### Accessories SLZ series

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**Clamping arm control system SLZ-HN**

There is the option of attaching a sensor (proximity switch) to the steady rests as standard, which measures the position of the opened steady rest. This option is not available for the steady rest of Type SLZ-047. The proximity switch is not included in the delivery of the steady rest.

**Control system of the clamping arms SLZ-HK**

All steady rests of Type SLZ, SLZB, and SLZW can be equipped with holders and rods, or rod only, in order to be able to recognize the closed as well as the opened clamping arms with a proximity switch.

Position only for SLZ-047

Cam switch / Position sensor

Not included
All standard steady rests come equipped with a safety valve integrated in the cylinder. If the clamping pressure in the cylinder should be interrupted, the valve prevents the steady rest from opening. With following applications, the safety valve isn’t necessary. This device is available as an option for the SLZ-047 series.

The standard steady rest is configured as follows:
- Cylindrical rollers
- Pressurization
- Central lubrication
- Axially extended cylinder with safety valve (except SLZ-047)
- Proximity switch component (open steady rest) HN
- Device for manual lubrication via grease cup or oiler

All Röhm steady rests have a G 1/8" air purge connection. This system protects the body of the steady rest from chip and dust penetration. When the steady rest is completely open, the air consumption is automatically reduced, but not completely interrupted to prevent unnecessary air consumption. The system includes the cleaning of the middle roller bearings. To activate this option, the screw „G“, which is located in bottom of the housing, must be removed. The pressure may differ between a minimum of 2 bar and a maximum of 4 bar (58 psi). The steady rest can also be used without the air purge. Drain holes are on the top and bottom part of the steady rest housing. It is recommended that the lower of the two seals is released to allow the coolant to drain and to prevent penetration of contaminants into the body of the steady rest.
Self-centering steady rests

Accessories SLZ series

Control system of the clamping arms HK-IP5

This system allows the position of the clamping arms (open/closed on the workpiece) to be controlled via two proximity switches with O-ring seals (IP552), located in the housing.

The proximity switch, which signals the closing of the steady rest during changing and the clamping diameter, is set with an external screw. The proximity switch and the bore must be considered by the customer.

Regulation of the clamping arm opening system

Sometimes the opening of the clamping arms must be limited, e.g. to set the supporting roller diameter with the steady rest open or to limit the dimensions of the lateral clamping arms or to reduce the opening and closing times of the steady rest. Here, the „RAB“ cylinder (regulation of the clamping arm opening) can be used. The device limits the cylinder stroke to 75 % of the total stroke.

Regulation is done manually. This device can be used with the steady rests of the SLZ and SLZB series. The device does not reduce the clamping range of the steady rest.

Compensation rod (on request)

Maintaining the center centering when the clamping pressure changes

The steady rest is centered via operating pressure which is selected depending on the work to be done. The center of the workpiece is shifted according to the increasing/decreasing cylinder pressure, depending on the working conditions. The shifting of the workpiece center due to a pressure change is be reduced by the patented system. See the table „Characteristics of the steady rest series SLZ, SLZB and the SLZ heavy series.
Precise steady rest function also depends on its stable and secure fastening to the lathe. The steady rest bracket must be made with corrugated, welded plates and meet the design standards. The bracket design of the steady rest depends on the type of steady rest and the application:

- Space available
- Height of the turning center
- How the steady rest is used (fixed or following)
- Position angle of the steady rest in relation to the dimensions of the tools.

The mounting surface of the steady rest bracket must be absolutely flat in order not to distort the steady rest when fastening. The steady rest must be exactly centered along the X and Y axes of the lathe. Max. deviation 0.01 mm.