

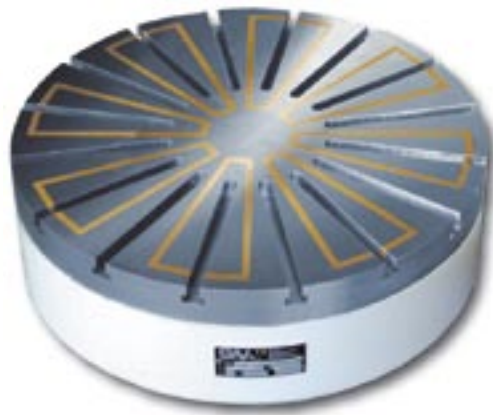
Electro Permanent Circular Chuck

SAV 244.70

With radial pole arrangement

These circular electro magnets are notable for their very strong, evenly distributed holding force.

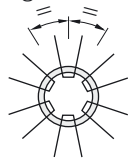
The magnetic force is produced by permanent magnets which are magnetized and demagnetized by short electric current pulses.



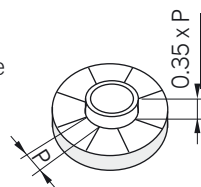
Use:

Mainly for precision grinding of small to large workpieces on rotary tables and circular grinders.

- for circular grinding and turning
- equal pole pitch within circle range; therefore very suitable for circular workpieces



- the minimum workpiece height; 35% of the pole pitch at the given circle segment



- also for thin rings



Nominal holding force:

120 N/cm²,
adjustable by control unit.

Nominal operating voltage:

210 V DC up to 250 mm diameter
360 V DC above 250 mm diameter

Features:

- solid designed pole plate
- switching off through demagnetizing cycle
- electro-permanent magnetic system, guaranteeing safe operation during power failure
- high precision due to fine grid pole-plate-to-body connection
- pole separation with brass in-lays for optimal wear behaviour
- pole plate exchangeable
- radial pole arrangement, especially suitable for the use of pole raisers. This is absolutely essential for the runout of the tool or the grinding wheel at three side operation. Therefore available with T-slots (T) according to DIN 650-10H10 on request.
- pole plate wearing limit 8mm
- sealed to IP 65
- suitable for use with control unit type 876.10 (see chapter 04)
- available with adapter flange on request (SAV 248.90 to 248.94, see chapter 06)

Scope of supply:

- Lifting bolts for transportation on larger models.
- T-slots and pole extensions not included as standard.
- Terminals for electrical connection in middle of back side in standard execution.
- Optional with integrated slip ring body for the bigger diameters.
- with industrial watertight plug-in type connector on request

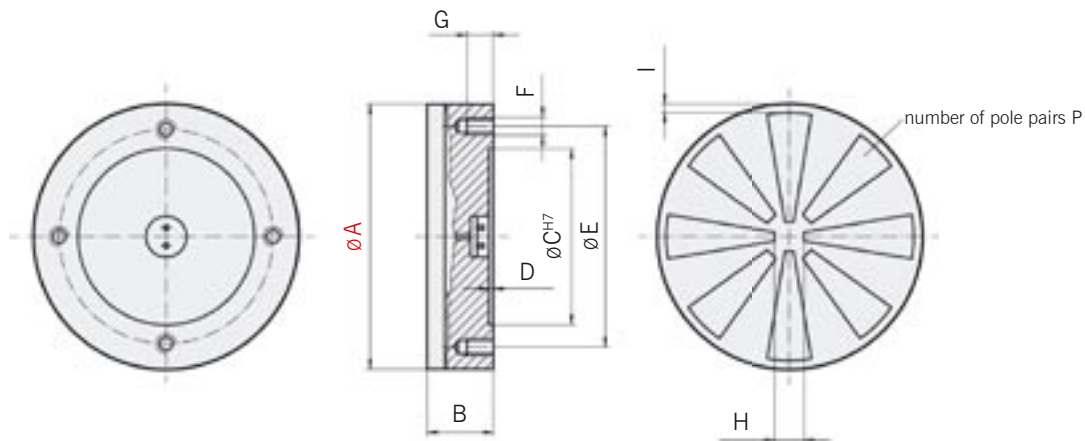


WORKHOLDING AND AUTOMATION

Electro Permanent Circular Chuck

SAV 244.70

With radial pole arrangement



A	B ₀	C	Dimensions in mm						P	Weight in kg	Chuck voltage in Vdc	Control unit max. current in A	Suitable control unit	
			D	E	F	G	H	I						
100	100	60	3	80	M8 (3x)	12	35	10	3	4	210	30	876.10 / 876.03	
150	100	90	3	120	M10 (3x)	14	35	10	3	9	210	30	876.10 / 876.03	
200	100	110	3	140	M10 (4x)	14	45	10	4	18	210	30	876.10 / 876.03	
250	100	140	3	170	M12 (4x)	16	45	10	4	29	210	30	876.10	
300	100	160	3	190	M12 (4x)	16	60	10	6	42	210 / 360	30	876.10	
400	100	210	4	250	M12 (6x)	16	70	15	6	76	210 / 360	30	876.10	
500	100	280	4	320	M12 (6x)	16	100	15	8	120	360	30	876.10	
600	100	350	4	390	M16 (6x)	18	100	15	8	195	360	30	876.10	
700	100	400	4	450	M16 (6x)	18	120	15	8	265	360	30	876.10	
800	100	450	4	500	M16 (6x)	18	150	18	12	365	360	30	876.10	
1000	100	550	4	620	M16 (8x)	18	200	18	12	550	360	60	876.10	
1200	125			Rear detail as required				300	25	18	990	360	60 x 2	876.10
1400	125			Rear detail as required				300	25	18	1350	360	60 x 2	876.10
1500	125			Rear detail as required				300	25	18	1550	360	60 x 2	876.10
1600	125			Rear detail as required				300	25	18	1760	360	60 x 2	876.10

Bigger sizes up to A = 3100 available on request. Please refer to SAV 876.03 to SAV 876.10 (see chapter 04), for details regarding suitable control units, based on the power rating.

Ordering example: **Electro Permanent Circular Chuck** SAV 244.70 - 1600 - T - 360 V

Ordering key: Name SAV - No. - A - Execution - Operating voltage