





**SPECIFICATIONS:**

| MODEL   | 710-150  | 710-002        | 710-102(S) | 710-004      | 710-104    | 710-230 (S)    | 710-300(S)     |
|---|--|----------------|------------|--------------|------------|----------------|----------------|
| TABLE DIA.  | 6.69<br>(170)  | 8.26<br>(210)  |            |              |            | 9.06<br>(230)  | 12.20<br>(310) |
| ANGLE INDEX BY ONE FULL STROKE                    | 45°  | 15°            |            | 90°          |            | 45°            | 45°            |
| TOTAL INDEX CYLINDER STROKE                       | 1.50<br>(38)   | 1.37<br>(35)   |            | 3.07<br>(78) |            | 2.20<br>(56)   | 2.95<br>(75)   |
| FORCE REQ'D. FOR CYLINDER STROKE Lbs (Kg)         | 66<br>(30)   | 132<br>(60)    |            | 176<br>(80)  |            | 88<br>(40)     | 242<br>(110)   |
| SPINDLE BRAKING FORCE                             | One Ton  |                |            |              |            | 1.5 Ton        | One Ton        |
| SPINDLE THRU HOLE                                 | 1.45<br>(37)   | 0.64<br>(16.5) |            |              |            | 2.28<br>(58)   | 2.04<br>(52)   |
| SETTING POSITION                                  | Horiz/Vert   | Horiz/Vert     | Vert       | Horiz/Vert   | Vert       | Horiz/Vert     | Vert           |
| CENTER HEIGHT                                     | 4.72<br>(120)  | 5.31<br>(135)  |            |              |            | 5.71<br>(1.45) | 7.28<br>(185)  |
| TABLE CENTER HOLE RUNOUT                          | 0.0004 (0.01) MAX  |                |            |              |            |                |                |
| TABLE SURFACE RUNOUT                              | 0.0004 (0.01) MAX  |                |            |              |            |                |                |
| SQUARENESS  | 0.001 (0.03) MAX   |                |            |              |            |                |                |
| INDEXING ACCURACY                                 | +/- 30 SECONDS   |                |            |              |            | +/- 15 SEC     | +/- 30 SEC     |
| INDEXING SPEED (for full stroke move*)            | APPROXIMATELY ONE SECOND MACHINE SPINDLE SPEED 200 Inch/Minute<br>(5,000mm/Minute) MAX |                |            |              |            |                |                |
| LOAD TOLERANCE (out of balance) Lbs (Kg)          | 18<br>(8)  |                |            |              |            | 15.4<br>(7)    | 18<br>(8)      |
| MAX WORK LOAD CAPACITY (Vert. position) Lbs (Kg)  | 100<br>(45)  | 200<br>(91)    |            |              |            | 200<br>(91)    | 400<br>(182)   |
| MAX WORK LOAD CAPACITY (Horiz. position) Lbs (Kg) | 200<br>(91)  | 400<br>(182)   |            |              |            | 400<br>(182)   | 800<br>(363)   |
| NET WEIGHT Lbs (Kg)                               | 66<br>(30)   | 92<br>(42)     | 81<br>(37) | 95<br>(43)   | 84<br>(38) | 92<br>(42)     | 176<br>(80)    |

**\*Note:** If the workload is more than 18lbs. (8Kg) "out of balance" then it may be necessary to either reduce the machine spindle speed in depressing the index cylinder, or use a counterweight to balance the load. Counterweight kits available from stock.



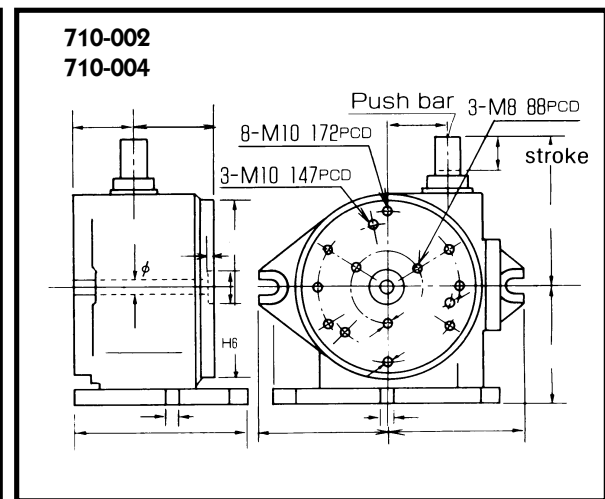
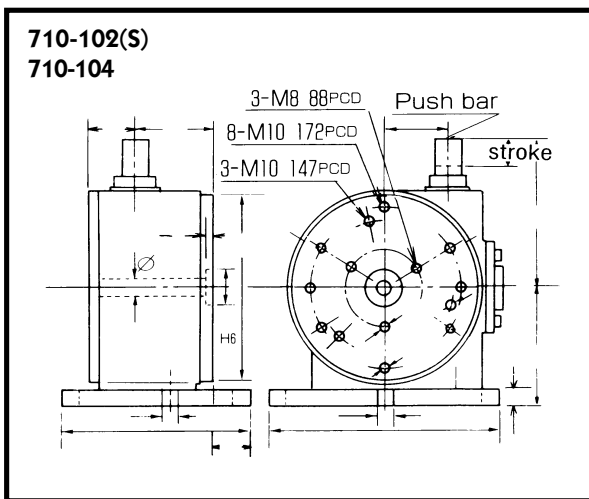
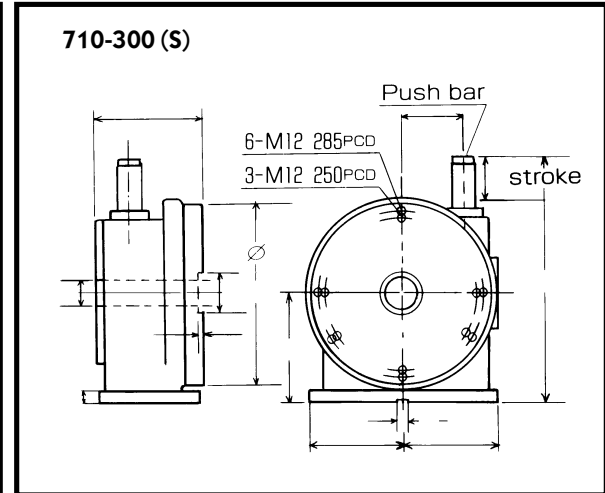
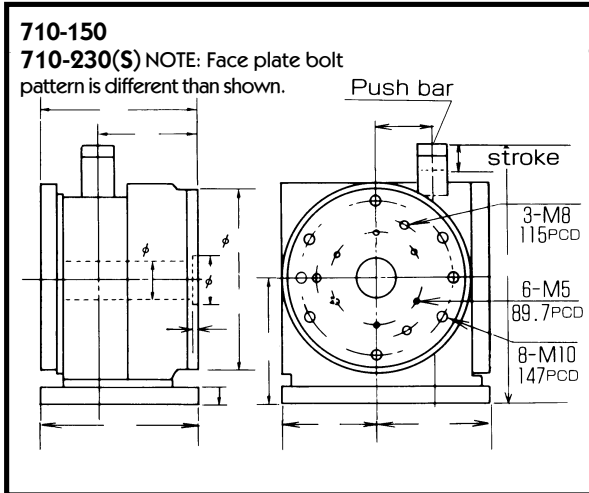
CNC ROTARY PRODUCTS

**SUPER RAPIDEX ACCESSORY CHART**

| MODEL                              | 710-150 | 710-002   | 710-102(S) | 710-004 | 710-104 | 710-230(S) | 710-300(S)     |
|------------------------------------|---------|---|------------|---------|---------|------------|----------------|
| TAILSTOCK (Manual) ADJUSTABLE      | 553-300 | 553-301   |            |         |         | 553-301    | 553-311        |
| 3 JAW LATHE CHUCK                  | 580-106 | 580-106 (direct mount) 585-108 (requires 710-108 adapter plate) |            |         |         | 580-108    | 580-110 or 112 |
| 3 JAW AIR OPERATED CHUCK           | 583-006 | 583-006 (direct mount) 583-008 (requires 710-108 adapter plate) |            |         |         | 583-008    | 583-010 or 012 |
| 5C AIR COLLET CLOSER AND DRAW TUBE | 710-110 | N/A   |            |         |         |            |                |
| 6" (152mm) SPECIAL CUBE FIXTURE    | N/A     | 710-109   |            |         |         |            | N/A            |

Note: For dimensional information on the accessories listed above, see our WORKHOLDING section.

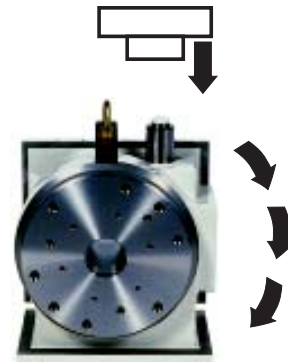
Note: Some other Workholding section accessories may be able to be adapted to the Super Rapidex's, call for more information.



Inch/(mm)

| MODEL   | A               | B              | C               | D              | E              | F            | G            | H             | I             | J             | K             | L                | M             | N              | O            | P              | Q             |
|---------|-----------------|----------------|-----------------|----------------|----------------|--------------|--------------|---------------|---------------|---------------|---------------|------------------|---------------|----------------|--------------|----------------|---------------|
| 710-150 | 5.94<br>(151)   | 3.74<br>(95)   | 5.94<br>(151)   | 6.69<br>(170)  | 1.46<br>(37)   | 1.57<br>(40) | 0.67<br>(17) | 4.72<br>(120) | 0.24<br>(6.2) | 3.58<br>(91)  | 4.29<br>(109) | 9.72<br>(247)    | 2.16<br>(55)  | N/A            | N/A          | N/A            | N/A           |
| 710-002 | N/A             | 3.86<br>(98)   | 8.03<br>(204)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | N/A          | 5.31<br>(135) | 0.24<br>(6.2) | 5.91<br>(150) | 6.30<br>(160) | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 2.72<br>(69) | N/A            | 6.38<br>(162) |
| 710-102 | N/A             | 3.86<br>(98)   | 8.46<br>(215)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | 0.79<br>(20) | 5.31<br>(135) | 0.24<br>(6.2) | N/A           | N/A           | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 1.93<br>(49) | 10.24<br>(260) | 6.38<br>(162) |
| 710-004 | N/A             | 3.86<br>(98)   | 8.03<br>(204)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | N/A          | 5.31<br>(135) | 0.24<br>(6.2) | 5.91<br>(150) | 6.30<br>(160) | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 2.72<br>(69) | N/A            | 8.19<br>(208) |
| 710-104 | N/A             | 3.86<br>(98)   | 8.46<br>(215)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | 0.79<br>(20) | 5.31<br>(135) | 0.24<br>(6.2) | N/A           | N/A           | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 1.93<br>(49) | 10.24<br>(260) | 8.19<br>(208) |
| 710-230 | 6.56<br>(166.5) | 4.0<br>(101.5) | 6.28<br>(159.5) | 9.06<br>(230)  | 2.28<br>(58)   | 2.76<br>(70) | 0.79<br>(20) | 5.71<br>(145) | 0.24<br>(6)   | 5.12<br>(130) | 5.12<br>(130) | 13.48<br>(342.5) | 2.76<br>(70)  | N/A            | N/A          | N/A            | N/A           |
| 710-300 | 6.97<br>(177)   | N/A            | N/A             | 12.20<br>(310) | 2.05<br>(52)   | 2.76<br>(70) | 0.79<br>(20) | 7.28<br>(185) | 0.24<br>(6.2) | 6.30<br>(160) | 6.46<br>(164) | 16.46<br>(418)   | 4.21<br>(107) | 0.71<br>(18)   | N/A          | N/A            | N/A           |

| MODEL   | R            | S            | T              |
|---------|--------------|--------------|----------------|
| 710-150 | N/A          | 1.50<br>(38) | N/A            |
| 710-002 | N/A          | 1.38<br>(35) | 0.65<br>(16.5) |
| 710-102 | 1.46<br>(37) | 1.38<br>(35) | 0.65<br>(16.5) |
| 710-004 | N/A          | 3.07<br>(78) | 0.65<br>(16.5) |
| 710-104 | 1.46<br>(37) | 3.07<br>(78) | 0.65<br>(16.5) |
| 710-230 | N/A          | 2.20<br>(56) | N/A            |
| 710-300 | N/A          | 2.95<br>(75) | N/A            |



*This illustration represents a machine spindle being used to depress the index cylinder of the Super Rapidex creating an index movement.*

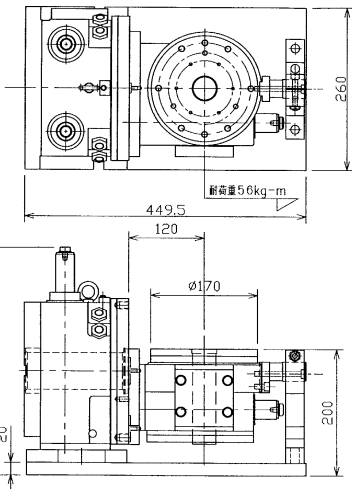
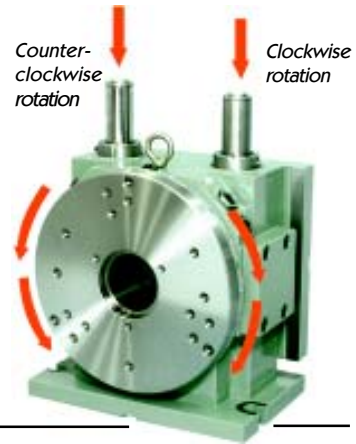
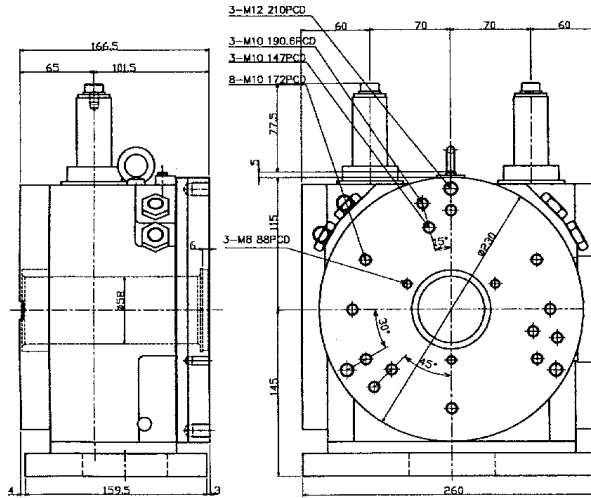
# SUPER RAPIDEX



710-230CS

## FEATURES:

- ▶ Dual index cylinder offers clockwise and counter-clockwise rotation.
- ▶ No problem for off-center loads; no imbalance difficulties
- ▶ Multiples of 5° indexing with a full index cylinder stroke of 45°
- ▶ 1.5 ton braking torque by the dual positive locking mechanism
- ▶ Table diameter is 230mm (9.06")
- ▶ Large thru hole of 56mm (2.20")
- ▶ Setting position is horizontal or vertical
- ▶ Total weight: 105 lb (48Kg)



## 710-230CST

- ▶ The perfect tilting/rotary table featuring movement for the bi-directional tilt positioning
- ▶ The entire unit is mounted to a steel base mounting plate and includes a rigid end support
- ▶ Table surface is 170mm (6.69")

## OTHER MODELS



# VISEDEX



## COMPLETE CHUCK/VICE & FLAT PLATE INDEXING SYSTEM FOR USE WITH MACHINING CENTERS

### FEATURES:

#### THREE FACE MACHINING IN A SINGLE SETUP

Once the workpiece is set, three faces may be machined

#### INDEXING

5°~90° (710-164, 201); 5°~45° (710-301). VISEDEX indexes by 90° each time the index cylinder is fully depressed (710-164, 201) 45° (710-301). Minimum index movement is 5°.

#### EASY INDEXING

VISEDEX can rotate just by depressing the index cylinder. No hydraulic or electric system is required.

#### HIGH PRECISION

The clearance between workpieces is maintained because the jaw plates are set and the soft-jaws are machined to fit the workpiece shape (preventing the workpiece from lifting up.)

#### CAN HOLD WORKPIECES OF VARIOUS SIZES

4 dish-shaped workpieces up to a max of Ø 4.96" (126mm) or 4 square-shaped workpieces up to a max of 3.94" x 3.94" (100mm x 100mm)(with the required fixed jaw (KY-16)) can be set at one time.

#### PROCESS THIN AND IRREGULARLY SHAPED WORK-PIECES

Thin and irregularly shaped workpieces can be machined by gripping with formed soft-jaws, (SJ-70.)

#### COST EFFECTIVE

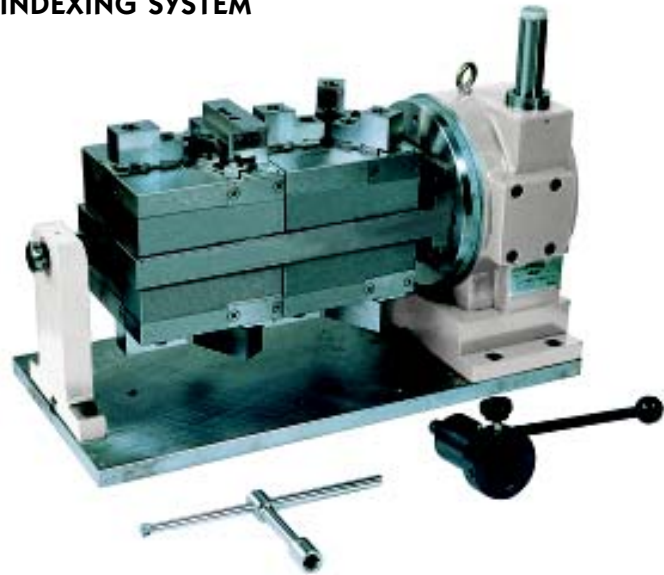
Enables simultaneous machining of multiple workpieces. Two or three faces of each workpiece can be machined in one setup maximizing the machining center's processing time.

#### RIGIDITY

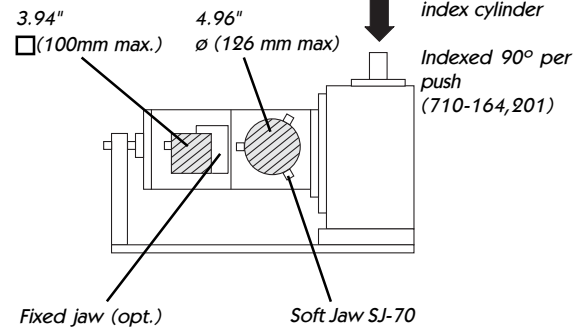
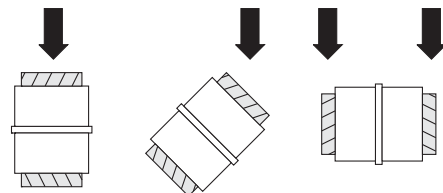
One ton of indexer spindle clamping force enables high-speed cutting, even when hard or exotic materials are machined.

#### PALLET CHANGERS

Great for use with manual or automatic pallet changers.



Machining      Machining      Machining



4 ea. Y-160 machining chucks  
page #74, used for 710-164



710-104 (Super Rapidex, pg. #39,  
used for 710-164, 201)



710-300 (Super Rapidex, pg. #40,  
used for 710-301)

**NOTE: All units include sub-plate & end support.**

CNC ROTARY PRODUCTS





## VISEDEX 710-164

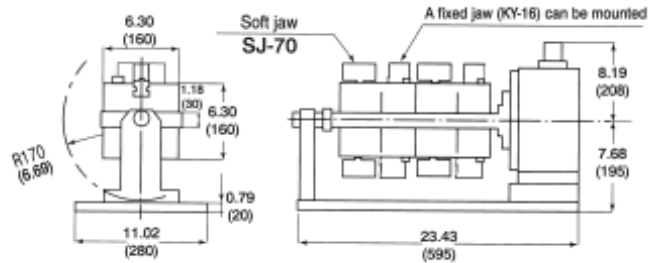
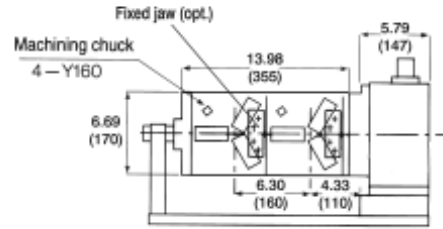
Equipped with:

- ▶ Y-160 machining chucks (4 pcs.)
- ▶ T-handle for machining chuck
- ▶ Handle for manual indexing
- ▶ Sub-plate & bearing end support



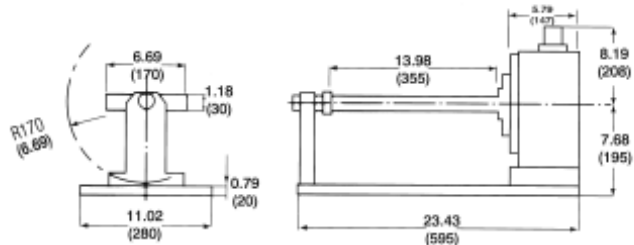
710-164

Inch/(mm)



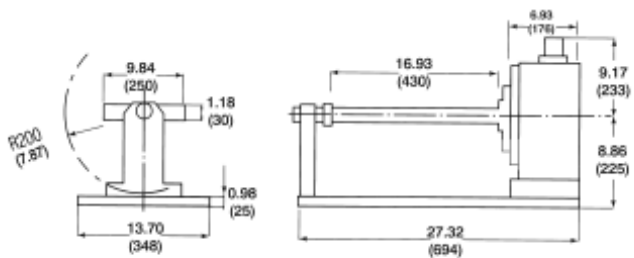
710-201

90° indexing when the index cylinder is pressed once.



710-301

45° indexing when the index cylinder is pressed once.



## VISEDEX 710-201 & 710-301

Chuckless type

- ▶ Includes flat fixturing plate
- ▶ Handle for manual indexing (included)



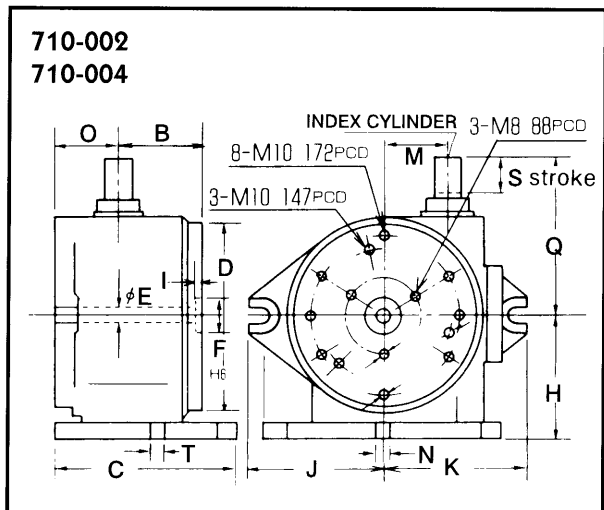
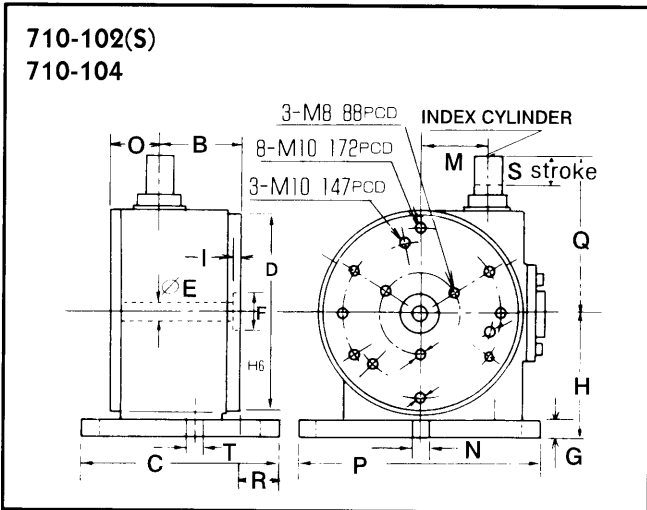
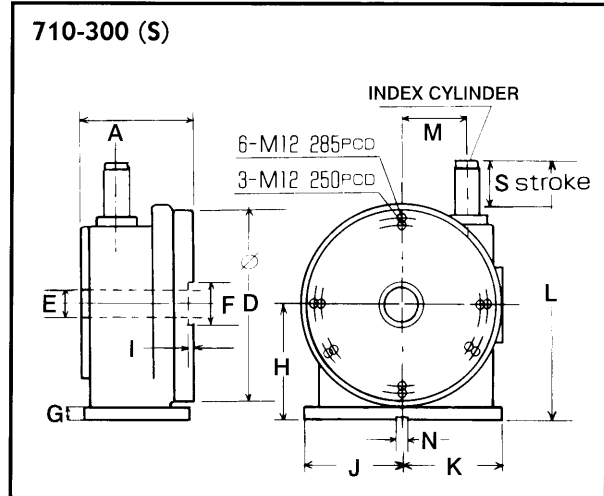
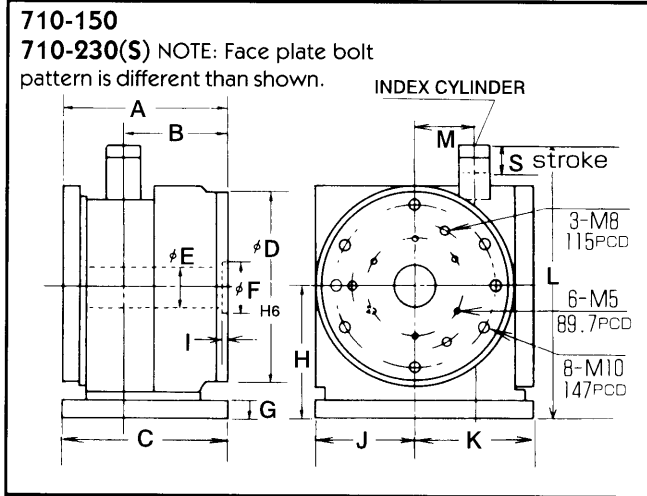
### Accuracy:

- ▶ Table center-hole runout . . . . . 0.0004 (0.01)
- ▶ Table surface runout . . . . . 0.0004 (0.01)  
(Measured 0.59 (15mm) inside the table perimeter)
- ▶ Table surface squareness . . . . . 0.001 (0.03)
- ▶ Indexing accuracy . . . . . ±30 seconds
- ▶ Deformation under load . . . . . .002 (0.06)  
(Measured at outside edge with 440lb. load)

NOTE: End supports may be purchased separately



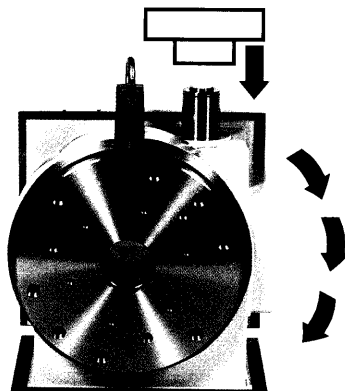
710-224



Inch/(mm)

| MODEL   | A               | B              | C               | D              | E              | F            | G            | H             | I             | J             | K             | L                | M             | N              | O            | P              | Q             |
|---------|-----------------|----------------|-----------------|----------------|----------------|--------------|--------------|---------------|---------------|---------------|---------------|------------------|---------------|----------------|--------------|----------------|---------------|
| 710-150 | 5.94<br>(151)   | 3.74<br>(95)   | 5.94<br>(151)   | 6.69<br>(170)  | 1.46<br>(37)   | 1.57<br>(40) | 0.67<br>(17) | 4.72<br>(120) | 0.24<br>(6.2) | 3.58<br>(91)  | 4.29<br>(109) | 9.72<br>(247)    | 2.16<br>(55)  | N/A            | N/A          | N/A            | N/A           |
| 710-002 | N/A             | 3.86<br>(98)   | 8.03<br>(204)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | N/A          | 5.31<br>(135) | 0.24<br>(6.2) | 5.91<br>(150) | 6.30<br>(160) | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 2.72<br>(69) | N/A            | 6.38<br>(162) |
| 710-102 | N/A             | 3.86<br>(98)   | 8.46<br>(215)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | 0.79<br>(20) | 5.31<br>(135) | 0.24<br>(6.2) | N/A           | N/A           | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 1.93<br>(49) | 10.24<br>(260) | 6.38<br>(162) |
| 710-004 | N/A             | 3.86<br>(98)   | 8.03<br>(204)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | N/A          | 5.31<br>(135) | 0.24<br>(6.2) | 5.91<br>(150) | 6.30<br>(160) | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 2.72<br>(69) | N/A            | 8.19<br>(208) |
| 710-104 | N/A             | 3.86<br>(98)   | 8.46<br>(215)   | 8.27<br>(210)  | 0.65<br>(16.5) | 1.57<br>(40) | 0.79<br>(20) | 5.31<br>(135) | 0.24<br>(6.2) | N/A           | N/A           | N/A              | 2.76<br>(70)  | 0.65<br>(16.5) | 1.93<br>(49) | 10.24<br>(260) | 8.19<br>(208) |
| 710-230 | 6.56<br>(166.5) | 4.0<br>(101.5) | 6.28<br>(159.5) | 9.06<br>(230)  | 2.28<br>(58)   | 2.76<br>(70) | 0.79<br>(20) | 5.71<br>(145) | 0.24<br>(6)   | 5.12<br>(130) | 5.12<br>(130) | 13.48<br>(342.5) | 2.76<br>(70)  | N/A            | N/A          | N/A            | N/A           |
| 710-300 | 6.97<br>(177)   | N/A            | N/A             | 12.20<br>(310) | 2.05<br>(52)   | 2.76<br>(70) | 0.79<br>(20) | 7.28<br>(185) | 0.24<br>(6.2) | 6.30<br>(160) | 6.46<br>(164) | 16.46<br>(418)   | 4.21<br>(107) | 0.71<br>(18)   | N/A          | N/A            | N/A           |

| MODEL   | R            | S            | T              |
|---------|--------------|--------------|----------------|
| 710-150 | N/A          | 1.50<br>(38) | N/A            |
| 710-002 | N/A          | 1.38<br>(35) | 0.65<br>(16.5) |
| 710-102 | 1.46<br>(37) | 1.38<br>(35) | 0.65<br>(16.5) |
| 710-004 | N/A          | 3.07<br>(78) | 0.65<br>(16.5) |
| 710-104 | 1.46<br>(37) | 3.07<br>(78) | 0.65<br>(16.5) |
| 710-230 | N/A          | 2.20<br>(56) | N/A            |
| 710-300 | N/A          | 2.95<br>(75) | N/A            |



*This illustration represents a machine spindle being used to depress the index cylinder of the Super Rapidex creating an index movement.*