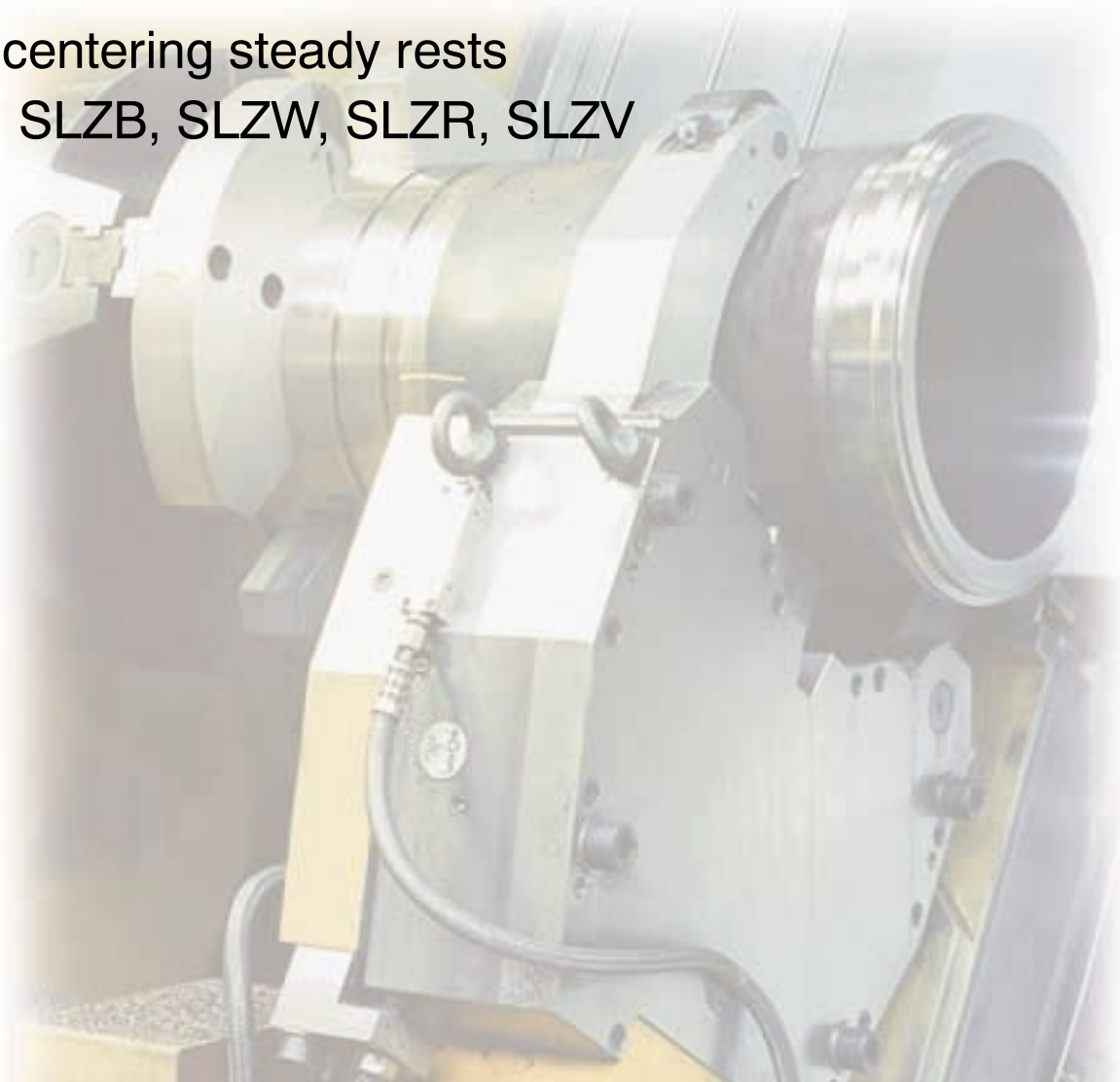


Self-centering steady rests

SLZ, SLZB, SLZW, SLZR, SLZV



A contribution to more efficient turning of slender shafts.

With the SLZ Type 576 steady rest, Röhm engineers have made an important contribution to solving the problems related to supporting slender work (shafts) on lathes.

The requirements that must be met by modern steady rests can be summarized as follows:

- Large clamping range with no need for interchangeable elements
- Compact (short and robust) construction
- High centering accuracy and repeatability throughout the clamping range
- No loss of accuracy when changing clamping pressure
- Connection to central lubrication

The steady rests of the new SLZ range meet all these requirements. The cam-and-lever system has been optimized in comparison to known solutions and permits the three rollers performing the centering and supporting functions to be applied to the workpiece almost symmetrically with a spacing of $3 \times 120^\circ$. This feature together with an innovative internal compensating system which compensates for the displacement of the workpiece center occurring under changing pressures in conventional steady rests accounts for the unusually high centering accuracy throughout the working range.

For central lubrication only one connection is necessary.

The proportioning units for the rollers are integrated in the body of the rest and assure sufficient greasing in the respective greasing interval.

Various mounting options permit these steady rests to be used for turning outside diameters, facing, centering, drilling, internal machining, recessing, parting-off, copy turning etc., both as fixed steady rests and following rests, in any desired angular positioning relative to the cutting tool.

Even with a fixed steady rest, the outside diameter of the shaft can be turned on its entire length since the clearance between the rollers leaves room for the cutting tool and the rollers are reclamped with self-centering action. As a rule, 2 steady rests should be used for support so that one can support the work on the full width of the rollers at any time.

The attached actuating cylinder can be selected for hydraulic or pneumatic actuation. The only difference is in the size of the piston areas.

In the standard version, the cylinder is attached as an axial extension of the steady rest housing. With type SLZB the cylinder is bolted to the side of the steady rests body.

Depending on requirements and proposed use, the steady rest is available with a stroke monitor or safety device only.

The supporting rollers are carried in radial and axial antifriction bearings. Both cylindrical and convex rollers are available as standard equipment. Convex rollers must be used for tapered work and follower rests. Here again, special designs are available on request to complete the range.

The self-centering rest type SLZV are designed in a way to meet the new automatization demands in the field of CNC grinders.

Clamping jaws which can be withdrawn make automatic charging easier without any risk of crashing of workpiece and rest.

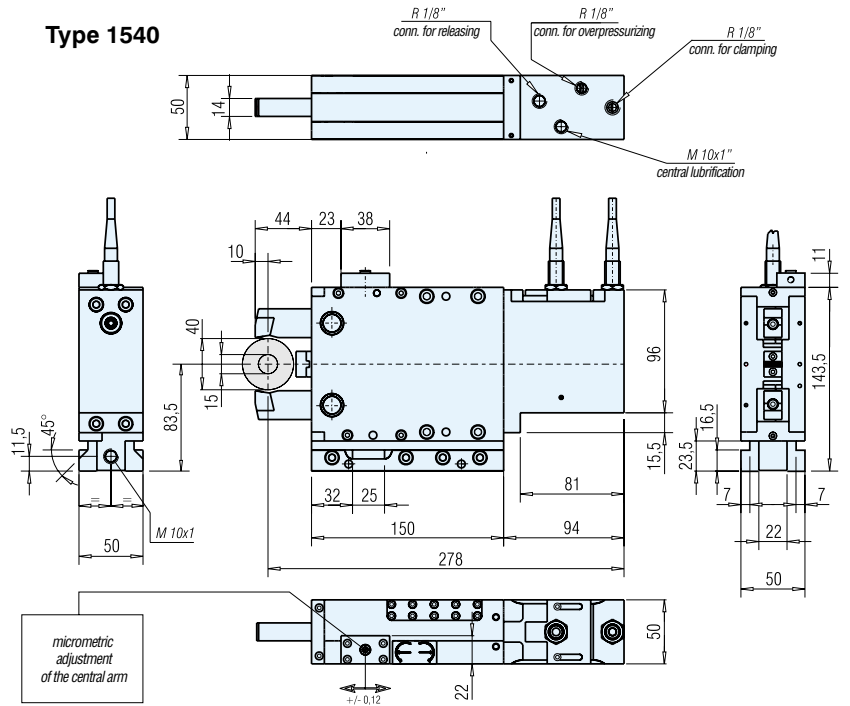
Excellent repeating accuracy, high rigidity, easy assembly, small dimensions, sealing air against the penetration of dirt are some of the properties that distinguish this type of self-centering rests.

- Structurally strong and extremely rigid
- High centering accuracy
- Fine adjustment over X-axis
- Compact and narrow design
- Air pressurization to prevent contamination
- Wear pads in carbide (CBN) or in "PKD" (Multicrystal Diamond) on request.
- Hydraulic or pneumatic actuation
- Opening and closing detection system
- Standard models on customer's request

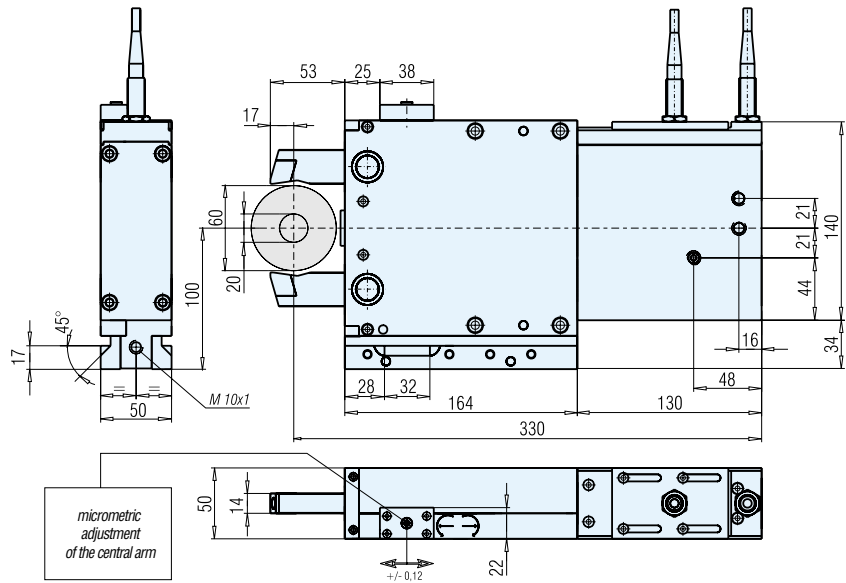


also available:
SLZV 1540 without fine adjustment over X-axis
Id.-No. 685283

Type 1540

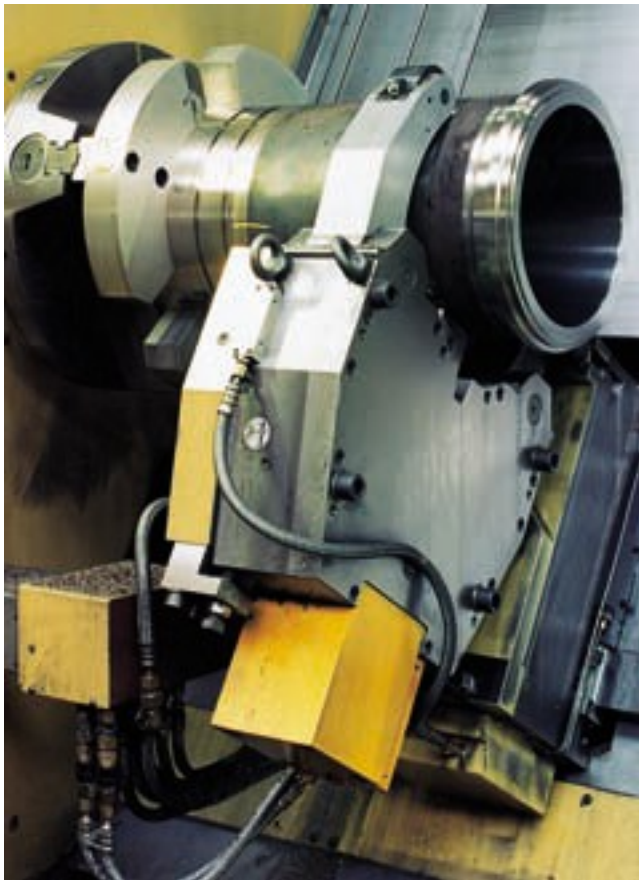


Type 2060

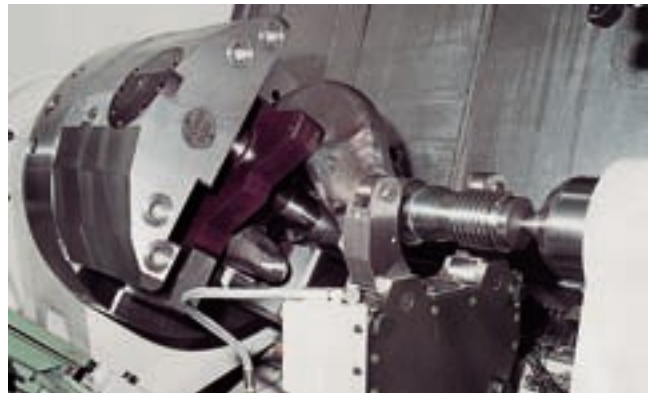


Technical features:

| Type | | SLZV 1540 | SLZV 2060 |
|--|---------|-------------------------|-------------------------|
| Id.-No. with fine adjustment over X-axis | 685416 | 685433 | |
| Clamping diameter | mm | 15 - 40 | 20 - 60 |
| Cylinder Type | | C32 = 8 cm ² | C32 = 8 cm ² |
| Piston stroke | mm | 59 | 76 |
| Max. working pressure | bar | 40 | 22 |
| Operating pressure min. | bar | 5 - 25 | 3 - 22 |
| Clamping power per arm | N / bar | 350 N / 15 bar | 350 N / 15 bar |
| Centering accuracy over whole range | mm | 0,01 | 0,01 |
| Repeatability at same clamping diameter and pressure | mm | 0,002 | 0,002 |



Turning: sleeves



Turning: load hooks



Turning: adapter cages



Reaming: crank shafts