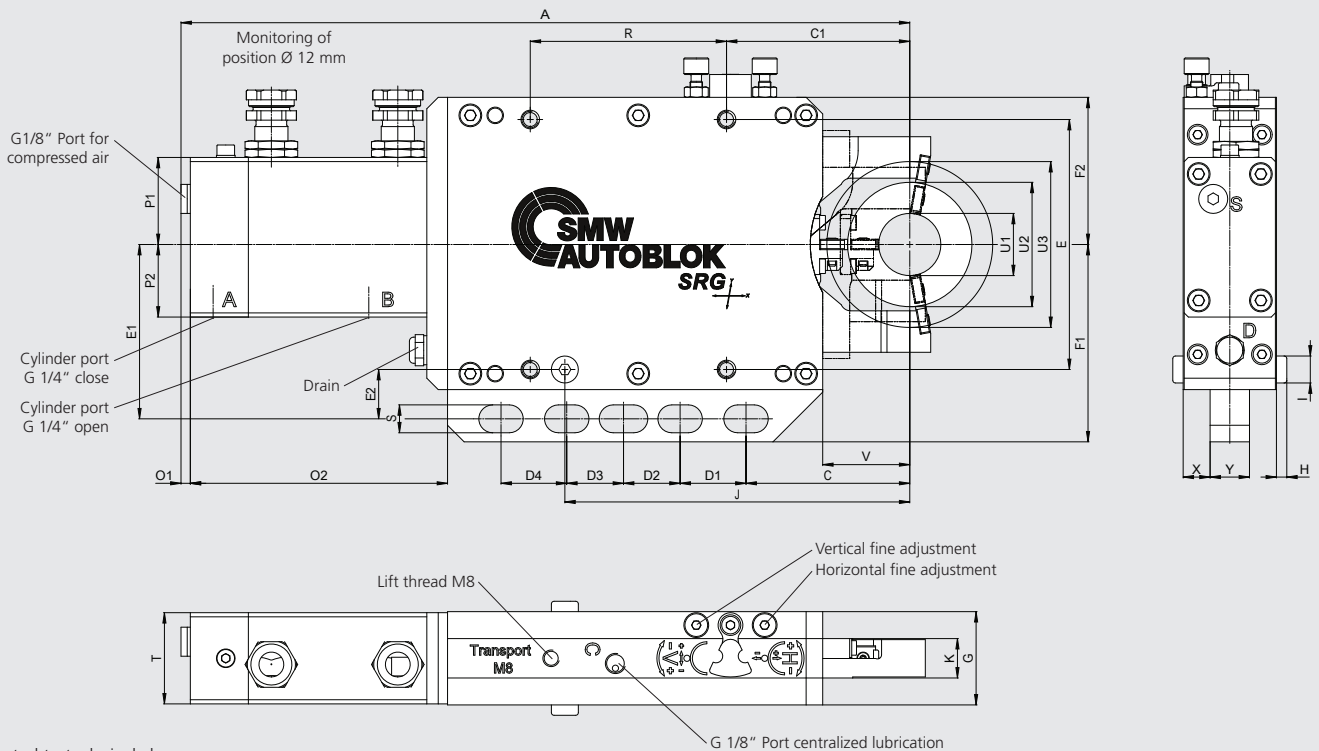
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 1 S 223060
Minimum clamping diameter	U1	mm	20
Maximum clamping diameter	U2	mm	35
Clear for part loading	U3	mm	42
Horizontal adjustment range		mm	± 0.20
Vertical adjustment range		mm	± 0.10
	A	mm	280
	C	mm	55.8
	C1	mm	66.7
	D1	mm	22.7
	D2	mm	22.7
	D3	mm	22.7
	D4	mm	22.7
	D5	mm	22.7
	E	mm	113
	E1	mm	76.2
	E2	mm	85.7
	E3	mm	20.7
	F1	mm	95.2
	F2	mm	61.5
	G	mm	25
	H	mm	5
	I	mm	13
	J	mm	109.35
	K	mm	9
	O1	mm	4.5
	O2	mm	87.2
	P1	mm	35
	P2	mm	35
	R	mm	157
	S1	mm	9 (5x)
	S2	mm	13.5
	T	mm	39
	V	mm	36.7
	X	mm	7.5
	Y	mm	10
Cylinder stroke		mm	53
Piston area		cm <sup>2</sup>	2.01
Operating pressure max.		bar	50
Working pressure		bar	20-50
Repeatability accuracy		mm	0.001
Mass		kg	4.8

# SRG 2

## Dimensions and technical data

## Grinding Steady Rest



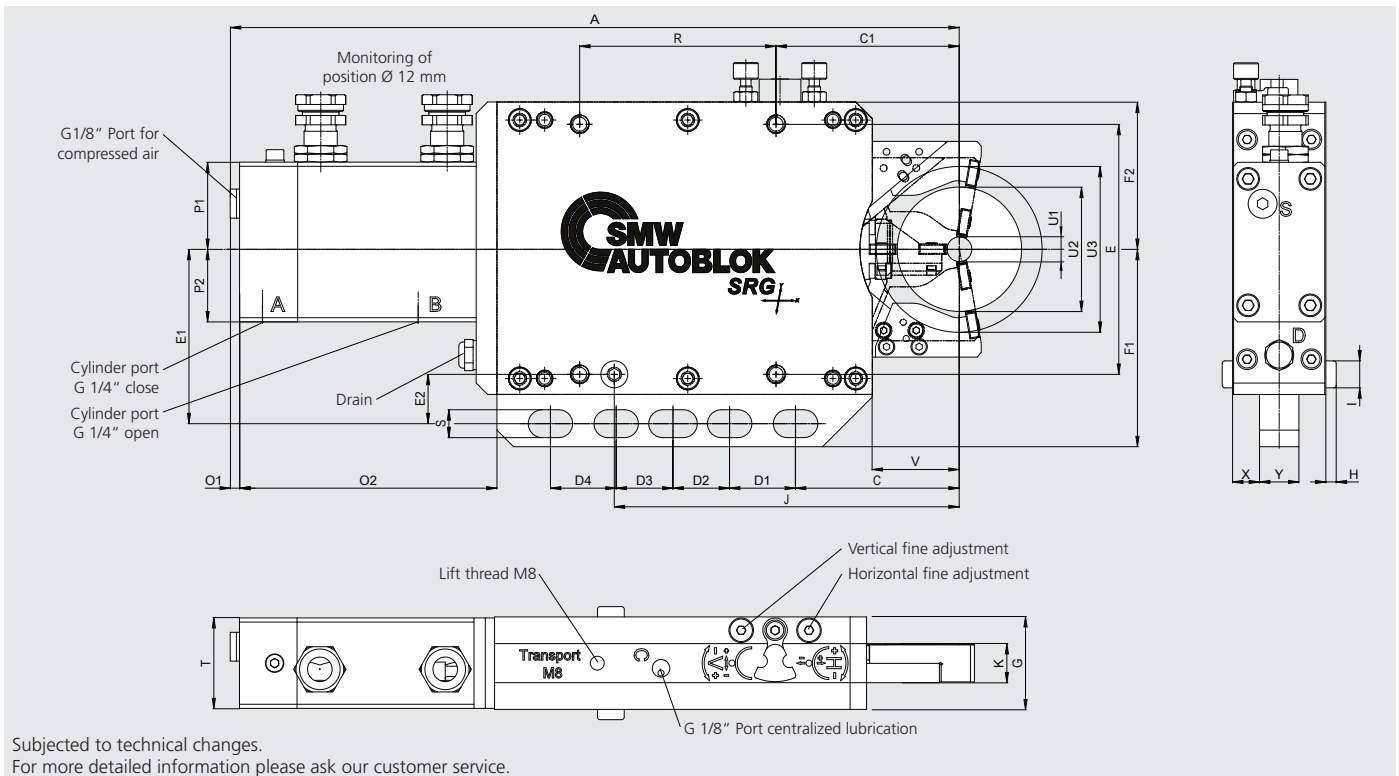
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For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 2 221871
Minimum clamping diameter	U1	mm	30
Maximum clamping diameter	U2	mm	60
Clear for part loading	U3	mm	63
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
	M	mm	41
	O1	mm	4.5
	O2	mm	124.1
	P1	mm	42
	P2	mm	35
	R	mm	94.7
	S	mm	13.5
	T	mm	45
	V	mm	42
	X	mm	13
	Y	mm	19
Cylinder stroke		mm	73.4
Piston area		cm <sup>2</sup>	7,07
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	0.001
Mass		kg	11.8

# SRG 2 F

Grinding Steady Rest

Dimensions and technical data



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

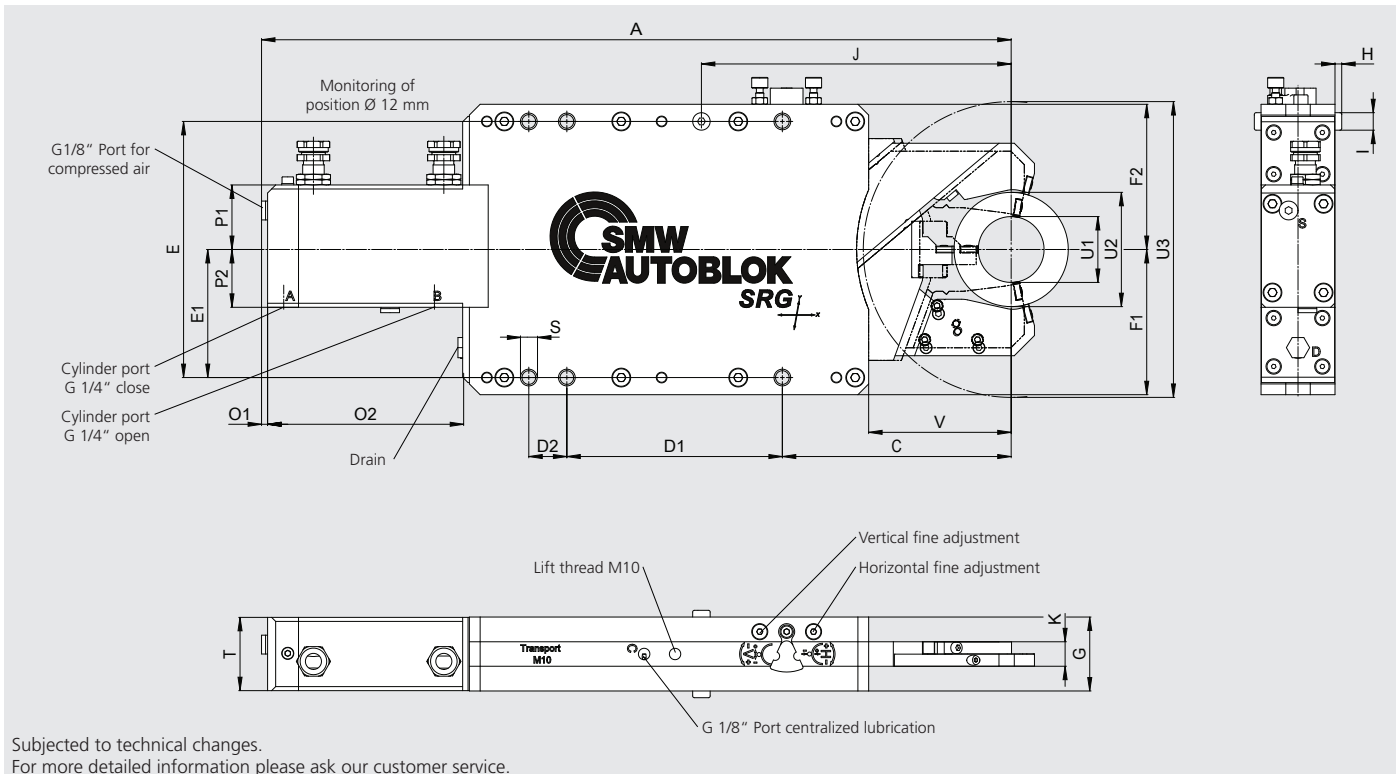
SMW-AUTOBLOK Type	SRG 2 F		
Id. No.	222260		
Minimum clamping diameter	U1	mm	12 *      28 *      44 *
Maximum clamping diameter	U2	mm	28 *      44 *      60 *
Clear for part loading	U3	mm	30 *      46 *      62 *
Horizontal adjustment range		mm	± 0.20
Vertical adjustment range		mm	± 0.14
	A	mm	351.6
	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
	M	mm	41
	O1	mm	4.5
	O2	mm	124.1
	P1	mm	42
	P2	mm	35
	R	mm	94.7
	S	mm	13.5
	T	mm	45
	V	mm	42
	X	mm	13
	Y	mm	19
Cylinder stroke		mm	66.4
Piston area		cm <sup>2</sup>	7.07
Operating pressure max.		bar	45
Working pressure		bar	15-30
Repeatability accuracy		mm	0.001
Mass		kg	11.2

(\*) Modular nests for the arms:  
 12-28 mm clamping range by using clamping kit I      28-44 mm clamping range by using clamping kit II      44-60 mm clamping range by using clamping kit III

# SRG 4 F

## Dimensions and technical data

## Grinding Steady Rest



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

SMW-AUTOBLOK Type Id. No.			SRG 4 F 221930					
Minimum clamping diameter	U1	mm	22 *	35 *	48 *	61 *	74 *	87 *
Maximum clamping diameter	U2	mm	35 *	48 *	61 *	74 *	87 *	100 *
Clear for part loading	U3	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	5					
	I	mm	13					
	J	mm	230.4					
	K	mm	18.2					
	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 <sup>2</sup>	12.56					
Operating pressure max.		bar	30					
Working pressure		bar	7-25					
Repeatability accuracy		mm	0.001					
Mass		kg	20					

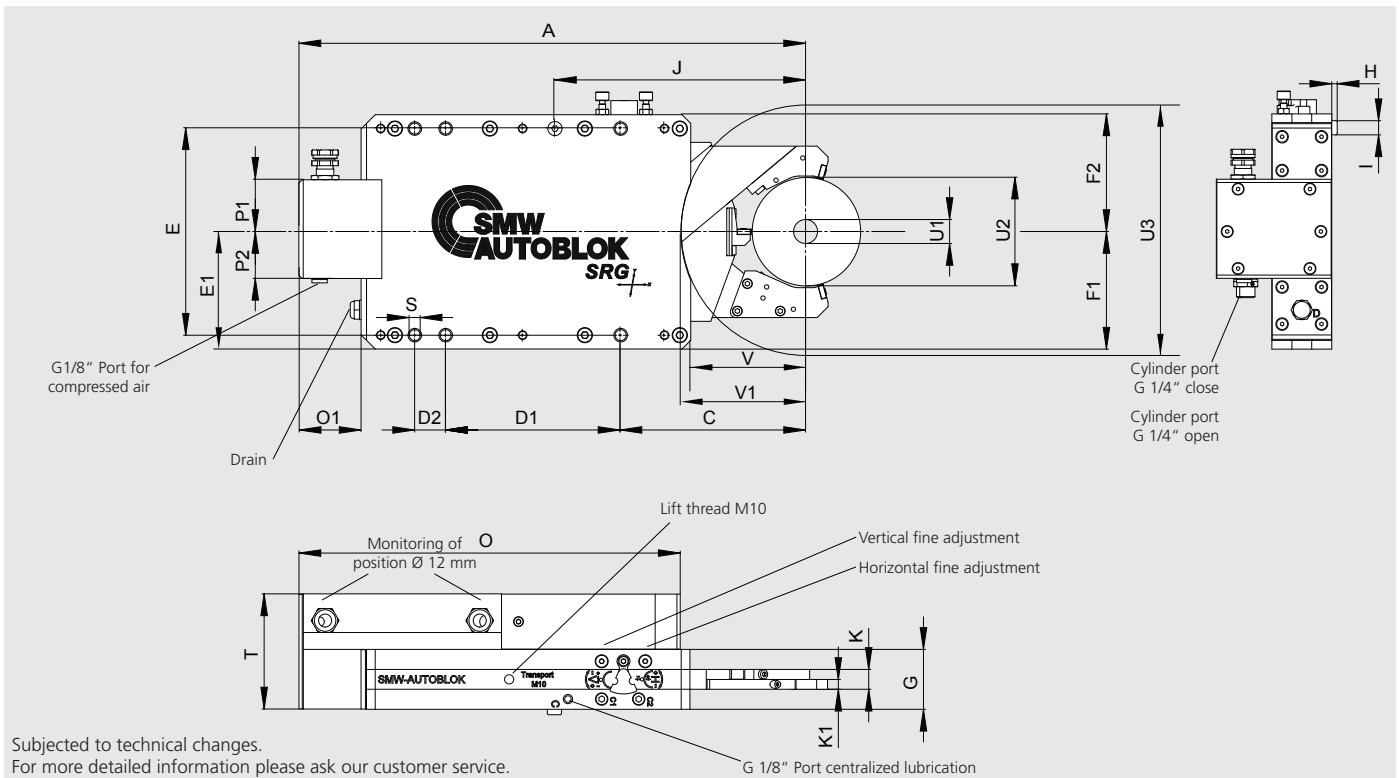
### (\*) Modular nests for the arms:

- 022-035 mm clamping range by using clamping kit I
- 035-048 mm clamping range by using clamping kit II
- 048-061 mm clamping range by using clamping kit III
- 061-074 mm clamping range by using clamping kit IV
- 074-087 mm clamping range by using clamping kit V
- 087-100 mm clamping range by using clamping kit VI

# SRG-B 4 F

Grinding Steady Rest

Dimensions and technical data



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

G 1/8" Port centralized lubrication

SMW-AUTOBLOK Type Id. No.			SRG-B 4 F 223140					
Minimum clamping diameter	U1	mm	22 *	35 *	48 *	61 *	74 *	87 *
Maximum clamping diameter	U2	mm	35 *	48 *	61 *	74 *	87 *	100 *
Clear for part loading	U3	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					
	O1	mm	54					
	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 <sup>2</sup>	10.02					
Operating pressure max.		bar	35					
Working pressure		bar	10-30					
Repeatability accuracy		mm	0.001					
Mass		kg	37.8					

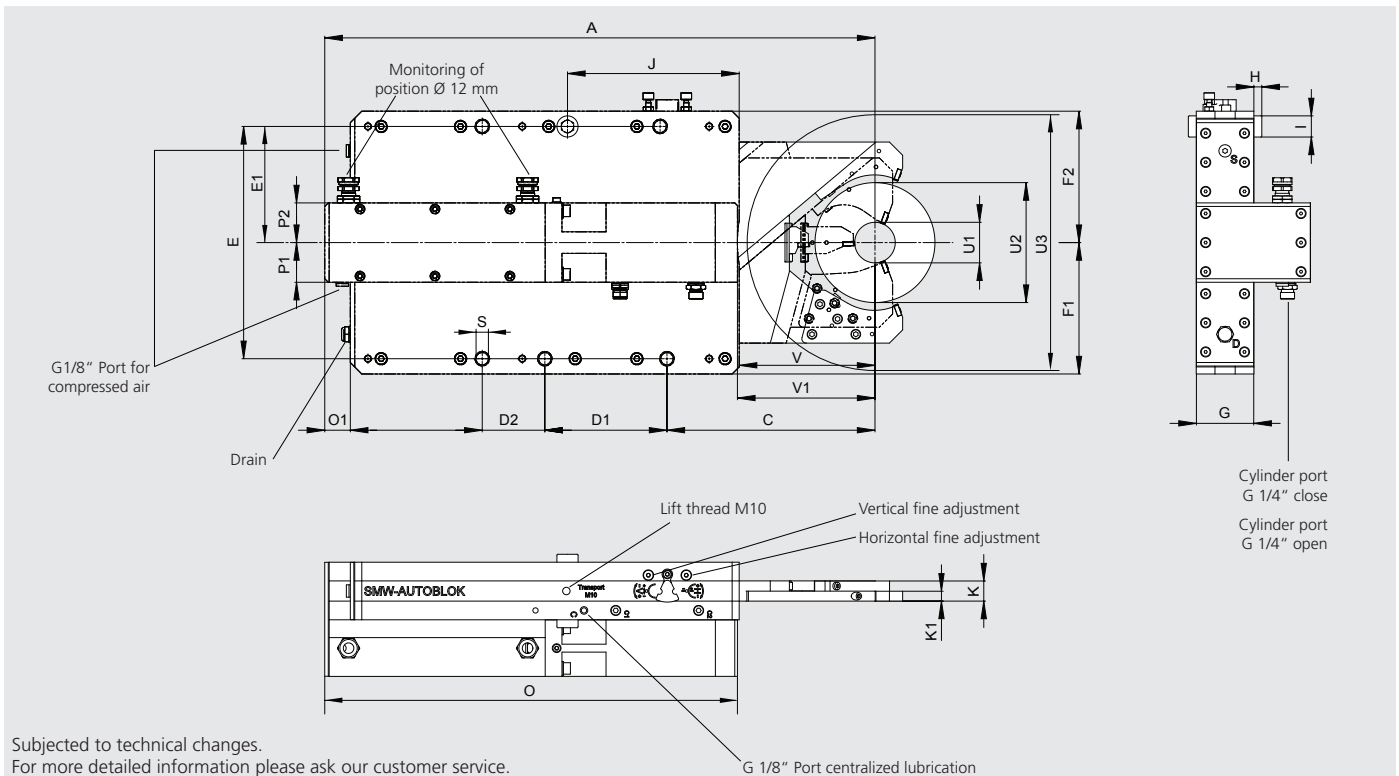
**(\*) Modular nests for the arms:**

- 022-035 mm clamping range by using clamping kit I
- 035-048 mm clamping range by using clamping kit II
- 048-061 mm clamping range by using clamping kit III
- 061-074 mm clamping range by using clamping kit IV
- 074-087 mm clamping range by using clamping kit V
- 087-100 mm clamping range by using clamping kit VI

# SRG-B 5 F

## Dimensions and technical data

## Grinding Steady Rest



SMW-AUTOBLOK Type Id. No.			SRG-B 5 F 222530			
Minimum clamping diameter	U1	mm	48 *	70 *	92 *	114 *
Maximum clamping diameter	U2	mm	70 *	92 *	114 *	136 *
Clear for part loading	U3	mm	300			
Horizontal adjustment range		mm	± 0.20			
Vertical adjustment range		mm	± 0.14			
	A	mm	595			
	C	mm	154			
	D1	mm	138.5			
	D2	mm	71			
	E	mm	263.5			
	E1	mm	170			
	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	11.2			
	O	mm	468			
	O1		29			
	P1		45			
	P2		45			
	S	mm	M12 (6x)			
	T	mm	129.5			
	V	mm	154			
	V1	mm	156			
Cylinder stroke		mm	179			
Piston area		cm <sup>2</sup>	16.49			
Operating pressure max.		bar	35			
Working pressure		bar	10-30			
Repeatability accuracy		mm	0.001			
Mass		kg	76.4			

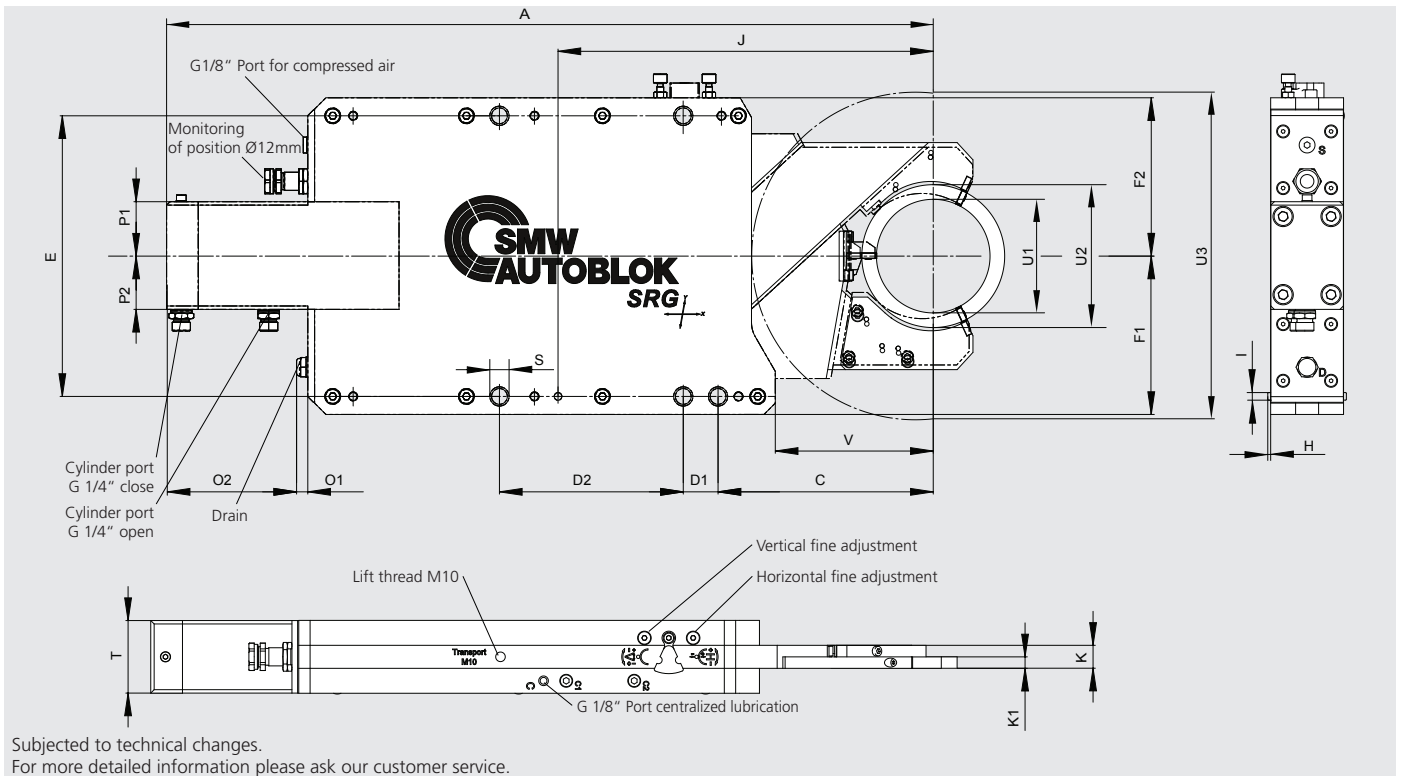
### (\*) Modulare Wechseleinsätze für Arme:

- 048-070 mm clamping range by using clamping kit I
- 070-092 mm clamping range by using clamping kit II
- 092-114 mm clamping range by using clamping kit III
- 114-136 mm clamping range by using clamping kit IV

# SRG 5.1 FS

Grinding Steady Rest

Dimensions and technical data



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

SMW-AUTOBLOK Type Id. No.			SRG 5.1 FS 222665				
Minimum clamping diameter	U1	mm	96 *	102 *	108 *	114 *	120 *
Maximum clamping diameter	U2	mm	102 *	108 *	114 *	120 *	126 *
Clear for part loading	U3	mm	228				
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				
	H	mm	6				
	I	mm	16				
	J	mm	331.2				
	K	mm	20.3				
	K1	mm	10				
	O1	mm	9.9				
	O2	mm	114.7				
	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 <sup>2</sup>	19.63				
Operating pressure max.		bar	23				
Working pressure		bar	8-18.5				
Repeatability accuracy		mm	0.001				
Mass		kg	54.8				

**(\*) Modular nests for the arms:**

- 096-102 mm clamping range by using clamping kit I
- 102-108 mm clamping range by using clamping kit II
- 108-114 mm clamping range by using clamping kit III
- 114-120 mm clamping range by using clamping kit IV
- 120-126 mm clamping range by using clamping kit V



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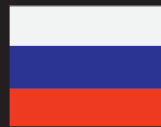
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