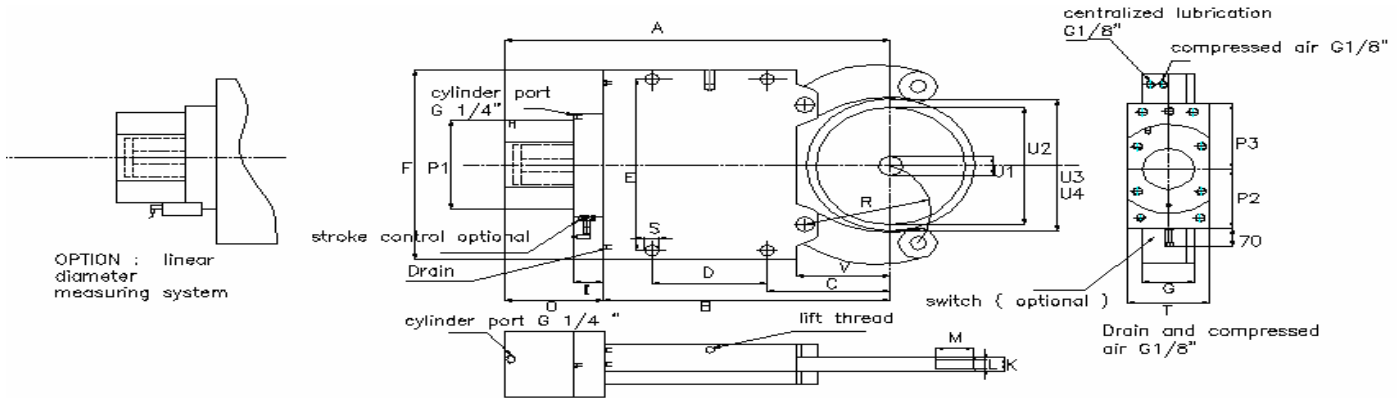


## AAU/AA SELF CENTERING STEADY REST/HYDRAULIC STEADY REST STANDARD SERIES FOR TURNING APPLICATIONS



**SUBJECT TO TECHNICAL CHANGES**

Hydraulic steady		AA - 1	AA - 2	AA - 3	AA - 3.1	AA - 3.2	AA - 4	AA - 5	AA - 5.1	AA - 6
Hydraulic self centering steady		AAU - 1	AAU - 2	AAU - 3	AAU - 3.1	AAU - 3.2	AAU - 4	AAU - 5	AAU - 5.1	AAU - 6
Centering range without chip guard	U 1	4	8	12	20	50	30	45	85	125
	U 2	64	101	152	165	200	245	310	350	460
Centering range with chip guard 3-piece	U 1	11	16	16	20	50	30	45	85	125
	U 2	64	101	152	165	200	245	310	350	460
<b>STANDARD FEATURES</b>										
1) centralized lubrication	A	207	279.5	431	440	455	608	697.5	720	944.5
2) connection for compressed air	B	137	195	312	320	335	448	510	530	709
	C	51	70	115	123	138	146	178	198	215
	D	64	85	135	135	135	240	270	270	330
	E	118	170	262	262	262	365	400	400	610/640
	F	132	190	290	290	290	400	440	440	680
<b>OPTIONAL FEATURES</b>										
1) Safety valve	G	55	70	85	85	85	110	145	145	145
2) Stroke control	I	33	33	37	37	37	37	37	37	37
3) Chip guard 3 pieces	J	24	42	52	52	52	67	83	83	83
4) Linear measuring system	K	20	35	45	45	45	60	75	75	75
5) Mounting bracket with base	L	12	19	25	25	25	25	29	29	29
6) Hydraulic control kit	M	19	35	47	47	47	52	62	62	80
7) Lubrication kit	N	6	21	25	25	25	32	36	36	42
8) Programmable roller force control	O	70	84.5	120	120	120	160	187.5	187.5	235.5
9) max opening feed back switch	P1	84	102	137	137	137	165	165	165	190
	P2	66	72	90	90	90	102	102	102	115
	P3	66	75	100	100	100	110	110	110	130
	R	50.5	74	119	124	139	172	209	229	290
	S	11	14	18	18	18	23	23	23	27
	T	70	70	100	100	100	144	144	144	158
	V	37	52	85	93	103	128	160	180	175
Piston area	cm sq	7	19.6	50	50	50	78	78	78	132
Operation pressure min./max.	bar	6/50	8/70	8/60	8/60	8/60	8/60	8/80	8/70	8/70
Max. clamping force/roller	daN	100	450	1000	1000	1000	1500	2000	2000	3000
centering accuracy within the whole range applicable for self centering steady	mm	0.02	0.02	0.04	0.04	0.04	0.05	0.06	0.06	0.06
Repeatability accuracy	mm	0.005	0.005	0.007	0.007	0.007	0.007	0.01	0.01	0.01
max. roller surface speed	m/min	800	800	725	725	725	715	700	700	700
Mass approx	kg	7	15	40	42	45	95	160	160	420

**How ever the steady rest can be designed as per customer's requirement**