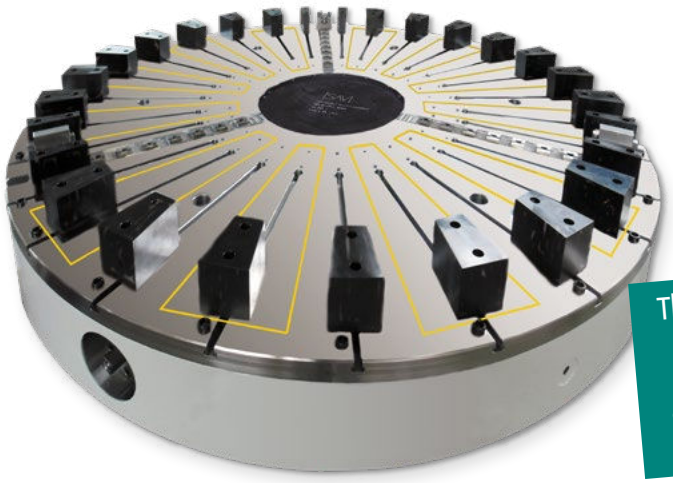
# SAV 244.76 COMBINED CIRCULAR CHUCKS

**Radial pole pitch and integrated jaw chuck**

Combination of magnetic and mechanical workholding



The innovative combination of magnetic workholding with a centring chuck – a complete system solution from a single source

## ADVANTAGES

- Reproducible centring
- Reliable process
- Option for combining first and second chucking
- Compact design (height from 170 mm)

## DESIGN OF MAGNET SYSTEM

- Combination/hybrid magnet chuck type **SAV 224.76** with electro permanent magnetic principle, magnet system with amplified design, holding forces on inducible area up to 170 N/cm²
- Full metal pole plate with brass insulation and T-slots as per DIN 650-$10^{H10}$ for mounting fixed and movable pole raisers
- 8 mm wear layer on the pole plate, can be replaced after many years of use and wear
- On request with heavy-duty power connector integrated into the circumference and as a quick-release coupling

## RATED HOLDING FORCE

170 N/cm², controllable with control unit

## RATED VOLTAGE, RECOMMENDED

360 V IMP

## DESIGN EXAMPLE FOR CENTRING CHUCK

- Power chuck SAV 260.20
- Centring accuracy of the chuck: 0.02 mm, centring range from: 450 – 1200 mm, magnetic chucking range from: 500 – 1100 mm
- Chuck equipped with brushed long-size base jaws, a chucking range of 500 – 1200 mm can be centred without gaps
- Holding force of the chuck: 180 kN at 210 Nm
- Travel per jaw: 9.6 mm
- Actuation of the jaw unlocking on the centring chuck with a control rod
- Spindle with precision bearing and sealing

## SPECIAL FEATURE

- Resistant to emulsions as per IP 65
- Can be controlled with machine spindle using rotary transmitter
- Control with demagnetising cycle and eight holding force levels for pre-selection
- System with potential-free switching to the enable signals, complete integration into the machine controller possible; plug-in version with parking station for connector check and enable

| mm | Pair | Qty. | mm | | kg | A |
|---|---|---|---|---|---|---|
| **Diameter** | **Pole pairs** | **No. of jaws** | **Height** | **Active diameter** | **Weight** | **Control max. pul. Current** |
| 500 | 6 | 3 | 170 | 250 - 464 | 260.0 | 30 |
| 600 | 9 | 3 | 170 | 300 - 564 | 378.0 | 30 |
| 800 | 9 | 3 | 170 | 300 - 764 | 670.0 | 30 |
| 1000 | 12 | 6 | 180 | 450 - 950 | 1100.0 | 60 |
| 1200 | 12 | 6 | 180 | 450 - 1150 | 1600.0 | 60x2 |
| 1400 | 12 | 6 | 180 | 450 - 1350 | 2180.0 | 60x2 |
| 1600 | 12 | 6 | 180 | 500 - 1430 | 3160.0 | 60x2 |
| 1800 | 18 | 6 | 180 | 600 - 1750 | 4000.0 | 60x2 |

Other designs upon request, force actuation possible upon clarification of spindle integration.

**ORDERING EXAMPLE**

| Designation | SAV no. - diameter x pole pairs - no. of jaws - magnet voltage |
|---|---|
| Combined circular chuck | SAV 244.76 - 1800 x 18 - 6 - 360 V |