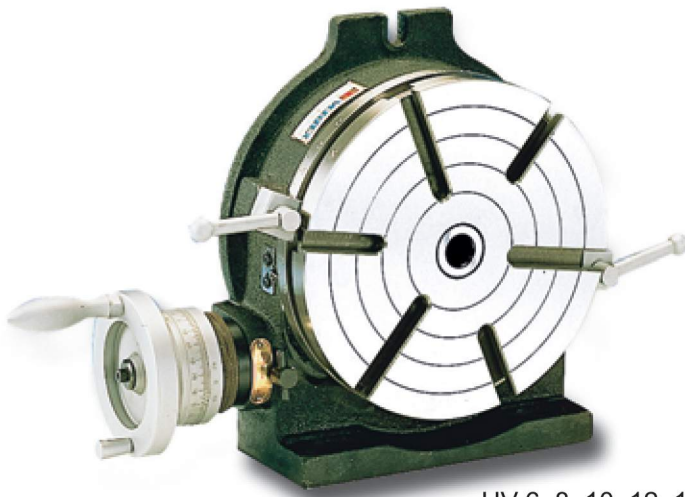


HORIZONTALNE A VERTIKÁLNE OTOČNÉ STOLY

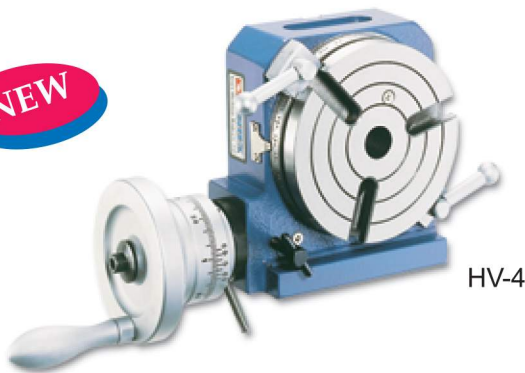


HV-6, 8, 10, 12, 14, 16

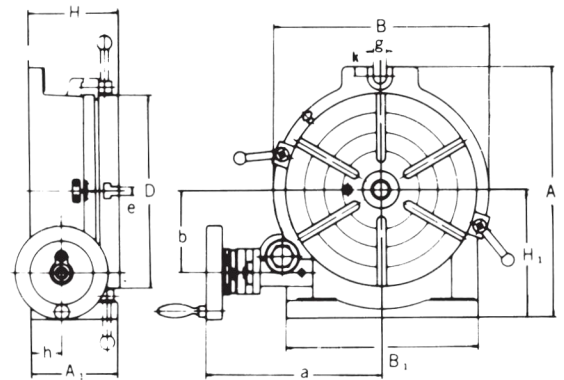
Special Accessories (Details on page 2)



NEW



HV-4



Unit:mm/inches

Order No. & Dimensions

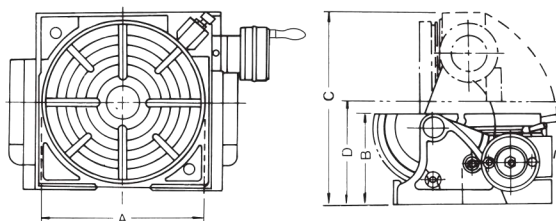
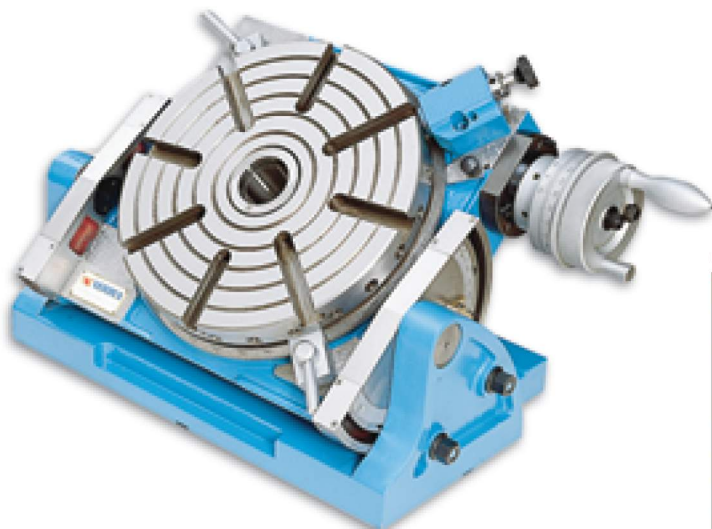
ORDER NO.	Table			Base dimension			Width of T-slot		Bolt slots	Center sleeve	Gross Weight kg/lb wooden case(W) Caron(C)	Meas. CFT	CODE NO.
	Outer diameter		Height	H1	A	B	e	Type					
	A1	D											
HV-4	70	110	80	85	145	115	11	⊕	12	MT-2	(C) 7.5	0.3	1001-000
HV-6	78 3.07	150 5.91	80 3.11	100 3.94	200 7.87	160 6.30	11 0.43	⊕	15 0.59	MT-2	(C) 13	0.4	1001-001
HV-8	100 3.94	200 7.87	105 4.13	135 5.31	265 10.43	220 8.66	14 0.55	⊕	17 0.67	MT-3	(C) 26	0.8	1001-002
HV-10	110 4.33	250 9.84	115 4.53	165 6.50	325 12.80	280 11.02	14 0.55	⊗	17 0.67	MT-3	(C) 37	2	1001-003
HV-12	130 5.12	300 11.81	135 5.32	195 7.68	388 15.27	330 12.99	16 0.63	⊗	18 0.71	MT-4	(W) 70	2.6	1001-004
HV-14	130 5.12	350 13.78	140 5.51	230 9.06	450 17.72	380 14.95	16 0.63	⊗	18 0.71	MT-4	(W) 93	3.2	1001-005
HV-16	150 5.90	406 15.98	155 6.10	255 10.03	500 16.69	430 16.93	16 0.63	⊗	18 0.71	MT-4	(W) 122	4.2	1001-006

1. Table is made of high density Meehanite and use "HEIDENHAIN" electronic equipment to inspect angle to assure the excellent quality and durability.
2. Use excellent machining center to process. Spindle end be applied accuracy bearing. Can be assured to keep very steady under load cutting.
3. Worm is hardened and ground. The ratio is 90:1. The work table is graduated a full 360° so that one turn of the handle moves the table through 4°. Micro collar is graduated in steps of 1' min. And vernier scale makes settings down to 10 seconds possible.
4. These Rotary Tables are popular for their excellent performance, practical design and reasonable cost. they are widely used for circular cutting work, angle setting, boring, spot-facing and similar work.
5. Used the Key guide block, the center can be corrected both quickly and accurately.

Test Report

ITEM NO.	TESTING OBJECTIVE	VARIATION(INCHES)(MM) MAXIMUM TESTED
1	FLATNESS OF CLAMPING SURFACE(CONCAVE)	.0006(0.015)
2	PARALLELISM OF CLAMPING SURFACE TO BASE	.0008(0.02)
3	SQUARENESS OF CLAMPING SURFACE TO ANGLE FACE	.0008(0.02)
4	TRUE RUNNING OF CLAMPING SURFACE	.0006(0.015)
5	TRUE RUNNING OF CENTER HOLE MEASURED AT HOLE EDGE	.0008(0.02)
6	INDEXING ACCURACY OF DIRECT INDEXING MECHANISM MAXIMUM CUMULATIVE SPACING ERROR	45"

UNIVERZÁLNY NAKLÁPACÍ OTOČNÝ STOL



Order No. & Dimensions

ORDER NO.	VU-300
TABLE DIAMETER A	300mm
TABLE HEIGHT (horizontal) B	185mm
TABLE O/A HEIGHT (VERTICAL) C	370mm
CENTER HOLE	MT5
CENTER HEIGHT (vertical) D	208mm
DIRECT INDEXING	24-div.
GEAR RATIO	90:1
WEIGHT(G.W.)	102kg
WEIGHT(N.W.)	93.4kg

ORDER NO. VU-300 **CODE NO. 1001-010**

This is an accurate and slidly designed table for use on milling, boring and other machine tools. This table allows indexing, facing and other work to be carried out rapidly with extreme precision.

Tilting range 90 degrees from horizontal to vertical position, 1 rotation of handle equals 3 degrees, 5 minutes tilting reading.

- 10 Second Vernier Scale.
- Table Dial 1 Minute Graduations.
- Fast Degrees: Dividing Notch Pin & 24 Holes in 15 Degrees Around The insures Rapid Accurate Spacing.
- Minimum Set-Up time.
- Rugged Construction.

SPECIAL ACCESSORIES

1.DIVIDING PLATE DP-5

2.TAILSTOCK

TSU-1 HEAVY-DUTY TYPE

TSU-2 ECONOMICAL TYPE

ORDER NO.	TSU-1
CODE NO.	1001-020
WEIGHT	23kg

ORDER NO.	TSU-2
CODE NO.	1001-021
WEIGHT	12kg



SPECIAL ACCESSORIES

A.DIVIDING PLATES



*DP set include index plate. crank handle, 3 pcs screw, sector, & U Washer.

1 carton with 1 set. Gross weight:3.5kgs.

Meas.:0.13 CFT.

Number of the holes of Dividing Plates

ORDER NO.	WEIGHT	CODE NO.
*DP-1 for HV-4 HV-6 VU-100/150	1.4kg	1001-030

A-PLATE	15,16,17,18,19,20
B-PLATE	21,23,27,29,31,33
C-PLATE	37,39,41,43,47,49

ORDER NO.	WEIGHT	CODE NO.
*DP-2 for HV ^{HV} RT -8 VU-200	4.5kg	1001-031
DP-3 for HV ^{HV} RT -10,12,14,16	4.5kg	1001-032
DP-4 for CS-6,8	4.5kg	1001-033
DP-5 for VU-300	4.5kg	1001-034

A-PLATE	26,30,34,38,41,44,47,51,57 28,32,37,39,43,46,49,53,59
B-PLATE	61,67,71,77,81,87,91,97 63,69,73,79,83,89,93,99

B.TAILSTOCK



TS-1

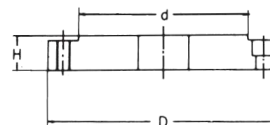
Unit:mm

ORDER NO.	adjustable highest	adjustable lowest	used of model	G.W kg	Meas. CFT	CODE NO.
TS-1	110	75	HV-4,HV-6,VSI-4 BS-0,VU-100 VU-150,VSI-5	3.9	0.4	1001-022
TS-2	145	115	BS-1,CC-6 CS-6,HV-8 VU-200	12	0.4	1001-023
TS-3	200	130	CS-8,HV-10 HV-12	13.5	0.4	1001-024
TS-4	260	190	HV-14 HV-16	20	0.7	1001-025

C.FLANGE



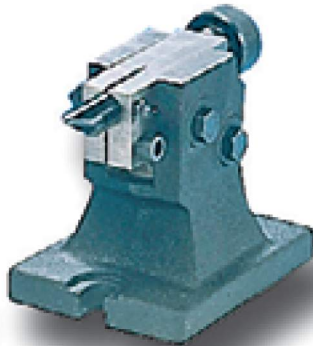
FLT-0 For VSC-5
FLT-1 For VSC-6
FLT-2 For VSC-7
FLT-3 For VSC-8



Unit:mm

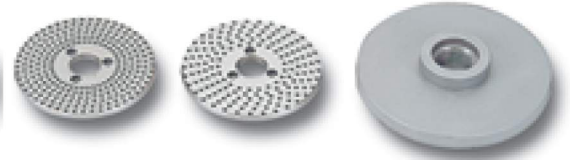
ORDER NO.	D	d	H	used of model	WEIGHT	CODE NO.
FLT-0	138	100	20	RT-HV- 6,8	1.9	1001-040
FLT-1	170	130	21	RT-HV- 8,10	3.3	1001-041
FLT-2	195	155	24	RT-HV-10,12,14	5.2	1001-042
FLT-3	210	160	24	RT-HV-12,14,16	4.9	1001-043

POLOUNIVERZÁLNA DELIACA HLAVA



ORDER NO.	WEIGHT	CODE NO.
BS-0	20kgs	1001-050
BS-1	33kgs	1001-051

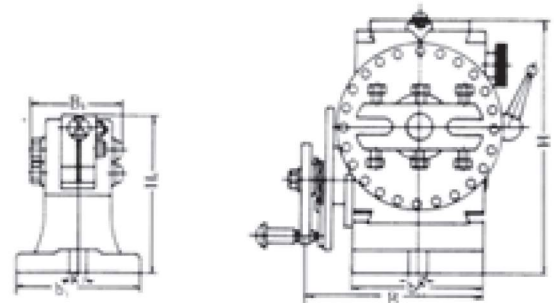
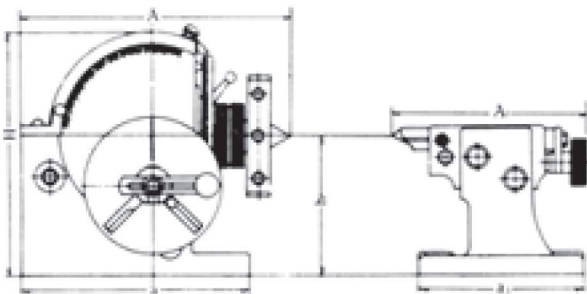
Standard Accessories



THREAD SPINDLE: BS-0. 1½ -8TPI
BS-0. 1½ -8TPI

Dividing Plate A,B,C

Numbers of hole	Plate A	15	16	17	18	19	20
	Plate B	21	23	27	29	31	33
	Plate C	37	39	41	43	47	49



Semi-Universal Index B & S Type
No.0 No.1(Head-stock):

Unit:mm/inches.

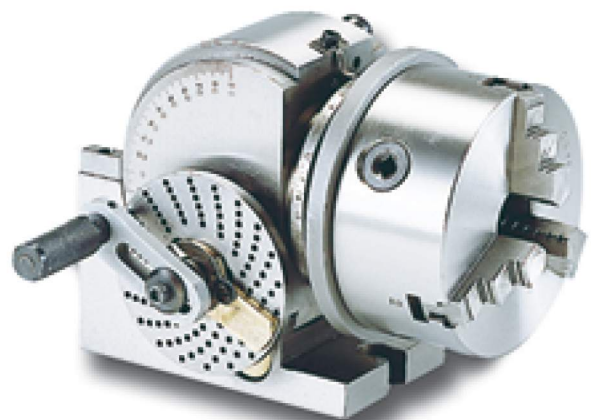
ORDER NO.	A	B	H	h	a	b	g	TAPER OF CENTER	Diameter of spindle hole
BS-0	189 7 7/16	140 5 2/4	173 6 13/16	100 3 11/16	160 6 1/4	91 3 3/4	13 33/64	MT-2	18
BS-1	293 11 7/32	156 6 3/4	220 8 2/32	128 5 3/4	207 8 5/32	114 4 3/4	16 5/8	MT-3	20

Semi-Universal Index B & S Type
No.0 No.1 (Tail-Stock):

Unit:mm/inches

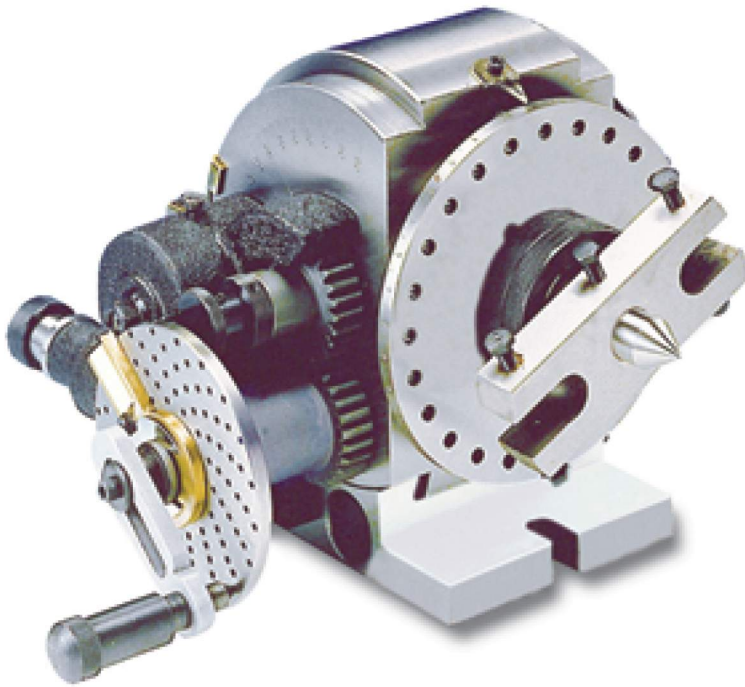
ORDER NO.	A1	B1	H1	h	a1	b1	g1
BS-0	167 6 37/34	80 3 5/32	107.5 4 19/64	100 3 19/16	130 5 1/8	92 3 2/8	13 33/64
BS-1	191 7 33/64	88 3 15/32	137 5 25/64	128 5 3/64	150 5 29/32	108 4 1/4	16 5/8

- 1.Dividing Head can divide in any angle by the direct, indirect, or different methods. The ratio between the worm and the worm gear is 40:1.
- 2.Hardened and ground spindle is rigidly held in a taper roller bearing. Worm is hardened and ground also.
- 3.The swivel head can be locked of any angle from 10° below horizontal to 90° vertical-precision fitting to base assures smooth rotation.
- 4.All models have threaded spindle nose and 24 hole dividing plate with easy conversion to fast direct indexing on numbers 2, 3, 4, 6, 8, 12, and 24.
- 5.Easy indexing of all numbers from 2 to 50 and many numbers from 52 to 380. Model BS-2 is also equipped for different indexing of all numbers from 2 to 380, and for spiral cutting.
- 6.Accurate precision, little backlash, fine appearance and strong structure so can assure smooth rotation.



The state of
BS-0 fitted with 5" 3-Jaw Chuck

UNIVERZÁLNA DELIACA HLAVA

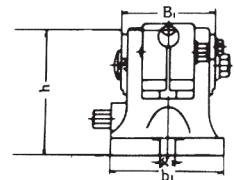
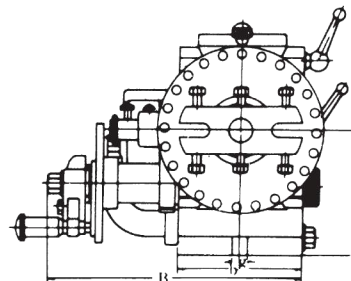
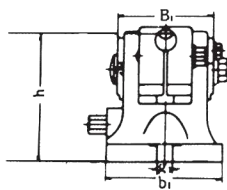
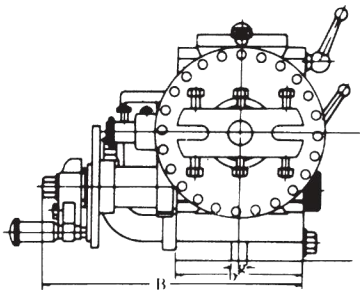


ORDER NO.	WEIGHT	CODE.NO.
BS-2	65kgs	1001-052

Standard Accessories



THREAD SPINDLE: 2 1/4"-8TPI



Universal Index B & S Type No.2 (Head-stock)

Unit:mm/inches.

ORDER NO.	A	B	H	h	a	b	g	Taper of center	Spindle hole
BS-2	365 14 13/32	272 10 45/64	236 9 13/64	132.7 5 15/64	213 5 29/64	134 5 9/32	16 5/8	MT-4	25.4 1

BS-2(Tail-stock)

Unit:mm/inches.

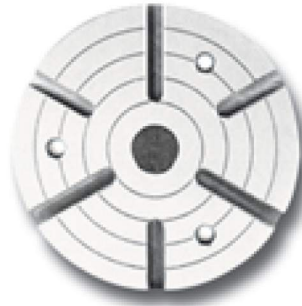
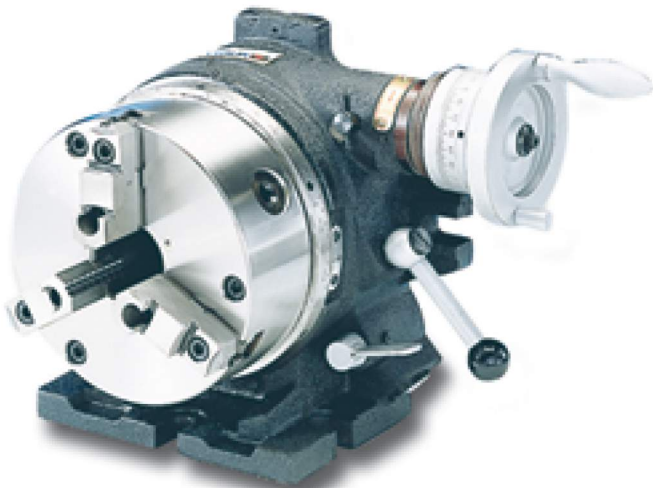
ORDER NO.	A1	B1	H1	h1	a1	b1	g1
BS-2	205~255 8 5/64 ~ 10 5/64	86 3 15/32	139 5 15/32	132.7 5 15/64	175 6 57/64	124 4 7/8	16 5/8

ORDER NO.	Gross Weight kg	Meas. CFT	Applicable Chuck
BS-0	(C)20	0.8	4" OR 5"
BS-1	(C)33	1.3	5" OR 6"
BS-2	(C)65	3.4	6" ,7" OR 8"

TEST REPORT

ITEM NO.	TESTING OBJECTIVE	VARIATION (INCHES)(MM) MAXIMUM TESTED	
1	TRUE RUNNING OF CENTER	0.0006(0.015)	
2	TRUE RUNNING OF INSIDE TAPER OF DIVIDING SPINDLE (1) MEASURED AT SPINDLE NOSE (2) MEASURED AT ARBOR 8-IN. LONG	(1)0.0004(0.01) (2)0.0012(0.03)	(1) (2)
3	AXIAL MOVEMENT OF DIVIDING SPINDLE	0.0004(0.01)	
4	DIVIDING ACCURACY OF WORM DRIVE MAXIMUM CUMULATIVE SPACING ERROR	1'30"	

Super Indexing Spacer



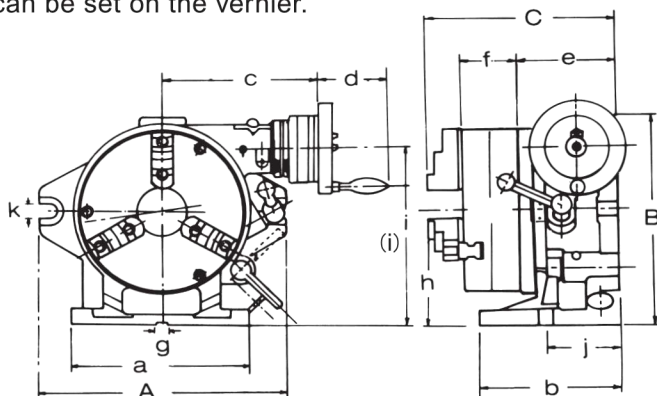
Special Accessories

The same as Rotay table
Please see page A2



CS-8 with VSK-8 3-JAW MASKING PLATE & FACE PLATE

This index combines the advantages of the Super Index with those of a worm-gear index. When mounted on a milling, boring or other machine tool it can carry out single-purpose indexing and indirect indexing using the worm-drive mechanism. Disengaging the worm drive the 24-notch master plate permits 2,3, 4,6,8,12 and 24 dividing in the same manner as the Simple Index. When the chuck is removed the unit can be used as a horizontal and vertical type rotary table. The operating handle to rotary table worm gear reduction ratio is 1:90. The operating handle collar is graduated 'in one minute, and readings down to ten seconds can be set on the vernier.



The state of CS-8 fitted with Face Plate & Dividing Plate

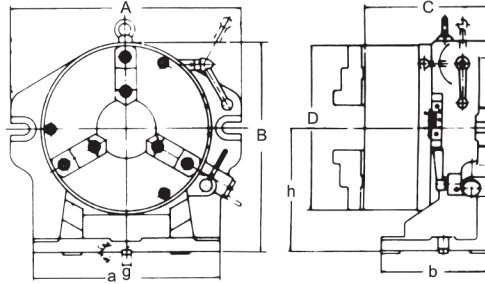
Order NO. & Dimensions

Unit:mm

ORDER NO.	Numbers of dividing	Chuck				Face plate			A	B	C	a	b	c	d	e	f	g	h	i	j	k	Gross Weight kg	Meas. CFT	CODE NO.
		Outer diameter	Inner jaw	Outer jaw	Inner dia	Outer dia	Thickness																		
CS-6	2,3,4,6	167 VSK-6	4~42	10~156	44	203	50	250	235	221	220	150	184	82	112	66	16	130	186	80	18	(W)50	1.2	1001-060	
CS-8	8,12,24	210 VSK-8	4~62	10~180	63	254	58	310	285	243	225	160	201	82	125	75	16	155	232	90	18	(W)79	3.1	1001-061	

(W)Wooden Case (C)Carton Case

Simple Indexing Spacer



Special Accessories



Order No. & Dimensions

Unit:mm

ORDER NO.	Dividual number	A	B	C	D	a	b	h	Inner jaw	Guide block g	Outer jaw	Diameter of hole(truuet)	Diameter of hole(truuet)	Gross weight kg	Meas. CFT	CODE NO.
CC-6	2. 3. 4. 6	260	218	156.2	167	220	130	130	4~42	16	10~156	44	36	(C)36	0.9	1001~062
CC-8	8. 12. 24	312	257	173.3	200	258	148	155	4~62	16	10~180	63	63	(C)51	1.3	1001~063

- 1.The center through hole is big to be suitable for the large and long workpiece.
- 2.Hardened and ground 24 position master plate, can index the special angle of 15 with excellent accuracy.
- 3.CS-Type can be used with 2 pcs type 3-Jaw Chuck. And to do similar work. as rotary table when it match with face plate.
- 4.Rapid indexing and easy operation. It's a sharp equipment for mass-production.
- 5.Super Spacer index include 3 jaw chuck, Face plate dia. 10",250mm Masking Plates 2,3,4,6,8,12.
- 6.Simple index include 3-jaw chuck, Masking Plates 2, 3, 4, 6, 8, 12
- 7.Used the key guide block, the center can be corrected both quickly and accurately.

STANDARDS OF ACCURACY for Simple Index for Super-Dex.

NO.	Testing Objective	Tolerances Unit: inches Permitted Max.
1	Parallelism of table surface to base per 12"	.0006
2	True running of axial movement of table surface	.0006
3	True running of center boss	.0004
4	Squareness of base to angle face per 12"	.0008
5	True running of chuck center	.0012
6	Dividing accuracy individual spacing error	45"

Precision 3-Jaw Scroll Chuck

•Detail specification shown on page E5.E6



- 1.Internal jaws and External Jaws may be used interchangeably.
- 2.This type of chuck is suitable for the operation of mass-production. It is durable and economical.

ORDER NO.

VSC-5 SUIT FOR BS-0 OR HV-6
 VSC-6 SUIT FOR BS-1 OR HV-8,10
 VSC-7,8 SUIT FOR BS-2 OR HV-10,12,14
 VSC-10 SUIT FOR HV-14,16

Reversible type



ORDER NO.

VSK-6 SUIT FOR CS-6 , CC-6
 VSK-8 SUIT FOR CS-8 , CC-8

For indexer, The fixing hole is from front.

- 1.This type of chuck have wide scope of applications. the hard jaws are suitable for heavy cutting. the soft jaws are suitable for light cutting they maybe used alternately.
- 2.Hard jaws may be used as both internal jaws and external jaws.

Precision Index Table



2 PCS hirth coupling

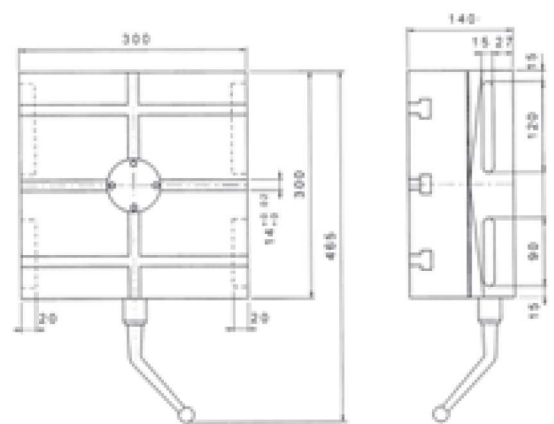
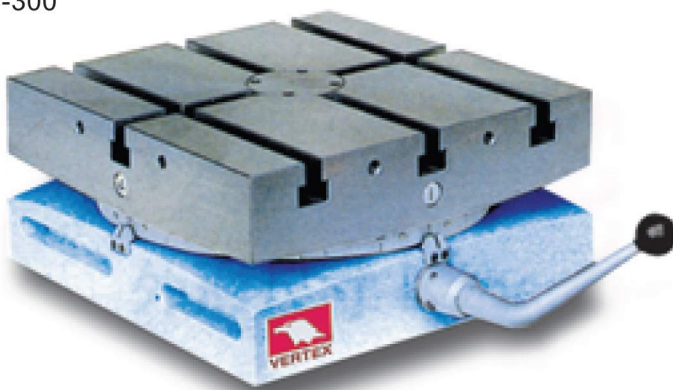
ORDER NO.	VIT-300-15	VIT-450-1	VIT-600-1	VIT-700-1	VIT-800-1	VIT-1000-1	VIT-1200-1	
		VIT-450-5	VIT-600-5	VIT-700-5	VIT-800-5	VIT-1000-5	VIT-1200-5	
Table size LxW(mm)	300x300	450x450	600x600	700x700	800x800	1000x1000	1200x1200	
Height(mm)	140	170	200	220	280	300	340	
Spindle hole(mm)	-	ø30	ø40	ø40	ø60	ø60	ø80	
T-slot(mm)	14	18	20	20	22	22	22	
Table rotating		Clockwise and counterclockwise						
Table Lifting up & Clamp down stroke(mm)	5	5	5	5	5	8	8	
Driving	Longitudinal	Manual						
	Revolving	Air Pressure 5~8kgs/cm ²						
Number of division(degree)	15°	1° or 5°						
Division(sec.)		±2						
Max.load weight in theory(kgs)	1200	2400	3400	3400	4500	6000	7000	
Allowable load weight(kgs)	500	1000	2000	2000	3000	5000	6000	
Clamping capacity(kgs)	-	2200	3200	3200	5400	5400	8100	
N.W.(kgs)	90	200	400	600	900	1200	2000	
CODE NO.	1°	1001-070(15)	1001-071	1001-072	1001-073	1001-074	1001-075	1001-076
CODE NO.	5°		1001-081	1001-082	1001-083	1001-084	1001-085	1001-086

- 1.The body is FC-35 cast iron, durable and will last longer without deformation.
- 2.Clamping/Unclamping by pneumatic, easy operation.
- 3.Powerful clamping design, allow heavy cutting and boring.

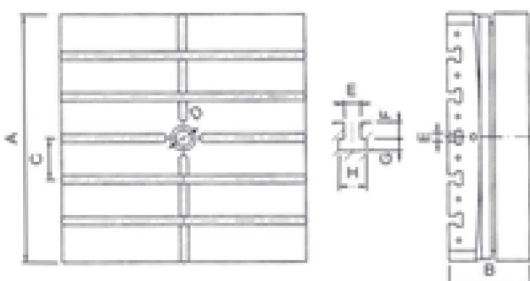
- 4.Build-in 2 pieces hirth coupling for positioning, indexing accuracy +/-3 sec, ensure a long-term operation.
- 5.Suitable for the high accuracy machining such as Boring-Milling, Grinding-Machine.

DIMENSION

VIT-300



VIT-450~1200



	VIT-450	VIT-600	VIT-700	VIT-800	VIT-1000	VIT-1200
A	450	600	700	800	1000	1200
B	170	200	220	280	300	340
C	100	100	125	100	150	200
D	30	40	40	60	60	80
E	18	20	20	22	22	22
F	16	20	20	23	23	23
G	12	14	14	15	15	15
H	28	35	35	38	38	38

Mini Rotary Table

ORDER NO. HV-4 CODE NO. 1001-000



OPTIONAL: 1.TAILSTOCK

ORDER NO.	TS-1
CODE NO.	1001-022



2.DIVIDING PLATE: DP-1

ORDER NO.	CODE NO.
*DP-1 for HV-4.6	1001-030



* DP set include index plate. crank handle, 3 pcs screw, sector, & U Washer.

1 carton with 1 set. Gross weight: 3.5kgs.

Meas.:0.13 CFT.

Number of the holes of Dividing Plates

A-PLATE	15,16,17,18,19,20
B-PLATE	21,23,27,29,31,33
C-PLATE	37,39,41,43,47,49

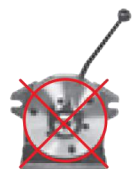
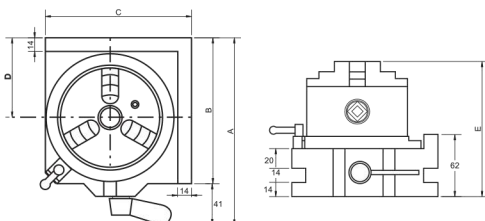
1. HORIZONTAL / VERTICAL TYPE
2. TABLE DIA.Ø110m/m. TABLE HEIGHT 26m/m.
3. CENTER BORE MT-2. SLOT ON TABLE 3 NOS.
4. CENTER HEIGHT 80m/m
5. BASE SIZE 145 x 130 x 80m/m
6. WORM IS HARDENED AND GROUND.
THE GEAR RATIO IS 90:1. THE WORK TABLE IS GRADUATED A FULL 360° SO THAT OF THE HANDLE MOVES THE TABLE THROUGH 4°. MICRO COLLAR IS GRADUATED IN STEPS OF 2' MIN.
7. G.W. 7.5KGS
8. CFT. 0.3CUFT

Economical Type Rapid Index



1. 3 JAW CHUCK VSC-4C, FOR VSI-4 / VSC-5C FOR VSI-5, THE BIG RANGE CLAMPING CAPACITY Ø3 – Ø100, IT'S BETTER THAN COLLET FIXING TYPE.
2. SIMPLE & RAPID OPERATION.
3. DIVIDUAL NUMBER 24-NOTCH (15° EACH)
4. TABLE SCALE 1°, FOR ANGULAR INDEXING.
5. TABLE BORE 30m/m.
6. HORIZONTAL / VERTICAL & 2 DIRECTION
7. SUIT FOR MILLING & DRILLING MACHINE USING.
8. OPTIONAL:TAILSTOCK TS-1, PLEASE SEE PAGE A2

(5C COLLET INDEXER
NON ECONOMICAL)



ORDER NO.	A	B	C	D	E	kgs	CODE NO.
VSI-4	187	146	146	80	135	10	1001-064
VSI-5	202	161	161	87	142	14	1001-065

UNIVERZÁLNY NAKLÁPACÍ OTOČNÝ STOL

NEW



- Tilting range 0-90 degrees from horizontal to vertical position, It is high rigidity.
- Minimum Set-up time has two screws to lock setting. Low profile body for bigger capability.
- Worm is hardened and ground. The ratio is 90:1. The work table is graduated a full 360° so that of the handle moves the table through 4°. Micro collar is graduated in steps of 2' min.
- The tailstock & Dividing plates are optional. The sizes is same as the rotary table, please see page A2.
- For arc or index cutting at milling machine, Grinding machine or drill Machine.....

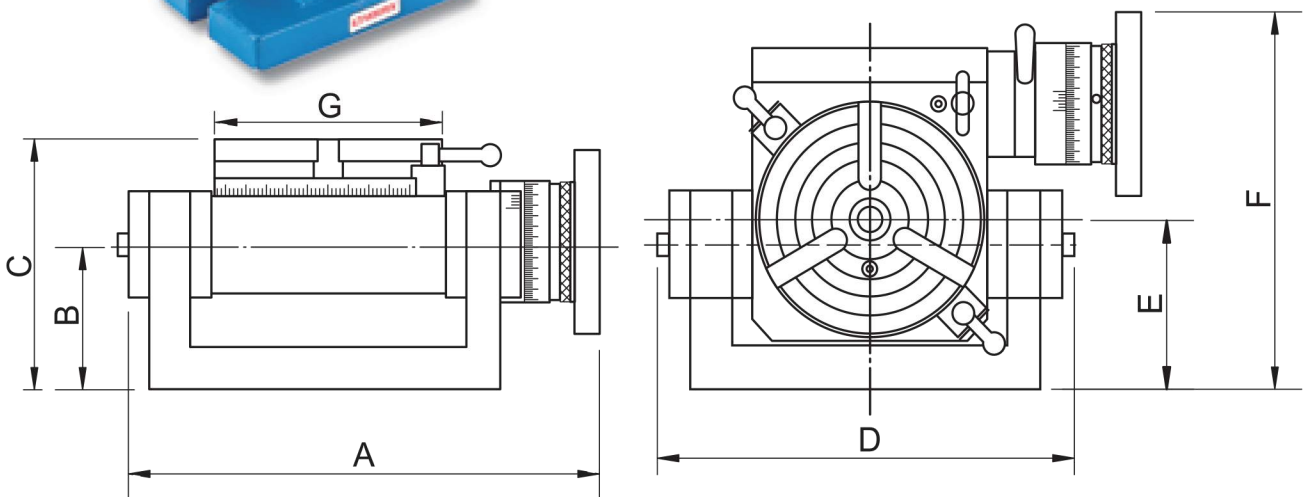
OPTIONAL: 1.TAILSTOCK

ORDER NO.	TS-1
CODE NO.	1001-022



2.DIVIDING PLATE: DP-1

ORDER NO.	CODE NO.
*DP-1 for VU-100, 150	1001-030
*DP-2 for VU-200	1001-031



ORDER NO.	A	B	C	D	E	F	G	SUITFUL TAILSTOCK	SUITFUL DIVIDING PLATE	WEIGHT kgs/cuft	CODE NO.
VU-100	228	68	117	202	80	177	100	TS-1	DP-1	13.5kgs/1.5	1001-011
VU-150	266	75	140	246	90	216	150	TS-1	DP-1	21kgs/2.0	1001-012
VU-200	322	85	165	294	100	276	200	TS-2	DP-2	50kgs/2.5	1001-013