



## SRG

High precision grinding Steady Rests  
Grinding diameter  $\varnothing$  3 - 126 mm

- Fine adjustment of the grinding center
- Retractable arms
- Suitable for follow down grinding
- High rigidity



## Application / customer benefits

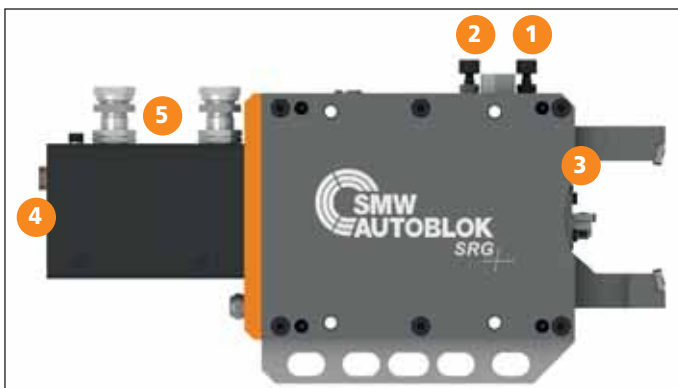
- Support of shaft type workpieces on grinding machines
- Particularly suitable for the machining of crankshafts and camshafts
- Rapid set up of the Steady Rest to the grinding center with the fine adjustment
- Suitable for Follow down grinding

## Standard equipment

- Basic Grinding Steady Rest SRG
- Delivery in transport box

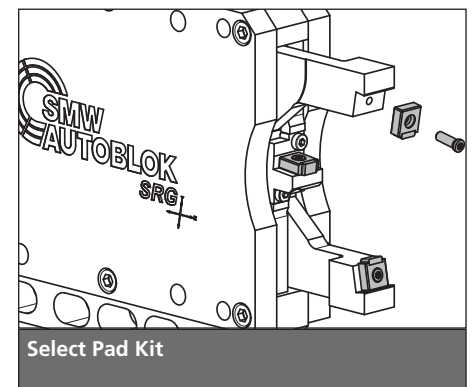
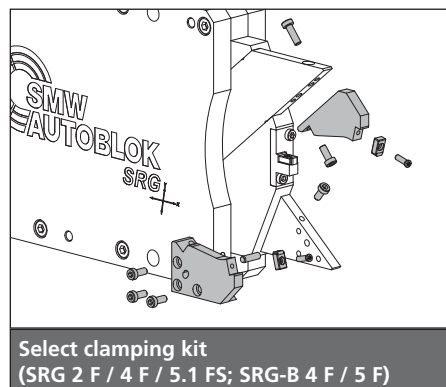
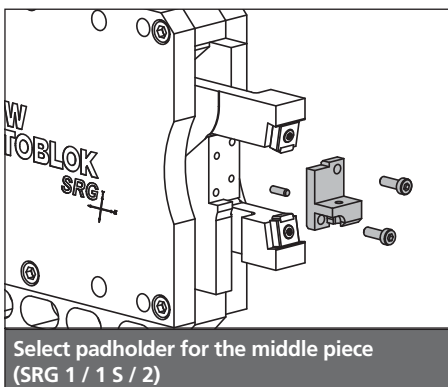
(Padholder for the middle piece, Clamping Kit and Pad Kits are not scope of delivery. See therefor the overview for the configurations below.)

## 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



### 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

### 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

### 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

# SRG/ SRG-B

Grinding Steady Rests

Ordering review

SMW-AUTOBLOK Type Basic Steady Rest		SRG 0.8 223250	SRG 1 221175	SRG 1 S 223060	SRG 2 221871
Clamping range	mm	<b>3-18</b>	<b>20-35</b>	<b>20-35</b>	<b>30-60</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
Pad Kit Standard	Id. No.	205439	203976	204161	203976
Pad Kit Special ***	Id. No.	-	203939	-	203939
Working pressure	bar	20-50	15-30	20-50	15-30
Follow down grinding		Yes	Yes	Yes	Yes

SMW-AUTOBLOK Type Basic Steady Rest		SRG 2 F 222260			SRG 4 F 221930						SRG 5.1 FS 222665				
Clamping range	mm	<b>12-60</b>			<b>22-100</b>						<b>96-126</b>				
Clamping kit		I	II	III	I	II	III	IV	V	VI	I	II	III	IV	V
Clamping range	mm	<b>12-28</b>	<b>28-44</b>	<b>44-60</b>	<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.	204383	204382	204381	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
Clamping kit -5 degree**	Id. No.	206349	206348	206347	-	-	-	-	-	-	-	-	-	-	-
Clamping kit -7 degree**	Id. No.	206346	206345	206344	-	-	-	-	-	-	-	-	-	-	-
Pad Kit Standard	Id. No.	203976			204161						204161				
Pad Kit Special***	Id. No.	203939			-						-				
Working pressure	bar	15-30			7-25						7-25				
Follow down grinding		Yes			Yes						Yes				

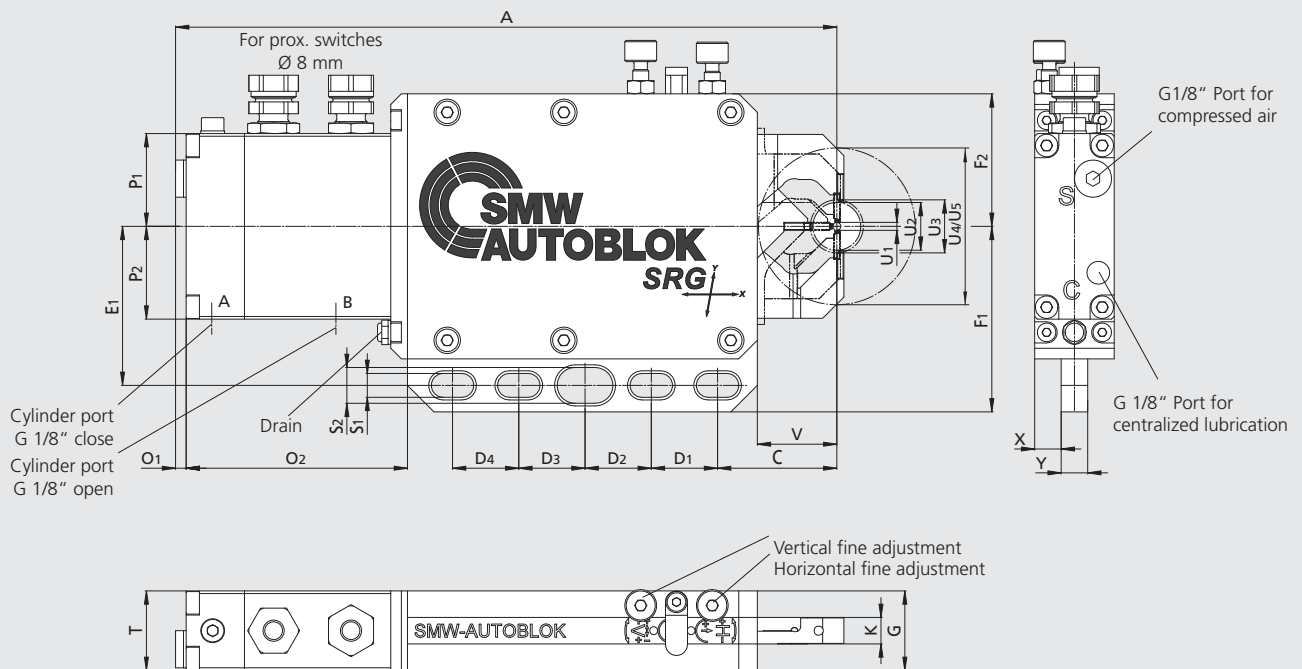
SMW-AUTOBLOK Type Basic Steady Rest		SRG-B 4 F 223140						SRG-B 5 F 222530			
Clamping range	mm	<b>22-100</b>						<b>48-136</b>			
Clamping kit		I	II	III	IV	V	VI	I	II	III	IV
Clamping range	mm	<b>22-35</b>	<b>35-48</b>	<b>48-61</b>	<b>61-74</b>	<b>74-87</b>	<b>87-100</b>	<b>48-70</b>	<b>70-92</b>	<b>92-114</b>	<b>114-136</b>
Clamping kit 0 degree**	Id. No.	205000	205001	205002	205003	205004	205005	-	-	-	-
Clamping kit -2 degree**	Id. No.	205006	205007	205008	205009	205010	205011	205018	205019	205020	205021
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



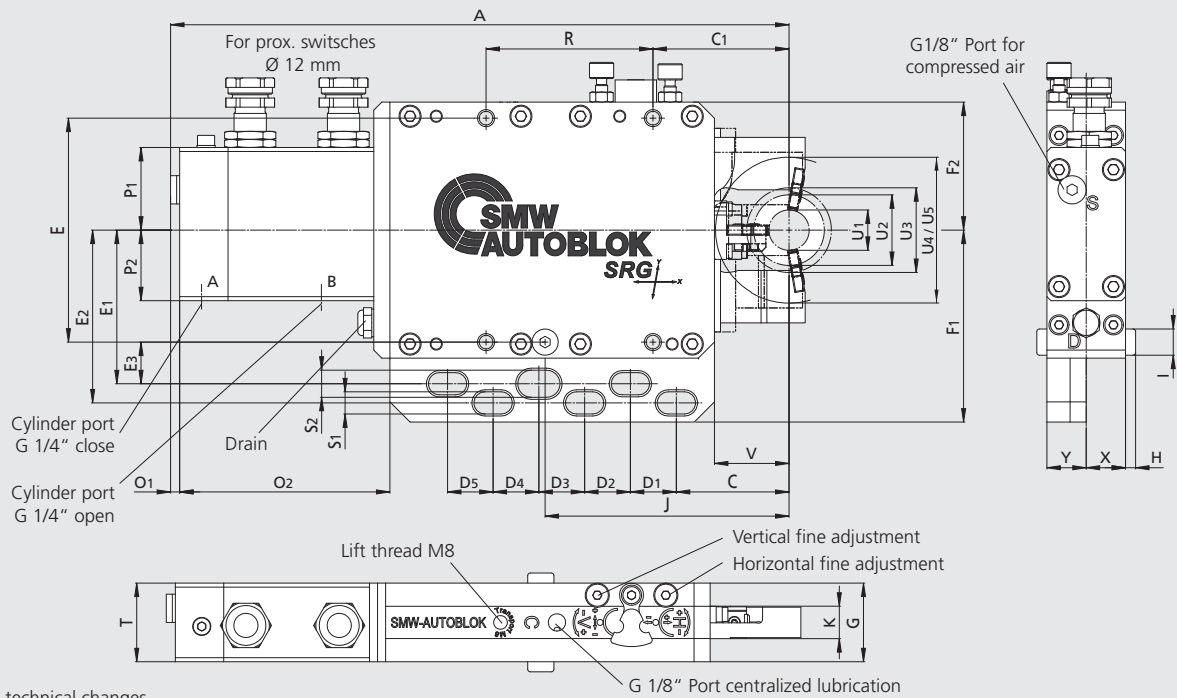
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		SRG 0.8	
Id. No.		223250	
Minimum clamping diameter	U1	mm	3
Maximum clamping diameter	U2	mm	18
Max. loading diameter (vertical, steady open)	U3	mm	58
Max. axial clearance diameter (steady open)	U4	mm	58
Max. swing diameter	U5	mm	58
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
	S1	mm	9 (4x)
	S2	mm	13.46 (1x)
	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

Grinding Steady Rests

Dimensions and technical data



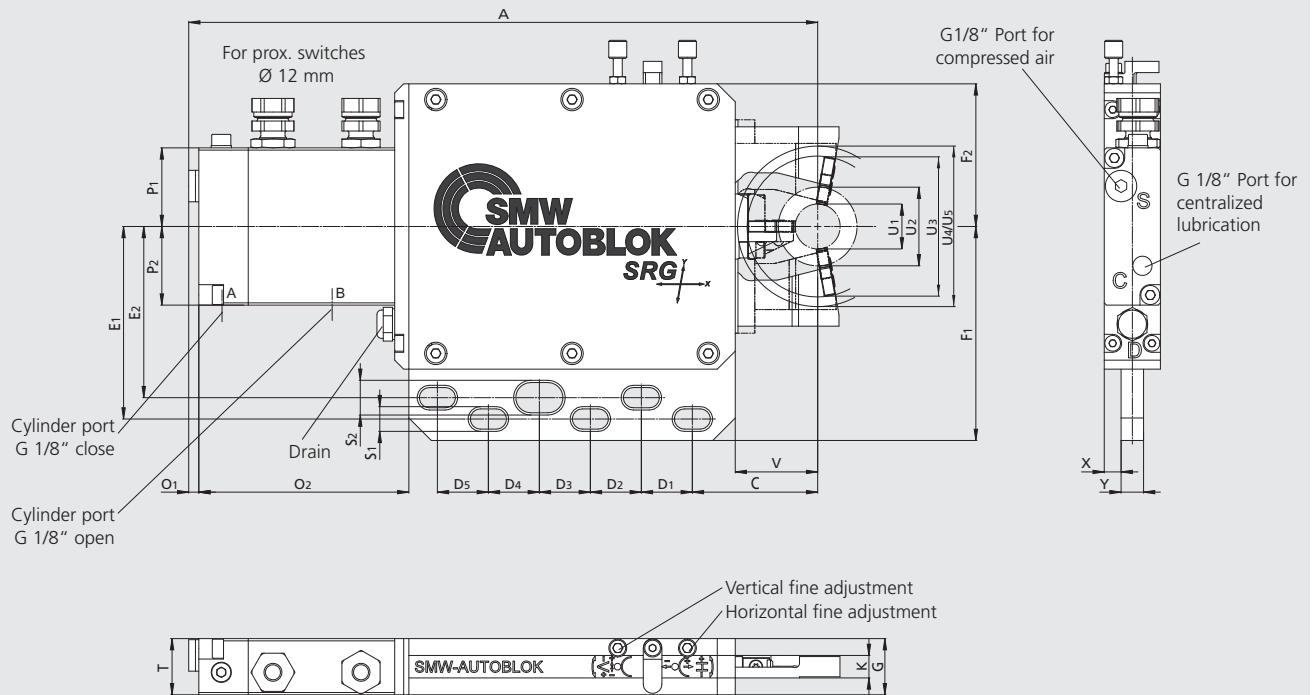
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 1 221175
Minimum clamping diameter	U1	mm	20
Maximum clamping diameter	U2	mm	35
Max. loading diameter (vertical, steady open)	U3	mm	72
Max. axial clearance diameter (steady open)	U4	mm	72
Max. swing diameter	U5	mm	72
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	20.65
	F1	mm	95.2
	F2	mm	63.5
	G	mm	39
	H	mm	5
	I	mm	13
	J	mm	121
	K	mm	16.1
	O1	mm	4.5
	O2	mm	104.3
	P1	mm	41
	P2	mm	35
	R	mm	82.8
	S1	mm	11 (5x)
	S2	mm	13.46 (1x)
	T	mm	39
	V	mm	37
	X	mm	19.5
	Y	mm	19.5
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	8.5

# SRG 1 S

## Dimensions and technical data

## Grinding Steady Rests



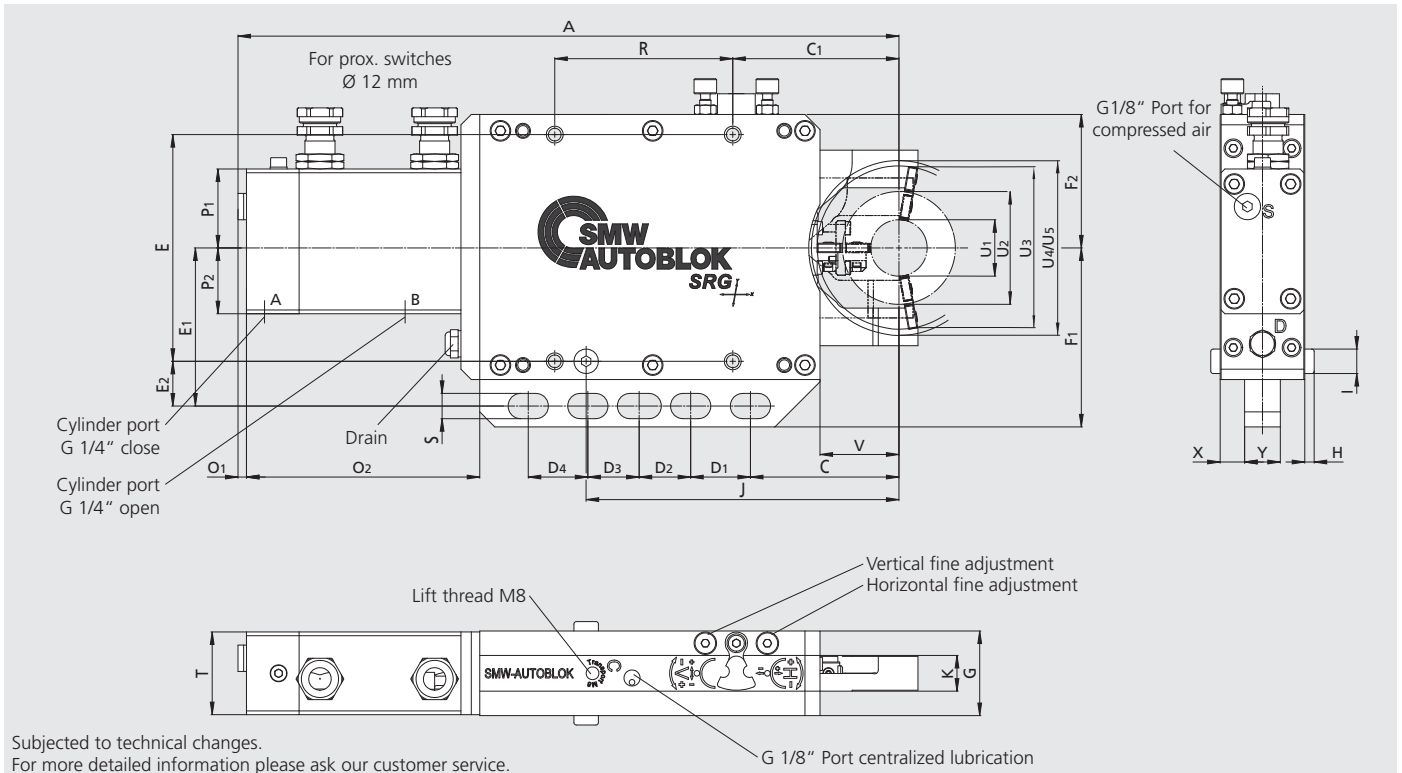
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 1 S 223060
Minimum clamping diameter	U1	mm	20
Maximum clamping diameter	U2	mm	35
Max. loading diameter (vertical, steady open)	U3	mm	62
Max. axial clearance diameter (steady open)	U4	mm	72
Max. swing diameter	U5	mm	72
Horizontal adjustment range		mm	± 0.20
Vertical adjustment range		mm	± 0.10
	A	mm	280
	C	mm	55.8
	D1	mm	22.7
	D2	mm	22.7
	D3	mm	22.7
	D4	mm	22.7
	D5	mm	22.7
	E1	mm	85.7
	E2	mm	76.2
	F1	mm	95.25
	F2	mm	63.5
	G	mm	25
	K	mm	10
	O1	mm	4.5
	O2	mm	93.5
	P1	mm	35
	P2	mm	35
	S1	mm	9 (5x)
	S2	mm	13.46 (1x)
	T	mm	25
	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

Grinding Steady Rests

Dimensions and technical data



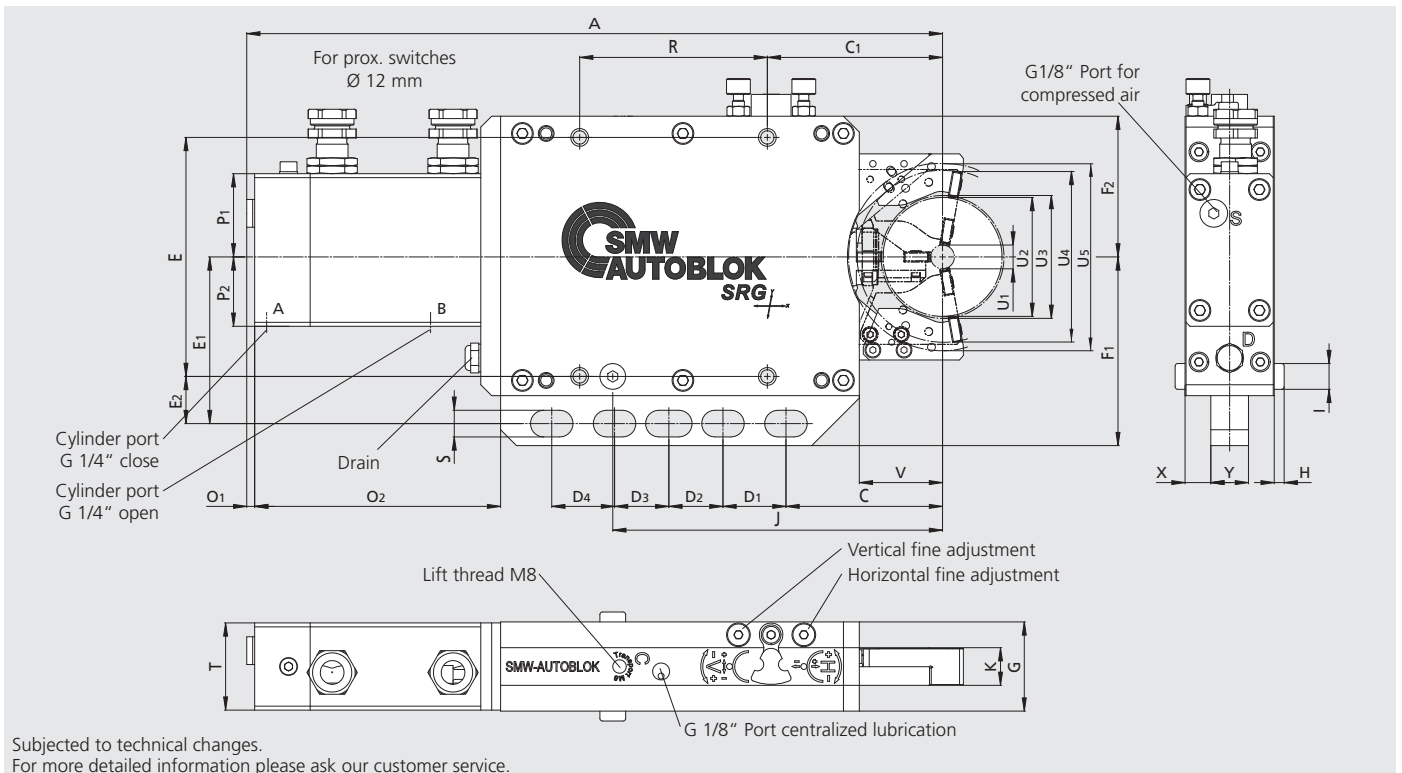
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type Id. No.			SRG 2 221871
Minimum clamping diameter	U1	mm	30
Maximum clamping diameter	U2	mm	60
Max. loading diameter (vertical, steady open)	U3	mm	82
Max. axial clearance diameter (steady open)	U4	mm	95
Max. swing diameter	U5	mm	95
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
	O1	mm	4.5
	O2	mm	124.1
	P1	mm	42
	P2	mm	35
	R	mm	94.7
	S	mm	13.46 (5x)
	T	mm	44
	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

## Dimensions and technical data

## Grinding Steady Rests



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

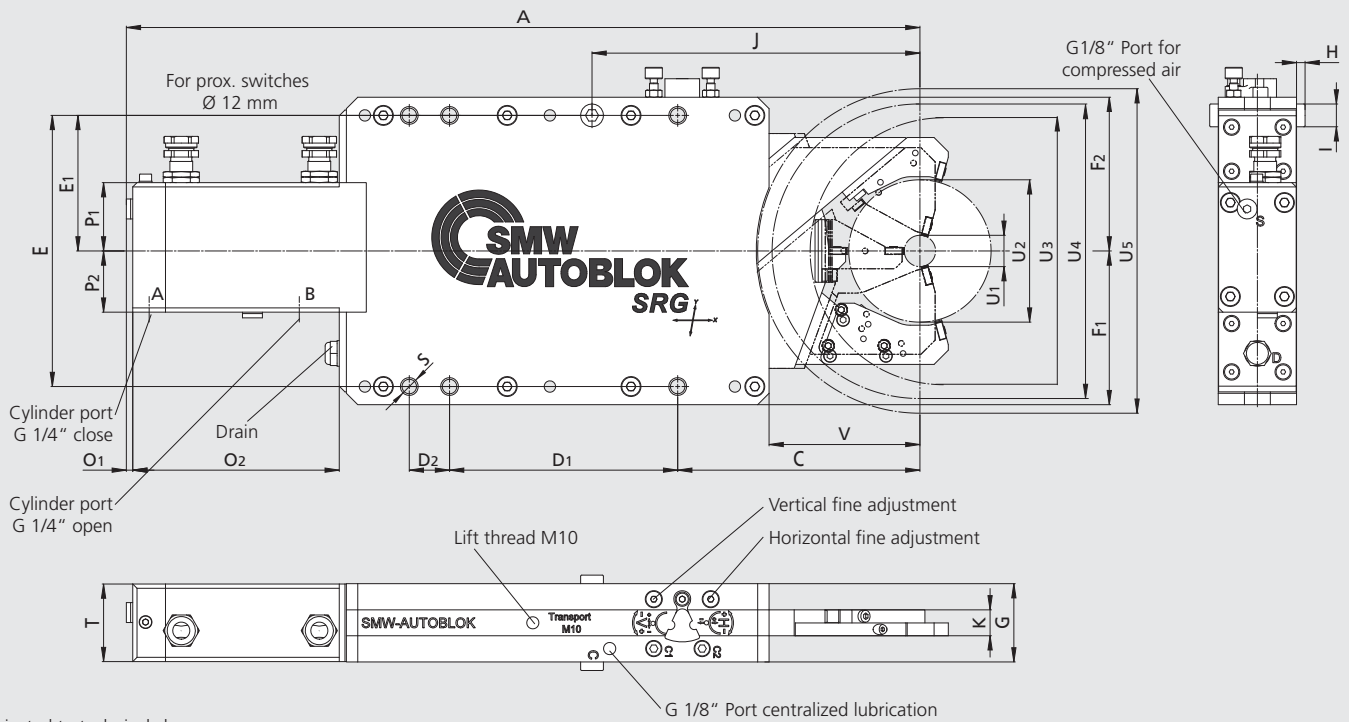
SMW-AUTOBLOK Type			SRG 2 F		
Id. No.			222260		
Clamping kit			I	II	III
Minimum clamping diameter	U1	mm	12	28	44
Maximum clamping diameter	U2	mm	28	44	60
Max. loading diameter (vertical, steady open)	U3	mm	82	82	82
Max. axial clearance diameter (steady open)	U4	mm	94	94	94
Max. swing diameter	U5	mm		94	
Horizontal adjustment range		mm		± 0.20	
Vertical adjustment range		mm		± 0.14	
	A	mm		351.1	
	C	mm		79	
	C1	mm		88.4	
	D1	mm		31.8	
	D2	mm		27.3	
	D3	mm		27.4	
	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	
	O1	mm		4.5	
	O2	mm		124.1	
	P1	mm		42	
	P2	mm		35	
	R	mm		94.7	
	S	mm		13.46 (5x)	
	T	mm		44	
	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	



# SRG 4 F

Grinding Steady Rests

Dimensions and technical data



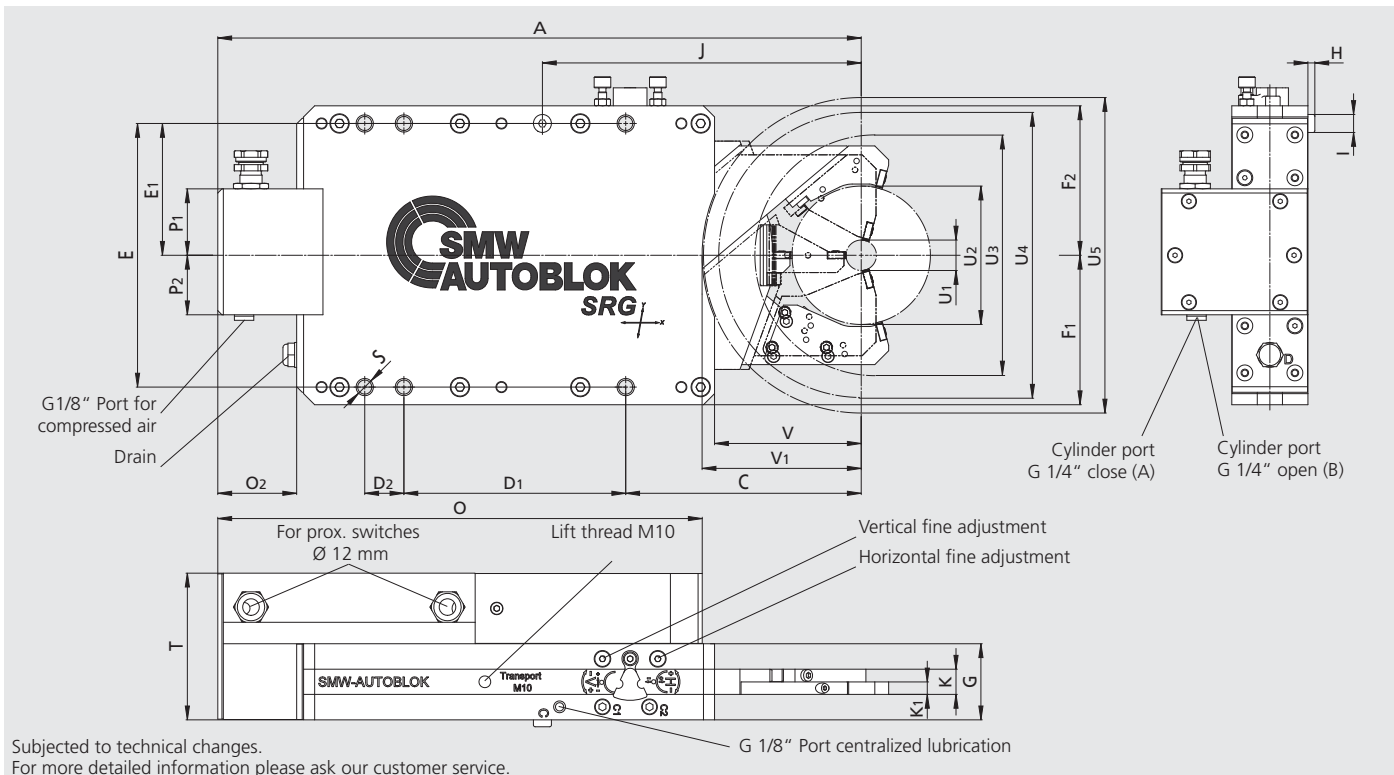
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			SRG 4 F					
Id. No.			221930					
Clamping kit			I	II	III	IV	V	VI
Minimum clamping diameter	U1	mm	22	35	48	61	74	87
Maximum clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady open)	U3	mm	206	204	200	196	194	190
Max. axial clearance diameter (steady open)	U4	mm	218	219	219	220	222	224
Max. swing diameter	U5	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	6					
	I	mm	16					
	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	30					

# SRG-B 4 F

Grinding Steady Rests

Dimensions and technical data

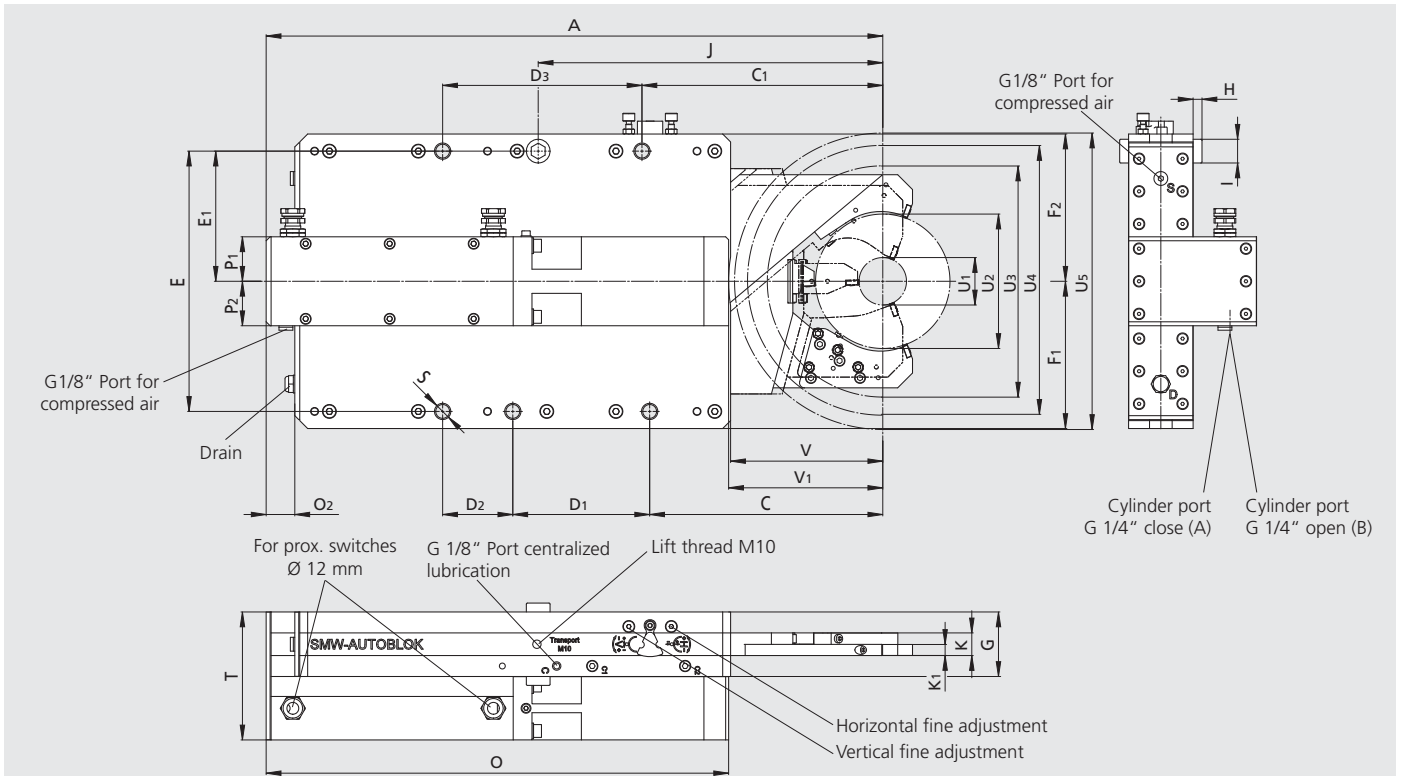


Subjected to technical changes.

For more detailed information please ask our customer service.

G 1/8" Port centralized lubrication

SMW-AUTOBLOK Type			SRG-B 4 F					
Id. No.			223140					
Clamping kit			I	II	III	IV	V	VI
Minimum clamping diameter	U1	mm	22	35	48	61	74	87
Maximum clamping diameter	U2	mm	35	48	61	74	87	100
Max. loading diameter (vertical, steady open)	U3	mm	206	204	200	196	194	190
Max. axial clearance diameter (steady open)	U4	mm	218	218	218	220	222	224
Max. swing diameter	U5	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	350.1					
	O2	mm	57					
	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					



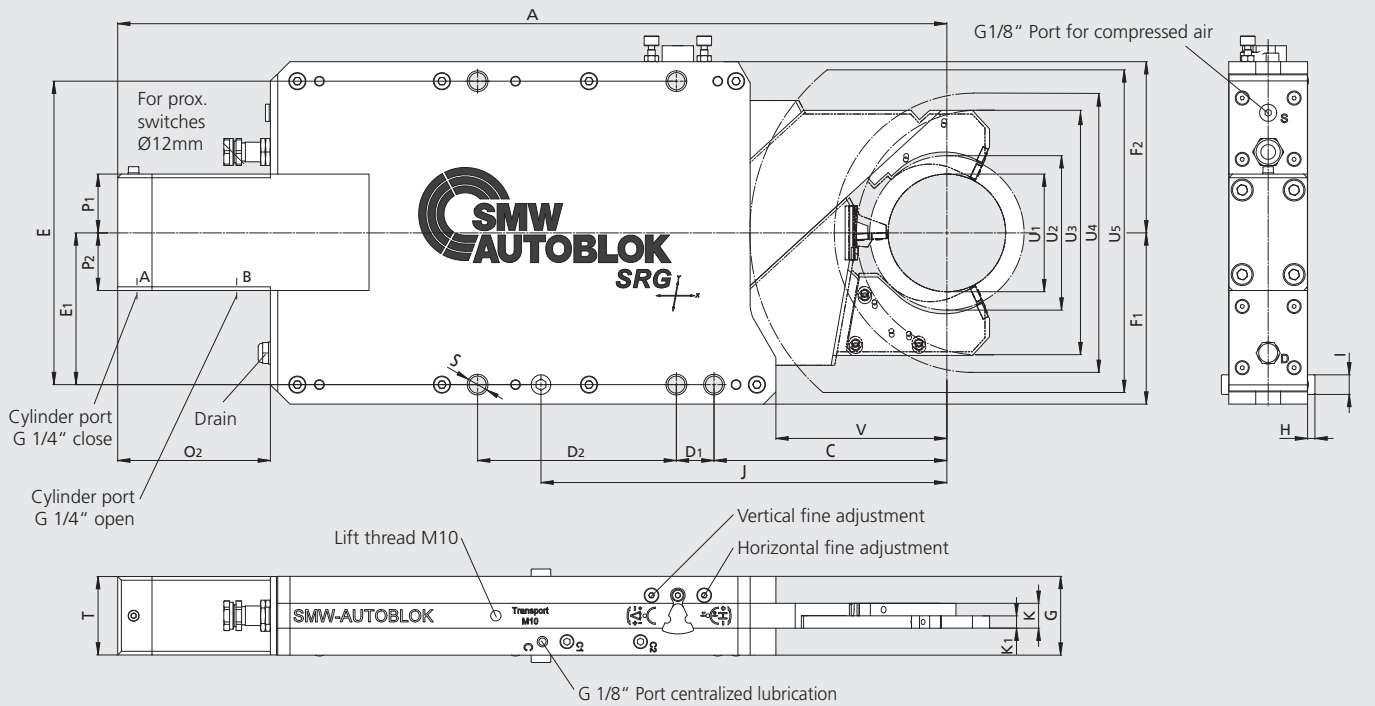
Subjected to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			SRG-B 5 F			
Id. No.			222530			
Clamping kit			I	II	III	IV
Minimum clamping diameter	U1	mm	48	70	92	114
Maximum clamping diameter	U2	mm	70	92	114	136
Max. loading diameter (vertical, steady open)	U3	mm	273	267	263	257
Max. axial clearance diameter (steady open)	U4	mm	298	298	298	299
Max. swing diameter	U5	mm	310			
Horizontal adjustment range		mm	± 0.20			
Vertical adjustment range		mm	± 0.14			
	A	mm	624			
	C	mm	235.9			
	C1	mm	243.7			
	D1	mm	138.5			
	D2	mm	71			
	D3	mm	201.7			
	E	mm	263.4			
	E1	mm	131.7			
	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	11.1			
	O	mm	468			
	O2	mm	29			
	P1	mm	45			
	P2	mm	45			
	S	mm	M16 (5x)			
	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	±0.002			
Mass		kg	76.4			

# SRG 5.1 FS

## Dimensions and technical data

## Grinding Steady Rests



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

SMW-AUTOBLOK Type			SRG 5.1 FS				
Id. No.			222665				
Clamping kit			I	II	III	IV	V
Minimum clamping diameter	U1	mm	96	102	108	114	120
Maximum clamping diameter	U2	mm	102	108	114	120	126
Max. loading diameter (vertical, steady open)	U3	mm	236	234	232	229	228
Max. axial clearance diameter (steady open)	U4	mm	272	272	272	272	272
Max. swing diameter	U5	mm	320				
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				
	E1	mm	123.8				
	F1	mm	139.7				
	F2	mm	139.7				
	G	mm	64.3				
	H	mm	6				
	I	mm	16				
	J	mm	331.2				
	K	mm	20.25				
	K1	mm	10				
	O2	mm	124.6				
	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	±0.002				
Mass		kg	54.8				