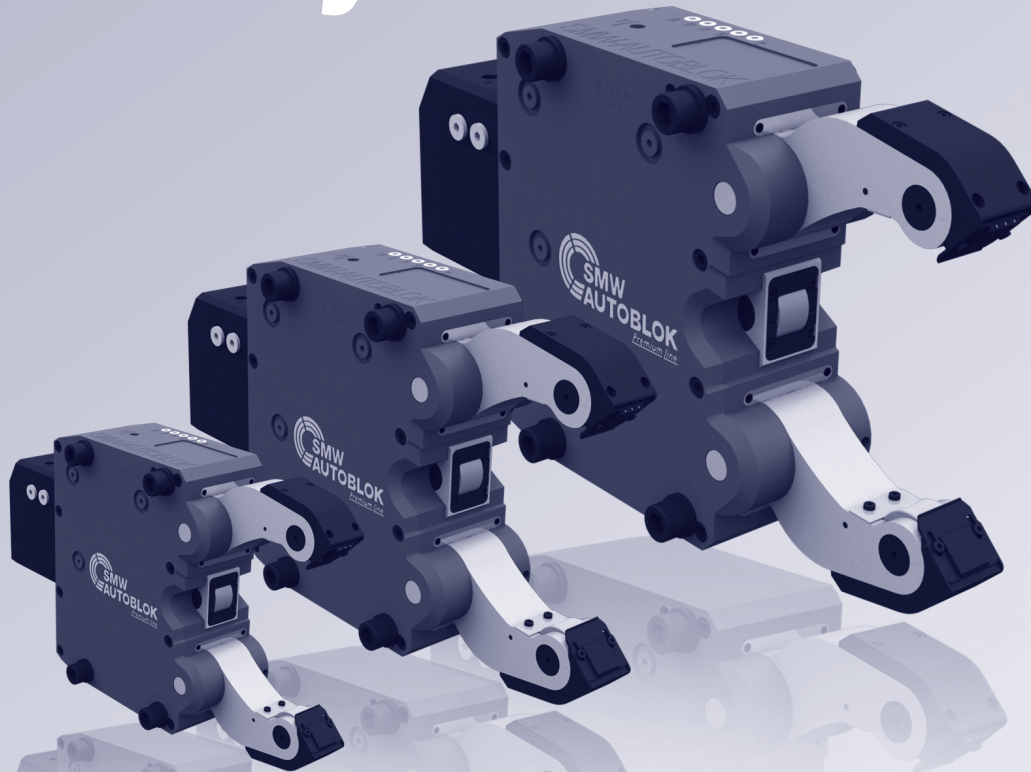


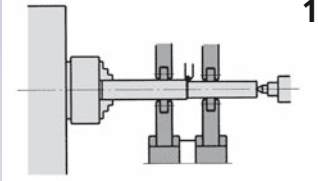
# SMW-AUTOBLOK

## worldwide leader

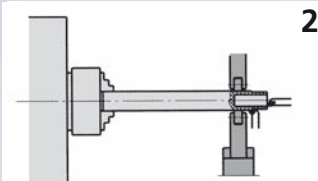
## in Steady Rests



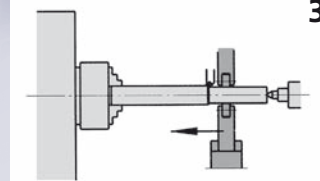
### Fixed or travelling application



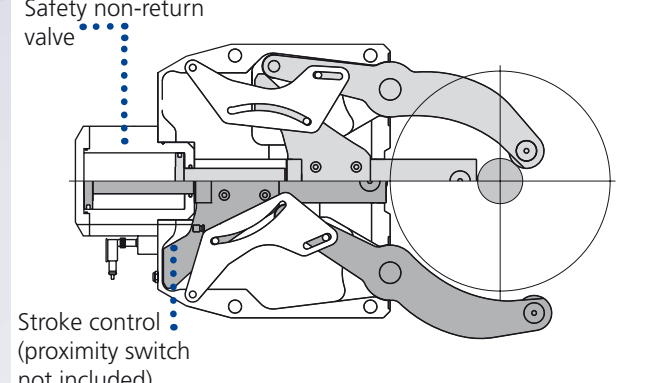
**1**



**2**



**3**



Safety non-return valve

Stroke control (proximity switch not included)

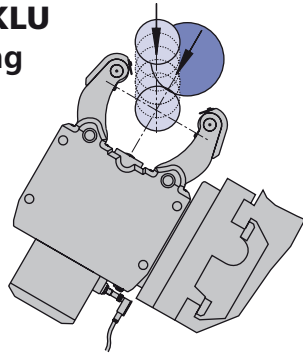
1. Tandem Steady Rest **fixed**
2. Steady Rest **fixed** for end machining
3. Steady Rest **travelling**

## Features included in standard range

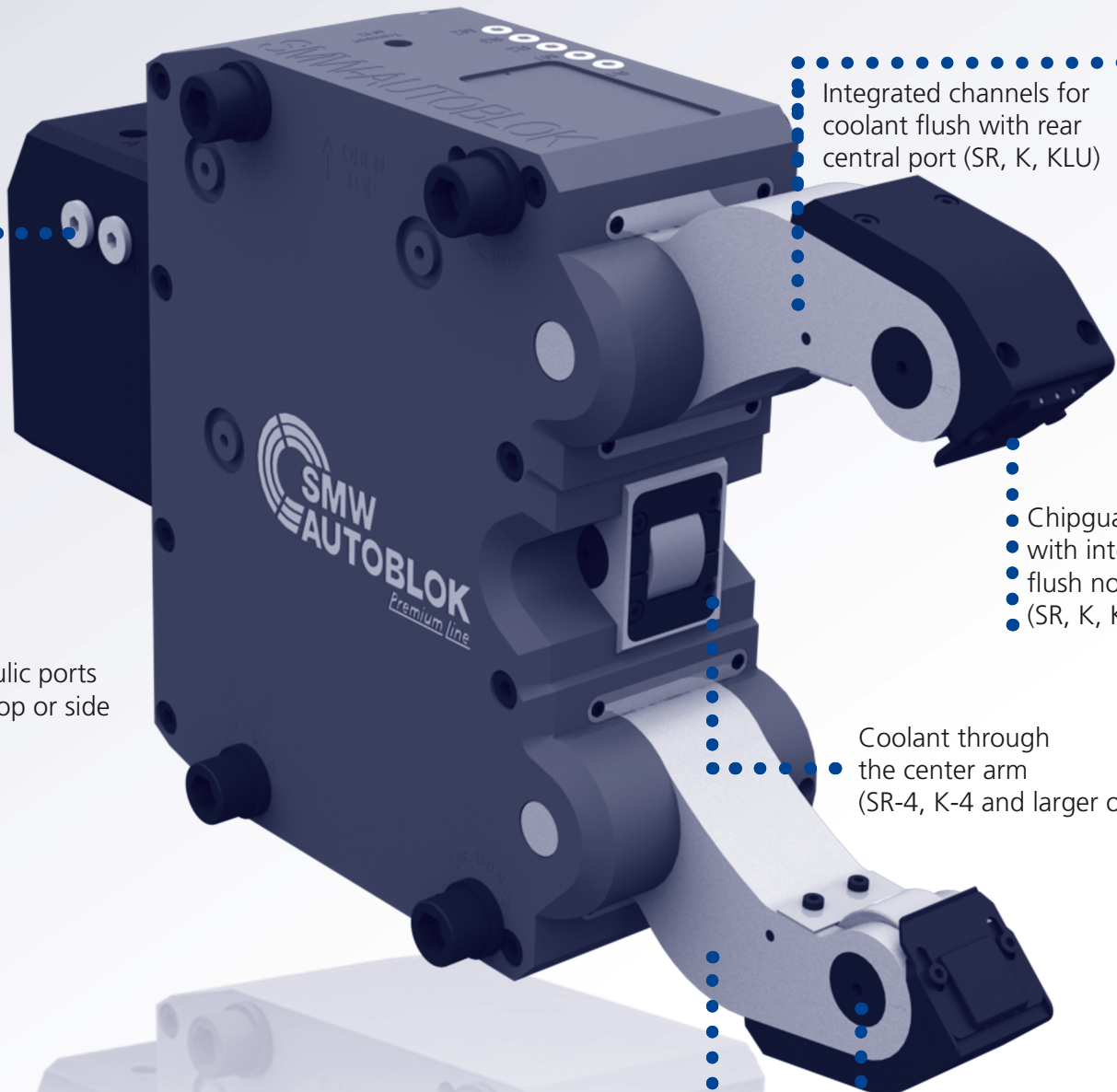
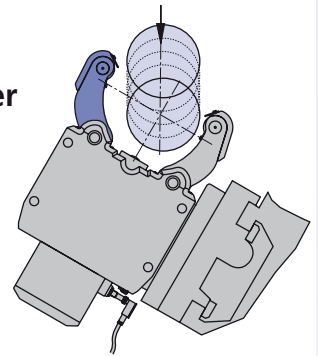
| Steady Rest type                                | Standard Line |               | Premium Line |              |                |                  |
|---|---------------|---------------|--------------|--------------|----------------|------------------|
|   | SLU-X, SLUA-X | SLU-B, SLUA-B | SR           | SRA          | K              | KLU              |
| <b>Steady Rest size</b>                         | <b>1 - 6</b>  | <b>3 - 6</b>  | <b>1 - 6</b> | <b>2 - 6</b> | <b>3 - 6.1</b> | <b>215 - 540</b> |
| Sealed body                                     | ■             | -             | ■            | ■            | ■              | ■                |
| Safety valve                                    | ■             | ■             | ■            | ■            | ■              | ■                |
| Stroke control (open position)                  | ■             | ■             | ■            | ■            | ■              | ■                |
| 1 set swarf guard 3-piece                       | ■             | ■             | -            | -            | -              | -                |
| 1 set swarf guard with integrated coolant flush | -             | -             | ■            | ■            | ■              | ■                |
| 1 set cylindrical rollers                       | ■             | ■             | ■            | ■            | ■              | ■                |
| Port for compressed air                         | ■             | ■             | ■            | ■            | ■              | ■                |
| Port for coolant through arms incl. chipguard   | -             | -             | ■            | ■            | ■              | ■                |

# SLU-X® / SR® / K / KLU

**SLU-X/SR/K/KLU**  
large clamping  
range



**SLUA-X/SRA**  
additional  
pivoting upper  
arm  
for automatic  
vertical loading  
(worldwide  
patented)



Hydraulic ports  
from top or side

Integrated channels for  
coolant flush with rear  
central port (SR, K, KLU)

Chipguard  
with integrated  
flush nozzle  
(SR, K, KLU)

Coolant through  
the center arm  
(SR-4, K-4 and larger only)

Arms and centerpiece  
hardened  
(SLU-X, SR, K, KLU)

Easy change of rollers  
without loose parts

**Patented mechanism  
for opening the arms of the  
Steady Rest without  
springs and free from wear.  
(worldwide patented)**

**SLU-X<sup>®</sup>**  
**SLU-B**

**SLUA<sup>®</sup>-X**  
**SLUA<sup>®</sup>-B**

**SR<sup>®</sup>**  
**SRA**

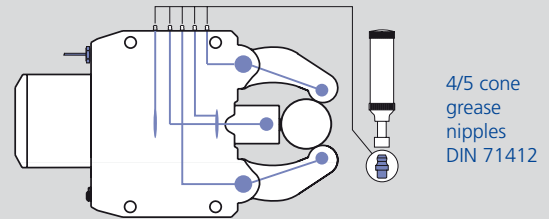
**KLU**  
**K**

**Equipment**

### Option of manual lubrication (M)

- Low cost solution for medium working conditions and low build up of swarf.
- The lubrication points and rollers are supplied with lubrication grease via the grease nipples and the grease gun.
- Lubrication intervals depending on the working conditions normally every 4 to 8 operating hours.
- Grease: KPE 2R-20 DIN 51502

### Manual lubrication (M)



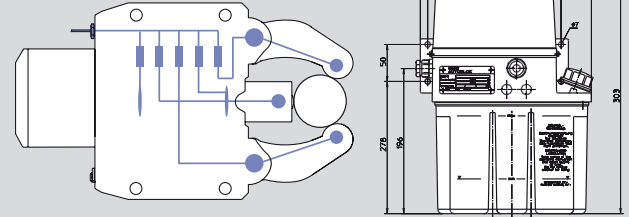
### Option of central oil lubrication (Z)

- For heavy working conditions and high build up of swarf
- For travelling Steady Rest applications.
- The use of our separate complete lubrication unit with timer control is recommended.
- Lubricating intervals 5 - 20 min
- Min./max. operating pressure 10 to 45 bar.
- Oil: HLP 46 DIN 51502.

### Central lubrication (Z)

**Lubrication unit oil**  
Id. No. 088707

Centralized lubrication G 1/8"



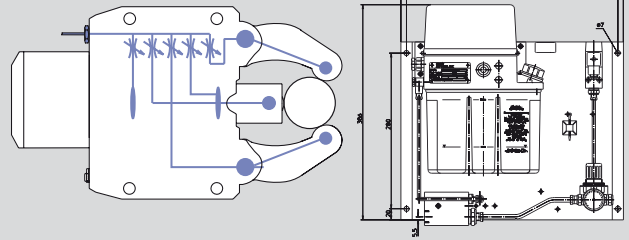
### Option of central lubrication oil + air (OLD)

- For heaviest cutting conditions with high built up of swarf, dust or coolant.
- The SMW-AUTOBLOK oil + air unit for lubrication with built-in timer control is mandatory.
- This unit injects oil for lubrication into the air hose in adjustable intervals ( 2 -12 min.).
- The permanent air flow (min. 3 bar) feeds the oil to the rollers and keeps them clean.
- Oil: HLP 46 DIN 51502.

### Oil + air lubrication (OLD)

**Lubrication unit oil + air**  
Id. No. 088708

Centralized lubrication G 1/8"

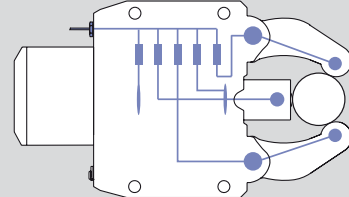


### Option of central grease lubrication (F)

- For machines with central grease lubrication
- For application and intervals please follow the instruction of the machine maker.
- Min./max. operating pressure 30 to 45 bar.
- Grease: NLGI class 0 or 1

### Central grease lubrication (F)

Centralized lubrication G 1/8"



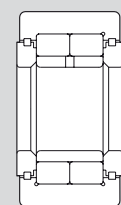
### Option of rollers

- SMW-AUTOBLOK rollers (precision class P05) specially developed for our Steady Rests.
- Special sealing ensures highest precision and service life.
- Standard equipment: 1 set of cylindrical rollers.
- Option: Spherical rollers (for travelling Steady Rests), synthetic material rollers, carbide rollers.

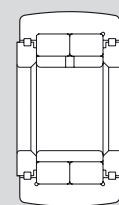
**Original**  
**SMW-AUTOBLOK**  
**roller**



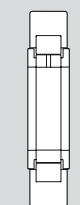
**cylindrical**



**spherical**



**narrow**



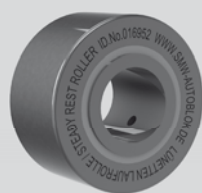
### Rollers (all types)

- Rollers steel (standard): Surface of workpiece not hardened

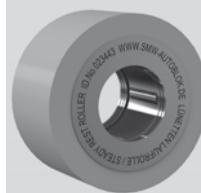
#### Available optional materials:

- Rollers synthetic material: Surface of workpiece polished or chrome plated
- Rollers carbide: Surface of workpiece hardened

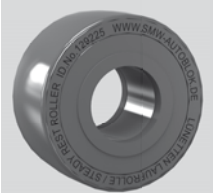
**Rollers**  
**steel**

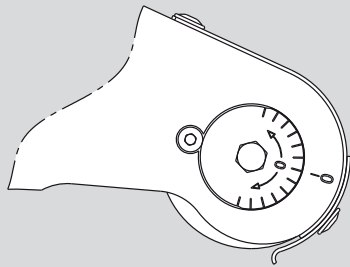


**Rollers synthetic**  
**material**

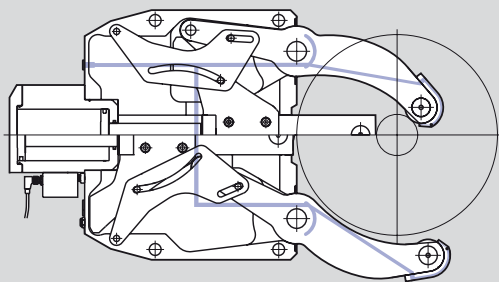


**Rollers**  
**carbide**

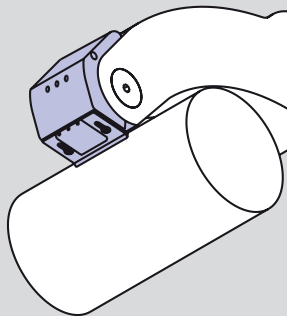


**Eccentric fine adjustment****Option fine adjustment of center line**

- Eccentric roller pins on the two Steady Rest arms allow a quick fine adjustment of the center line.
- This avoids to unlock and adjust the entire Steady Rest on the bracket for small adjusting movements.
- Adjustment of open steady rest only!

**Coolant/air feed****Coolant/air feed (SR/K/KLU only)**

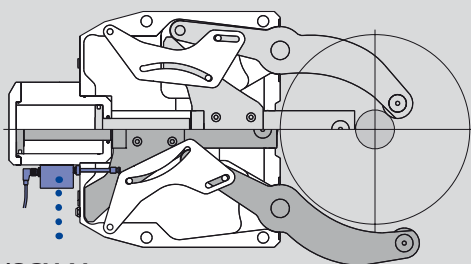
- Built-in channels to feed coolant or air from a central connecting port to the Steady Rest arms.

**Chipguard coolant/air****Patented coolant/air chipguard with integrated flush nozzles (SR/K/KLU only)**

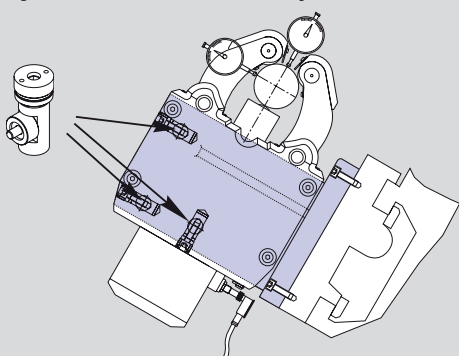
- Keeps roller clamping area free from chips
- The patented double flush nozzles keep front and rear of the wiper area clean.

**Benefit:**

- Constant centering accuracy
- No damage of workpiece and rollers caused by chips/swarf
- Less roller consumption = less costs

**SCU-A/SCU-V  
diameter measuring system****SCU-A/SCU-V****Option linear diameter measuring system  
SCU-A/SCU-V**

- The position of the clamping arms is monitored by the linear measuring system SCU-A/SCU-V.
- Avoids collision with workpieces, turret, loader etc.
- Reduced cycle time due to position controlled opening of the arms to the requested opening only.
- SCU-A: In: 24 V Out: 4 – 20 mA
- SCU-V: In: 24 V Out: 0 – 10 V

**Steady Rest bracket with adjustment device****Steady Rest bracket**

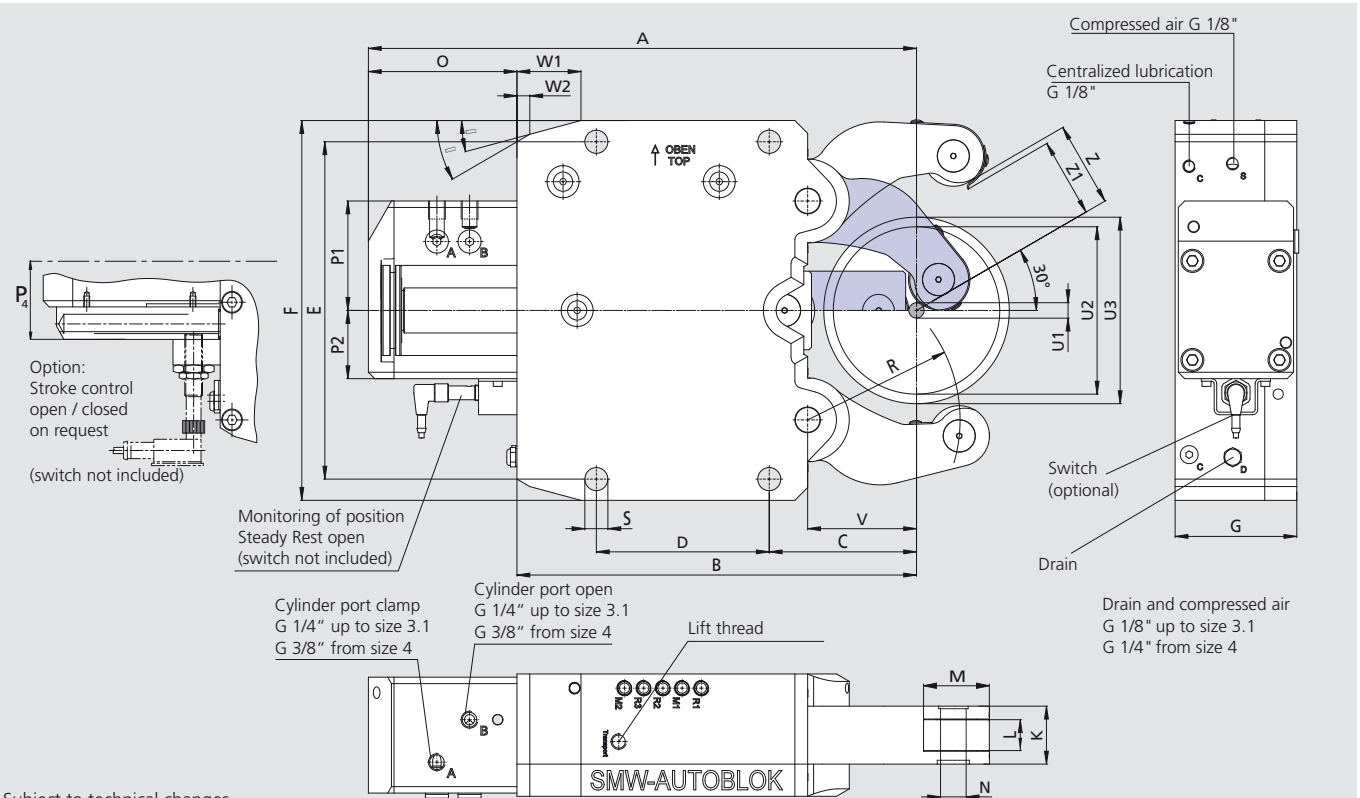
- A perfect bracket is very important for the function/precision of the Steady Rest.
- Fast and easy adjustment can be done with the SMW-AUTOBLOK adjustment device integrated into the bracket.
- SMW-AUTOBLOK supplies the correct bracket for all applications as a turnkey solution.

# SLUA®-X

Self-centering Steady Rests  
Standard Line

## Additional pivoting upper arm for vertical loading

- Sealed body
- Stroke control for end position open (switch not included)



Subject to technical changes  
For more detailed information please ask for customer drawing

| SMW-AUTOBLOK Type<br>Size                 |                 | SLUA-X<br>1 | SLUA-X<br>2 | SLUA-X<br>3 | SLUA-X<br>3.1 | SLUA-X<br>4 | SLUA-X<br>5 |
|---|-----------------|-------------|-------------|-------------|---------------|-------------|-------------|
| Centering range without chip guard        | U1              | 6           | 8           | 12          | 20            | 30          | 45          |
|   | U2              | 55          | 80          | 130         | 150           | 220         | 268         |
|   | Z               | 28          | 41          | 66          | 76            | 111         | 135         |
| Max. axial clearing dia.                  | U3              | 75          | 99          | 158         | 168           | 253         | 295         |
| Centering range with chip guard 3-piece   | U1              | 8           | 11          | 14          | 20            | 30          | 45          |
|   | U2              | 55          | 80          | 130         | 150           | 220         | 268         |
|   | Z1              | 24          | 37.3        | 61.5        | 71.4          | 105.9       | 129.7       |
|   | A               | 214.5       | 277         | 428         | 436           | 603         | 697         |
|   | B               | 149         | 195         | 312         | 320           | 448         | 510         |
|   | C               | 52          | 70          | 115         | 123           | 146         | 178         |
|   | D               | 66          | 85          | 135         | 135           | 240         | 270         |
|   | E               | 140         | 170         | 262         | 262           | 365         | 400         |
|   | F               | 160         | 195         | 295         | 295           | 405         | 440         |
|   | G               | 63          | 75          | 95          | 95            | 110         | 145         |
|   | K               | 28          | 35          | 45          | 45            | 60          | 75          |
| Roller width                              | L               | 15          | 19          | 25          | 25            | 25          | 29          |
| Roller diameter                           | M               | 24          | 35          | 47          | 47            | 52          | 62          |
|   | N               | 8           | 15          | 20          | 20            | 25          | 30          |
|   | O               | 65.5        | 82          | 116         | 116           | 155         | 187         |
|   | P1              | 53          | 63          | 85          | 85            | 91          | 97          |
|   | P2              | 29          | 40          | 53          | 53            | 61          | 63          |
|   | P4              | 40          | 61          | 74          | 74            | 82          | 84          |
|   | R               | 55          | 74          | 119         | 124           | 172         | 209         |
|   | S               | 11          | 14          | 18          | 18            | 23          | 23          |
|   | V               | 37          | 51          | 85          | 93            | 128         | 160         |
|   | W1              | 20          | 30          | 50          | 50            | 58          | 62          |
|   | W2              | 5           | 11.2        | 10          | 10            | 18.3        | 19.1        |
|   | α               | 15°         | 15°         | 15°         | 15°           | 15°         | 18°         |
|   | β               | 45°         | 30°         | 30°         | 30°           | 40°         | 40°         |
| Piston area*                              | cm <sup>2</sup> | 7           | 19.6        | 38.5        | 38.5          | 63.6        | 78.5        |
| Operation pressure min./max.              | bar             | 6/70        | 8/70        | 8/80        | 8/80          | 8/70        | 8/80        |
| Max. clamping force/roller                | daN             | 165         | 450         | 1000        | 1000          | 1500        | 2000        |
| Centering accuracy within the whole range | mm              | 0.02        | 0.02        | 0.04        | 0.04          | 0.05        | 0.06        |
| Repeatability accuracy                    | mm              | 0.005       | 0.005       | 0.007       | 0.007         | 0.007       | 0.01        |
| Max. roller surface speed                 | m/min           | 800         | 800         | 725         | 725           | 715         | 600         |
| Weight approx.                            | kg              | 8           | 17          | 50          | 51            | 103         | 168         |

\* On request cylinder differing from standard available  
Subject to technical changes!

**SLU-X<sup>®</sup>**  
**SLU-B**

**SLUA<sup>®</sup>-X**  
**SLUA<sup>®</sup>-B**

■ Ordering review  
■ Equipment

**SLU-X Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)\***

| Steady Rest size                                  |         | 1      | 2      | 3      | 3.1    | 3.2    | 4      | 5      | 5.1    | 6 |
|---|---------|--------|--------|--------|--------|--------|--------|--------|--------|---|
| <b>SLU-X-M</b><br>manual lubrication              | Id. No. | 127563 | 129001 | 129018 | 129196 | 129234 | 129141 | 129278 | 129291 | - |
| <b>SLU-X-Z</b><br>central lubrication oil         | Id. No. | 127562 | 129000 | 129020 | 129195 | 129235 | 129140 | 129280 | 129292 | - |
| <b>SLU-X-OLD</b><br>central lubrication oil & air | Id. No. | 127564 | 129002 | 129019 | 129197 | 129236 | 129142 | 129279 | 129293 | - |
| <b>SLU-X-F</b><br>central grease lubrication      | Id. No. | 129761 | 129762 | 129763 | 129764 | 129765 | 129766 | 129767 | 129768 | - |

\* Stroke control open / closed on request

**SLU Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)**

| Steady Rest size                                    |         | 1 | 2 | 3      | 3.1    | 3.2    | 4      | 5      | 5.1    | 6      |
|---|---------|---|---|--------|--------|--------|--------|--------|--------|--------|
| <b>SLU-B-M</b><br>manual lubrication                | Id. No. | - | - | 029865 | 029866 | -      | 029867 | 029868 | 029909 | 029869 |
| <b>SLU-B-Z</b><br>central lubrication oil           | Id. No. | - | - | 029855 | 029856 | 123929 | 029857 | 029858 | 029908 | 029859 |
| <b>SLU-B-Z-OLD</b><br>central lubrication oil & air | Id. No. | - | - | 029875 | 029876 | -      | 029877 | 029878 | 029910 | 029879 |

**SLUA-X Steady Rest with stroke control Steady Rest open via proximity switch (without proximity switch)\***

| Steady Rest size                                   |         | 1      | 2      | 3      | 3.1    | 3.2 | 4      | 5      | 5.1 | 6 |
|--|---------|--------|--------|--------|--------|-----|--------|--------|-----|---|
| <b>SLUA-X-M</b><br>manual lubrication              | Id. No. | 127569 | 221744 | 221761 | 221771 | -   | 221801 | 221821 | -   | - |
| <b>SLUA-X-Z</b><br>central lubrication oil         | Id. No. | 127568 | 221745 | 221760 | 221770 | -   | 221800 | 221820 | -   | - |
| <b>SLUA-X-OLD</b><br>central lubrication oil & air | Id. No. | 127570 | 221746 | 221762 | 221772 | -   | 221802 | 221822 | -   | - |
| <b>SLUA-X-F</b><br>central grease lubrication      | Id. No. | 221757 | 221747 | 221763 | 221773 | -   | 221803 | 221823 | -   | - |

\* Stroke control open / closed on request

**SLUA-B Steady Rest with stroke control Steady Rest open / closed via proximity switch (without proximity switch)**

| Steady Rest size                                     |         | 1 | 2 | 3      | 3.1    | 3.2 | 4      | 5      | 5.1 | 6      |
|--|---------|---|---|--------|--------|-----|--------|--------|-----|--------|
| <b>SLUA-B-M</b><br>manual lubrication                | Id. No. | - | - | 029870 | 029871 | -   | 029872 | 029873 | -   | 029874 |
| <b>SLUA-B-Z</b><br>central lubrication oil           | Id. No. | - | - | 029860 | 029861 | -   | 029862 | 029863 | -   | 029864 |
| <b>SLUA-B-Z-OLD</b><br>central lubrication oil & air | Id. No. | - | - | 029880 | 029881 | -   | 029882 | 029883 | -   | 029884 |

- Ordering review
- Accessories and wearing parts

**SLU-X<sup>®</sup>**  
**SLU-B**

**SLUA<sup>®</sup>-X**  
**SLUA<sup>®</sup>-B**

## Accessories and wearing parts

### Type SLU-X, SLU-B, SLUA-X, SLUA-B

◆ denotes wearing parts, recommended stock items

| Steady Rest size  |   | 1          | 2      | 3      | 3.1    | 3.2    | 4      | 5      | 5.1    | 6          |
|---|---|------------|--------|--------|--------|--------|--------|--------|--------|------------|
| Compact lubrication system for oil pressure lubrication Container 2.7 l, 220 V *,**         |   | 088707     | 088707 | 088707 | 088707 | 088707 | 088707 | 088707 | 088707 | 088707     |
| Compact lubrication system for oil & air lubrication Container 2.7 l, 220 V *,**            |   | 088708     | 088708 | 088708 | 088708 | 088708 | 088708 | 088708 | 088708 | 088708     |
| Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest) (SLU-B / SLUA-B)      |   | -          | 026120 | 018437 | 018437 | 018437 | 018444 | 018450 | 018450 | 026595     |
| Eccenter fine adjustment compl. at lever arm (2 pcs. per Steady Rest) (SLU-X / SLUA-X)      |   | -          | 127237 | 127240 | 127240 | 127240 | 128474 | 128584 | 128584 | -          |
| Inductive limit switch  |   | 087926     | 087926 | 087926 | 087926 | 087926 | 087926 | 087926 | 087926 | 087926     |
| Swarf guard 3-pieces (SLU-B / SLUA-B)   | ◆ | -          | 026116 | 026117 | 026117 | 026117 | 026118 | 026119 | 026119 | 026597     |
| Swarf guard 3-pieces (SLU-X / SLUA-X)   | ◆ | 126171     | 026116 | 026117 | 026117 | 026117 | 026118 | 026119 | 026119 | -          |
| Roller stripper (2-pieces) for middle piece (SLU-B / SLUA-B)                                | ◆ | 029795     | 029796 | 029797 | 029797 | 029797 | 029798 | 029799 | 029799 | 029800     |
| Roller stripper (2-pieces) for middle piece (SLU-X / SLUA-X)                                | ◆ | 200155     | 200154 | 198950 | 198950 | 198950 | 196199 | 196200 | 196200 | -          |
| Rollers cylindrical design (SLU-B / SLUA-B)   | ◆ | -          | 016952 | 016951 | 016951 | 016951 | 016953 | 018345 | 018345 | 026594     |
| Rollers cylindrical design (SLU-X / SLUA-X)   | ◆ | 023122     | 016952 | 016951 | 016951 | 016951 | 016953 | 018345 | 018345 | -          |
| Rollers spherical design (SLU-B / SLUA-B)   | ◆ | -          | 017658 | 018433 | 018433 | 018433 | 018443 | 019545 | 019545 | 121302     |
| Rollers spherical design (SLU-X / SLUA-X)   | ◆ | 028738     | 017658 | 018433 | 018433 | 018433 | 018443 | 019545 | 019545 | -          |
| Rollers synthetic material  | ◆ | on request | 029451 | 023443 | 023443 | 023443 | 023672 | 023650 | 023650 | on request |
| Roller stripper (2-pieces) for middle piece with roller synthetic material (SLU-X / SLUA-X) | ◆ | -          | 204211 | 204212 | 204212 | 204212 | 204213 | 204215 | 204215 | -          |
| Rollers carbide   | ◆ | on request | 129223 | 129225 | 129225 | 129225 | 220918 | 222038 | 222038 | on request |
| Adjustment device 1 set = 3 pieces  |   | -          | -      | 200178 | 200178 | 200178 | 200179 | 200179 | 200179 | 200179     |

\* When placing an order please advise voltage

\*\* On request 110 V available