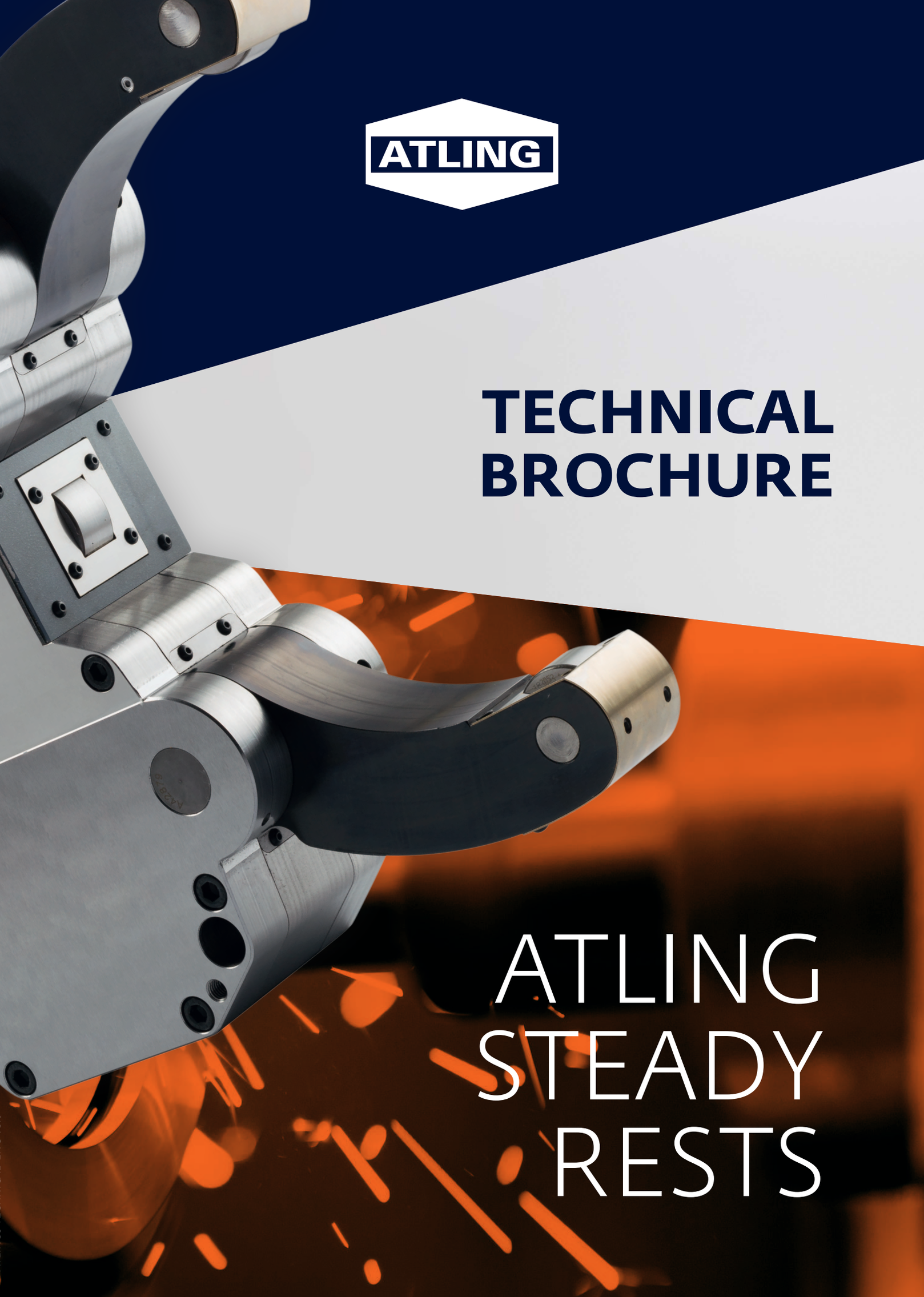
ATLING

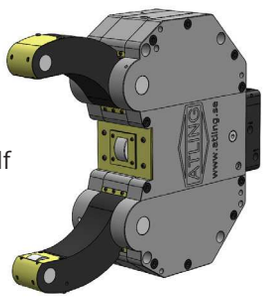
TECHNICAL BROCHURE



ATLING STEADY RESTS

GRIPPING RANGE

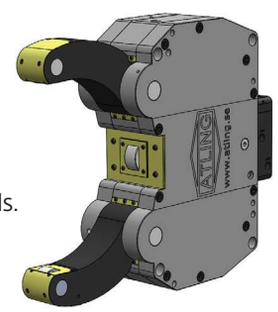
» **Atling AX-series:**
Our standard range of self centering steady rests.



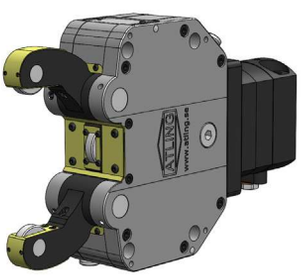
GRIPPING RANGE AX-SERIES (MM)

Model	AX1	AX2	AX3	AX4	AX5	AX6	AX7	AX8	AX8.5	AX8.7	AX9	AX10	AX11
Gripping range	6-70	8-105	12-125	12-160	20-200	30-255	45-320	85-360	100-430	140-470	100-510	250-680	450-870

» **Atling AS-series:**
Designed to fit hole patterns of other brands.



» **Atling AN-series:**
Our range of steady rests with narrow arms.



GRIPPING RANGE AS-SERIES (MM)

Model	AS6	AS7	AS8
Gripping range	30-255	45-320	85-360

GRIPPING RANGE AN-SERIES (MM)

Model	AN1	AN2	AN3	AN4
Gripping range	6-70	8-105	12-125	12-160

Order configuration code

AX/AS/AN: Model serie. (AS only 6, 7 and 8)

Model Size: **1 - 11** (according to list)

Cylinder type:
E = External Cylinder
I = Internal Cylinder

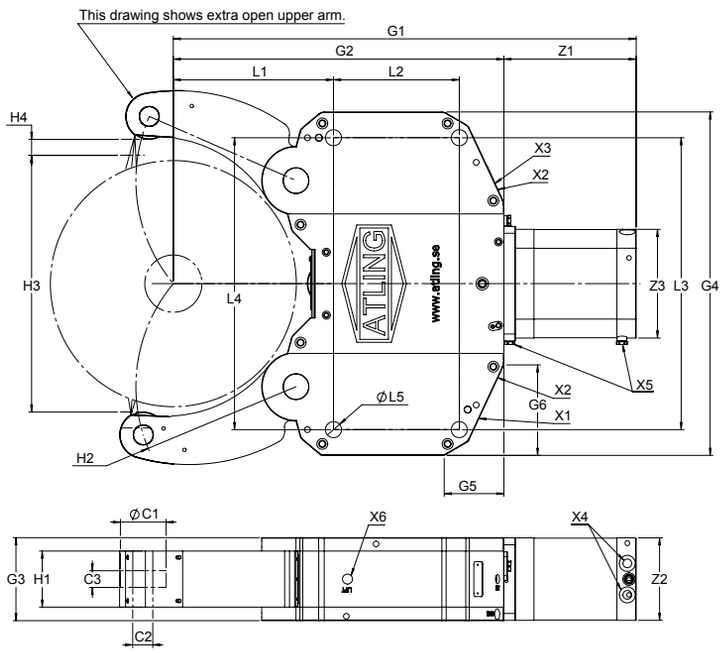
Extra open arm:
N = No extra open arm
U = Extra open arm, upper arm
L = Extra open arm, lower arm
B = Extra open arm, both arms

Lubrication Type:
A = Automatic
M = Manual

Lubricant:
O = Oil
G = Grease

Roller type:
S = Standard
C = Cambered

DIMENSIONS AXE



X1 - Central lubrication connection G1/8"

X2 - Air barrier connection G1/8"

X3 - Water flush connection G1/4" (AX1E - G1/8")

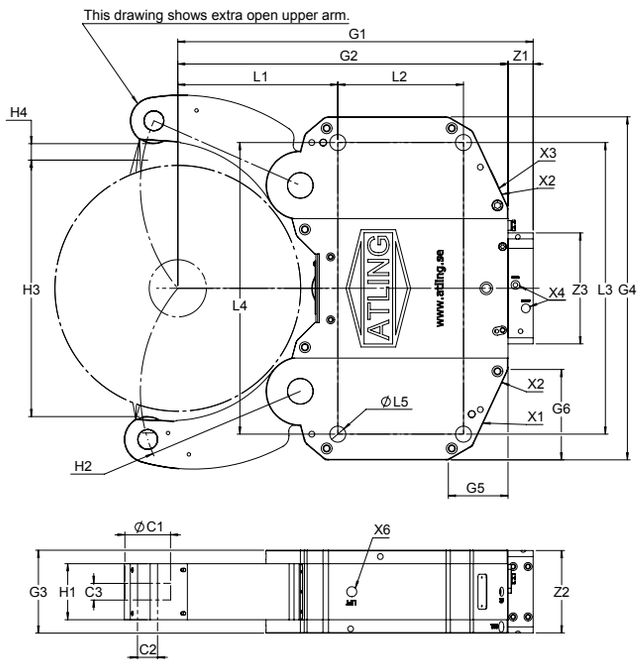
X4 - Hydraulic Open/Close G3/8" (AX1E - G1/4")

X5 - Stroke control thread M12x1 (AX1E - M8x1)

Min operating pressure - 10 bar

Model size			AX1E	AX2E	AX3E	AX4E	AX5E	AX6E	AX7E	AX8E	AX8.5E	AX8.7E	AX9E	AX10E	AX11E
Gripping range			6-70	8-105	12-125	12-160	20-200	30-255	45-320	85-360	100-430	140-470	100-510	250-680	450-870
Roller	(mm)	C1	Ø24	Ø35	Ø35	Ø47	Ø52	Ø52	Ø62	Ø72	Ø80	Ø80	Ø80	Ø100	Ø160
	(mm)	C2	Ø8	Ø15	Ø15	Ø20	Ø20	Ø20	Ø30	Ø30	Ø35	Ø35	Ø35	Ø45	Ø65
	(mm)	C3	15	19	19	25	25	25	29	29	29	29	29	32	75
Lever	(mm)	H1	30	37	37	53	53	53	68	68	98	98	98	98	118
	(mm)	H2	R55	R75	R88	R116	R140	R168	R215	R235	R280	R300	R325	R430	R606
	(mm)	H3	75	110	128	168	208	267	331	377	448	491	521	686	930
	(mm)	H4	5	2	8	10	15	24	27	38	27	33	38	38	33
Housing	(mm)	G1	220	301	344	428	465	563	669	697	809	840	938	1103	1578
	(mm)	G2	137	200	231	290	314	380	465	493	578	603	661	803	1200
	(mm)	G3	60	70	70	90	90	110	145	145	145	145	145	165	198
	(mm)	G4	163	215	270	315	315	438	500	500	600	600	700	760	1200
	(mm)	G5	17	43	56	45	38	83	102	97	104	104	156	108	135
	(mm)	G6	27	37	68	45	66	133	105	100	158	158	220	188	254
Hole pattern	(mm)	L1	51	70	77	115	123	146	178	208,5	280	305,5	292,5	415	640
	(mm)	L2	64	85	102	135	135	155	210	210	220	220	260	312	400
	(mm)	L3	118	170	220	262	262	365	400	400	510	510	620	470	670
	(mm)	L4	118	170	210	262	262	365	400	400	510	510	620	700	1100
	(mm)	L5	Ø11	Ø14	Ø14	Ø18	Ø18	Ø23	Ø23	Ø23	Ø28	Ø28	Ø28	Ø35	Ø35
Cylinder	(mm)	Z1	83	101	113	138	151	183	204	204	231	237	277	300	378
	(mm)	Z2	60	70	70	89	89	109	144	144	144	144	144	144	197
	(mm)	Z3	86	106	106	128	128	140	155	155	190	190	190	190	250
Lifting threads	(mm)	X6	-	-	-	M16	M16	M16	M16	M20	M20	M20	M20	M24	M30
Max gripping force/roller	(daN)		100	390	390	1170	1170	1480	1830	1830	2260	2260	2260	2260	3070
Max roller speed	(m/min)		730	930	930	805	890	890	655	765	685	685	685	685	457
Centering accuracy	(mm)		0,02	0,02	0,04	0,04	0,06	0,06	0,06	0,06	0,06	0,06	0,10	0,10	0,20
Repeatability	(mm)		0,005	0,005	0,005	0,005	0,005	0,005	0,005	0,005	0,01	0,01	0,02	0,02	0,02
Max operating pressure	(bar)		25	60	60	70	70	70	70	70	60	60	60	60	60
Weight	(kg)		8	17	23	45	48	83	158	156	234	237	280	450	1415

DIMENSIONS AXI



X1 - Central lubrication connection G1/8"

X2 - Air barrier connection G1/8"

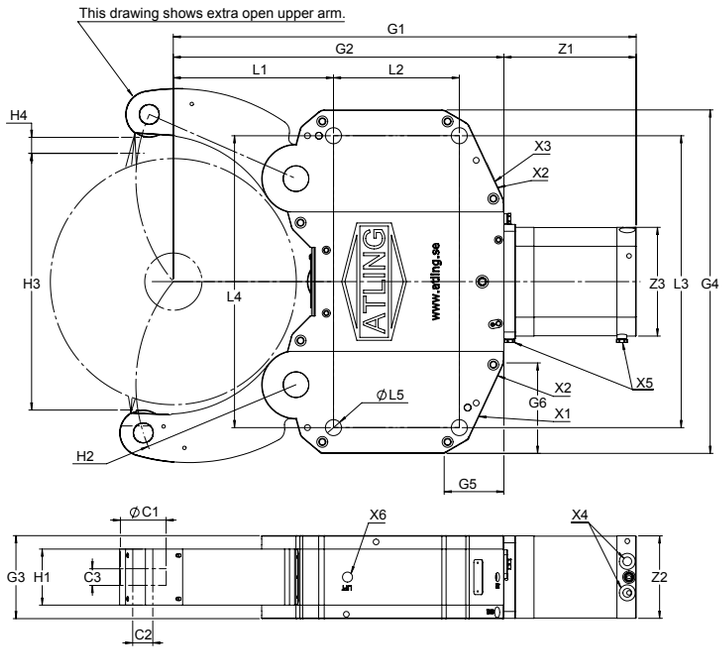
X3 - Water flush connection G1/4"

X4 - Hydraulic Open/Close G3/8"

Min operating pressure - 20 bar

Model size			AX4I	AX5I	AX6I	AX7I	AX8I	AX8.5I	AX8.7I	AX9I	AX10I	AX11I
Gripping range			12-160	20-200	30-255	45-320	85-360	100-430	140-470	100-510	250-680	450-870
Roller	(mm)	C1	Ø47	Ø52	Ø52	Ø62	Ø72	Ø80	Ø80	Ø80	Ø100	Ø160
	(mm)	C2	Ø20	Ø20	Ø20	Ø30	Ø30	Ø35	Ø35	Ø35	Ø45	Ø65
	(mm)	C3	25	25	25	29	29	29	29	29	32	75
Lever	(mm)	H1	53	53	53	68	68	98	98	98	98	118
	(mm)	H2	R116	R140	R168	R215	R235	R280	R300	R325	R430	R606
	(mm)	H3	168	208	267	331	377	448	491	521	686	930
	(mm)	H4	10	15	24	27	38	27	33	38	38	33
Housing	(mm)	G1	334	368	434	509	537	622	647	705	847	1244
	(mm)	G2	290	314	380	465	493	578	603	661	803	1200
	(mm)	G3	90	90	110	145	145	145	145	145	165	198
	(mm)	G4	315	315	438	500	500	600	600	700	760	1200
	(mm)	G5	45	38	83	102	97	104	104	156	108	135
	(mm)	G6	45	66	133	105	100	158	158	220	188	254
Hole pattern	(mm)	L1	115	123	146	178	208,5	280	305,5	292,5	415	640
	(mm)	L2	135	135	155	210	210	220	220	260	312	400
	(mm)	L3	262	262	365	400	400	510	510	620	470	670
	(mm)	L4	262	262	365	400	400	510	510	620	700	1100
	(mm)	L5	Ø18	Ø18	Ø23	Ø23	Ø23	Ø28	Ø28	Ø28	Ø35	Ø35
Cylinder	(mm)	Z1	44	54	54	44	44	44	44	44	44	44
	(mm)	Z2	89	89	109	144	144	144	144	144	144	197
	(mm)	Z3	158	158	158	164	164	194	194	194	194	260
Lifting threads	(mm)	X6	M16	M16	M16	M16	M20	M20	M20	M20	M24	M30
Max gripping force/roller	(daN)		1170	1170	1480	1830	1830	2260	2260	2260	2260	3070
Max roller speed	(m/min)		805	890	890	655	765	685	685	685	685	457
Centering accuracy	(mm)		0,04	0,06	0,06	0,06	0,06	0,06	0,06	0,10	0,10	0,20
Repeatability	(mm)		0,005	0,005	0,005	0,005	0,005	0,01	0,10	0,02	0,02	0,02
Max operating pressure	(bar)		70	70	70	70	70	60	60	60	60	60
Weight	(kg)		40	42	78	145	147	220	223	270	440	1360

DIMENSIONS ASE



X1 - Central lubrication connection G1/8"

X2 - Air barrier connection G1/8"

X3 - Water flush connection G1/4"

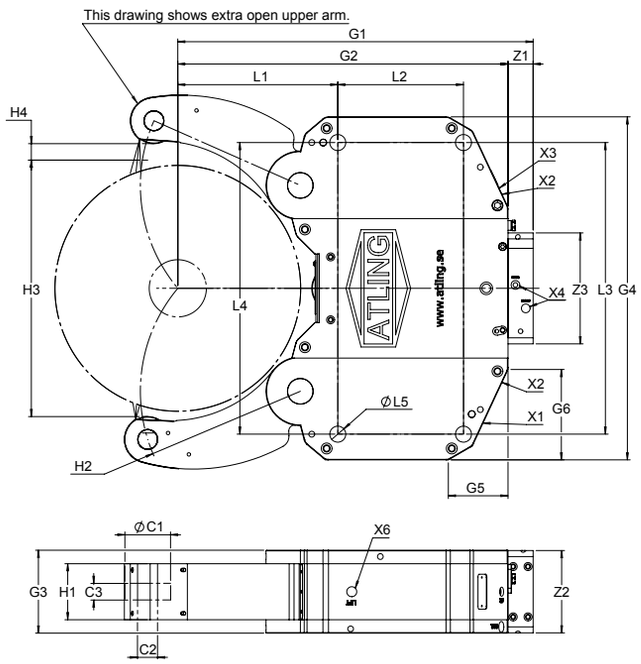
X4 - Hydraulic Open/Close G3/8"

X5 - Stroke control thread M12x1

Min operating pressure - 10 bar

Model size			AS6E	AS7E	AS8E
Gripping range			30-255	45-320	85-360
Roller	(mm)	C1	Ø52	Ø62	Ø72
	(mm)	C2	Ø20	Ø30	Ø30
	(mm)	C3	25	29	29
Lever	(mm)	H1	53	68	68
	(mm)	H2	R168	R215	R235
	(mm)	H3	267	331	377
	(mm)	H4	24	27	38
Housing	(mm)	G1	563	669	697
	(mm)	G2	403	465	493
	(mm)	G3	110	145	145
	(mm)	G4	438	500	500
	(mm)	G5	113	105	100
	(mm)	G6	20	38	42
Hole pattern	(mm)	L1	146	178	198
	(mm)	L2	240	270	270
	(mm)	L3	365	400	400
	(mm)	L4	365	400	400
	(mm)	L5	Ø23	Ø23	Ø23
Cylinder	(mm)	Z1	182	204	204
	(mm)	Z2	109	144	144
	(mm)	Z3	140	155	155
Lifting threads	(mm)	X6	M16	M16	M20
Max gripping force/roller	(daN)		1480	1830	1830
Max roller speed	(m/min)		890	655	765
Centering accuracy	(mm)		0,06	0,06	0,06
Repeatability	(mm)		0,005	0,005	0,005
Max operating pressure	(bar)		70	70	70
Weight	(kg)		92	167	165

DIMENSIONS ASI



X1 - Central lubrication connection G1/8”

X2 - Air barrier connection G1/8”

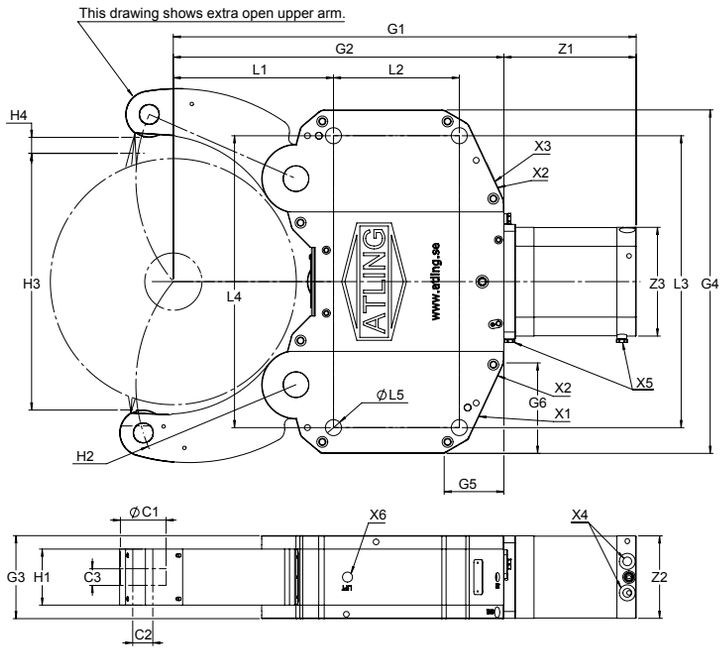
X3 - Water flush connection G1/4”

X4 - Hydraulic Open/Close G3/8”

Min operating pressure - 20 bar

Model size			AS6I	AS7I	AS8I
Gripping range			30-255	45-320	85-360
Roller	(mm)	C1	Ø52	Ø62	Ø72
	(mm)	C2	Ø20	Ø30	Ø30
	(mm)	C3	25	29	29
Lever	(mm)	H1	53	68	68
	(mm)	H2	R168	R215	R235
	(mm)	H3	267	331	377
	(mm)	H4	24	27	38
Housing	(mm)	G1	434	509	537
	(mm)	G2	403	465	493
	(mm)	G3	110	145	145
	(mm)	G4	438	500	500
	(mm)	G5	113	105	100
	(mm)	G6	20	38	42
Hole pattern	(mm)	L1	146	178	198
	(mm)	L2	240	270	270
	(mm)	L3	365	400	400
	(mm)	L4	365	400	400
	(mm)	L5	Ø23	Ø23	Ø23
Cylinder	(mm)	Z1	54	44	44
	(mm)	Z2	109	144	144
	(mm)	Z3	158	164	164
Lifting threads	(mm)	X6	M16	M16	M20
Max gripping force/roller	(daN)		1480	1830	1830
Max roller speed	(m/min)		890	655	765
Centering accuracy	(mm)		0,06	0,06	0,06
Repeatability	(mm)		0,005	0,005	0,005
Max operating pressure	(bar)		70	70	70
Weight	(kg)		84	155	153

DIMENSIONS ANE



X1 - Central lubrication connection G1/8"

X2 - Air barrier connection G1/8"

X3 - Water flush connection G1/4" (AN1E - G1/8")

X4 - Hydraulic Open/Close G3/8" (AN1E - G1/4")

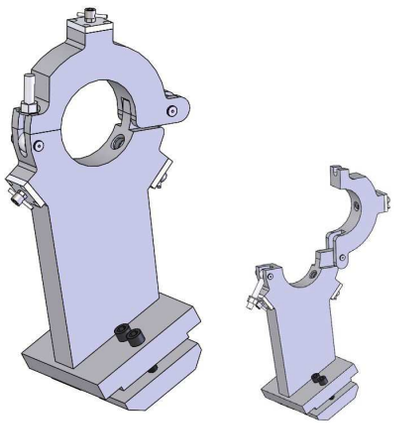
X5 - Stroke control thread M12x1 (AN1E - M8x1)

Min operating pressure - 10 bar

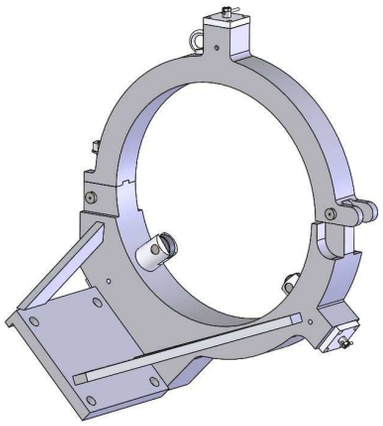
Model size			AN1E	AN2E	AN3E	AN4E
Gripping range			6-70	8-105	12-125	12-160
Roller	(mm)	C1	Ø24	Ø35	Ø35	Ø47
	(mm)	C2	Ø8	Ø15	Ø15	Ø20
	(mm)	C3	10	10	10	10
Lever	(mm)	H1	19	19	19	19
	(mm)	H2	R55	R75	R88	R116
	(mm)	H3	75	110	128	168
	(mm)	H4	5	2	8	10
Housing	(mm)	G1	220	301	344	428
	(mm)	G2	137	200	231	290
	(mm)	G3	60	70	70	90
	(mm)	G4	163	215	270	315
	(mm)	G5	17	43	56	45
	(mm)	G6	27	37	68	45
Hole pattern	(mm)	L1	51	70	77	115
	(mm)	L2	64	85	102	135
	(mm)	L3	118	170	220	262
	(mm)	L4	118	170	210	262
	(mm)	L5	Ø11	Ø14	Ø14	Ø18
Cylinder	(mm)	Z1	83	101	113	138
	(mm)	Z2	60	70	70	89
	(mm)	Z3	86	106	106	128
Lifting threads	(mm)	X6	-	-	-	M16
Max gripping force/roller	(daN)		60	190	190	500
Max roller speed	(m/min)		730	930	930	805
Centering accuracy	(mm)		0,02	0,02	0,04	0,04
Repeatability	(mm)		0,005	0,005	0,005	0,005
Max operating pressure	(bar)		15	30	30	30
Weight	(kg)		8	17	23	45

CUSTOMER ADAPTED SOLUTIONS

MANUAL STEADY RESTS

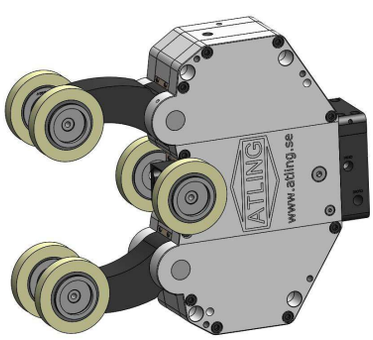


» Manual steady rests –
Mounted on machine bed

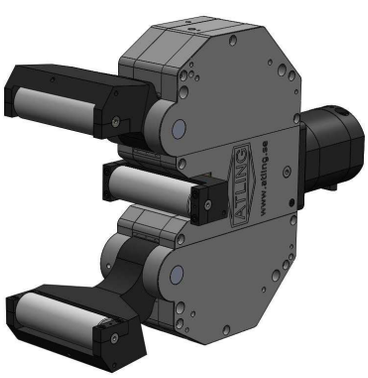


» Manual steady rests –
Mounted on steady rest base

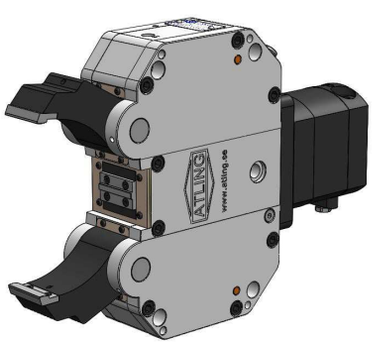
ROLLERS/PADS



» Rubber Rollers

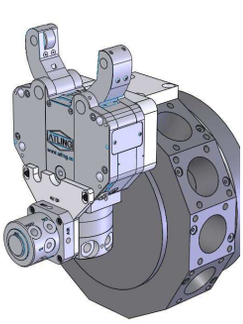


» Wide Rollers

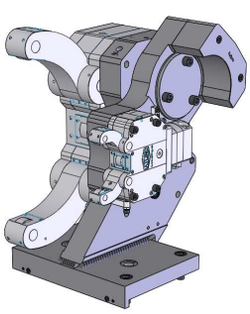


» Diamond Pads

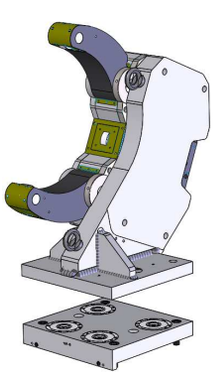
BRACKETS & ADAPTER PLATES



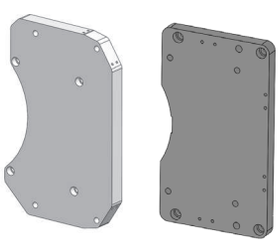
» Turret Bracket



» Flexi Bracket



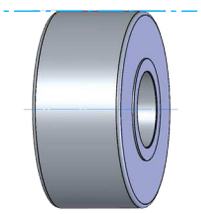
» Zero Point Clamping



» Adapter Plates

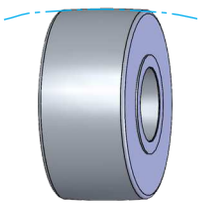
ATLING STEADY REST ROLLER

» Cylindrical Roller



Used to hold the work piece. This type of roller have nearly a plain surface, and therefore this is standard when the Steady Rest is fixed during the processing.

» Cambered Roller



The Cambered rollers have got a convex surface and are used in applications where the steady rest is moving along the work piece.

Model	1	2	3	4	5	6	7	8	8.5	8.7	9	10	11
Cylindrical	A5055044	A5055040	A5055040	A5055014	A5055026	A5055026	A5055005	A5055008	A5055017	A5055017	A5055017	A5551310	A5551311
Cambered	A5055050	A5551203	A5551203	A5551204	A5551205	A5551205	A5551207	A5551208	A5551209	A5551209	A5551209	A5551210	A5551211

EXTRA OPEN ARM

Extra open arm is an option to increase the opening of the arms to give more space to apply the work piece. The extra open arm track plate can be installed in the steady rest or purchased as a spare part and replace a standard track plate, on any arm or both. The gripping range does not get affected by this option.

» Track Plate

» Track Plate Extra open arm

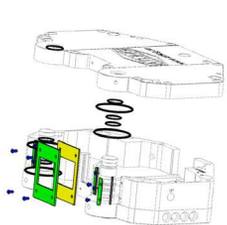
Model	AX1	AX2	AX3	AX4	AX5	AX/AS6	AX/AS7	AX/AS8	AX8.5	AX8.7	AX9	AX10	AX11
Standard	A43007	A42932	A42973	A42981	A42946	A42875	A42895	A42989	A43160	A30941	A42899	A43227	A43241
Extra open arm	A43006	A42933	A42972	A42982	A42947	A42874	A42896	A42988	A43161	A30942	A42898	A43228	A43242

SEAL KIT CYLINDER

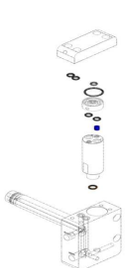
» Seal Kit Cylinder for AXI- and ASI-models

» Seal Kit Cylinder for AXE- and ASE-models

SEAL KIT HOUSE



MINI BOOSTER



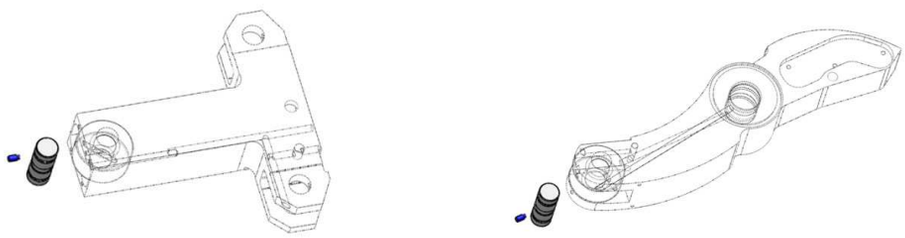
» Mini Booster

» Seal Kit for Mini Booster

Model	1	2	3	4	5	6	7	8	8.5	8.7	9	10	11
Seal Kit Cylinder													
AXI/ASI				A5550412	A5550512	A5550612	A5550712	A5550812	A5550912	A5550912	A5550912	A5551012	A5551112
AXE/ASE	A5550102	A5550202	A5550302	A5550402	A5550502	A5550602	A5550702	A5550802	A5550902	A5550902	A550902	A5551002	A5551102
Seal Kit House													
AX/AS	A5550101	A5550201	A5550301	A5550401	A5550501	A5550601	A5550701	A5550801	A5550901	A5550901	A5550901	A5551001	A5551101
Mini Booster				A5235034	A5235034	A5235034	A5235034	A5235034	A5235034	A5235034	A5235034	A5235034	A5235034
Seal Kit for Mini Booster				A5550506	A5550506	A5550606	A5550606	A5550606	A5550606	A5550606	A5550606	A5550606	A5550606

SHAFTS KIT

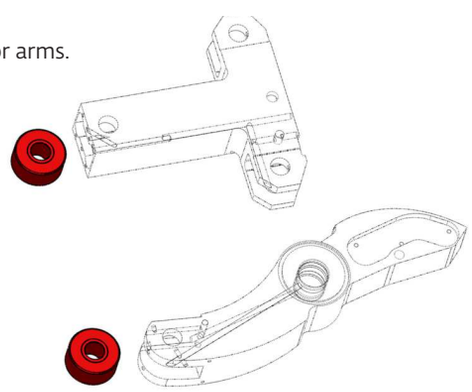
One shaft for middle piece and two shafts for arms.



Model	1	2	3	4	5	6	7	8	8.5	8.7	9	10	11
AX/AS	A5550105	A5550205	A5550305	A5550405	A5550505	A5550605	A5550705	A5550805	A5550905	A5550905	A5550905	A5551005	A5551105

ROLLERS KIT

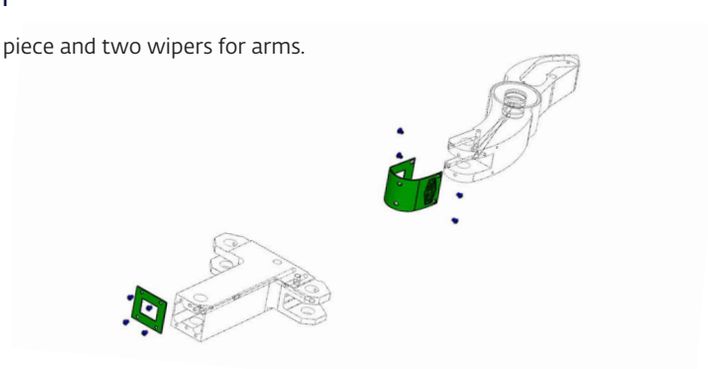
One roller for middle piece and two rollers for arms.



Model	1	2	3	4	5	6	7	8	8.5	8.7	9	10	11
AX/AS	A5550104	A5550204	A5550304	A5550404	A5550504	A5550604	A5550704	A5550804	A5550904	A5550904	A5550904	A5551004	A5551104

WIPERS KIT

One wiper for middle piece and two wipers for arms.

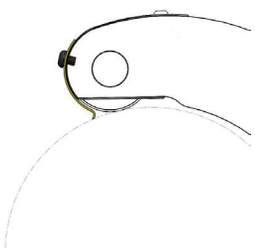


Model	1	2	3	4	5	6	7	8	8.5	8.7	9	10	11
AX/AS	A5550103	A5550203	A5550303	A5550403	A5550503	A5550603	A5550703	A5550803	A5550903	A5550903	A5550903	A5551003	A5551103

WORKPIECE WIPER

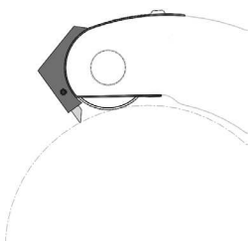
Wiper to remove dirt and chips from workpiece.

» **Standard workpiece wiper.**



The standard workpiece wiper is used to remove chips from the workpiece. It's manually adjusted and can be assembled in existing holes on standard arms.

» **Resilient workpiece wiper.**

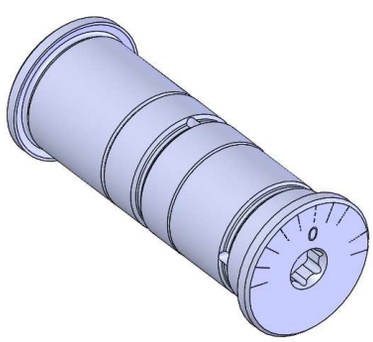


The resilient workpiece wiper is used to remove chips from the workpiece. Its spring function makes it automatically adjusted to the workpiece surface. It is assembled in existing holes on standard arms.

Model	AX1	AX2	AX3	AX4	AX5	AX6	AX7	AX8	AX8.5	AX8.7	AX9	AX10	AX11
Standard	A51001	A51002	A51002	A51004	A51005	A51005	A51007	A51008	A51009	A51009	A51009	A51010	A51011
Resilient		A50002	A50002	A50004	A50005	A50005	A50007	A50008	A50009	A50009	A50009	A50010	A50011

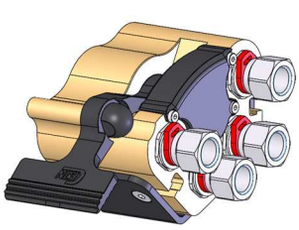
ECCENTRIC FINE ADJUSTMENT KIT

Eccentric roller pins on the arms provides a quick fine adjustment of the center line.

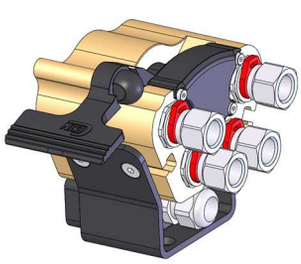


MULTI-X COUPLINGS

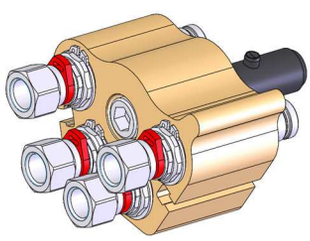
Multi X-Couplings, the quick way to connect hyudralics, coolant and automatic lubrication systems together. It's also possible to attach electrical connections for example sensors in the same coupling.



Art.No: A5065308



Art.No: A5065308 + A5065311



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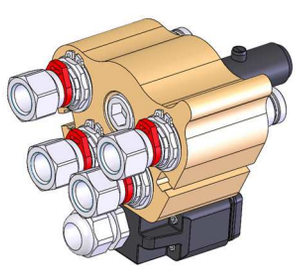

Art.No: A5065309 + A5065310

ATLING

Atlings Maskinfabrik AB
P.O. Box 21
SE 816 25 Ockelbo, Sweden
+46 297 557 00
steadyrest@atling.se
www.atling.com

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