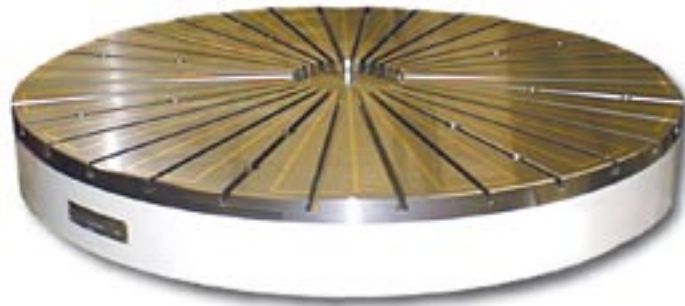


Electro Permanent Circular Chuck

SAV 244.71

Enhanced magnetic system with radial pole arrangement and exceptional holding force

This new design of circular magnet, using high-energy magnetic materials, provides extremely high holding forces. Magnetization and demagnetization through a short electric direct current pulse. The homogeneous nature and precision of this circular magnet makes it suitable for turning hardened steels as well as general heavy cutting.

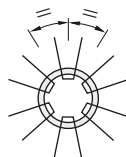


Use:

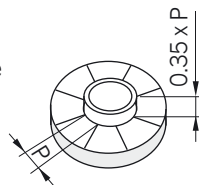
Turning of hardened steel and heavy cutting of small to large workpieces. Also for highest precision grinding.

- for turning and hard turning

- equal pole pitch within circle range; therefore very suitable for circular and ring-shaped workpieces



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



- also for thin rings



Nominal holding force:

160 N/cm²,
adjustable by control unit
with encoded switch.

Nominal operating voltage:

360 V DC

Features:

- evenly distributed strong magnetic field
- solid constructed 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 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:

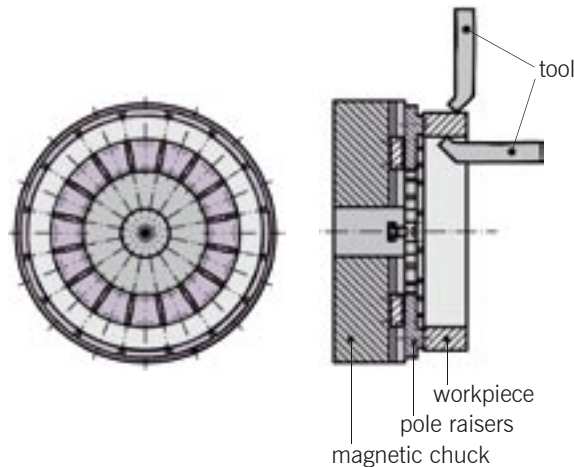
- Lifting bolts for transportation on larger models.
- T-slots and pole extensions not included as standard.
- Terminals for electrical connection in middle of back side in standard execution.
- Optional with integrated slip ring body for the bigger diameters.
- with industrial watertight plug-in type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


WORKHOLDING AND AUTOMATION

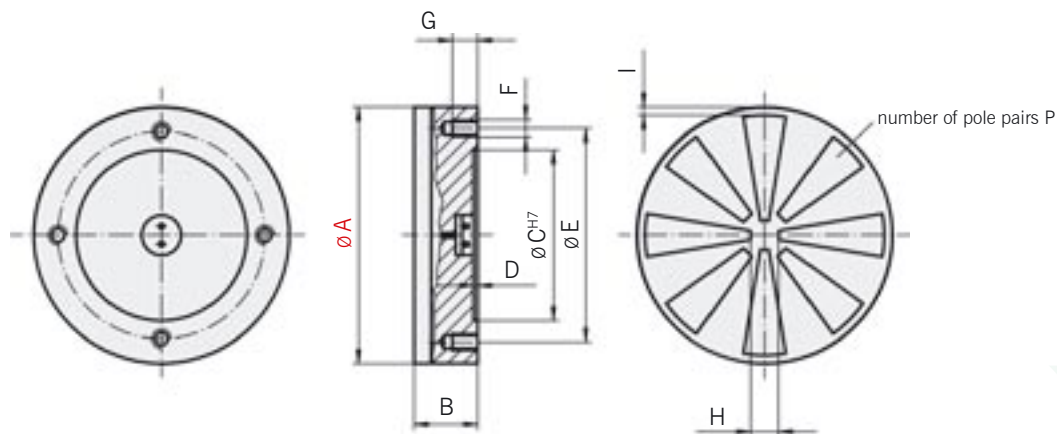
Electro Permanent Circular Chuck

SAV 244.71

Enhanced magnetic system with radial pole arrangement and exceptional holding force



Segment-shaped pole raisers ensure an undisturbed tool path during 3-side machining. A solid axial mounting face is provided by 3 rigid pole extensions, the remainder being floating types. For workpieces with differing diameters, the pole raisers can be repositioned along the radial milled slots (available on request).



A	B ^o	C	Dimensions in mm							Weight in kg	Chuck voltage in Vdc	Control unit max. current in A	Suitable control unit	
			D	E	F	G	H	I	P					
200	100	110	3	140	M10 (4x)	14	45	10	4	24	360	30	876.10	
250	100	140	3	170	M12 (4x)	16	45	10	4	39	360	30	876.10	
300	100	160	3	190	M12 (4x)	16	60	10	6	54	360	30	876.10	
400	100	210	4	250	M12 (6x)	16	70	15	6	85	360	30	876.10	
500	110	280	4	320	M12 (6x)	16	100	15	8	150	360	30	876.10	
600	110	350	4	390	M16 (6x)	18	100	15	8	210	360	30	876.10	
700	110	400	4	450	M16 (6x)	18	120	15	8	280	360	30	876.10	
800	110	450	4	500	M16 (6x)	18	150	18	12	380	360	30	876.10	
1000	125	550	4	620	M16 (8x)	18	200	18	12	680	360	60	876.10	
1200	125	Rear detail as required						300	25	18	975	360	60 x 2	876.10
1400	150	Rear detail as required						300	25	18	1600	360	60 x 2	876.10
1500	150	Rear detail as required						300	25	18	1850	360	60 x 2	876.10
1600	150	Rear detail as required						300	25	18	2105	360	60 x 2	876.10

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

Ordering example: **Electro Permanent Circular Chuck**
 Ordering key: Name

SAV 244.71 - 1600 - T - 360 V
 SAV - No. - A - Execution - Operating voltage