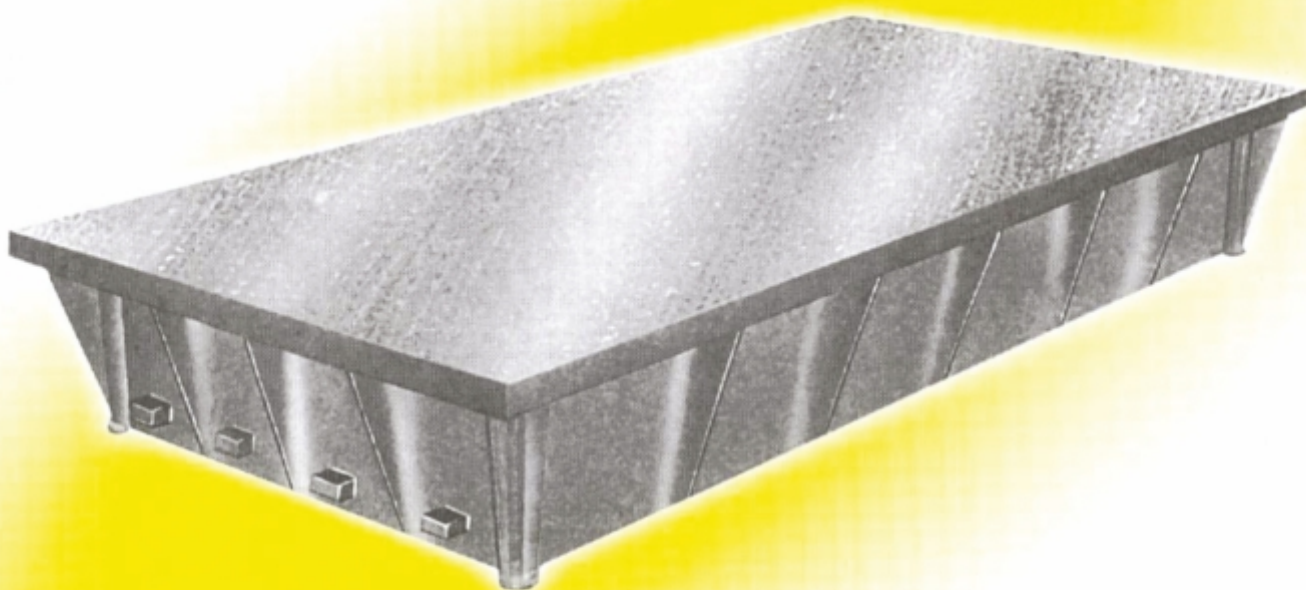


CAST IRON SURFACE PLATES



CAST IRON SURFACE PLATES SPECIFICATIONS

Sl. No.	Normal Size (in mm)	Maximum deviation from flatness over the entire area expressed in Microns as per IS 2285 - 1991			Approx. weight in kgs.
		Grade-0	Grade-I	Grade-II	
1	300 x 300	4.0	7	15	21
2	400 x 400	4.5	9	17	50
3	450 x 300	4.0	8	16	39
4	450 x 450	4.5	9	18	62
5	600 x 450	5.0	10	20	79
6	630 x 400	5.0	10	20	96
7	600 x 600	5.0	10	20	128
8	630 x 630	5.0	10	21	156
9	900 x 600	6.0	12	23	204
10	1000 x 630	6.0	12	24	271
11	1000 x 1000	7.0	14	28	514
12	1200 x 900	7.0	14	28	437
13	1500 x 1200	8.0	16	33	986
14	1600 x 1000	8.0	16	33	870
15	1800 x 1200	9.0	18	36	1188
16	2000 x 1000	9.0	18	37	1345
17	2400 x 1200	10.5	21	42	1683
18	3000 x 1000	12.0	24	48	1845
19	3000 x 1200	12.0	24	49	2085

Other sizes are offered against specific request

Local Area	Local Deviation in flatness		
	Grade - 0	Grade - I	Grade - II
250 x 250 mm	3.5 μ	7 μ	15 μ

GMT Cast Iron Surface Plates are the products of years of manufacturing experience.

These plates are of close-grained cast iron. They are amply ribbed to minimize deflection under load. The composition of the metal, the depth and cross-section of the ribs and the thickness of the plates are designed to conform to the deflection limits specified in IS-2285-2003.

Surface Plates are manufactured to three grades namely Grade-0, Grade-I & Grade-II. as per the standard stated above.

Grade-"0" & Grade-I plates are artificially seasoned. They are hand scraped to achieve maximum local deviation from flatness as per standard of any point on the working surface. A special scraping technique is used to achieve a uniform distribution of load bearing point and oil pockets. An average of 15-20 load bearing points after finish scraping is standard. This finish scraping technique ensures that the area of the load bearing points increases after the initial dulling of the high points. This guarantees a long working life, at the required accuracies. Grade-II plates are accurately machined to get the requisite flatness.

STANDARD ACCESSORIES

Plates of sizes 1000 x 630 mm. and smaller, are provided with handle. A wooden cover is provided to protect the working surfaces.

OPTIONAL ACCESSORIES

Fabricated heavy angle iron stands, with required levelling screws, are offered for all plates to provide convenient working height.

Cast Iron column floor stands each with a levelling screw and nut are also offered as an option as under:

- A set of five, three for levelling and two for support for 2000 x 1000 mm plate.
- A set of seven, five for levelling and two for support for 3000 x 1000 mm & 3000 x 1200 mm.

To meet Special requirements we offer on request bigger size cast iron surface plates above 3000 x 1200 mm. as a joint surface plate, with fabricated heavy angle iron stands, Bed plates with special cast iron floor stands.

Manufactured by

 **Guindy Machine Tools Limited**
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Due to constant development work we reserve the right to depart from the catalogue specifications.