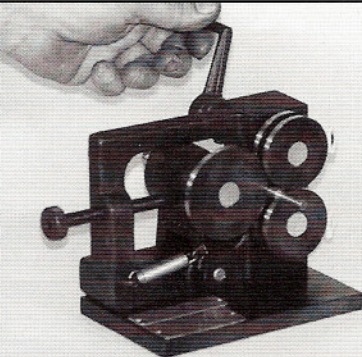
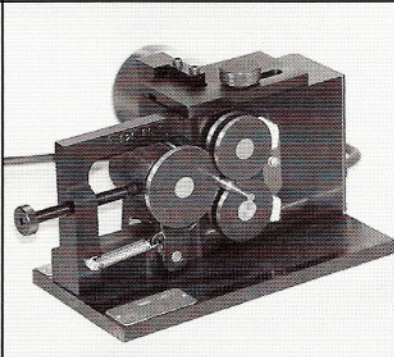
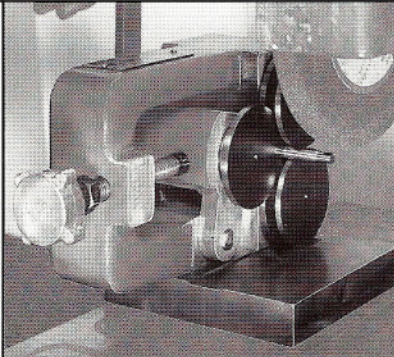


Model	525-M	525-P	500-M
Features	<ul style="list-style-type: none"> Assured concentricity .0005 Manual driven Quick, easy, and accurate loading Constant torque handle optional Compact and lightweight 	<ul style="list-style-type: none"> Assured concentricity .0005 Power driven/enclosed motor Quick, easy, and accurate loading Constant torque handle optional Compact and lightweight Optional extended stop for lengths up to 20" 	<ul style="list-style-type: none"> Assured concentricity .0002 Manual driven Quick, easy, and accurate loading Constant torque handle standard Compact and lightweight
Description	<p>The original and basic Spin Roll. Simply mount this compact, portable, lightweight workholder on a suitable machine, insert the workpiece between the three intermeshing contact rolls and against the adjustable end stop. Tighten the clamping knob (no additional clamping, fitting or adjusting is necessary). Turn the hand crank (on the shaft of one contact roll). All rolls revolve and rotate the piece on its own circumference, achieving precise concentricity while maintaining linear position. All set for easy, efficient, accurate grinding or other machining. Workpieces remove easily, Spin Roll assures exact duplication on multiple runs.</p>	<p>Identical to Model 525 but equipped with a 1/8 HP electric motor and gear reducer which produces 193 RPM on a direct drive output shaft. Greater versatility has been incorporated with an optional 20" adjustable, extended stop.</p>	<p>The 500-M automatically centers diameters and assures concentricity, linear positioning and precise duplication for any number of workpieces. Just mount the Model 500-M on the magnetic chuck of a surface grinder, adjust the finger stop to shank diameter and length of workpiece and proceed with grinding operation.</p>
Specifications			
Overall Dimensions (inches)	6 1/8 long x 4 1/2 high x 4 wide	9 1/2 long x 6 high x 10 wide	11 long x 6 1/2 high x 7 wide
Workpiece Capacities:			
Diameter (inches)	1/64 to 1 1/4	1/64 to 1 1/4	1/64 to 1 1/4
Length (inches)	*5/8 to 5 standard	*5/8 to 5 standard	*5/8 to 5 standard
Power	NA	1/8 HP (motor equipped with gear reducer producing 193 RPM on direct output shaft)	NA
Bearings	3 Permanently Sealed and Lubricated	3 Permanently Sealed and Lubricated	12 Permanently Sealed and Lubricated
Clamping	Single Clamping Knob	Single Clamping Knob	Adjustable Torque Handle
Weight (approx. lbs.)	9 lbs	24 lbs	19 lbs
Options	*Special roll widths available Optional torque handle	*Special roll widths available Optional torque handle Extended stop bracket for workpiece lengths up to 20"	*Special roll widths available
<p><i>In accordance with our established policy of constant product improvement, the specifications and dimensions contained herein are subject to change without notice.</i></p>			

500-PT

500-VP

500-D

- Assured concentricity .0002
- Power driven/enclosed motor
- Quick, easy, and accurate loading
- Constant torque handle standard
- Lubricated air clamp optional
- Compact and lightweight

- Assured concentricity .0002
- Power driven variable speed/enclosed motor
- Quick, easy, and accurate loading
- Constant torque handle standard
- Lubricated air clamp optional
- Lower silhouette

- Assured concentricity .0002
- Power driven variable speed/enclosed motor
- Quick, easy and accurate loading
- Lubricated air clamp standard
- Spin Roll has 2 interlock rolls parallel to base for use on cylindrical grinders. O.D., I.D., or cutter grinder
- Base furnished to fit requirements of your machine

Power driven by a 1/8 HP motor, this Spin Roll model can be used as an accessory or a self-contained bench unit.

Now, even machine shops with minor capacity rotary operations cannot afford to be without this time, work and money-saver.

Also available with special mounting platens for other machine tools.

Similar to the Model 500-PT Spin Roll but with these additional, special features:

- variable speed control with a rheostat which permits selection of constant torque speeds between 0 and 200 RPM;
- a lower silhouette (only 7 inches high), allowing for better work observation

This special Spin Roll model incorporates all the features of Model 500-VP but is provided with sturdy, solid cast base plates and structural components made to accommodate the particular dimensions of your machine and production requirements. (Data sheets supplied for specifications and approval)

12 long x 10¹/₂ high x 8 wide

1/64 to 1¹/₄
*5/8 to 5 standard

1/8 HP, 110V

12 Permanently Sealed and Lubricated

Adjustable Torque Handle

28 lbs

*Special roll widths available
Lubricated Air Clamp

22 long x 7 high x 9 ³/₄ wide

1/64 to 1¹/₄
*5/8 to 5 standard

1/8 HP, (0 to 200 RPM)

12 Permanently Sealed and Lubricated

Adjustable Torque Handle

45 lbs

*Special roll widths available
Lubricated Air Clamp

variable to requirements

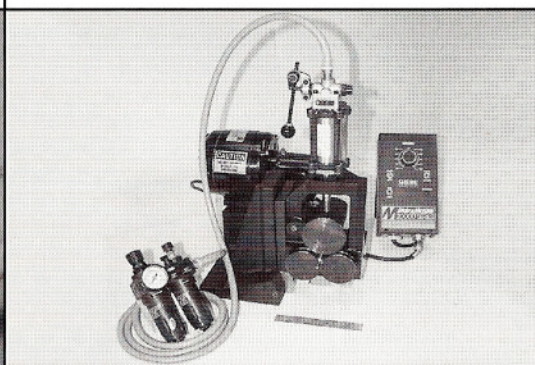
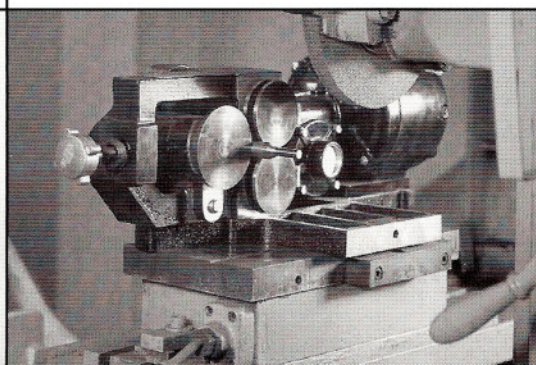
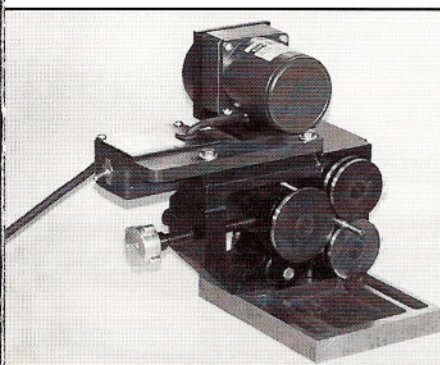
1/64 to 1¹/₄
*5/8 to 5 standard

1/8 HP , (0 to 200 RPM)

12 Permanently Sealed and Lubricated

Air Cylinder Closure including Lubricator-Filter and Gage with 8' Air Hose
50 lbs

*Special roll widths available



530-M

- Assured concentricity .0002
- Manual driven
- Quick, easy, and accurate loading
- Constant torque handle standard
- Compact and lightweight
- Ideal for rotating larger diameters

Having the same advantages offered by Model 500-M, the Model 530-M will accommodate workpiece diameters from 1 1/4" to 3".

13 long x 7 high x 9 3/4 wide

1 1/4 to 3
*5/8 to 5 standard

NA

12 Permanently Sealed and Lubricated

Adjustable Torque Handle

22 lbs

*Special roll widths available

530-PT

- Assured concentricity .0002
- Power driven/enclosed motor
- Quick, easy, and accurate loading
- Constant torque handle standard
- Lubricated air clamp optional
- Compact and lightweight
- Ideal for rotating larger diameters

This model is identical in performance to the manual Model 530-M but is powered by its own self-contained motor.

13 long x 11 high x 9 3/4 wide

1 1/4 to 3
*5/8 to 5 standard

1/8 HP, 110V (motor & gear box which produces 193 RPM on direct drive output shaft)

12 Permanently Sealed and Lubricated

Adjustable Torque Handle

30 lbs

*Special roll widths available
Lubricated Air Clamp

530-VP

- Assured concentricity .0002
- Power driven variable speed/enclosed motor
- Quick, easy, and accurate loading
- Constant torque handle standard
- Lubricated air clamp optional
- Lower silhouette
- Ideal for rotating larger diameters

This model is similar to the 530-PT but with a variable speed control with a rheostat which permits selection of constant torque speeds between 0 and 200 RPM.

24 long x 7 high x 9 3/4 wide

1 1/4 to 3
*5/8 to 5 standard

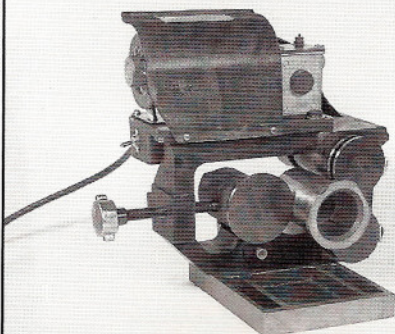
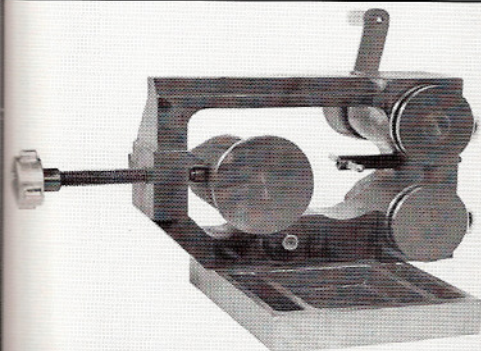
1/8 HP, 110V (0 to 200 RPM)

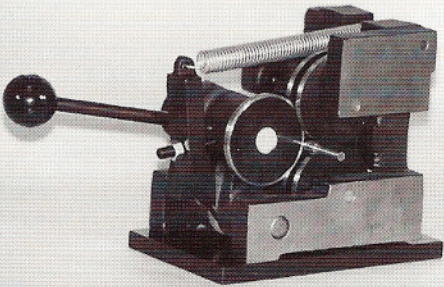
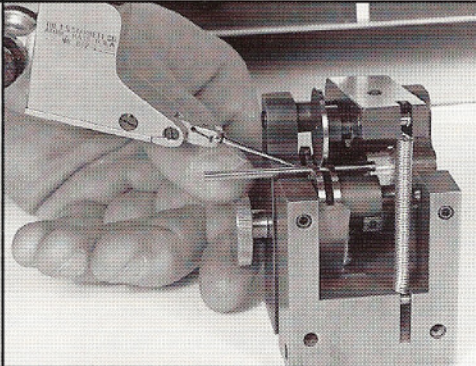
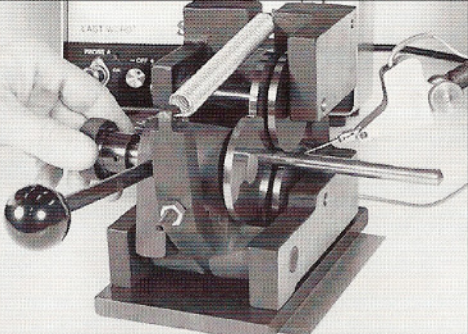
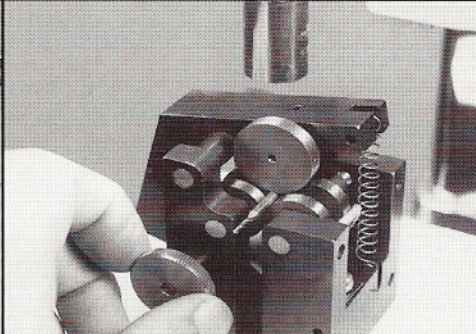
12 Permanently Sealed and Lubricated

Adjustable Torque Handle

52 lbs

*Special roll widths available
Lubricated Air Clamp



Model	RVM-100	MRV-10
Features	<ul style="list-style-type: none"> • Assured concentricity to .00005 T.I.R. • Quick, easy, and accurate loading • Mounts vertically or horizontally • Portable • Finished lengths from 11/16 to 8" standard • Handle fits choice of positions for operation 	<ul style="list-style-type: none"> • Assured concentricity to .00005 T.I.R. • Quick, easy, and accurate loading • Mounts vertically or horizontally • Portable • Finished lengths from 11/16 to 3" standard
Description	<p>Inspects the concentricity and straightness of circular or round shafted objects quickly, safely and accurately.</p> <p>Workpiece is inserted between the three intermeshing contact rolls and against the end stop which has been adjusted to the length required. The workpiece rotates on its own circumference, achieving precise concentricity while maintaining linear positioning. Because of the greater ratio of diameter of rolls to diameters of workpiece, the workpiece makes many revolutions per turn of the rolls.</p>	<ul style="list-style-type: none"> • Similar to RVM-100 <p>This miniature Rotary "V" Block is designed for inspection of small circular products requiring true concentricity.</p>
Specifications		
Overall Dimensions (inches)	7 1/4 long x 4 1/2 high x 6 1/4 wide	3 1/2 long x 3 1/4 high x 3 wide
Workpiece Capacities:		
Diameter (inches)	1/64 to 1 1/4	1/64 to 1/4
Length (inches)	1 1/16* to 8	1 1/16* to 3
Power	Manual	Manual
Bearings	Precision Ground Centers	Precision Ground Centers
Clamping	Adjustable Spring Pressure	Automatic Adjustable Spring Pressure
Weight (approx. lbs.)	20 lbs	2 lbs
Options	*Special roll widths available for shorter lengths	*Special roll widths available for shorter lengths
		
		



Near the Mighty Niagara Falls

St. Mary manufacturing corp.

1254 Erie Avenue

North Tonawanda, NY 14120-3095

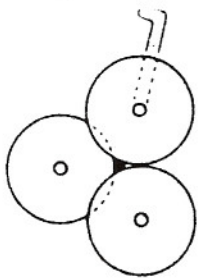
The Spin Roll Principle

St. Mary's unique Spin Roll work holding fixtures provide low-cost, precision cylindrical grinding or other machining capabilities. A patented design, employing three intermeshing contact rolls, assures precise, repeatable, automatic linear positioning and concentricity up to .0002".

Available in nine manual and motorized models, Spin Rolls mount easily on many standard shop machines, including most internal, cylindrical (ID & OD) or surface grinders, drill presses, finishing, cutting, chucking, and other machine tools.

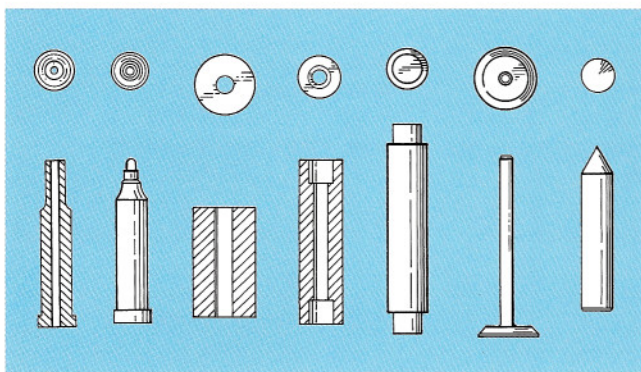
Standard models accommodate workpieces from 1/64" to 3" diameter and 5/8" to 5" lengths, with an optional mounting bracket on Model 525-P for lengths up to 20".

Workpieces can be loaded quickly, easily and accurately, allowing the Spin Roll to be used efficiently for both prototype and production machining.



Three intermeshing contact rolls are the basis of the Spin Roll principle

Automatic concentricity (within .0002"), linear positioning, and precise duplication for any number of workpieces are assured by the Spin Roll's three intermeshing contact rolls which revolve and rotate the cylindrical piece on its own circumference.



Some typical examples of workpieces turned on Spin Rolls

Spin Roll Rotary "V" Block

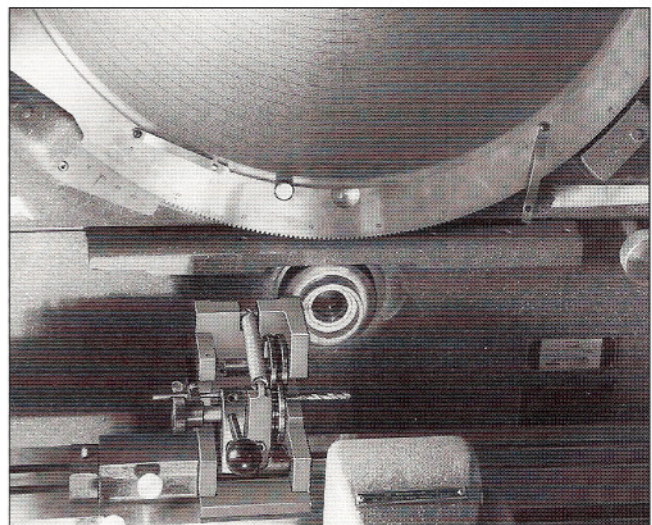
With St. Mary's Rotary "V" Block, the concentricity and straightness of circular or round shafted objects can now be inspected quickly, (to within .00005) safely and accurately by a practically unskilled operator!

Just insert the workpiece between the three intermeshing contact rolls and against the end stop which has been adjusted to the length required. The workpiece rotates on its own circumference, achieving precise concentricity while maintaining linear positioning. Because of the greater ratio of diameter of rolls to diameters of workpiece, the workpiece makes many revolutions per turn of the rolls.

The rolls in the Spin Roll Rotary "V" Block are especially lapped for true roundness. The female contact rolls are mounted on **dead centers** and the intermeshing (or clamp) roll is mounted on a permanently sealed bearing. The rolls are so true that only a slight turn of the clamping roll provides for accurate checking of any diameter by means of a mechanical or electronic indicator or optical comparator.

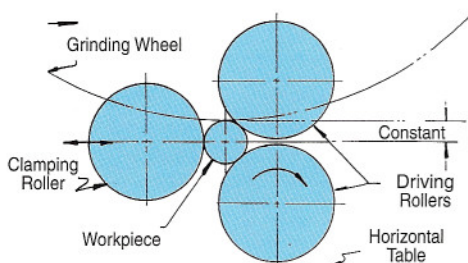
The Spin Roll Rotary "V" Block loads, locks and releases quickly and simply by means of its adjustable spring loaded arm. Assures exact duplication on multiple runs.

A Micro Rotary "V" Block (Model MRV-10) is also available for inspection of small circular parts requiring true concentricity (within .00005).

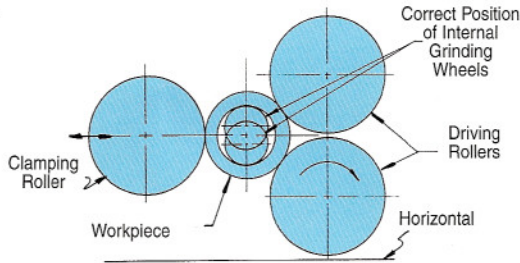


Rotary "V" Block mounted on standard optical comparator checks concentricity and size of rotary cutting tool.

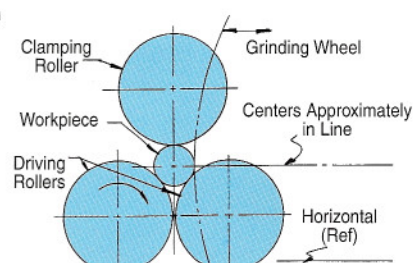
Some Typical Spin Roll Set-Ups



Set-up Using Surface or Universal Grinder



Set-up for Internal Grinder



Set-up for Plunge Grinding Outside Diameter