STAN -SAMARA

JIG-BORING MACHINE PLANT

The works of coordinate boring machines "Stan Samara" is located in the City of Samara, Privolzhsky Federal District of the Russian Federation, was founded in 1991 and specializes in manufacture of high precision equipment. The manufacturing area is 8300 square meters, the manpower is about 100 men.

Our engineers and craftsmen are highly qualified machine tool builders combining many years of experience with professional skills. Reliability, durability and warranted quality of manufacturing, pursuance of dialogue allow us to cooperate effectively with Russian and foreign enterprises of various industries for many years, and having a well equipped manufacturing base can meet the requirements of the most demanding customer.

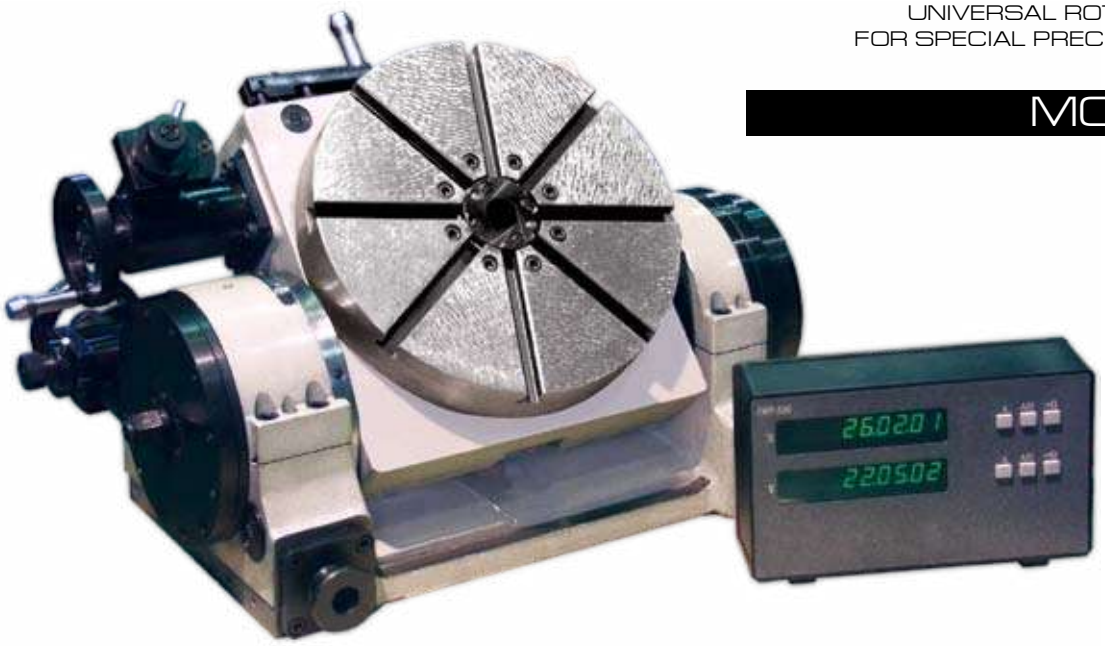
Documentation for all products manufactured by "Stan Samara" has been developed by its own design engineering department. We manufacture nowadays:

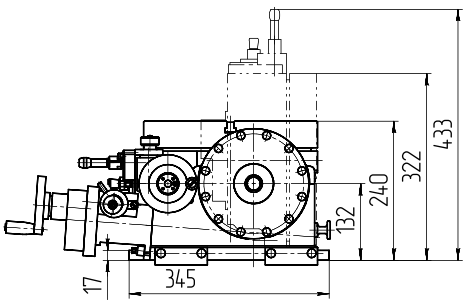
- Vertical coordinate boring and jig grinding machines with the working surface table size 400 mm x 800 mm.
- Manufacture range of high precision rotary indexing tables with the faceplate diameter from 260 mm up to 1000 mm with manual control and control from a NC unit as well as special indexing tables and rotary devices.
- A wide standard range of drive and electrical spindles for the newly designed equipment to be operated.

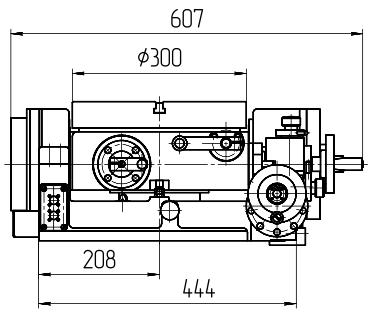
Herewith, we provide an overview and specifications of some models of our dividing tables and spindles.

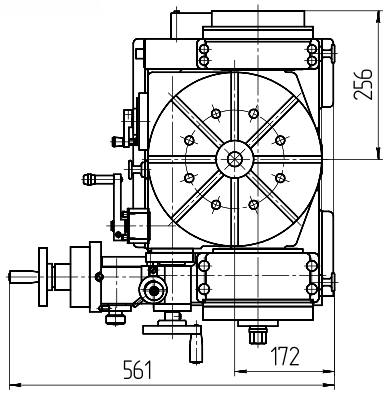
UNIVERSAL ROTARY INDEXING TABLE
FOR SPECIAL PRECISION MACHINING AND
MEASUREMENTS

MODEL CY 30







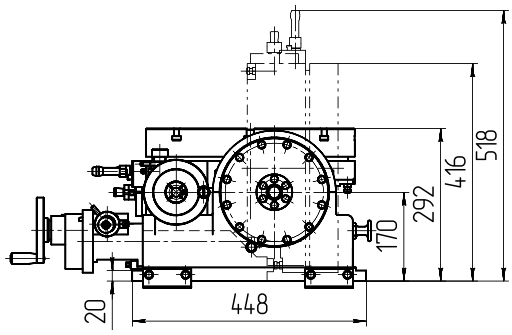


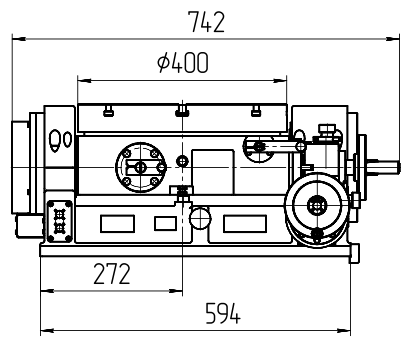
Faceplate diameter, mm	300
Quantity of T-shaped radial grooves, pcs	8
Width of T-shaped grooves, mm	12
Diameter of the faceplate center hole, mm	25H7
The largest weight of the workpiece, kg	60
Resolution of the digital readout unit	0°00'01″
Accuracy of the faceplate rotation angle	±3″ (±1″)*
Accuracy of inclination angle setting	±4″
Straightness of the table faceplate working surface, mm	0,004
End play of the table faceplate working surface, mm	0,004
Parallel alignment of faceplate working surface to the table base, mm	0,003
Parallel alignment of faceplate inclination axis to the table base in vertical plane, mm	0,0025
Radial runout of the table faceplate center hole, mm	0,003
Length, mm	607
Width, mm	561
Height, mm	240
Weight, kg	170

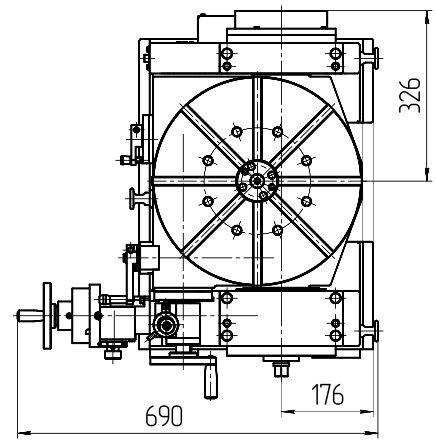
* Data in brackets for the custom-made tables.

UNIVERSAL ROTARY INDEXING TABLE
FOR SPECIAL PRECISION MACHINING AND
MEASUREMENTS

MODEL CY 40





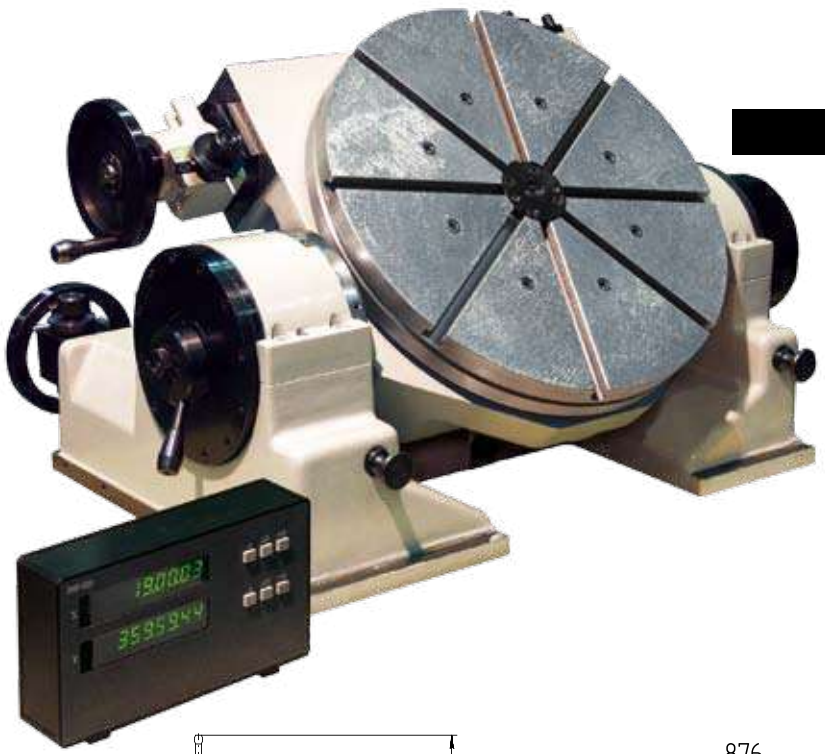


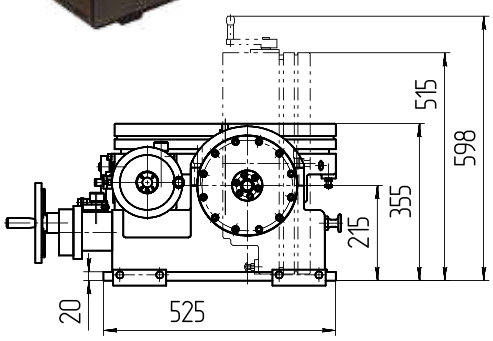
Faceplate diameter, mm	400
Quantity of T-shaped radial grooves, pcs	8
Width of T-shaped grooves, mm	14
Diameter of the faceplate center hole, mm	25H7
The largest weight of the workpiece, kg	80
Resolution of the digital readout unit	0°00'01″
Accuracy of the faceplate rotation angle	±3″ (±1″)*
Accuracy of inclination angle setting	±4″
Straightness of the table faceplate working surface, mm	0,005
End play of the table faceplate working surface, mm	0,005
Parallel alignment of faceplate working surface to the table base, mm	0,004
Parallel alignment of faceplate inclination axis to the table base in vertical plane, mm	0,003
Radial runout of the table faceplate center hole, mm	0,003
Length, mm	742
Width, mm	690
Height, mm	292
Weight, kg	273

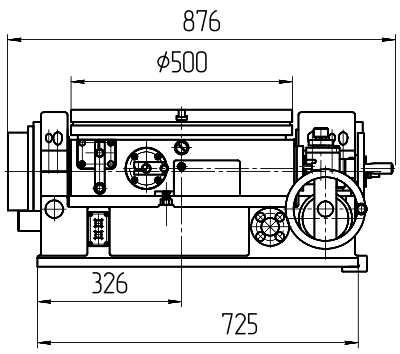
* Data in brackets for the custom-made tables.

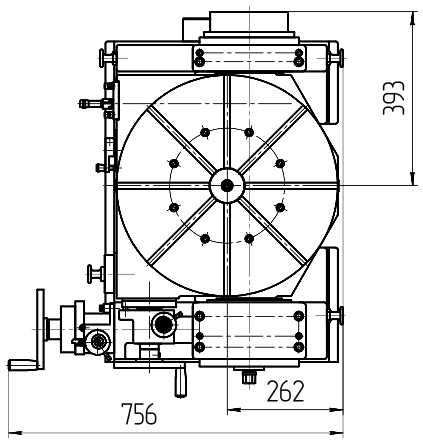
UNIVERSAL ROTARY INDEXING TABLE
FOR SPECIAL PRECISION MACHINING AND
MEASUREMENTS

MODEL CY 50







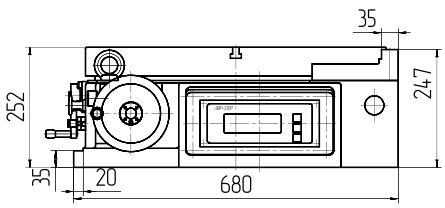


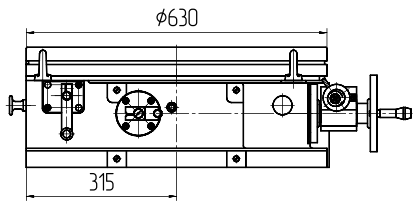
Faceplate diameter, mm	500
Quantity of T-shaped radial grooves, pcs	8
Width of T-shaped grooves, mm	14
Diameter of the faceplate center hole, mm	25H7
The largest weight of the workpiece, kg	100
Resolution of the digital readout unit	0°00'01″
Accuracy of the faceplate rotation angle	±3″ (±1″)*
Accuracy of inclination angle setting	±4″
Straightness of the table faceplate working surface, mm	0,005
End play of the table faceplate working surface, mm	0,005
Parallel alignment of faceplate working surface to the table base, mm	0,004
Parallel alignment of faceplate inclination axis to the table base in vertical plane, mm	0,003
Radial runout of the table faceplate center hole, mm	0,003
Length, mm	876
Width, mm	756
Height, mm	355
Weight, kg	480

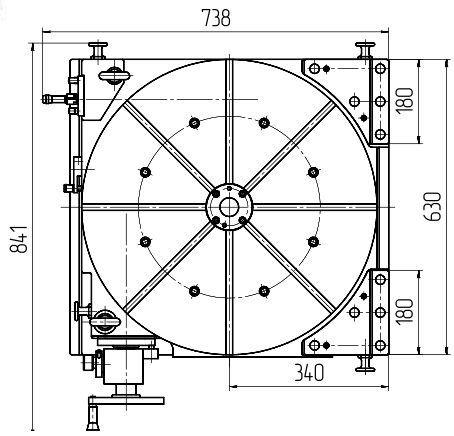
* Data in brackets for the custom-made tables.

TURNED ROTARY INDEXING TABLE FOR SPECIAL
PRECISION MACHINING
AND MEASUREMENTS

MODEL CK 63







It is made with a digital read-out or with control of a NC unit

Faceplate diameter, mm	630
Quantity of T-shaped radial grooves, pcs	8
Width of T-shaped grooves, mm	14
Diameter of the faceplate center hole, mm	40H7
The largest weight of the workpiece, kg	500
Resolution of the digital readout unit	0°00'01″
Resolution of the NC unit*	0,001°
Accuracy of the faceplate rotation angle	±3″ (±1″)**
The average bilateral positional deviation of the faceplate rotation angle*	6″
Straightness of the table faceplate working surface, mm	0,006
End play of the table faceplate working surface, mm	0,006
Parallel alignment of faceplate working surface to the table base, mm	0,005
Radial runout of the table faceplate center hole, mm	0,004
Perpendicularity of the faceplate working surface to the lateral base surface of the table, mm	0,005
Length, mm	841
Width, mm	738
Height, mm	252
Weight, kg	486

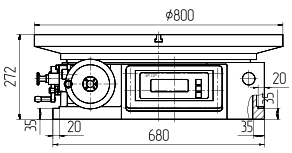
* Data for tables controlled by the NC unit.
**Data in brackets for the custom-made tables.

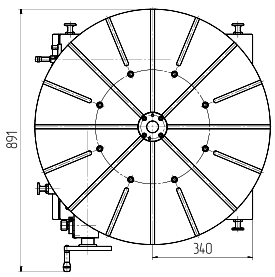
ROTARY INDEXING TABLE FOR SPECIAL PRECISION MACHINING AND MEASUREMENTS

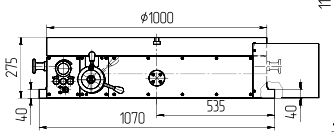
MODEL СП 80

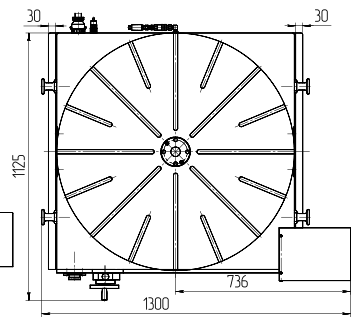
ROTARY INDEXING TABLE FOR SPECIAL PRECISION MACHINING AND MEASUREMENTS

MODEL СП 100









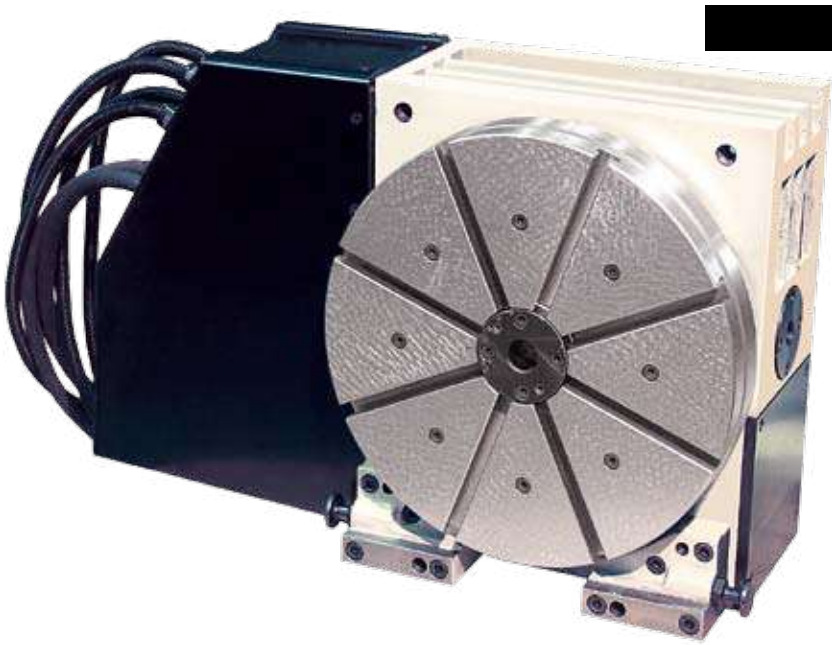
It is made with a digital read-out or with control of a NC unit

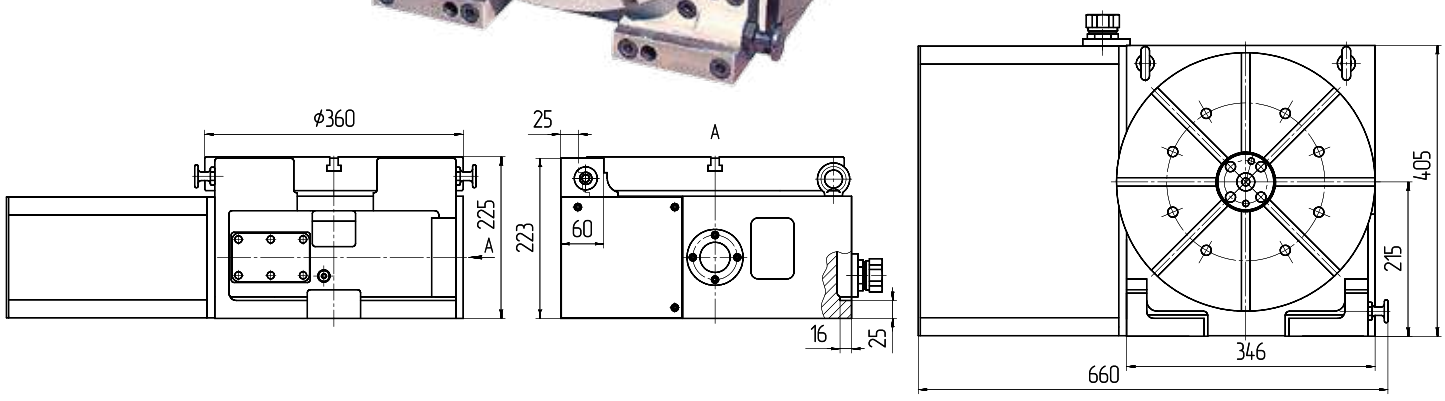
	СП100	СП80
Faceplate diameter, mm	1000	800
Quantity of T-shaped radial grooves, pcs	16	16
Width of T-shaped grooves, mm	18	14
Diameter of the faceplate center hole, mm	40H7	40H7
The largest weight of the workpiece, kg	1000	500
Resolution of the digital readout unit	0°00'01″	0°00'01″
Resolution of the NC unit*	0,001°	-
Accuracy of the faceplate rotation angle	±2,5″ (±1″)**	±3″ (±1″)**
The average bilateral positional deviation of the faceplate rotation angle*	6″	-
Straightness of the table faceplate working surface, mm	0,008	0,006
End play of the table faceplate working surface, mm	0,008	0,006
Parallel alignment of faceplate working surface to the table base, mm	0,006	0,005
Radial runout of the table faceplate center hole, mm	0,005	0,004
Length, mm	1300	891
Width, mm	1125	800
Height, mm	275	272
Weight, kg	1300	530

* Data for tables controlled by the NC unit.
**Data in brackets for the custom-made tables.

TURNED ROTARY INDEXING TABLE WITH
CONTROL OF A NC UNIT
IN ORDER TO EQUIP THE HIGH-PRECISION METAL-
CUTTING MACHINE TOOLS

MODEL CK 36

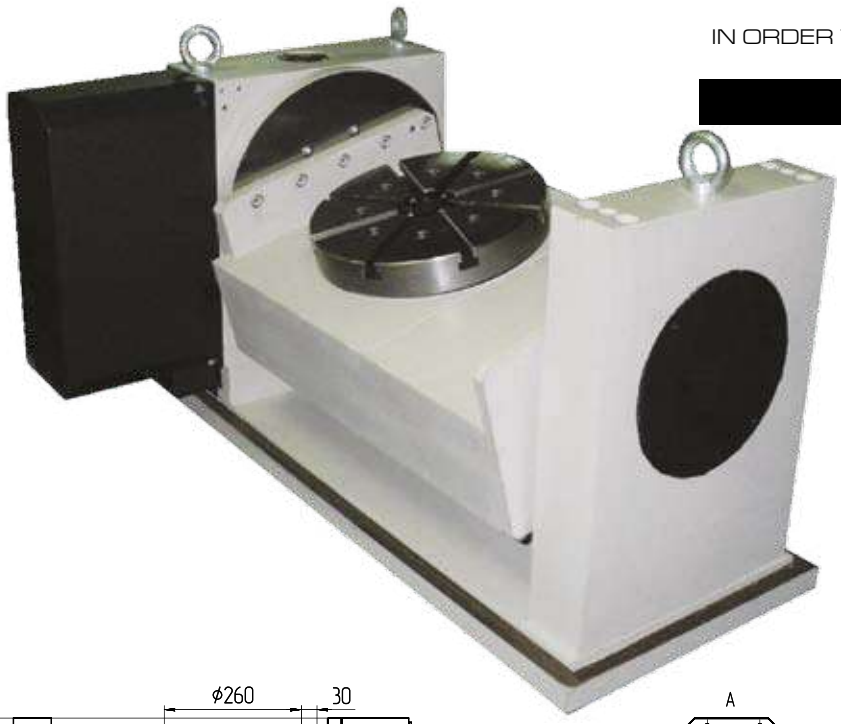


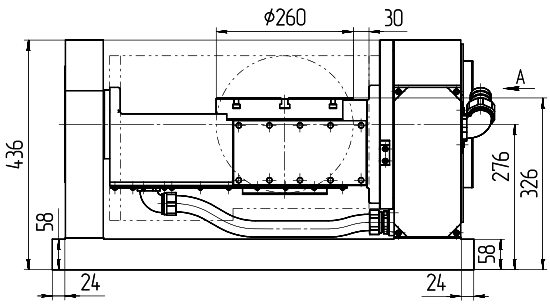


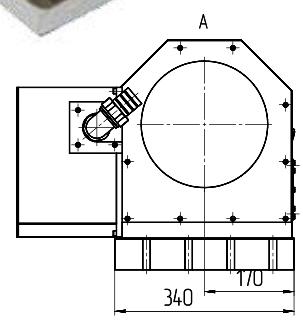
Faceplate diameter, mm	360
Quantity of T-shaped radial grooves, pcs	8
Width of T-shaped grooves, mm	12
Diameter of the faceplate center hole, mm	25H7
The largest weight of the workpiece, kg	100
Resolution of the NC unit	0,001°
The average bilateral positional deviation of the faceplate rotation angle	6″
Straightness of the table faceplate working surface, mm	0,005
End play of the table faceplate working surface, mm	0,005
Parallel alignment of faceplate working surface to the table base, mm	0,004
Radial runout of the table faceplate center hole, mm	0,003
Perpendicularity of the faceplate working surface to the lateral base surface of the table, mm	0,004
Length, mm	660
Width, mm	405
Height, mm	225
Weight, kg	200

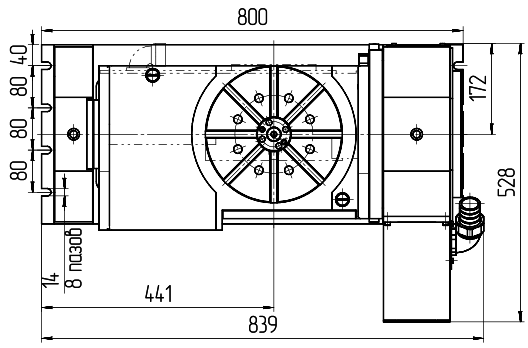
UNIVERSAL ROTARY INDEXING TABLE WITH
CONTROL OF A NC UNIT
IN ORDER TO EQUIP THE HIGH-PRECISION METAL-
CUTTING MACHINE TOOLS

MODEL CY 26









Faceplate diameter, mm	260
Quantity of T-shaped radial grooves, pcs	8
Width of T-shaped grooves, mm	12
Diameter of the faceplate center hole, mm	25H7
The largest weight of the workpiece, kg	60
Resolution of the NC unit	0,001°
The average bilateral positional deviation of the faceplate rotation angle	6″
The average bilateral positional deviation of the faceplate inclination angle	8″
Straightness of the table faceplate working surface, mm	0,004
End play of the table faceplate working surface, mm	0,004
Parallel alignment of faceplate working surface to the table base, mm	0,003
Parallel alignment of faceplate inclination axis to the table base in vertical plane, mm	0,0025
Radial runout of the table faceplate center hole, mm	0,003
Length, mm	839
Width, mm	528
Height, mm	436
Weight, kg	410

DRIVE AND ELECTRICAL SPINDLES IN ORDER TO EQUIP OPERATING AND NEWLY DESIGNED GRINDING AND BORING EQUIPMENT

The structural features of the spindles in combination with high precision manufacturing and careful dynamic balancing of rotating elements determine the consistent quality of the surfaces processed with their use. The high precision

The basic types of drive spindles:

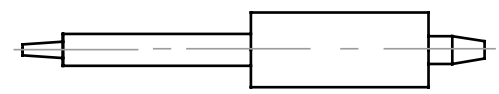
Type СПШП

spindle with a faceplate

Type СПШО

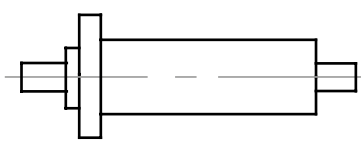
with a mandrel

Type СПШК



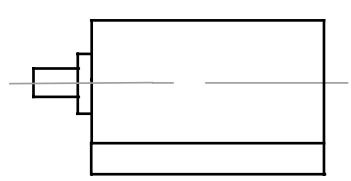
cantilevered

Type СПШФ



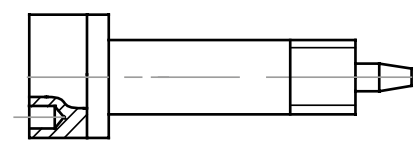
flanged

Type СПШР



boring

Type СПШИ



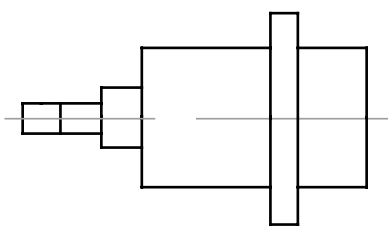
spindle of the product

angular contact bearings installed in the bearings of the central shaft with a system of preliminary normalized tension are lubricated depending on the rotation range with a grease or oil spray.

Drive spindles are manufactured at rotational rate up to 24,000 rpm. Electric spindles – from 3,000 rpm up to 126,000 rpm and power from 0.5 up to 23 kW.

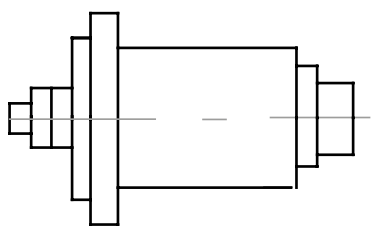
The basic types of electrical spindles:

Type СШК



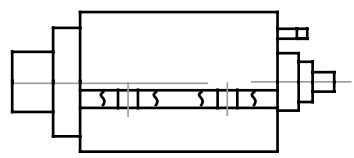
coordinate grinding

Type СШФ



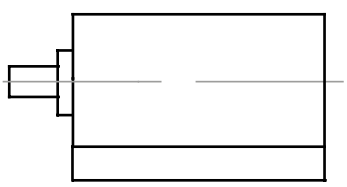
flanged

Type СШЗ



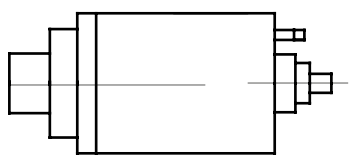
for internal grinding machines

Type СШР



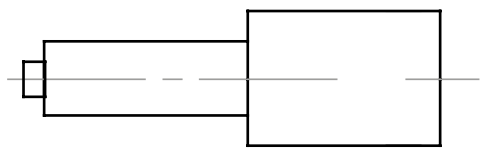
boring

Type СШЦ



cylindrical

Type СШП



quill type

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