

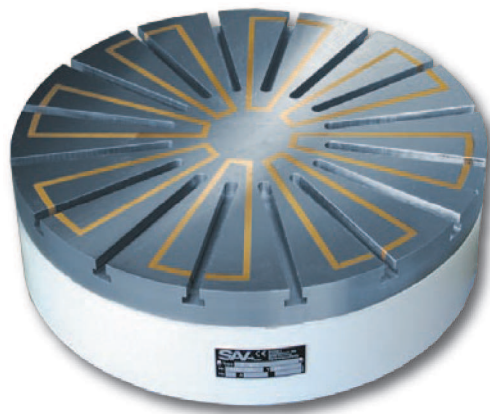
## Electro-Permanent Magnetic Circular Chuck

SAV 244.70

### With radial pole arrangement

These circular electro magnets are not able for their very strong, evenly distributed holding force.

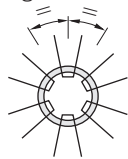
The magnetic force is produced by permanent magnets which are magnetized and demagnetized by short electric current pulses.



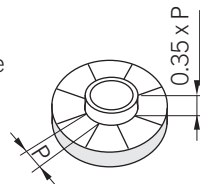
### Use:

Mainly for precision grinding of small to large workpieces on rotary tables and circular grinders.

- for circular grinding and turning
- equal pole pitch within circle range; therefore very suitable for circular workpieces



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



- also for thin rings



### Nominal holding force:

120 N/cm<sup>2</sup>,  
adjustable by control unit.

### Nominal operating voltage:

210 V DC up to 250 mm diameter  
360 V DC above 250 mm diameter

### Features:

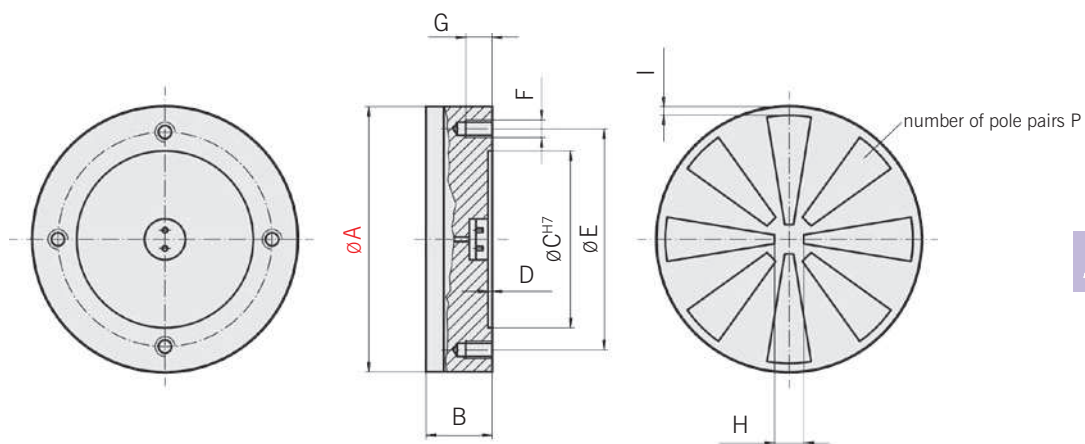
- solid designed pole plate
- switching off through demagnetizing cycle
- electro-permanent magnetic system, guaranteeing safe operation during power failure
- high precision due to fine grid pole-plate-to-body connection
- pole separation with brass in-lays for optimal wear behaviour
- pole plate exchangeable
- 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 to 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

**Electro-Permanent Magnetic Circular Chuck**
**SAV 244.70**

With radial pole arrangement



| A    | B   | C   | Dimensions in mm |                         |          |    |     |     | P  | Weight in kg | Chuck voltage in Vdc | Control unit max. current in A | Suitable control unit |        |
|------|-----|-----|------------------|-------------------------|----------|----|-----|-----|----|--------------|----------------------|--------------------------------|-----------------------|--------|
|      |     |     | D                | E                       | F        | G  | H   | I   |    |              |                      |                                |                       |        |
| 100  | 100 | 60  | 3                | 80                      | M8 (3x)  | 12 | 35  | 10  | 3  | 4            | 210                  | 30                             | 876.10 / 876.03       |        |
| 150  | 100 | 90  | 3                | 120                     | M10 (3x) | 14 | 35  | 10  | 3  | 9            | 210                  | 30                             | 876.10 / 876.03       |        |
| 200  | 100 | 110 | 3                | 140                     | M10 (4x) | 14 | 45  | 10  | 4  | 18           | 210                  | 30                             | 876.10 / 876.03       |        |
| 250  | 100 | 140 | 3                | 170                     | M12 (4x) | 16 | 45  | 10  | 4  | 29           | 210                  | 30                             | 876.10                |        |
| 300  | 100 | 160 | 3                | 190                     | M12 (4x) | 16 | 60  | 10  | 6  | 42           | 210 / 360            | 30                             | 876.10                |        |
| 400  | 100 | 210 | 4                | 250                     | M12 (6x) | 16 | 70  | 15  | 6  | 76           | 210 / 360            | 30                             | 876.10                |        |
| 500  | 110 | 280 | 4                | 320                     | M12 (6x) | 16 | 100 | 15  | 8  | 120          | 360                  | 30                             | 876.10                |        |
| 600  | 110 | 350 | 4                | 390                     | M16 (6x) | 18 | 100 | 15  | 8  | 195          | 360                  | 30                             | 876.10                |        |
| 700  | 110 | 400 | 4                | 450                     | M16 (6x) | 18 | 120 | 15  | 8  | 265          | 360                  | 30                             | 876.10                |        |
| 800  | 110 | 450 | 4                | 500                     | M16 (6x) | 18 | 150 | 18  | 12 | 365          | 360                  | 30                             | 876.10                |        |
| 1000 | 125 | 550 | 4                | 620                     | M16 (8x) | 18 | 200 | 18  | 12 | 550          | 360                  | 60                             | 876.10                |        |
| 1200 | 125 |     |                  | Rear detail as required |          |    |     | 300 | 25 | 18           | 990                  | 360                            | 60 x 2                | 876.10 |
| 1400 | 150 |     |                  | Rear detail as required |          |    |     | 300 | 25 | 18           | 1350                 | 360                            | 60 x 2                | 876.10 |
| 1500 | 150 |     |                  | Rear detail as required |          |    |     | 300 | 25 | 18           | 1550                 | 360                            | 60 x 2                | 876.10 |
| 1600 | 150 |     |                  | Rear detail as required |          |    |     | 300 | 25 | 18           | 1760                 | 360                            | 60 x 2                | 876.10 |

Bigger sizes up to A = 5400 available on request. Please refer to SAV 876.03 to SAV 876.10 (see chapter 04), for details regarding suitable control units, based on the power rating.

For execution with T-slots, the height increases with 10 mm.

Ordering example: **Electro-Permanent Magnetic Circular Chuck SAV 244.70 - 1600 - T - 360 V**  
 Ordering key: Name SAV - No. - A - Execution - Operating voltage