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Set up instruction for the Stallion Trunnion Table.

Before placing Trunnion on your machine table, the rotary table must be indicated in Y & Z as close to "0" as possible. MOST tables will need a shim under the front or back in order to get the rotary straight up and down in Z. **Z is EXTREMELY CRITICAL** for the proper performance of the Trunnion Table

1. Using two people lift unit onto machine.
2. Place a 1 x 2 under unit to help support
3. Slide unit to face of rotary and lineup straight (visually is fine)
4. Gently slide nub of trunnion into faceplate hole of rotary (do not force as there is only .001 clearance between rotary and plug)
5. Once faceplate of trunnion is touching faceplate of rotary, tighten the faceplate to the rotary using t-nuts and 3/8-16 cap screws. Snug outboard support to table (do not tighten all the way yet).
6. Rotate trunnion using the hand wheel of machine until it is flat in the Y plane by setting a level on trunnion. Remove level and indicate until it is a minimum of .001 total indicator readout in the Y plane. SET THIS IN THE CONTROL AS A0
7. Now rotate to + or -90 degrees and indicate straight in the X axis just as you would a vice. NOTE: At this point you may have to bump the outboard support a little bit to indicate straight. Once straight, tighten down.
8. Move indicator out of the way.
9. Program in MDI: G0 G90 A0
10. Double check the Y axis to be sure it is at 0 degrees.

Any questions please let us know.

Thank You for your order,

Stan Martin

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