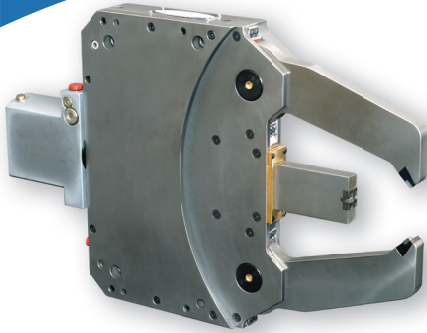


GRINDING STEADY RESTS

THE
BEST.

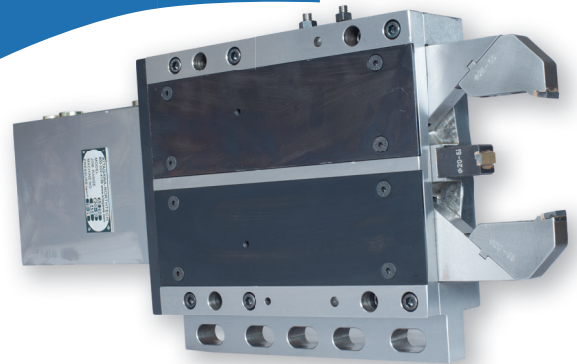
Available in a Broad Range
of Gripping Diameters for
Crankshaft Grinding & More

KRGU



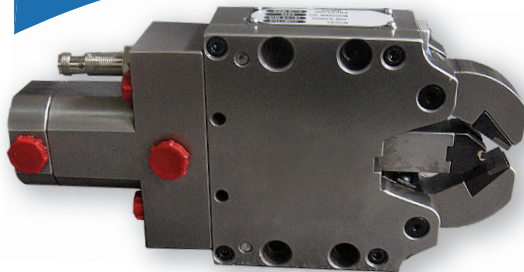
*Designed to Accomodate the
Maximum Eccentric Throw and
Journal Diameter of Crank Shafts*

AS



*Features Narrow Retractable
Arms for Increased Grind
Envelope Accessibility*

GHS



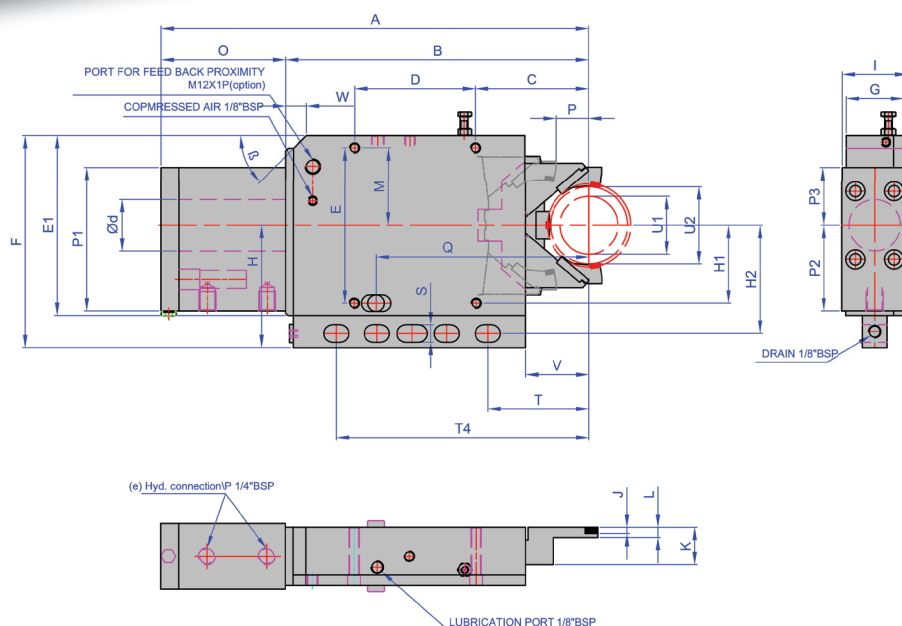
*Ideal for Automated Grinding Applications
such as Cylindrical Grinding, Camshaft
Grinding and Camlobe Grinding*

kitagawa[®]
NORTHTECH
The Best Workholding.

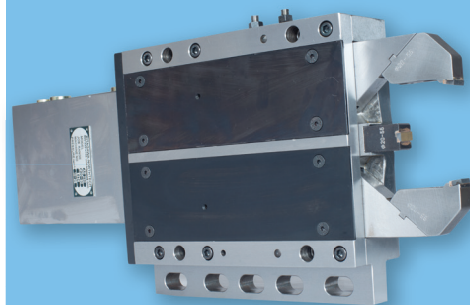
TECHNICAL SPECIFICATIONS

AS Series Grinding Steadies

- Steady rest with retractable arms for easy overhead gantry/robot loading
- Suitable for all crankshaft, camshaft and cylindrical grinding applications
- High accuracy, with three-point finely adjustable centering capability
- Modular regrindable Carbide or relappable PCD work rest pads
- Suitable for pass through grinding
- Provisions to accommodate attenuating In-Process-Gaging (IPG)

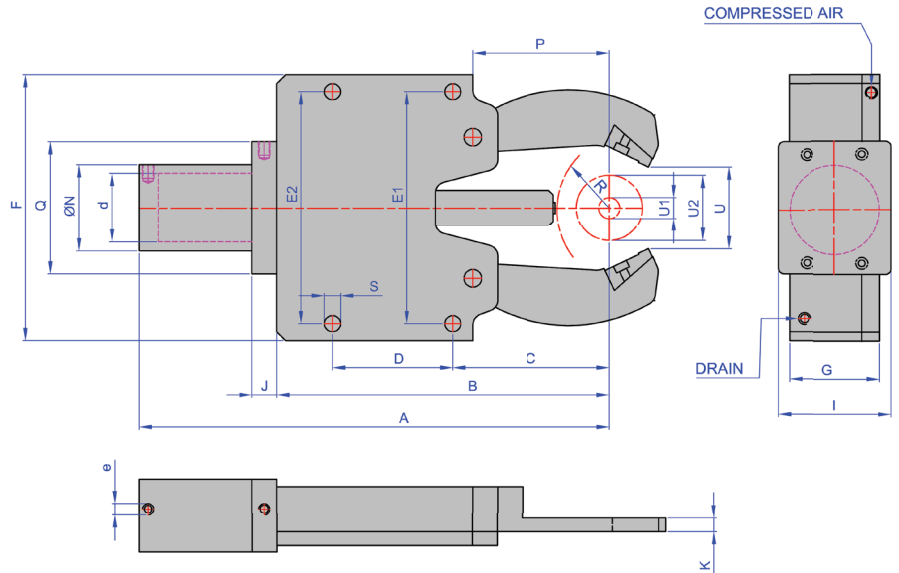


Steady Rest Type		AS125	AS235	AS260	AS460	AS6011	AS5514
A		338.5	333.5	355	333.5	674.5	650
B		236.5	236.5	236.5	236.5	536.5	565
C		88	88	88	88	175	295
D		95	95	95	95	260	135
E		121	121	121	121	254	254
E1		140	140	140	140		
F		165	165	165	165	285	285
G		45	45	45	45	69	65
H		95	95	95	95	142.5	142.5
H1		60.5	60.5	60.5	60.5	—	—
H2		84	84	84	84	—	—
I		51	51	51	51	62	65
J		5	5	5	5	5	5
L		10	8	8	8	12	10
K		19	29	29	29	26	23
M		60.5	60.5	60.5	60.5	—	—
O		124.5	97	97	97	138	85
P		33.5	28.5	25.3	25.3	—	—
P1		111.5	111.5	111.5	111.5	—	—
S		13.5	13.5	13.5	13.5	M16	M18
T		79	79	79	79	—	—
T4		197	197	197	197	—	—
V		49.5	49.5	49.5	49.5	140	185
W		16	16	16	16	68	96.5
X		19	19	19	19	270	255
Centering Ranges		U1	20	20	45	60	55
		U2	35	60	60	115	142
Cylinder bore.	d	40	40	40	40	50	40
Hyd. Connection. (BSP)	e	1/4"	1/4"	1/4"	1/4"	1/8"	1/4"
Standard operating pressure	bar	4-25	4-25	4-25	4-25	10-35	4-35
Centering accuracy over the whole clamping range	mm	0.002	0.002	0.002	0.002	0.01	0.002
Repeatability	mm	0.01	0.01	0.01	0.01	0.002	0.01
Weight Approx.	kg	35	35	35	35	55	60



KRGU Series Grinding Steadies

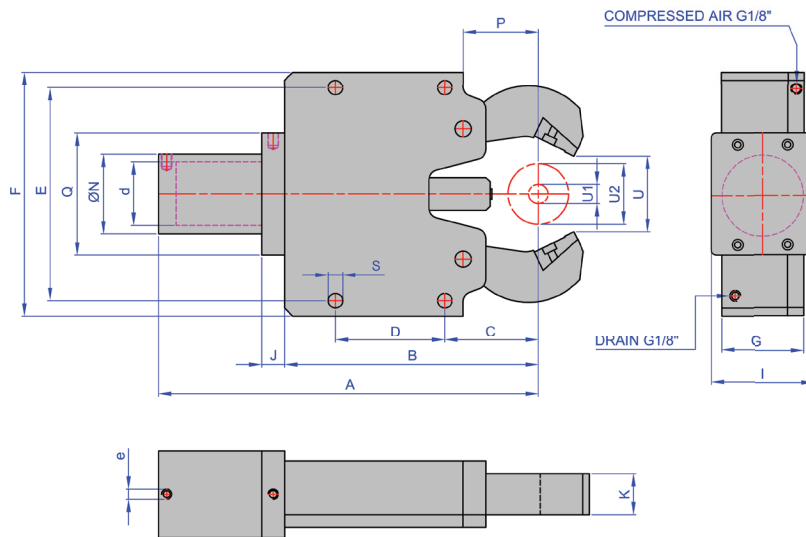
- Retractable body using guide ways
- Suitable for all crank shaft, cam shaft and cylindrical grinding applications where high eccentric load is a requirement
- High accuracy, with three-point finely adjustable centering capability
- Modular regrindable Carbide or relappable PCD work rest pads
- Works well with retracting In-Process-Gaging (IPG)

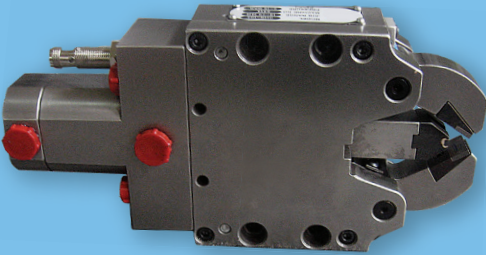


Steady Rest Type		KRGHS790	KRGU1517	KRGU4510	KRGHS9585	KRGU502	KRGU580	KRGU1019
	A	420	518.5	516.5	591	508.5	565.5	502
	B	323	423	408	444	405	462	355.5
	C	190	230	215	254	236	293	162
	D	90	135	135	142	125	125	135
	E1	202	262	262	350	337	234	262
	E2	202	262	262	320	337	234	262
	F	234	290	290	400	363	260	290
	G	55	64	62	64	62	62	64
	I	62	68	68	72	68	68	72
	J	25	33	33	25	33	33	25
	K	10	16	10	21	10	12	24
	N	53	105	119	95	105	105	95
	P	158.5	206.4	191.5	194.5	206.8	268.4	133.4
	Q	96	141	148	130	141	141	130
	S	M12 X 1.75	14	14	18	22/14	20/14	18
Clamping Ranges	U1	70	150	45	95	50	50	100
	U2	90	170	105	185	102	80	190
Max. axial Opening	U	98	181	125	210	109	106.5	226
Eccentric throw (R value)	R	120	175	125	285	59	57	122
Cylinder bore.	d	40	50	50	60	50	50	60
Hyd. Connection. (BSP)	e	1/4"	1/4"	1/4"	1/4"	1/4"	1/4"	1/4"
Standard Operating Pressure	bar	1-10	6-30	6-30	12-45	6-30	6-30	12-45
Max. Operating pressure	bar	15	35	35	60	30	35	60
Clamp. Press./Pad at 6 bar	daN	25	180	180	56	39	39	56
Max. clamp pressure/Pad.	daN	60	196	196	425	196	196	425
Centering accuracy over the whole clamping range.	mm	0.004	0.01	0.01	0.01	0.01	0.01	0.01
Repeatability	mm	0.005	0.004	0.004	0.004	0.002	0.004	0.004
Weight Approx.	kg	20	55	50	65	196	196	196

GHS General Purpose Series Grinding Steadies

- Suitable for all crank shaft, cam shaft and cylindrical grinding applications
- High accuracy, with three-point finely adjustable centering capability
- Modular regrindable Carbide or relappable PCD work rest pads
- Works well with attenuating In-Process-Gaging (IPG)



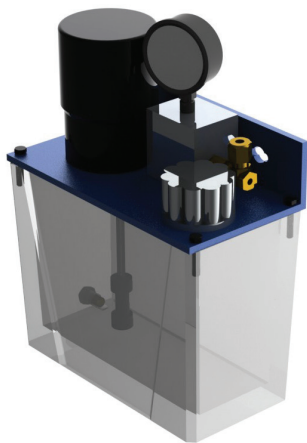
Steady Rest Type		GHS 260E	GHS260H	GHS 1012A	GHS103
	A	241.5	221.5	463	241.6
	B	146.5	146.5	312	141.5
	C	56	56	115	73.5
	D	65	65	135	35
	E	128	128	262	106
	F	146	146	300	123
	G	44	44	85	50
	I	44	44	85	50
	J	23	23	25	35
	K	32	20	45	20
	N	44	82.5	65	55
	P	44	46.5	93.5	44
	Q	96	96	110	105
	S	M12x1.75P	12	18	14.5/9
Clamping Ranges	U1	20	15	10	12
	U2	60	45	120	29
Max. axial Opening	U	63	48	125	30
Cylinder bore.	d	30	30	80	30
Hyd. Connection. (BSP)	e	1/4"	1/4"	1/4"	1/4"
Standard Operating Pressure	bar	1-10	2-10	2-15	5-18
Max. Operating pressure	bar	15	15	20	15
Clamp. Press./Pad at 6 bar	daN	25	25	100	25
Max. clamp pressure/Pad.	daN	100	100	1000	100
Centering accuracy over the whole clamping range.	mm	0.008	0.005	0.01	0.02
Repeatability	mm	0.003	0.002	0.003	0.003
Weight Approx.	kg	7	7	42	7

*Other models are available on request.

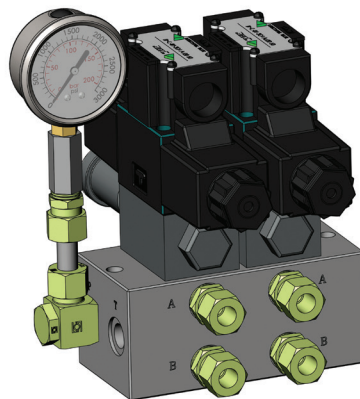
ACCESSORIES

THE
BEST.

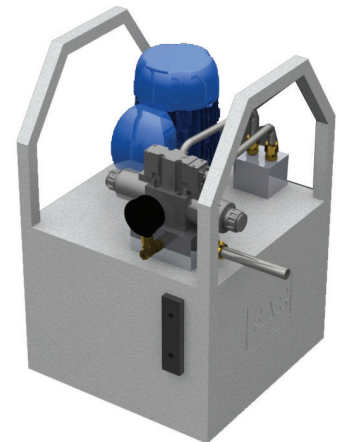
All the Accessories & Mounting
Components to Complete the Project
for a Turnkey Solution



Lubrication Elements



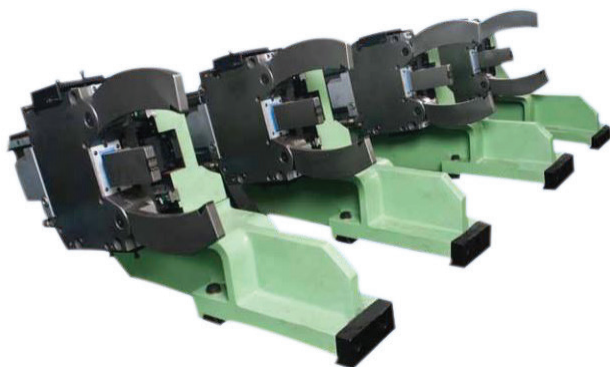
Hydraulic Elements



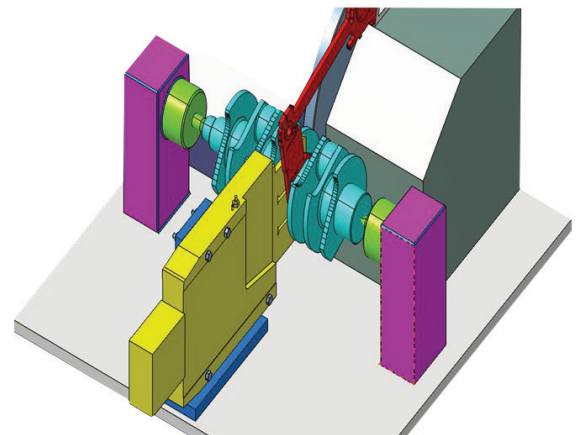
Hydraulic Power Pack



Hydraulic Hoses & Fittings

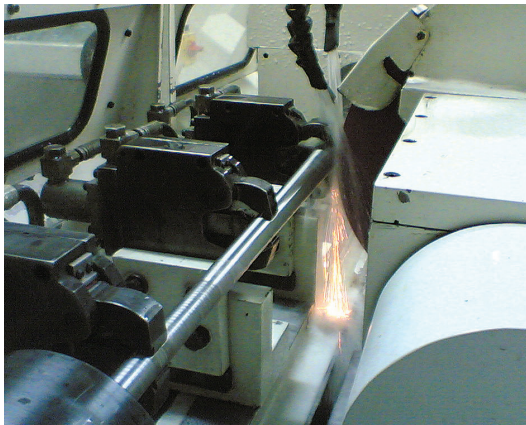
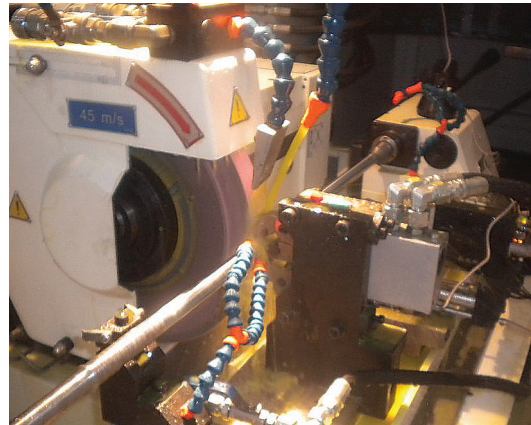


Mounting Bracket



Steady Rest with IPG

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