



MICRON

NEWSLETTER FROM SOLITAIRE MACHINE TOOLS LIMITED

OCT. - DEC. 2007



Dear Friends,

You will recollect that on October 17, 1986 an Exclusive License Agreement was signed between Cincinnati Milacron Inc. of Cincinnati Ohio, USA and JBS Machinery Corporation, USA (a subsidiary of Solitaire Machine Tools Limited) to manufacture Centerless Grinders.

Solitaire undertook this project in 1987. In this 20 years span, Solitaire has manufactured over 500 centerless grinders and nearly 50% have been exported to USA. Solitaire also serves over 100 customers in India.

On September 12, 2007, Solitaire crossed another milestone and signed an Exclusive License Agreement with **Bocca & Malandrone Sunebo S.p.A** of Turin, Italy to manufacture BOCCA range of centerless grinders in India. The new manufacturing plant envisages meeting the requirement of Bocca's customers in India as well as world wide through Bocca's Partnership.

Bocca Centerless Grinders have been in business since 1965 and their customer base includes most of the Automotive and Automotive Component Manufacturers in Europe. Bocca also serve reputed engineering and automotive components manufacturers in India.

Bocca Grinders are unique in the construction as they are built with fixed centers facilitating automation and easy set up. The grinders also have hydrodynamic spindles, hydrostatic infeed slides, CNC dressing for Grinding & Regulating wheel and Servo Drive for Regulating wheel. The grinders are offered with 5 axes CNC Controls and additional axis are provided as required for specific grinding solutions.

Solitaire has set up the infrastructure to start the manufacturing of Bocca line of grinders in a period of 6 to 8 months. Solitaire expects to serve the industry with more choices of grinders and meeting high quality and productivity level. We would welcome your inquiries and hope to be partner with you for your upcoming projects.

Please write to us at solitaire@satyam.net.in

With Warm Regards,

P.J. Sheth



Mr. Eugenio Boggio Sella
Bocca & Malandrone Sunebo S.p.A

Mr. Ashok J. Sheth

SIGNING OF AGREEMENT

Precision to the last micron



R 50 / CF

R 90 / CF



R 130 / CF



BOCCA &
MALANDRONE
SUNEBO S.p.A.

TECHNICAL FEATURES - FIX CENTRE

Diameter Working range	mm	R 50 / CF	R 90 / CF		R 130 / CF	
		1 - 80	1 - 150	1 - 100	3 - 400	3 - 250

GRINDING WHEEL

Max / Min OD	mm	508 - 610 / 380	610 / 420	660 / 510	610 / 440	660 / 440
ID	mm	254 - 305	305		305	
Width	mm	254	355		508 - 610	

REGULATING WHEEL

Max / Min OD	mm	305 / 230	305 / 230	355 / 240	355 / 240	
ID	mm	127 - 152,4	127 - 152,4		127 - 152,4	
Width	mm	254	355		508 - 610	

GENERAL

Grinding wheel cutting speed	m / s	33 - 80	33 - 60	33 - 60	
Regulating wheel rotation	rpm	3 - 300 (400)	3 - 300	3 - 300	
Regulating wheel truing (dressing) rotation	rpm	300 (400)	300	300	
Grinding wheel motor	kW	15 - 18	45 - 55	45 - 75 - 90 - 110	
Regulating wheel motor	Nm	10	22	42 - 58	
Dimensions (cabinet incl.)	mm	2150 x 3400 x H2200	2200 x 4070 x H2260	2200 x 4500 x H2425	
Weight	kg.	8.000	13.000	17.000	

MAIN FEATURES OF BOCCA GRINDERS:

- Fixed Center: The Workrest is fixed enabling easy installation of automation and fast set up.
- Machine Base: welded and stress relieved steel base filled with antivibration concrete.
- Grinding Wheel head: Spindle housed in hydrodynamic self aligning bushes. Outboard twin grip support provided for spindle.
- Regulating Wheel head: Spindle housed in hydrostatic bushes. Drive by servo motor. Outboard support provided for spindle.
- Grinding Wheel & Regulating Wheel slides: Square hydrostatic slides by hydraulic system. Slides move with ball screw and servo motors. High vibration absorption capacity.
- Grinding Wheel & Regulating Wheel dressers: CNC profile dressing for both wheels with linear and circular interpolation. Auto compensation after dressing.

SOLITAIRE AT IMTEX 2007



No.3 - 500mm Twin Grip CNC Centerless Grinder



No.2 CNC Groove Grinder for Engine Valves



Sample Parts on Display



IF YOU THINK OF CENTERLESS - THINK OF SOLITAIRE



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