



**STOP
HANDLING
START
MACHINING.**





Our Story



Martin Manufacturing, a family owned business, was founded in 1991 by Stan Martin. The company was a humble, two door garage shop when Stan designed the first trunnion table. His only goal in mind was to increase the efficiency of his own business, and it did exactly that by making the company's worst paying jobs its most profitable. Often able to include four to five operations in one cycle, the trunnion freed operators to work on multiple machines at once. Realizing the product's efficiency, local shops began requesting them for their own use. Twenty years later, 100% of the business is in designing trunnion tables and custom workholding. The Stallion Trunnion Table, as it's known today, is designed to allow you to machine parts without handling them multiple times.





5th AXI
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STOP H

STALLION TRUNNION PRODUCTS

HANDLING, START MACHINING.

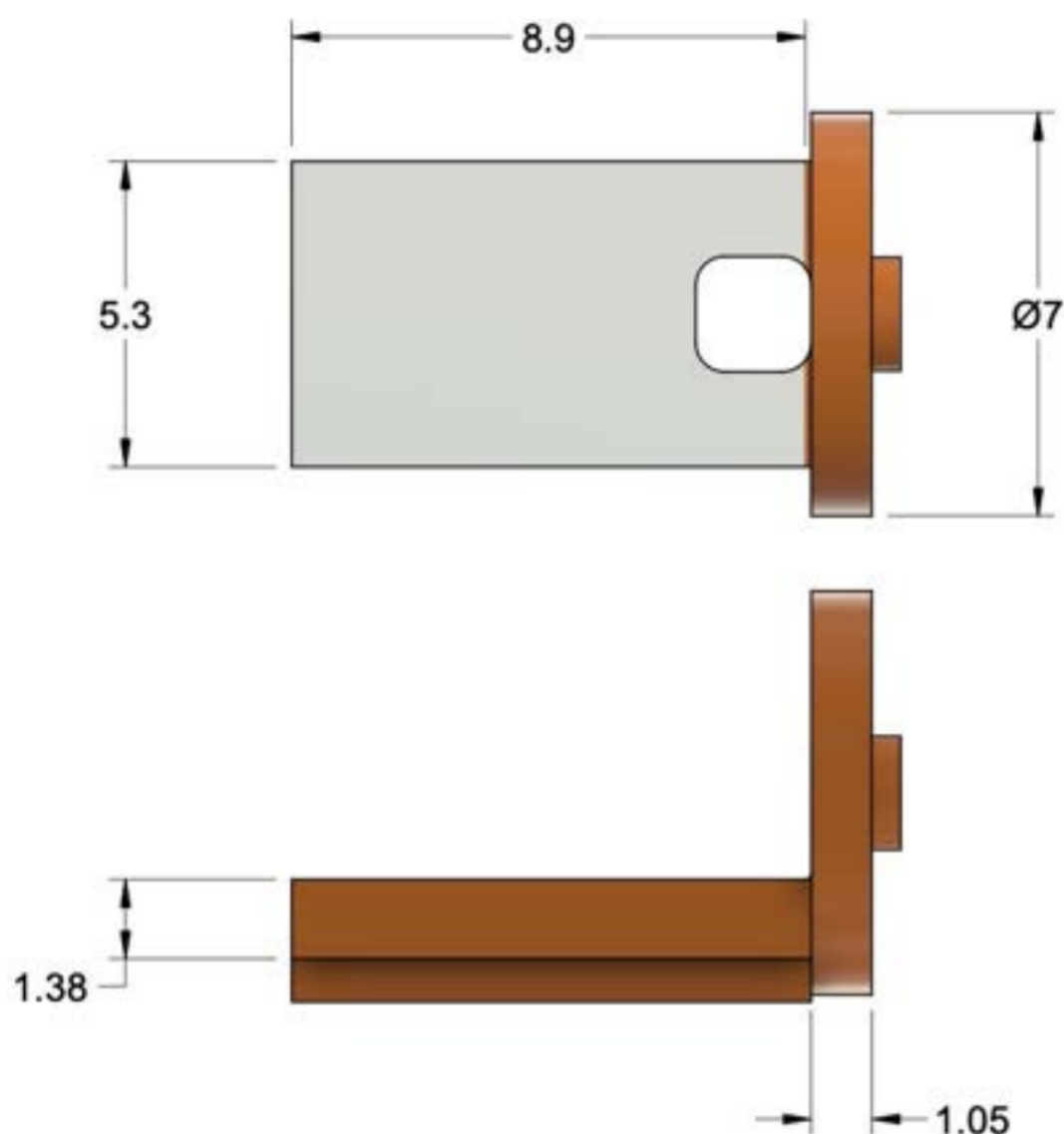
Martin Trunnion Tables is the industry leader in 4th axis workholding solutions. For nearly 20 years, we have effectively provided 4th axis solutions and consultations for a variety of customers in a wide range of industries. Our trunnion systems are made from class #35 cast iron, resulting in a rigid, robust fixture, ready to take on your toughest parts. Send us your prints and models, we will develop the perfect solution for your vertical mill and rotary table.



Single Sided Stallion Shelf Unit

This entry-level 4th axis workholding fixture has a working surface of 8.9" x 5.3" and is perfect for a self centering vise.

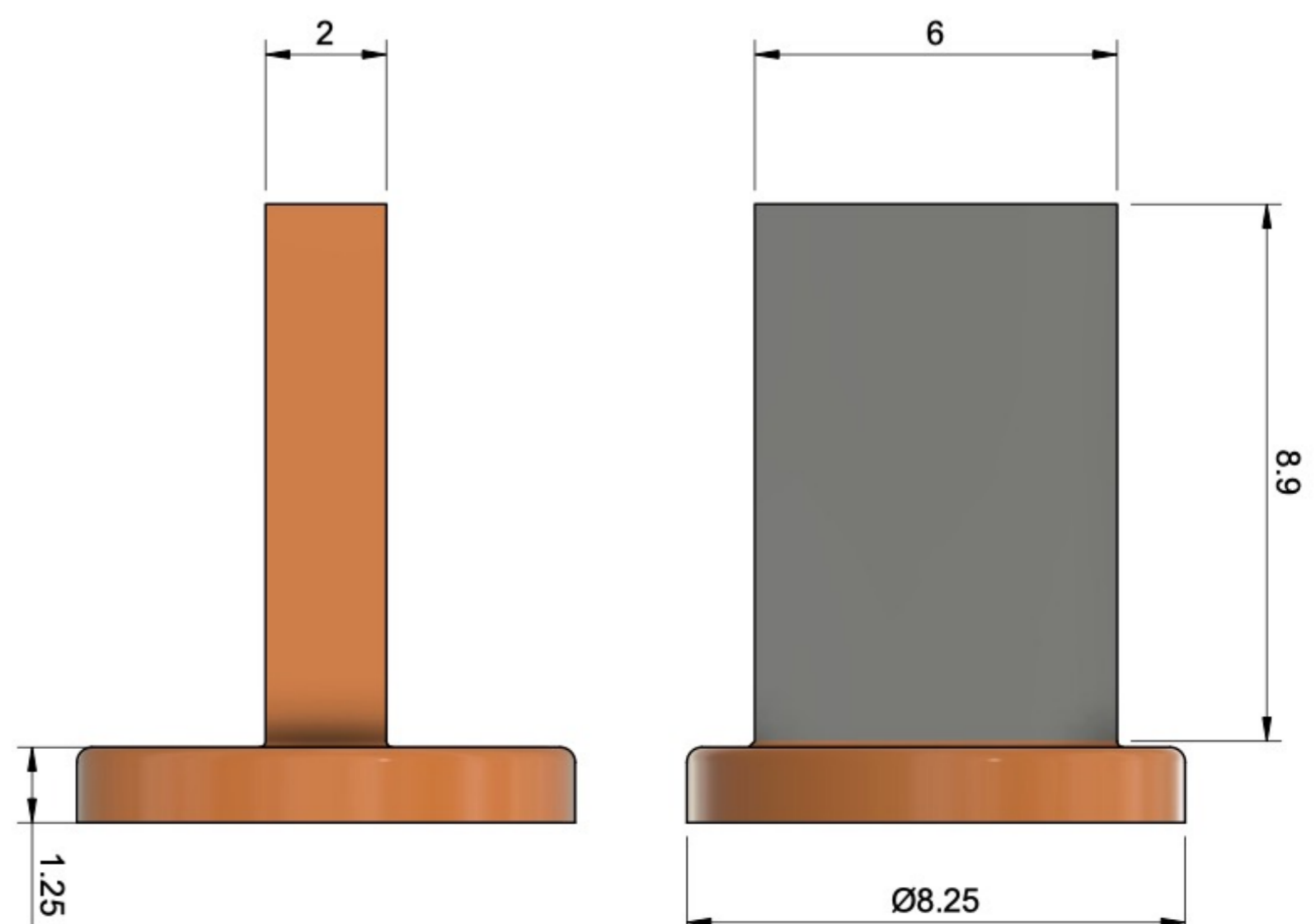
- Custom grid patterns available
- Workholding vises available as a package
- Made to fit any indexer on the market

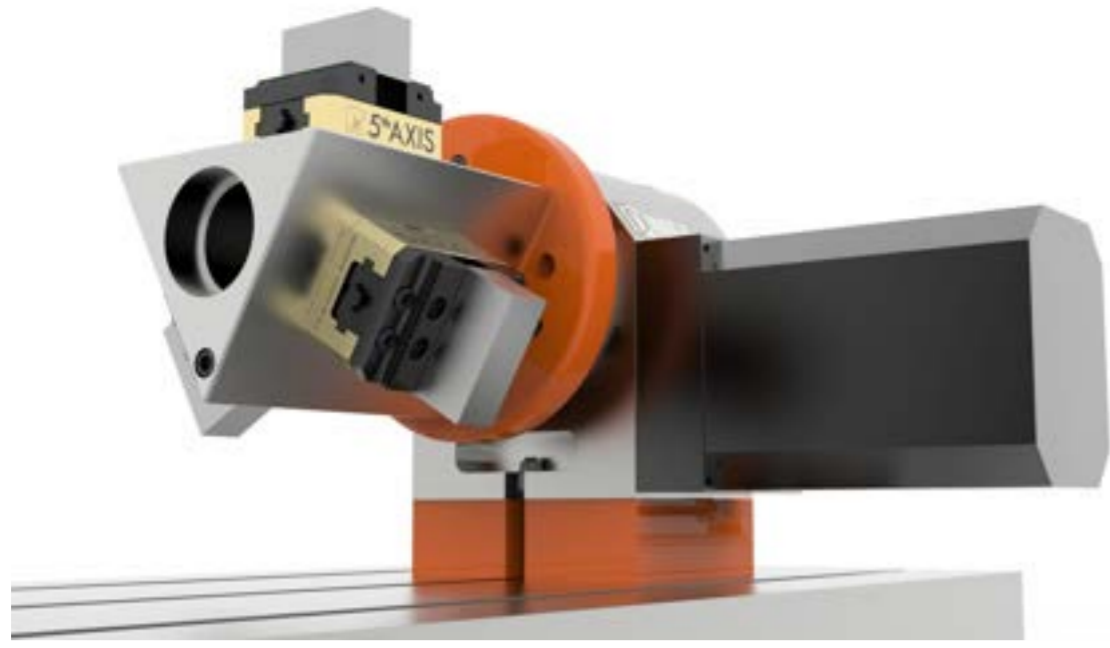


Double-Sided Shelf Unit

Ideal for parts that require two operations. This entry-level workholding fixture can also be outfitted with self-centering vises.

- Working surface of 8.9" x 6"
- Workholding vises available as a package
- Made to fit any indexer

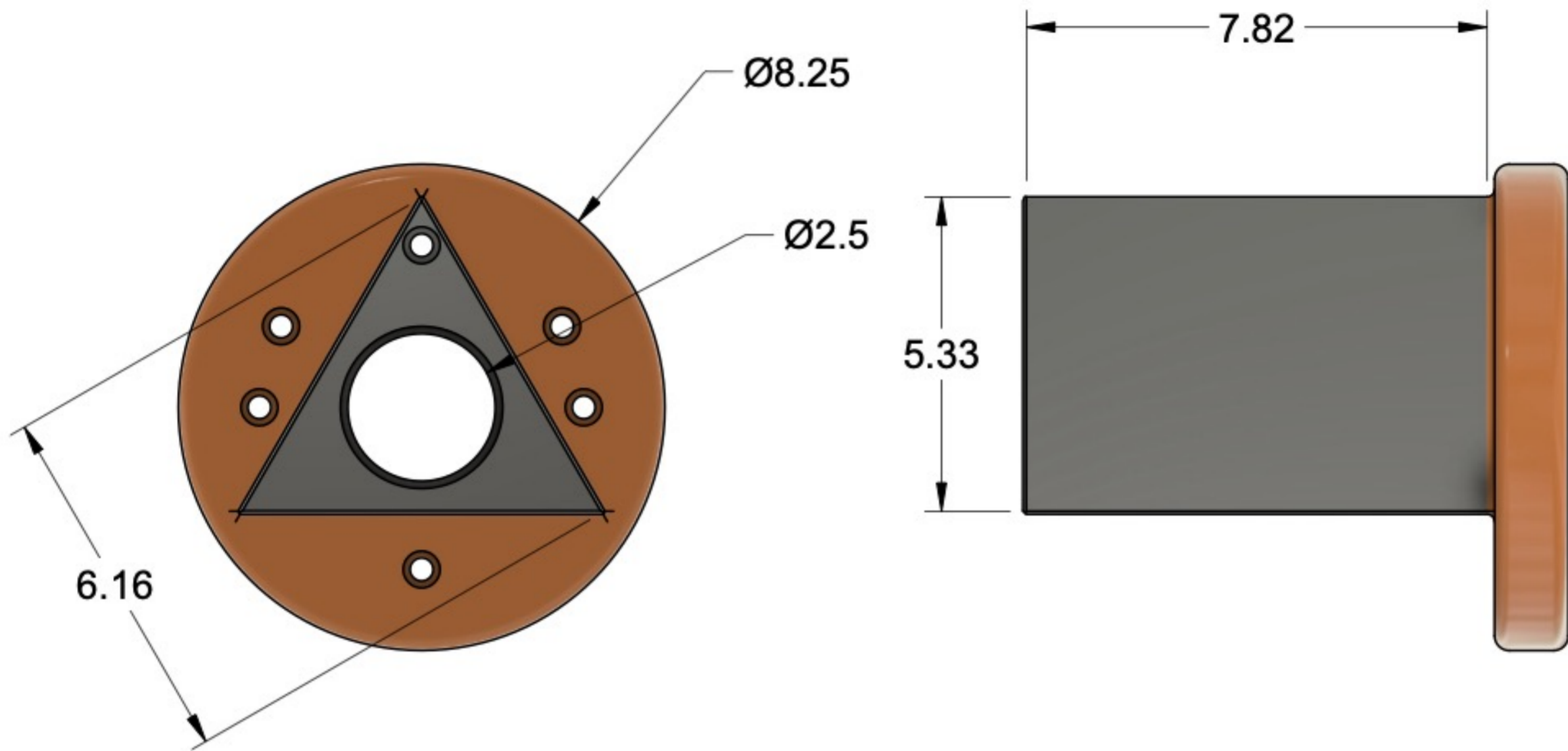




Three-Sided Shelf Unit

A handy fixture when tool clearance is limited. Has a working surface of 7.8" x 5.3". Available with workholding vises.

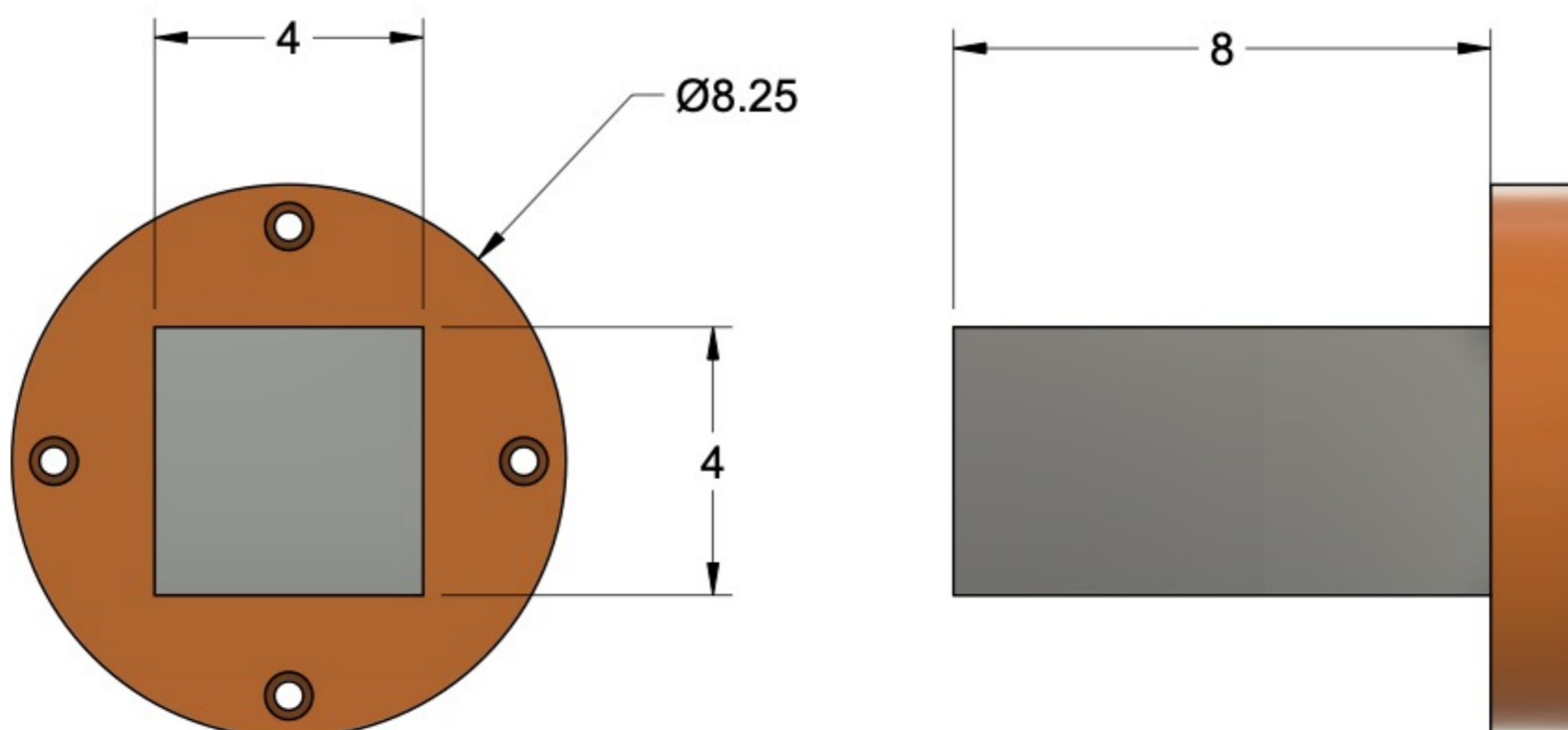
- Made from rigid, class # 35 cast iron
- Designed for customer's rotary table
- Custom grid patterns available

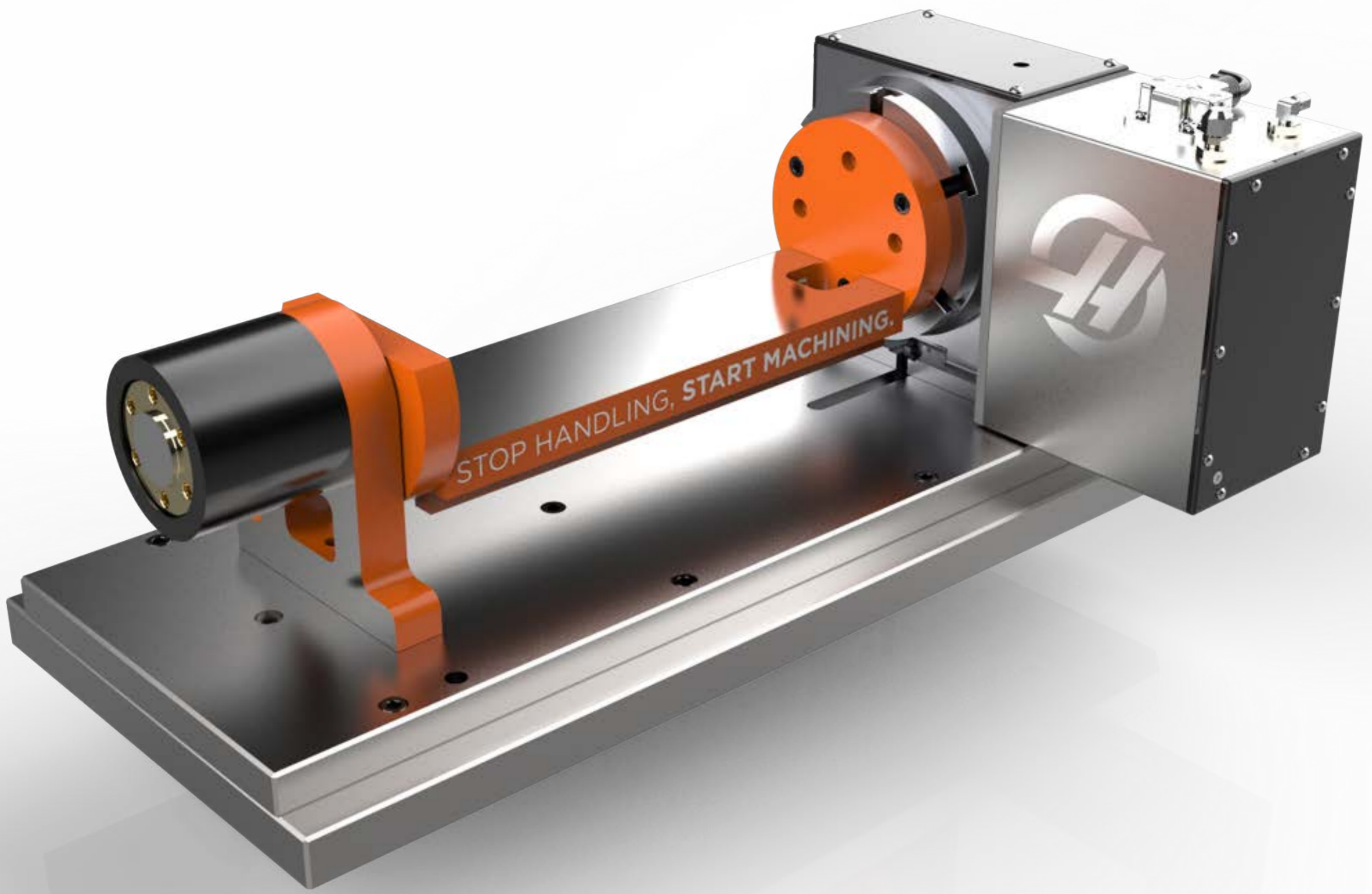


Quad Shelf-Unit

Made for that high volume job that's tempting you to buy a horizontal, this 4-Sided rotary table fixture is rigid, accurate, and can be mounted to just about any rotary table.

- Made from rigid, class # 35 cast iron
- Designed for customer's rotary table
- Custom grid patterns available





Stallion 5/18 Trunnion Table

Available Options



TS1200 Braking System



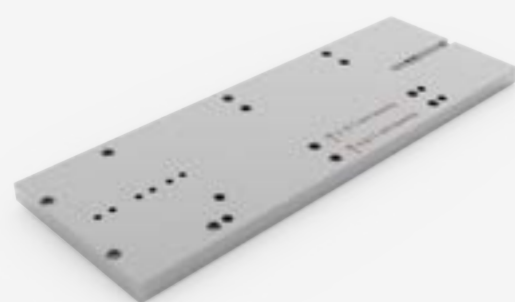
Workholding Systems



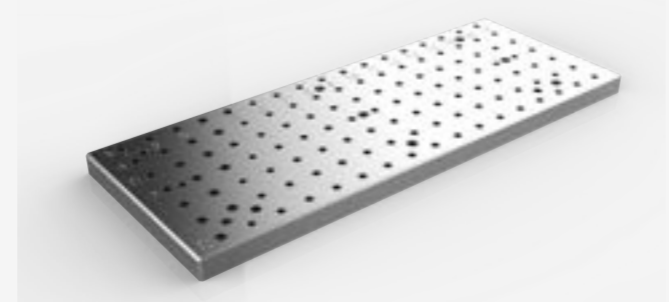
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

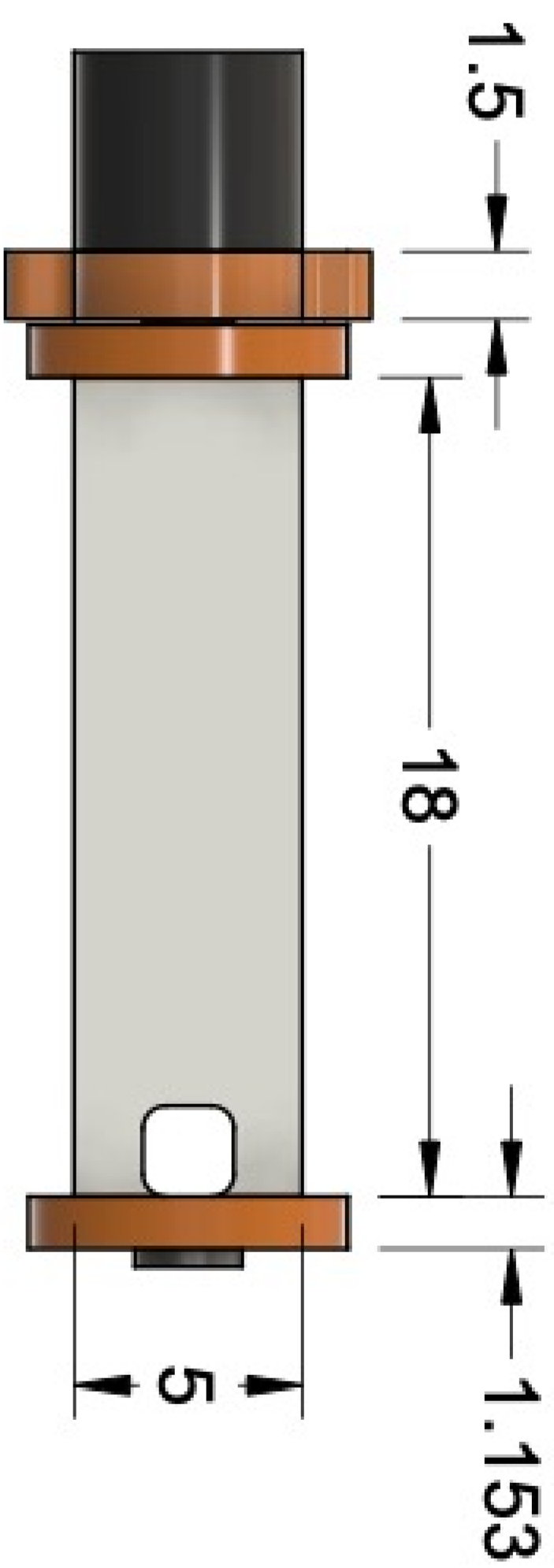


Foundation Plate

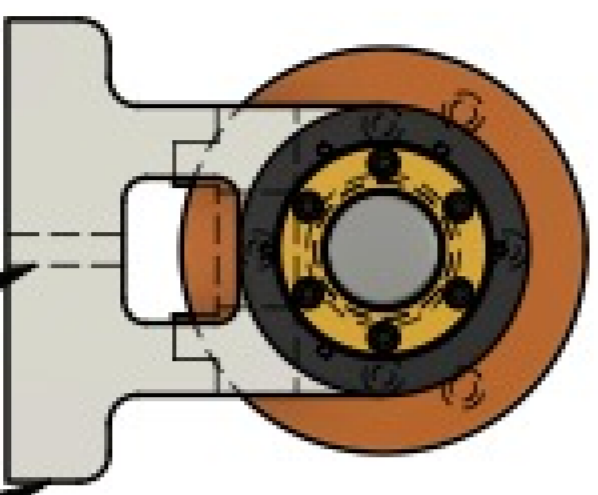
The Stallion 5/18 Trunnion Table is our smallest standard model and is ideal for 160-200mm rotary tables. Like all of our models, this fixture can be outfitted with a variety of grid patterns and workholding options.

- 5" x 18" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern
- One piece design for added rigidity

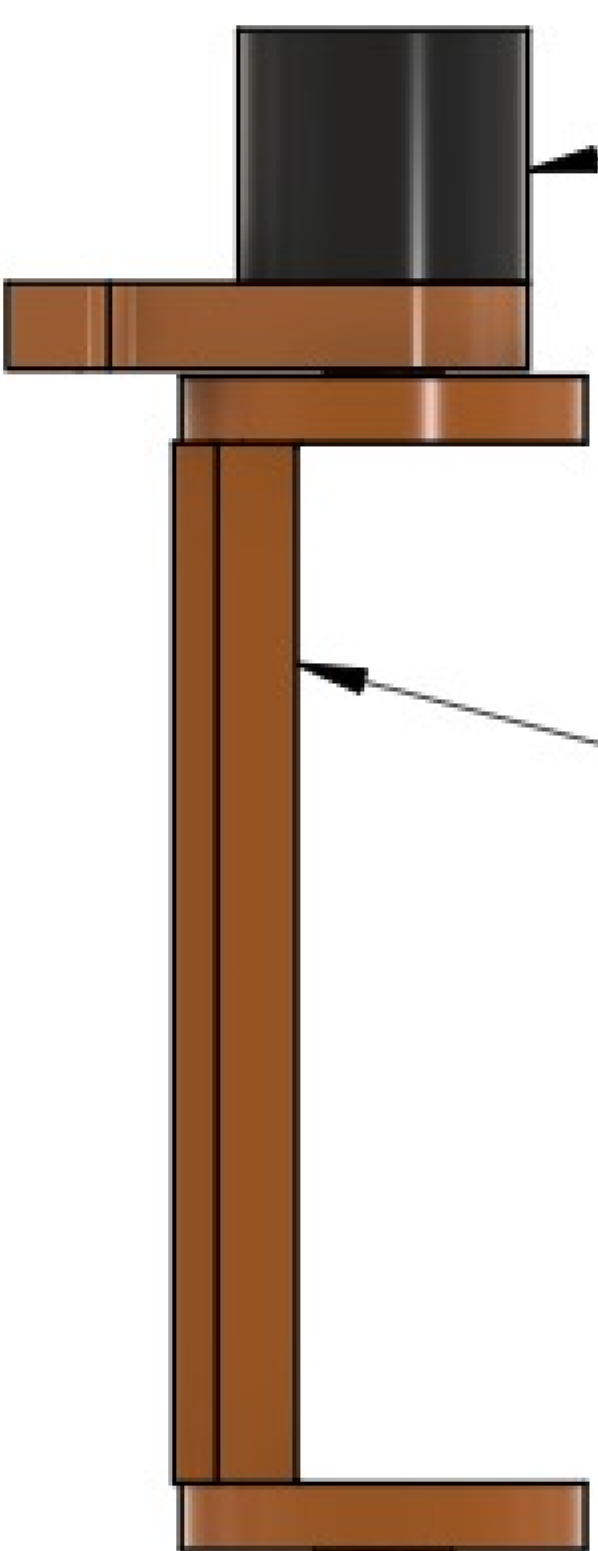
**STOP
HANDLING
START
MACHINING.**



Optional hydraulic or pneumatic
braking system for rigidity

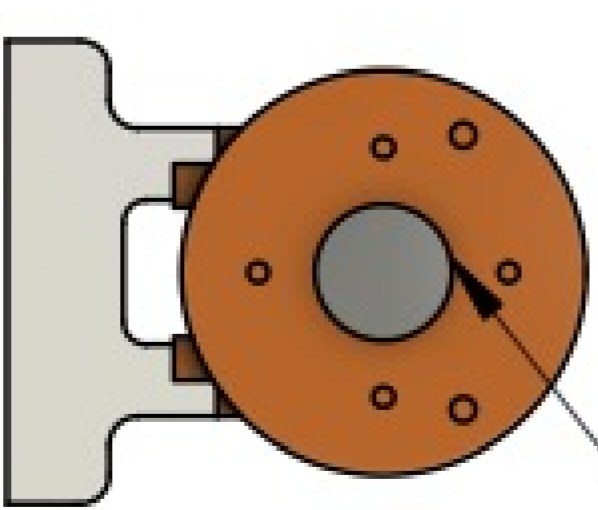


Outboard support centerheight
matched to customer's rotary table

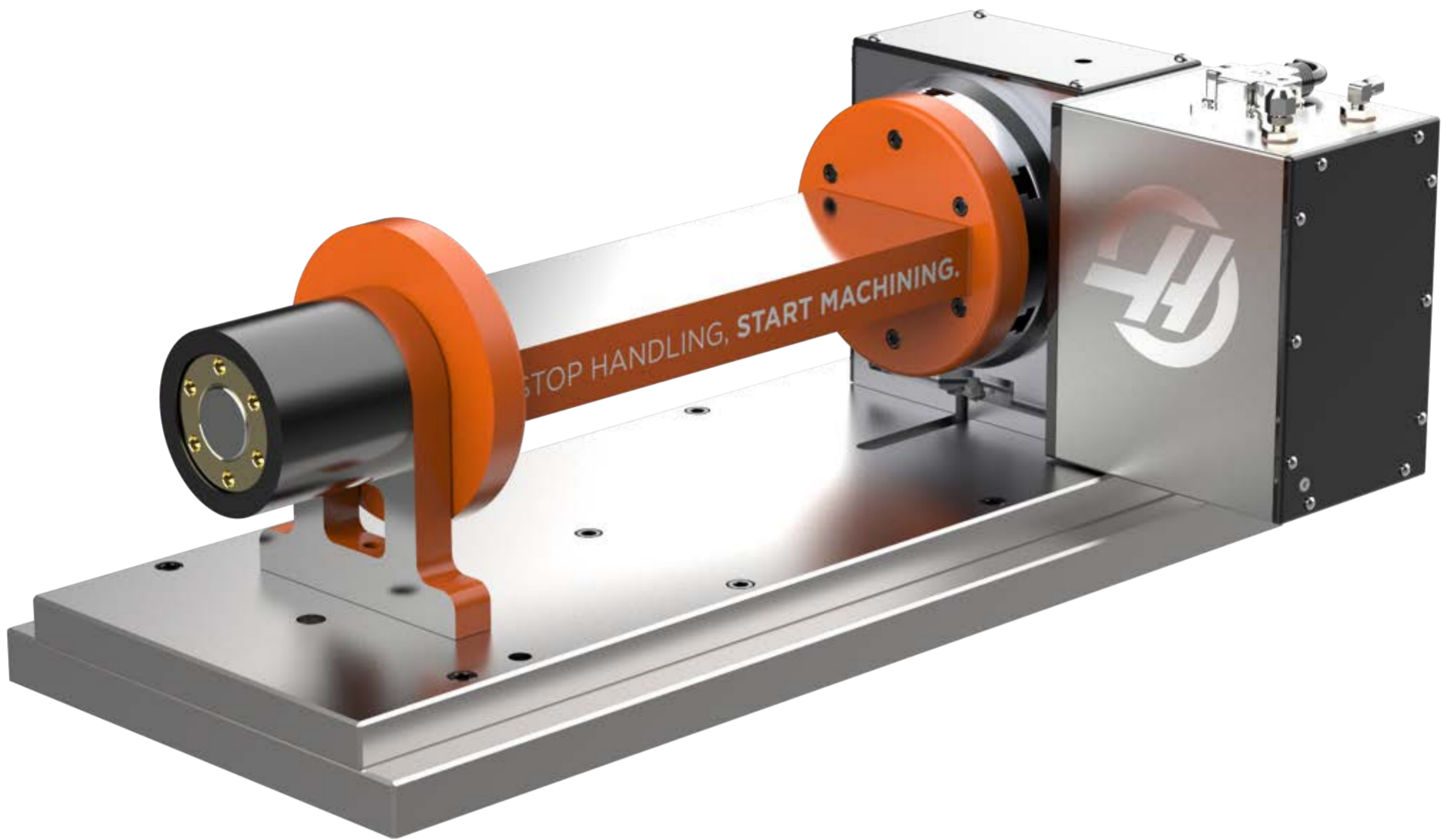


Surface milled flat
and square to faceplate

Bolt pattern and center plug made
specific to customer's rotary table



Hole in outboard support for
mounting to machine table



Stallion 6/18/DBS Trunnion Table

Available Options



TS1200 Braking System



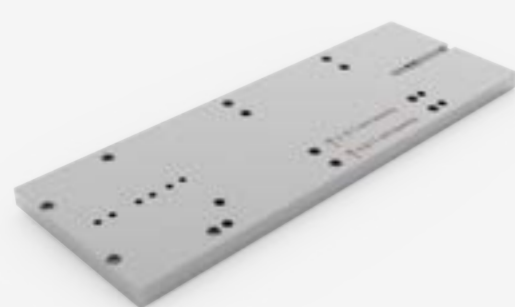
Workholding Systems



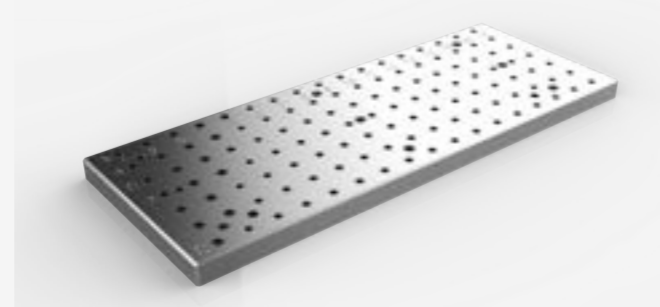
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

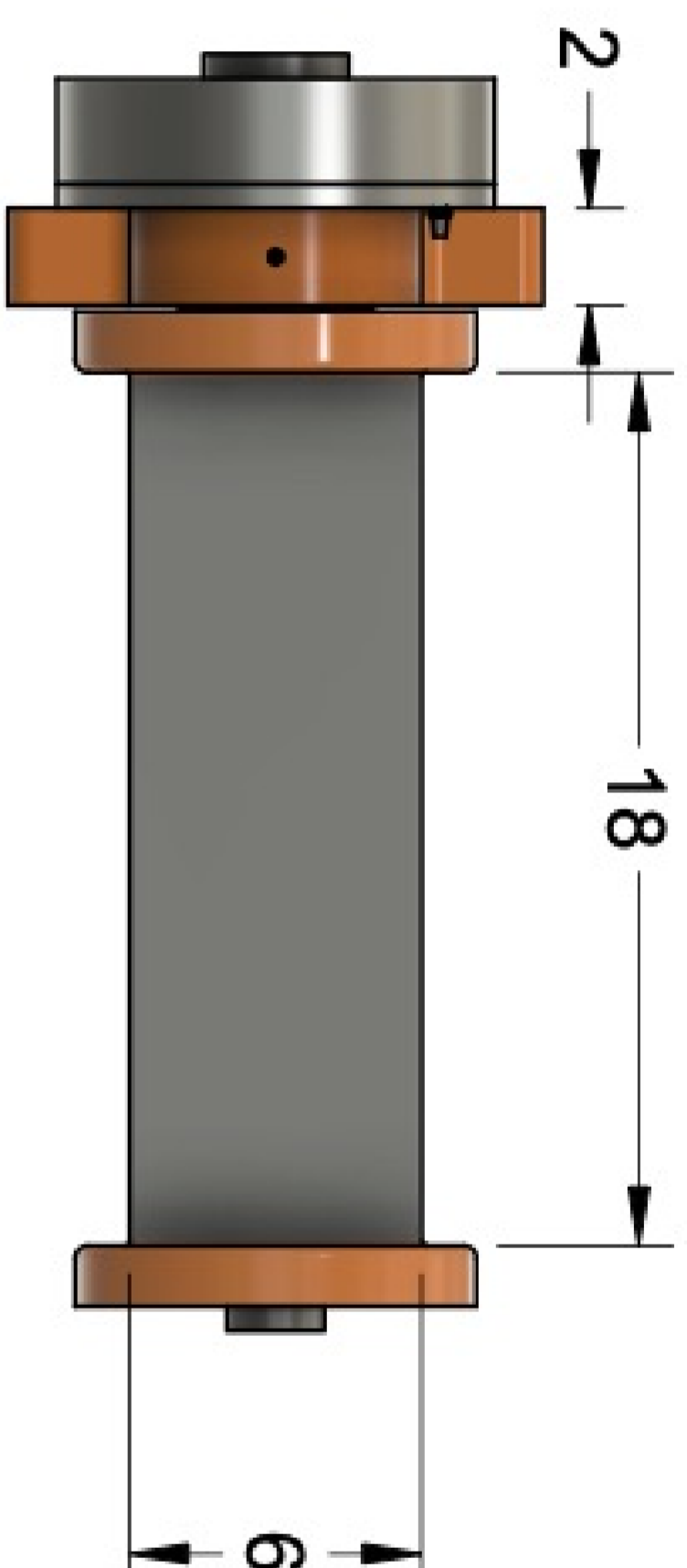


Foundation Plate

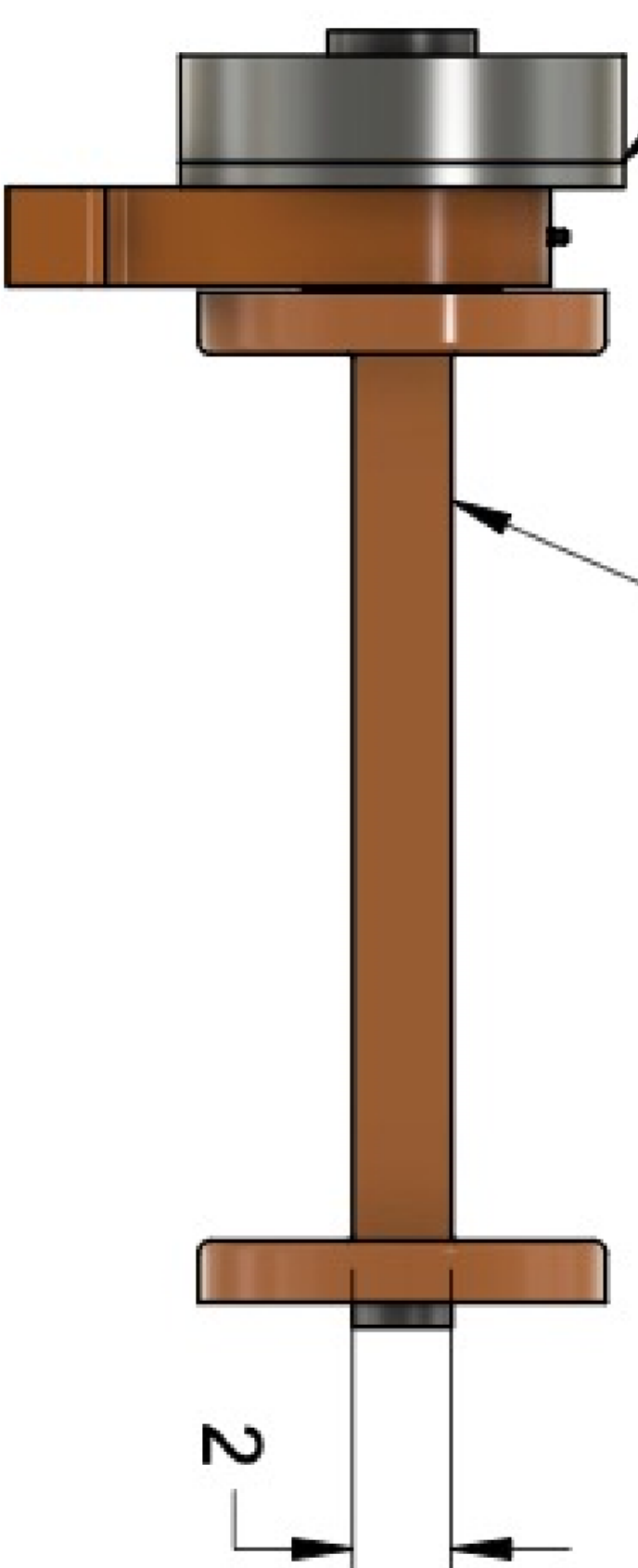
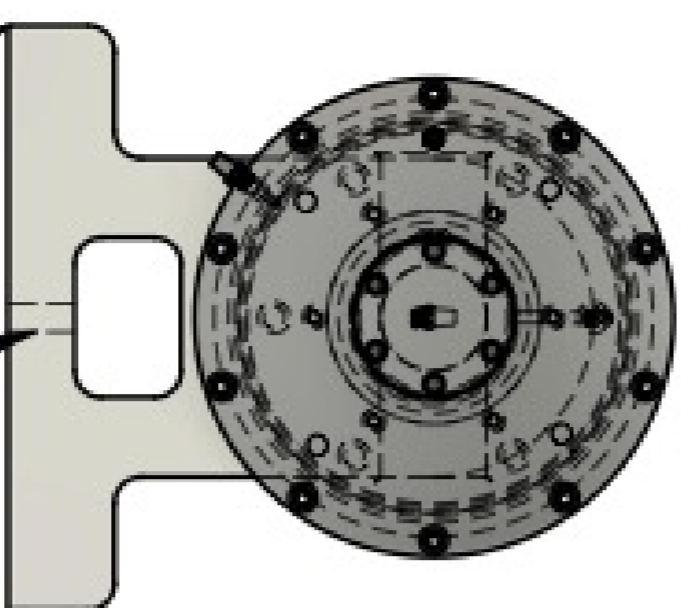
The Stallion 6/18/DBS Trunnion Table is our smallest double-sided model and is ideal for 160-200mm rotary tables. Like all of our models, this fixture can be outfitted with a variety of grid patterns and workholding options. Riser blocks available for part clearance.

- 6" x 18" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern
- One piece design for added rigidity

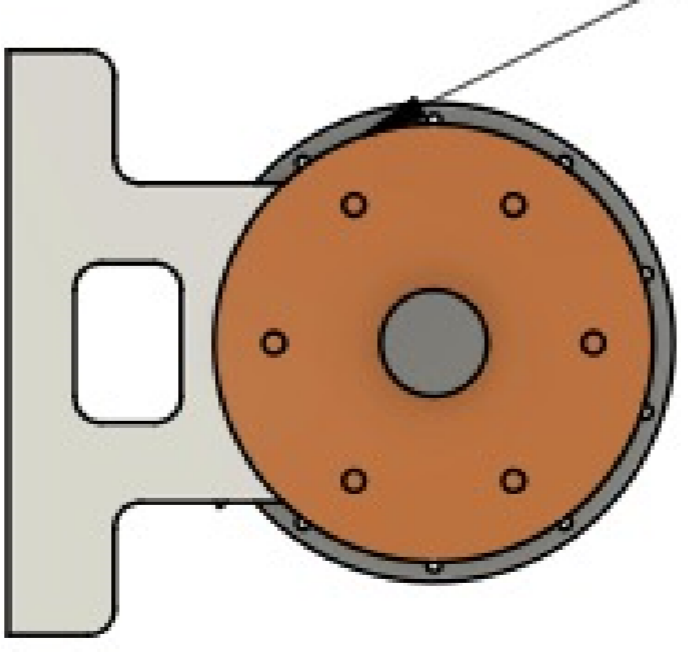
**STOP
HANDLING
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MACHINING.**



Optional braking system
for added rigidity



Surface of trunnion
flat and square to faceplate



Bolt pattern and center
plug made to rotary table

Hole in outboard to mount
to machine table

Outboard made to match
center height of rotary table



Stallion 9/20 Trunnion Table

Available Options



TS1200 Braking System



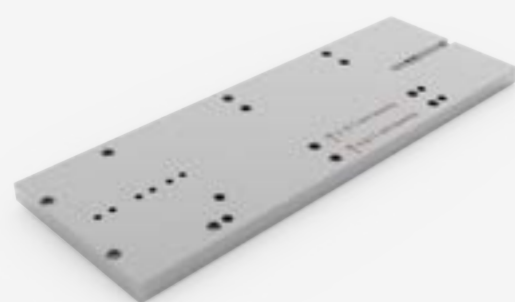
Workholding Systems



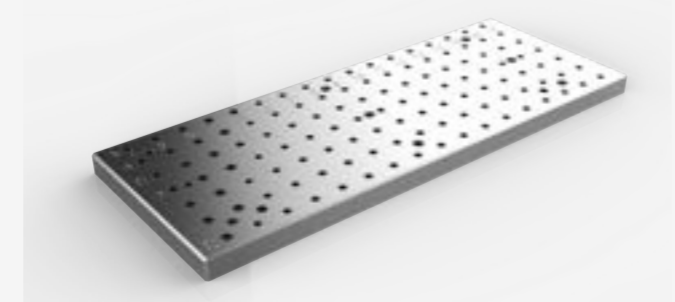
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

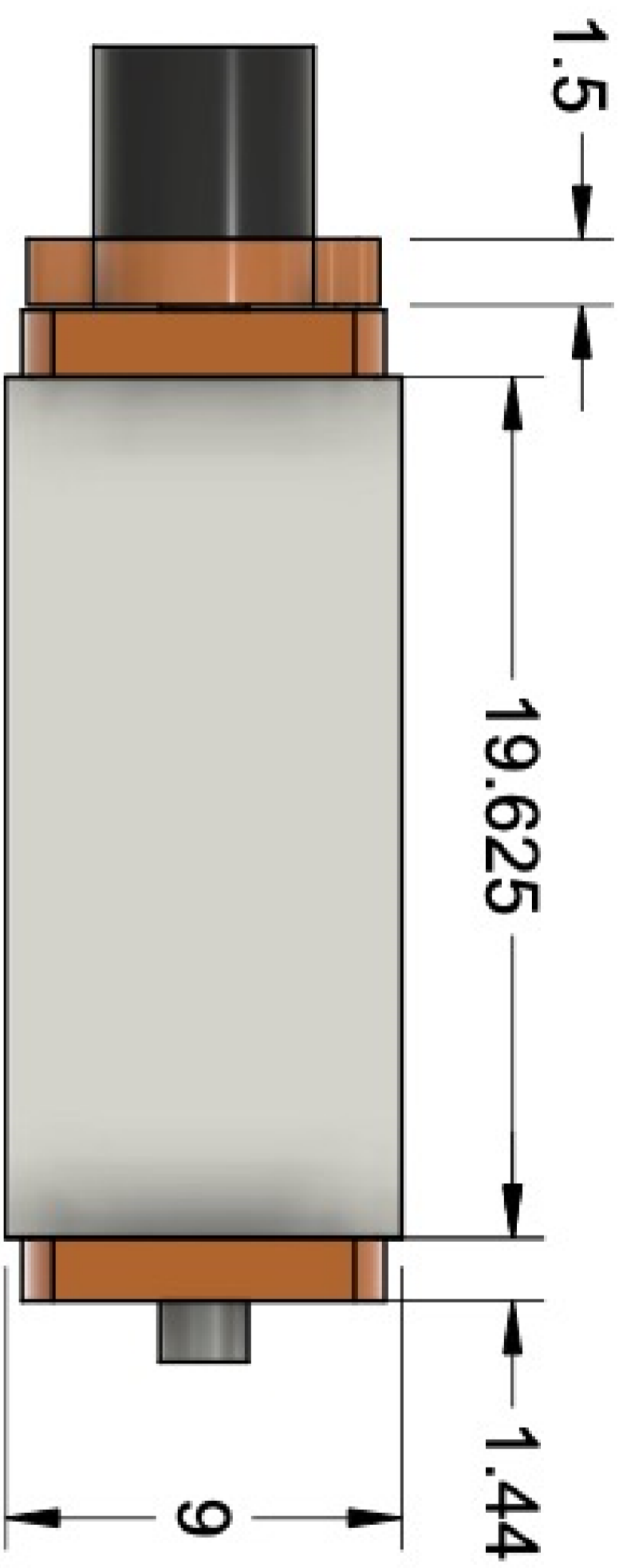


Foundation Plate

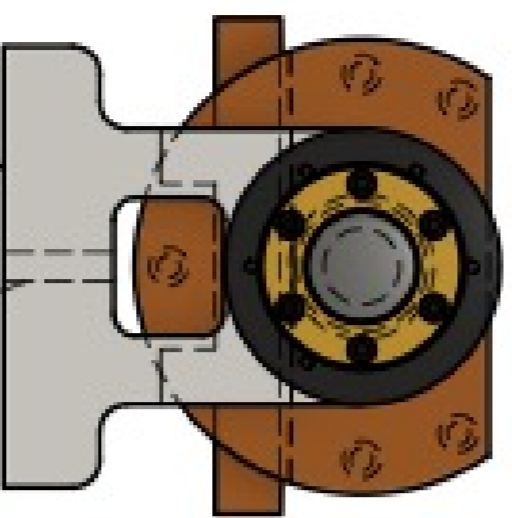
The Stallion 9/20 Trunnion Table is made specifically to fit a single station table vise and is ideal for 160-200mm rotary tables. Like all of our models, this fixture can be outfitted with a variety of grid patterns and workholding options.

- 9" x 20" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern
- One piece design for added rigidity

**STOP
HANDLING
START
MACHINING.**

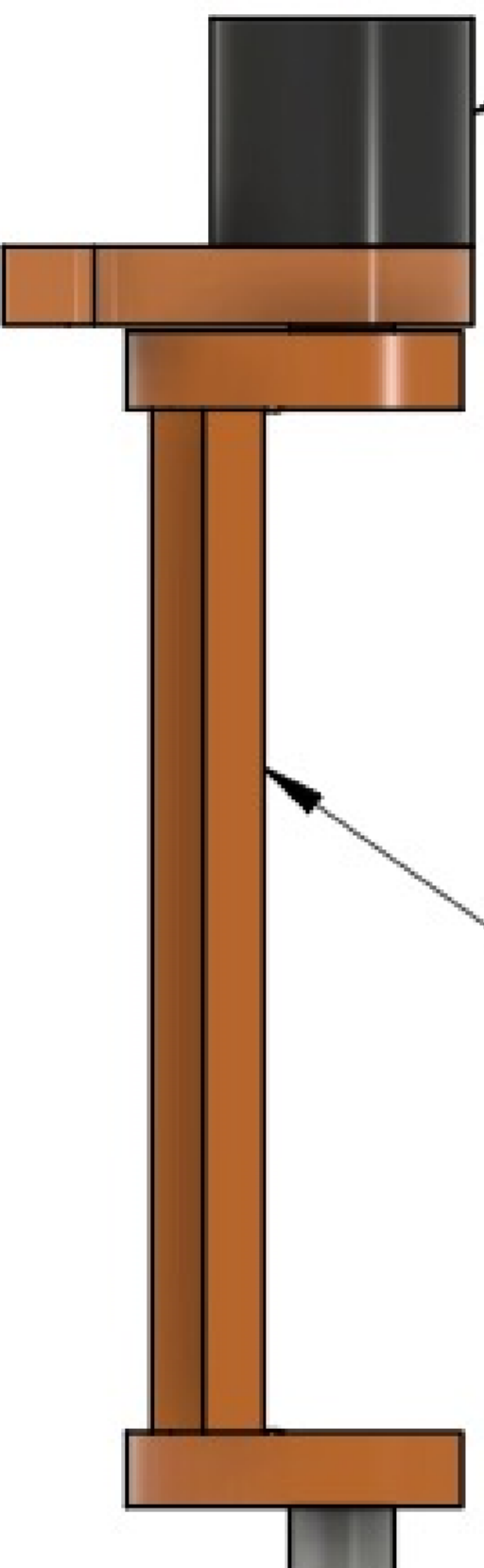


Optional brake
for added rigidity

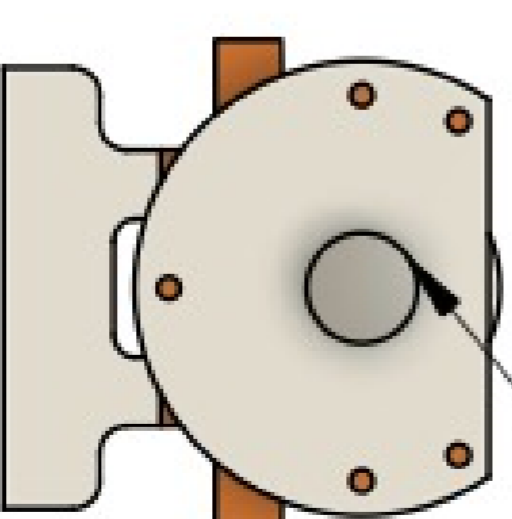


Hole in outboard to
mount to machine table

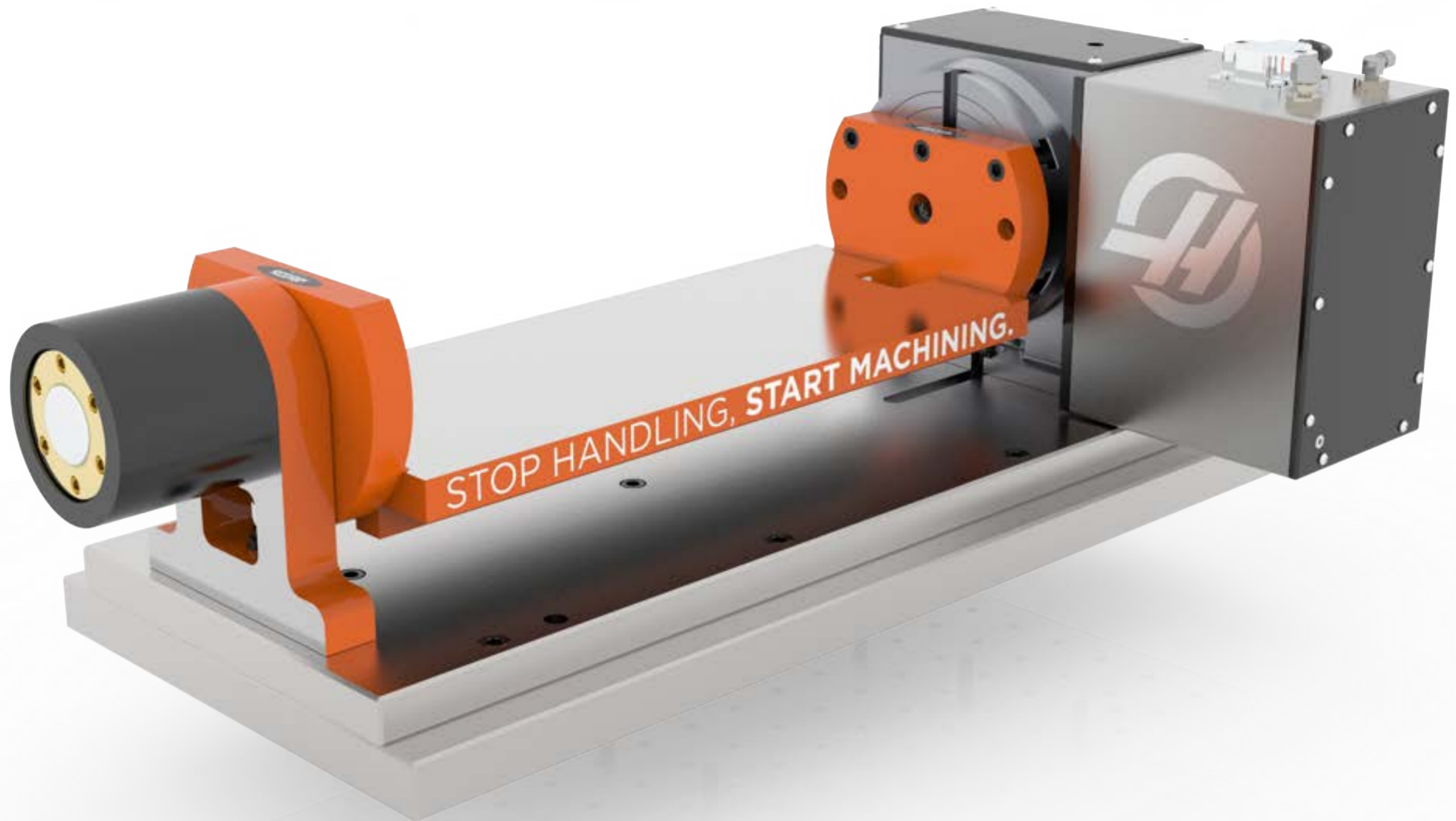
Outboard center height
made to match rotary table



Surface of trunnion flat
and square to face



Bolt pattern and center plug made
specific to customer rotary table



Stallion 9/23 Trunnion Table

Available Options



TS1200 Braking System



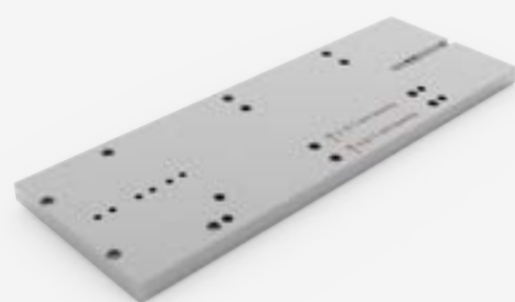
Workholding Systems



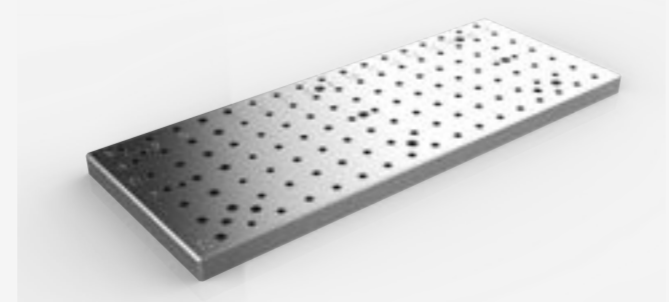
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

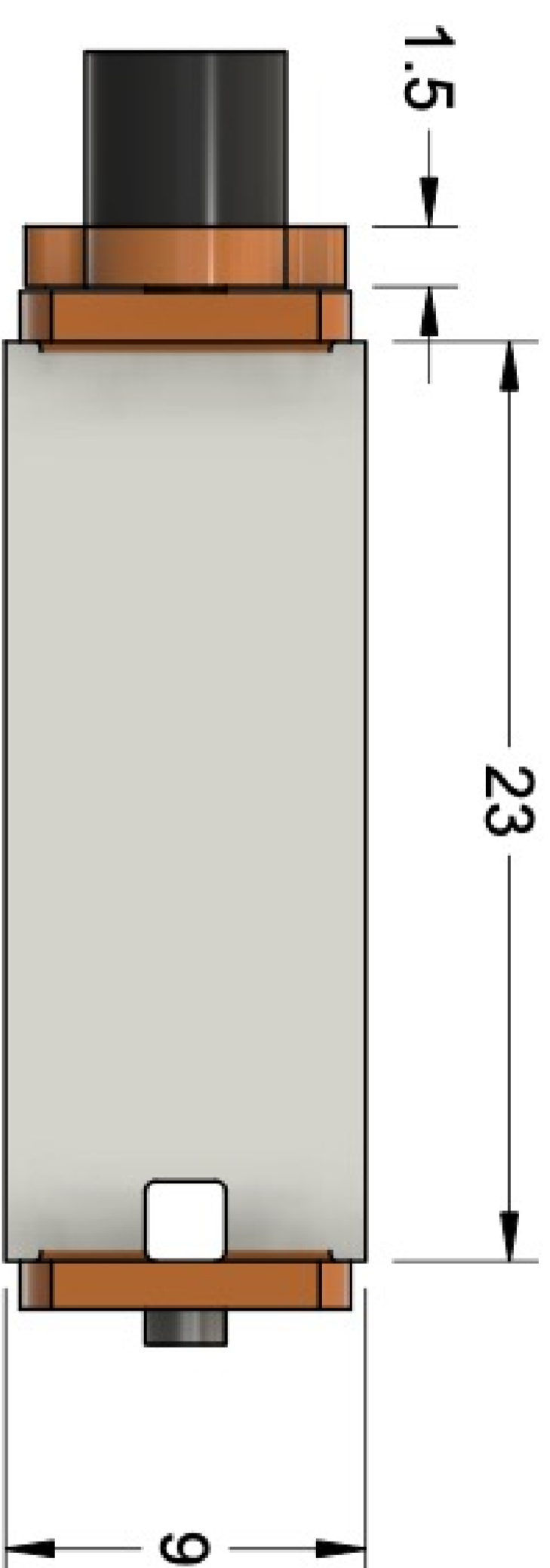


Foundation Plate

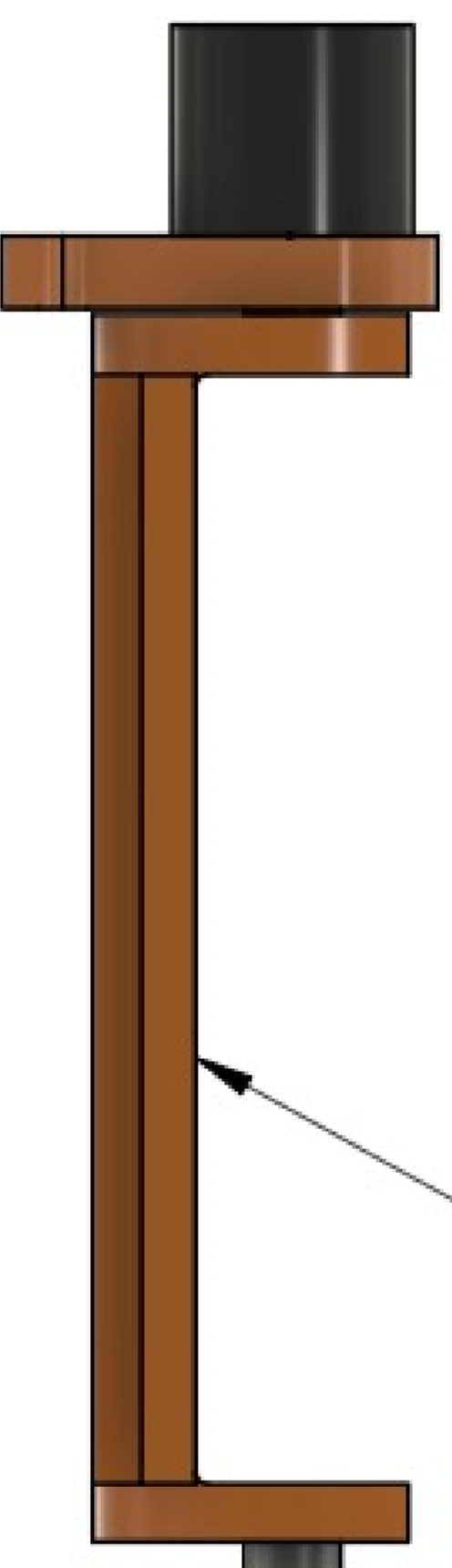
The Stallion 9/23 Trunnion Table is specifically designed for a double station vise and is ideal for 160-200mm rotary tables. Like all of our models, this fixture can be outfitted with a variety of grid patterns and workholding options.

- 9" x 23" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern
- One piece design for added rigidity

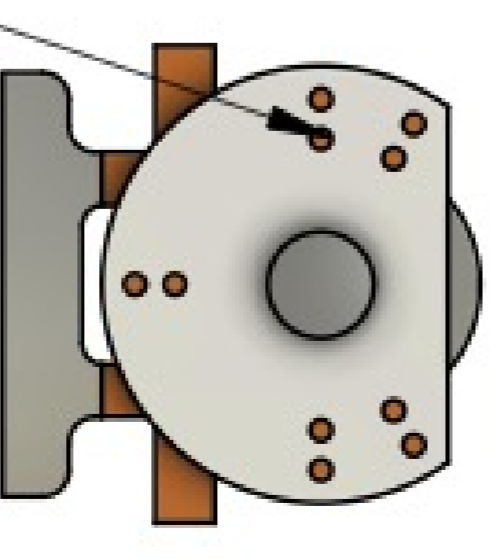
**STOP
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MACHINING.**



Surface of trunnion flat
and square to face

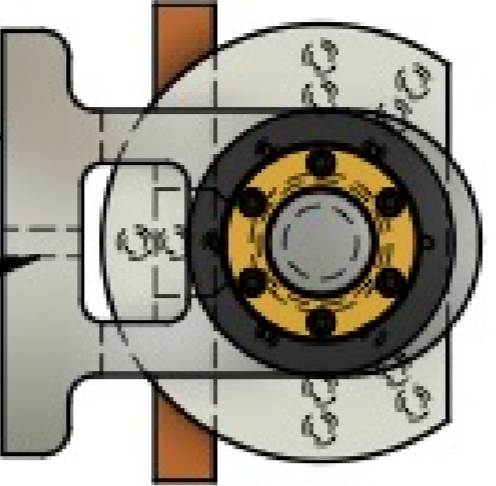


Bolt pattern and centering
plug made specific to customer's
rotary table



Hole for mounting
outboard to machine table

Outboard center height
made to match rotary table





Stallion 9/23/DBS Trunnion Table

Available Options



TS1200 Braking System



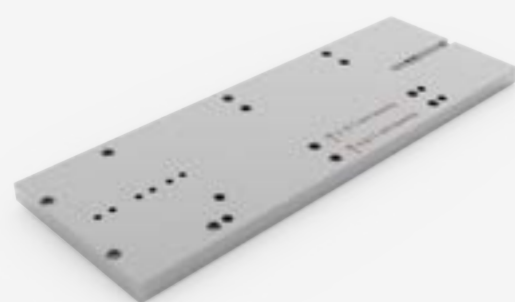
Workholding Systems



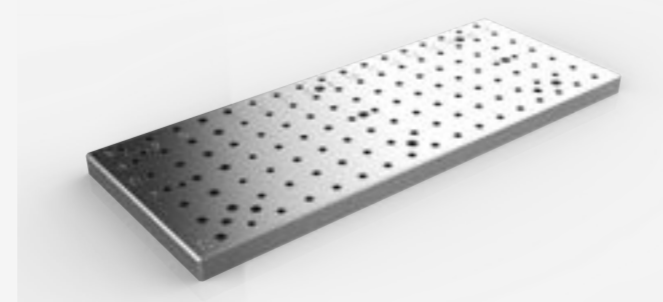
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate



Foundation Plate

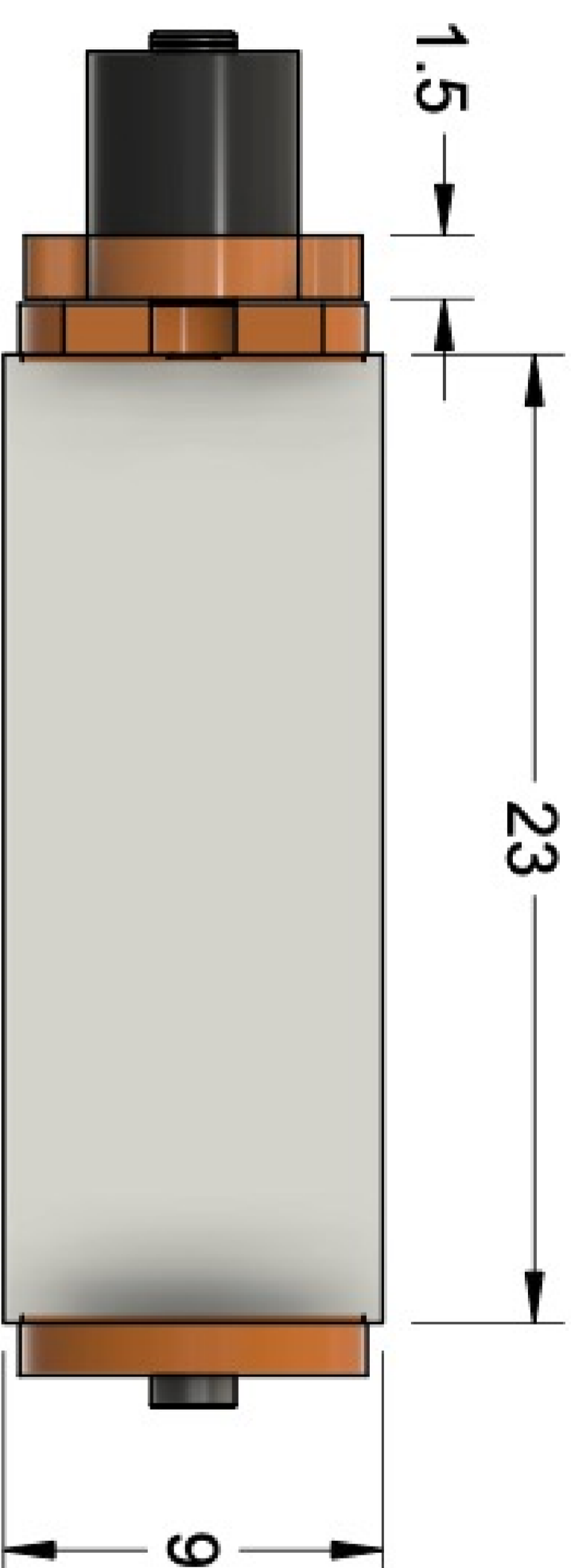
The Stallion 9/23/DBS Trunnion Table is specifically designed for a double station vise and is ideal for 160-200mm rotary tables. Like all of our models, this fixture can be outfitted with a variety of grid patterns and workholding options. Risers are available for part clearance.

- 9" x 23" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern
- One piece design for added rigidity

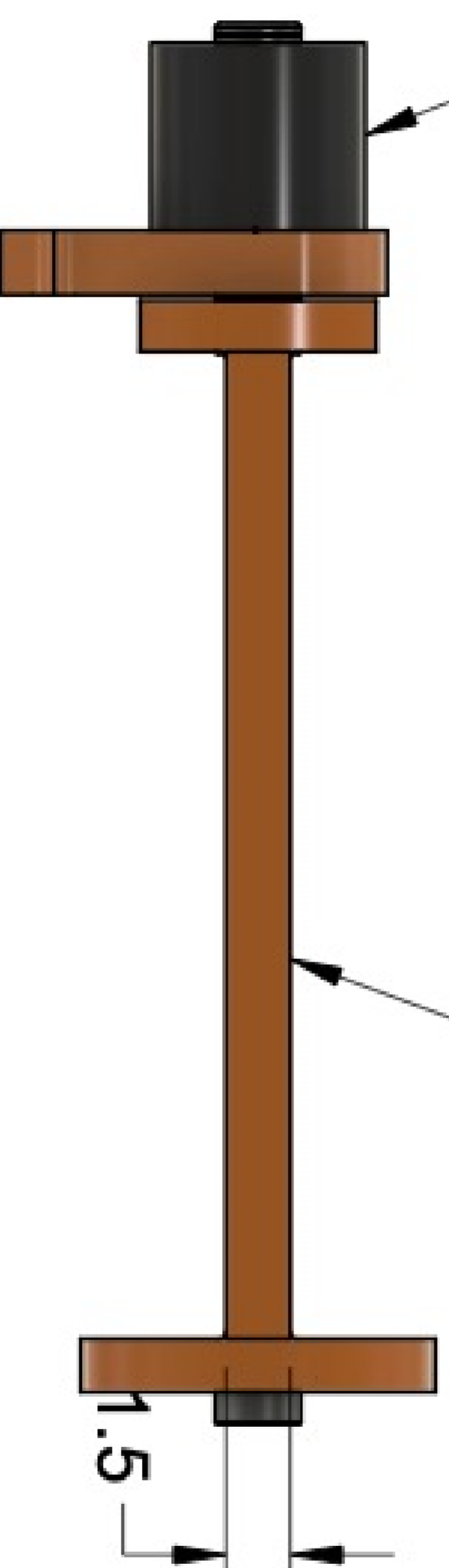
**STOP
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Optional TS1200 brake for

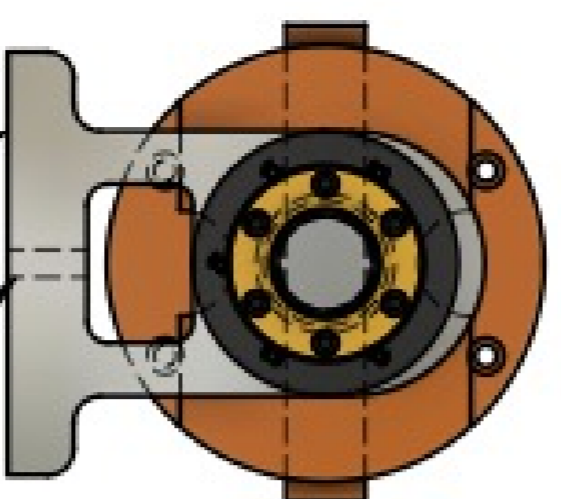
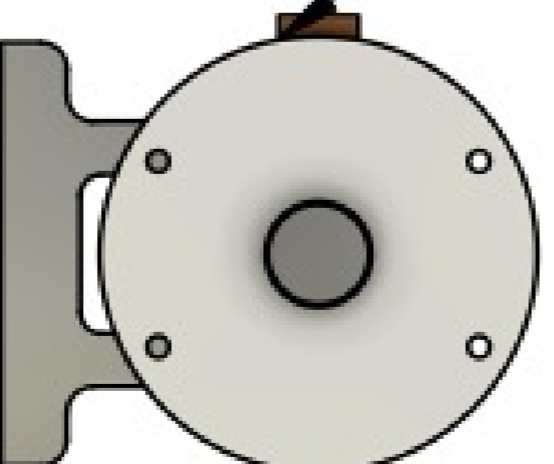
added rigidity



Surface of trunnion flat
and square to faceplate

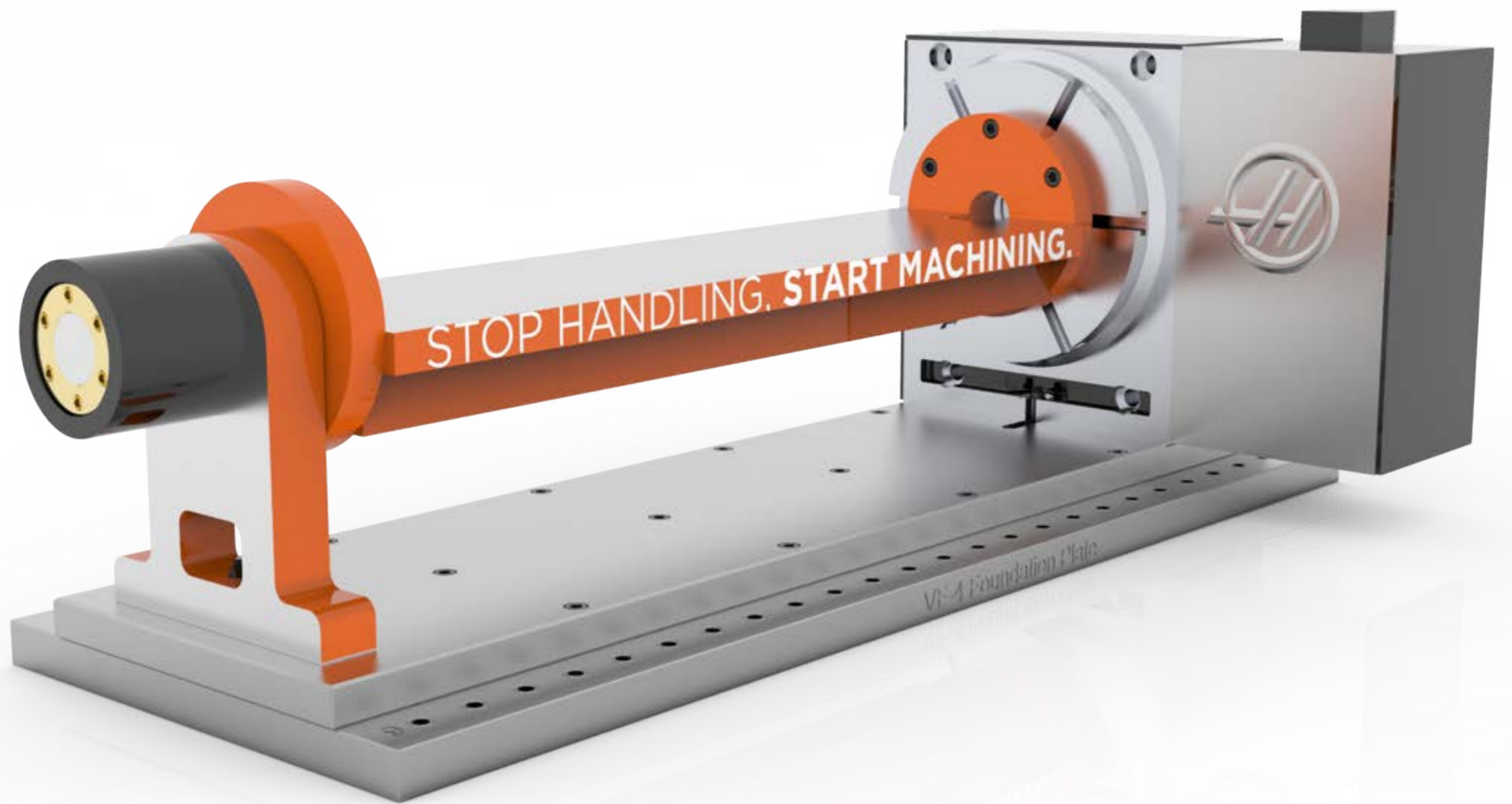


Bolt pattern and center
plug specific to rotary table



Hole in outboard
to mount to machine table

Outboard made to match
center height of rotary table



Stallion 9/35 Trunnion Table

Available Options



TS1200 Braking System



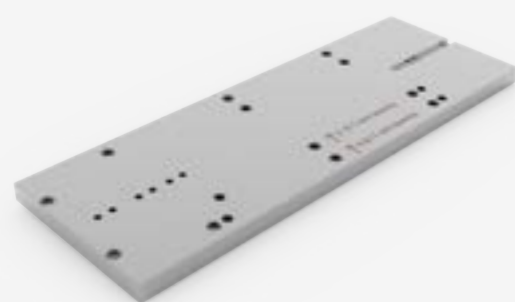
Workholding Systems



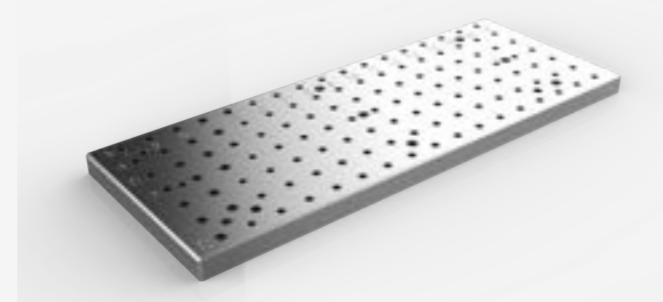
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

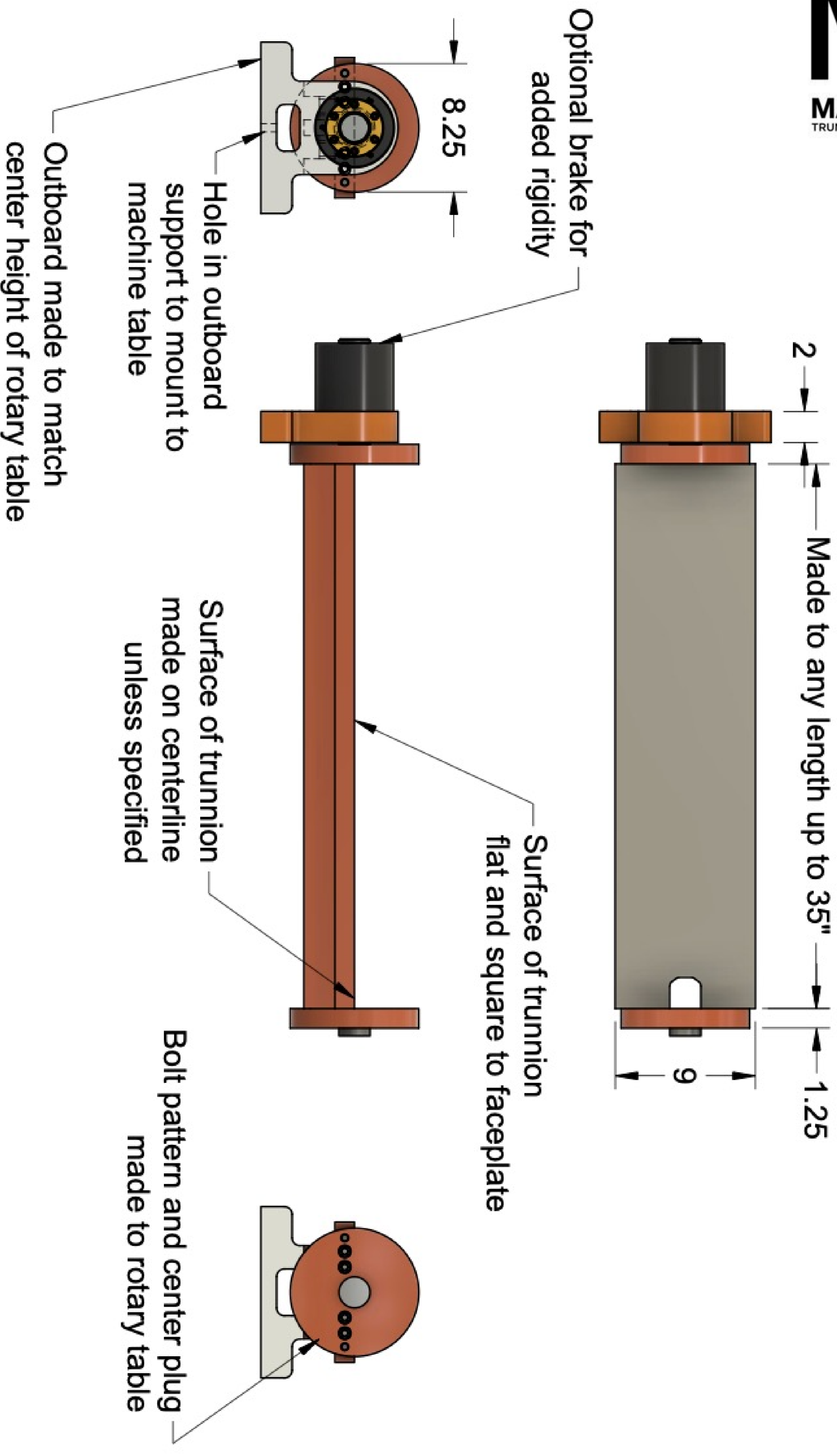


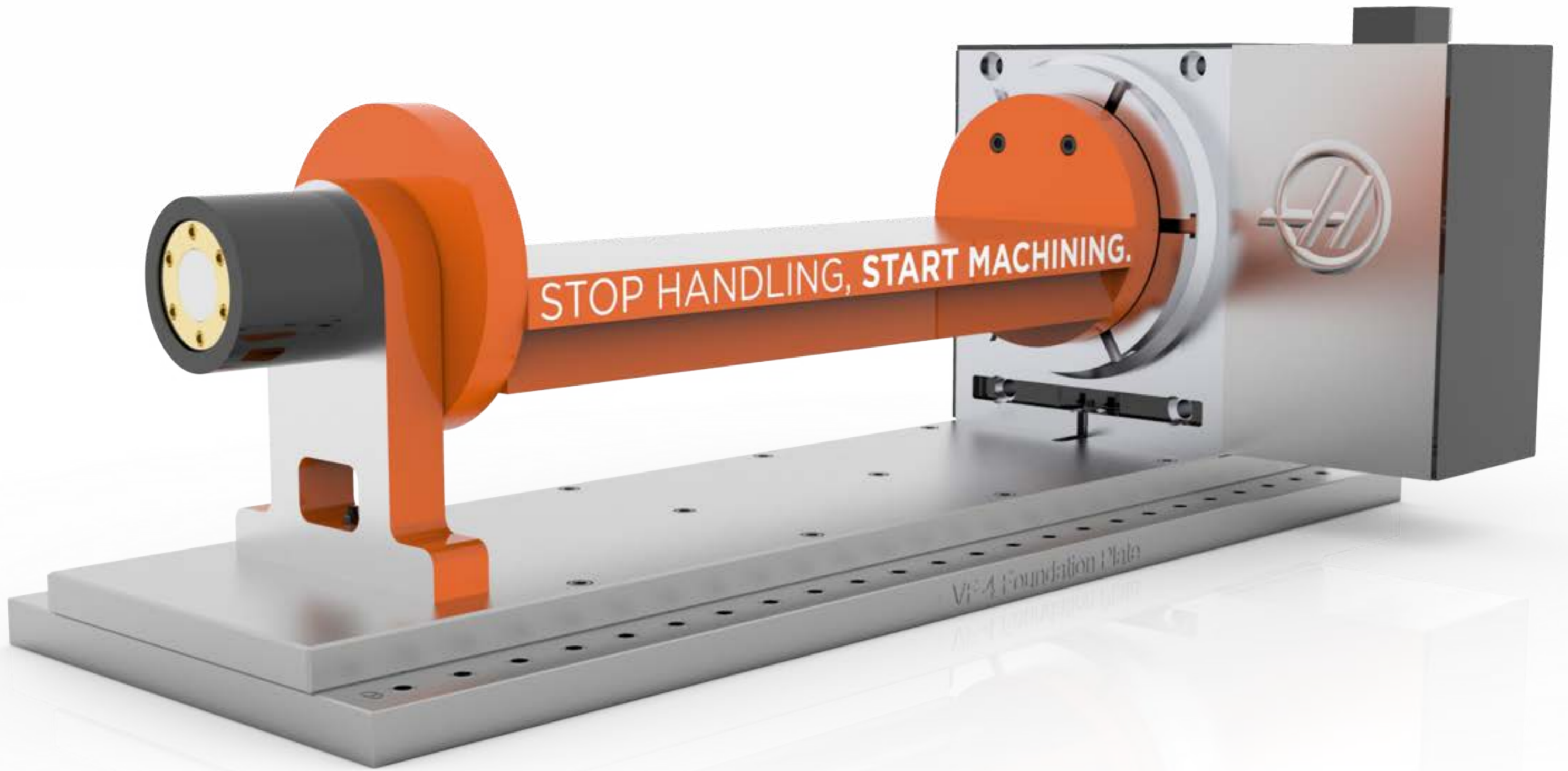
Foundation Plate

The Stallion 9/35 Trunnion Table is ideal for larger rotary tables (250-350mm) and features a heavy-duty, ribbed class #35 casting for maximum rigidity. The TS1200 braking system is highly recommended for off-center milling.

- 9" x 35" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

**STOP
HANDLING
START
MACHINING.**





Stallion 10/30 Trunnion Table

Available Options



TS1200 Braking System



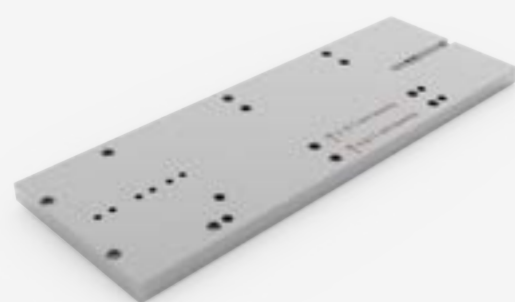
Workholding Systems



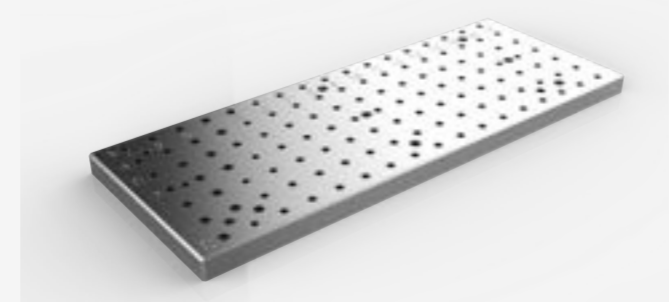
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

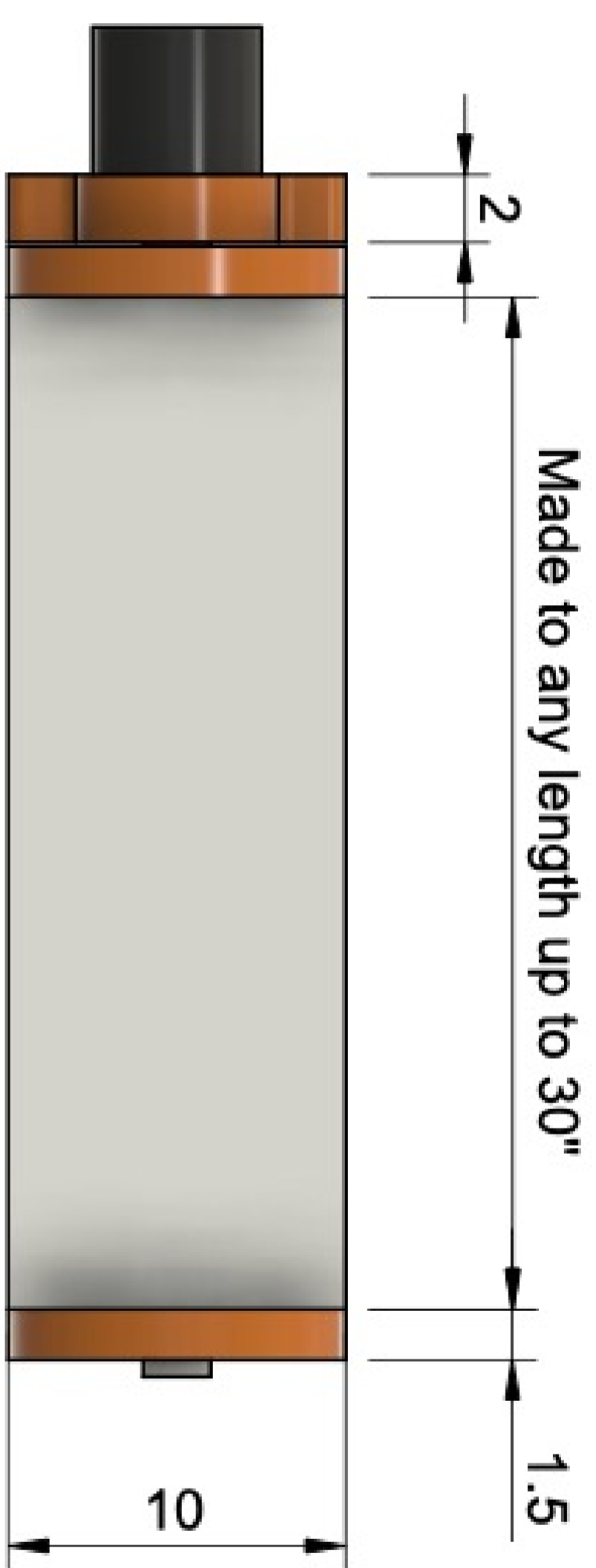


Foundation Plate

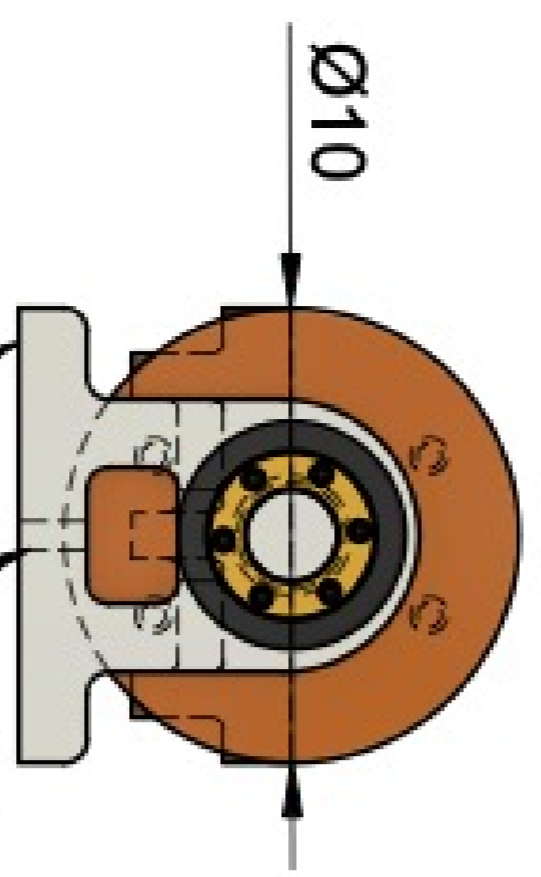
The Stallion 10/30 Trunnion Table is ideal for larger rotary tables (250-350mm) and features a heavy-duty, ribbed class #35 casting for maximum rigidity. The TS1200 braking system is highly recommended for off-center milling.

- 10" x 30" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

**STOP
HANDLING
START
MACHINING.**

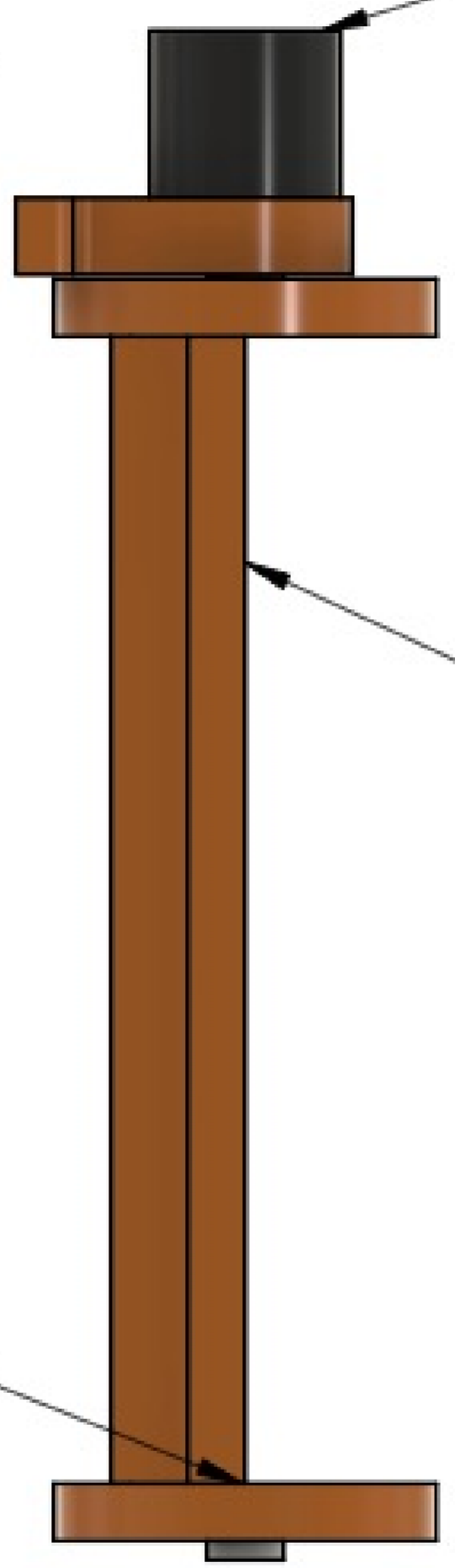


Optional brake for added rigidity



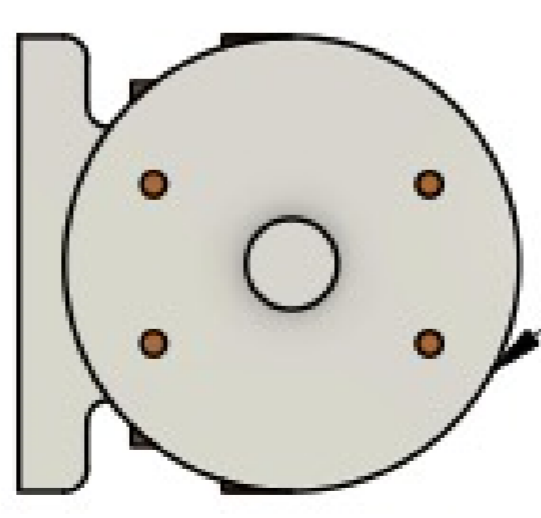
Hole in outboard support to mount to machine table

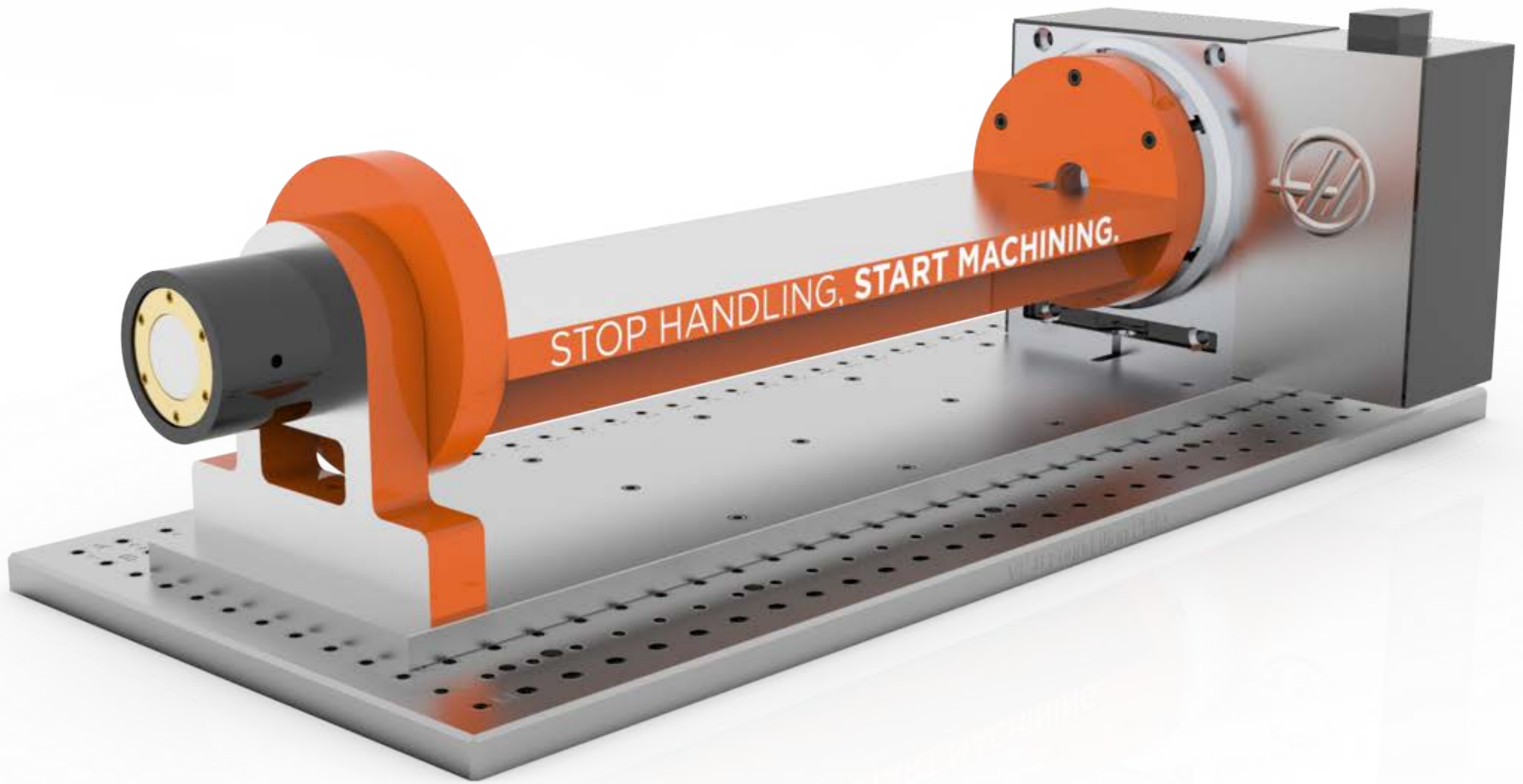
Outboard support made to match center height of rotary table



Surface of trunnion flat and square to faceplate

Bolt pattern and plug made for rotary table





Stallion 12/48 Trunnion Table

Available Options



TS3500 Braking System



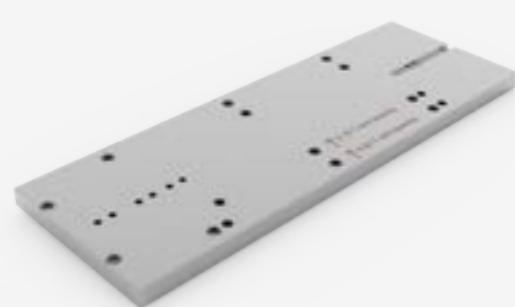
Workholding Systems



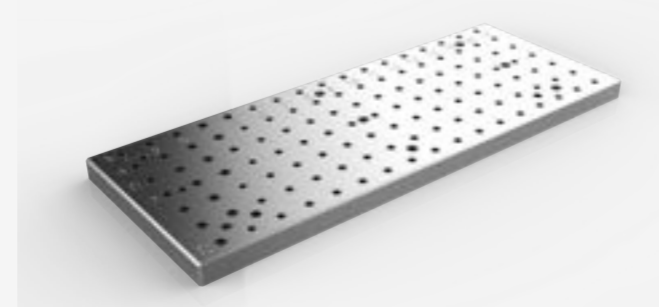
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

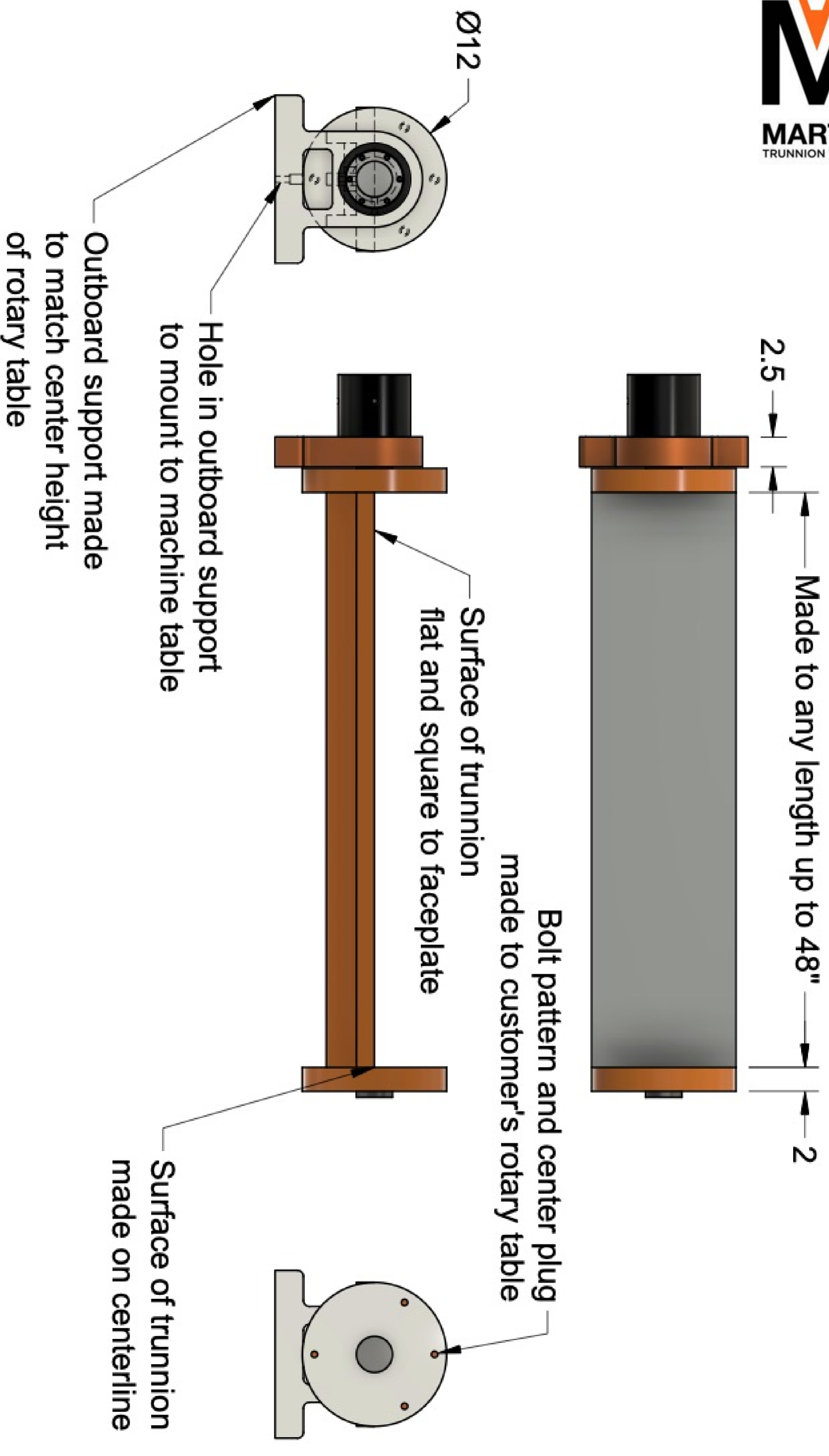


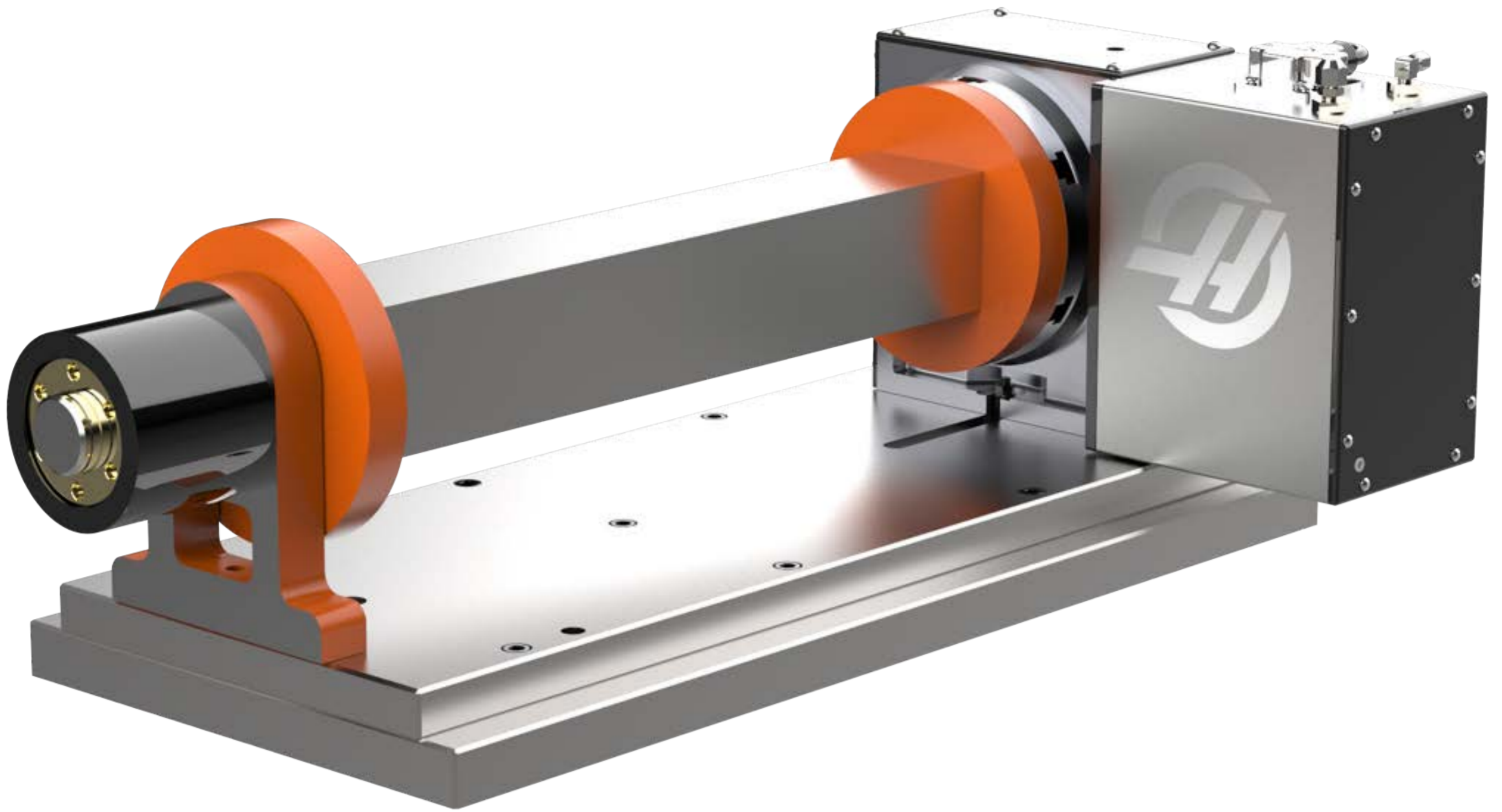
Foundation Plate

The Stallion 12/48 is designed for the industry's largest and most powerful rotary tables. The casting features ribbing engineered specifically for maximum rigidity and vibration damping.

- 12" x 48" working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

**STOP
HANDLING
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MACHINING.**





Stallion 4" Tombstone Trunnion

Available Options



TS1200 Braking System



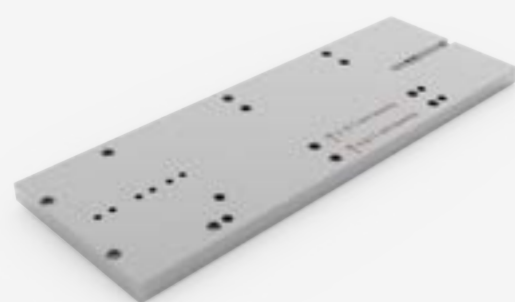
Workholding Systems



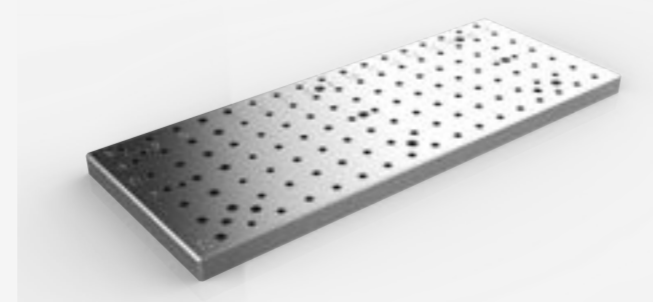
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

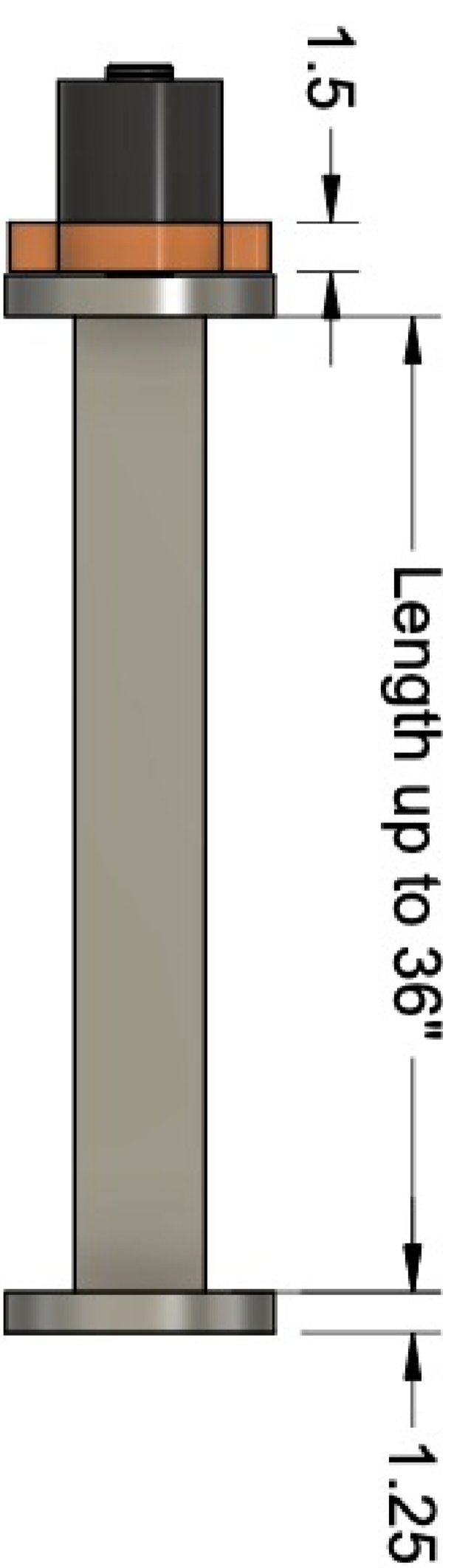


Foundation Plate

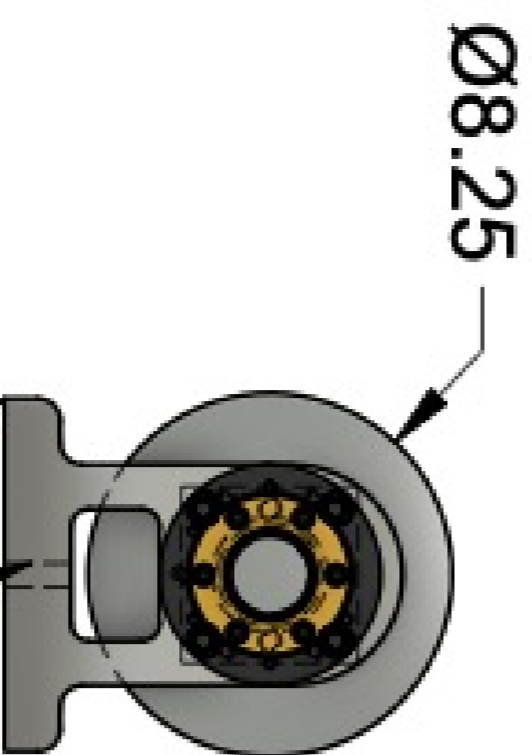
The Stallion 4" tombstone is designed for high-volume jobs and can be manufactured up to 36" in working surface length. This fixture is made from class #35 cast iron and can be outfitted with custom or standard grid patterns.

- 4" x custom length working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

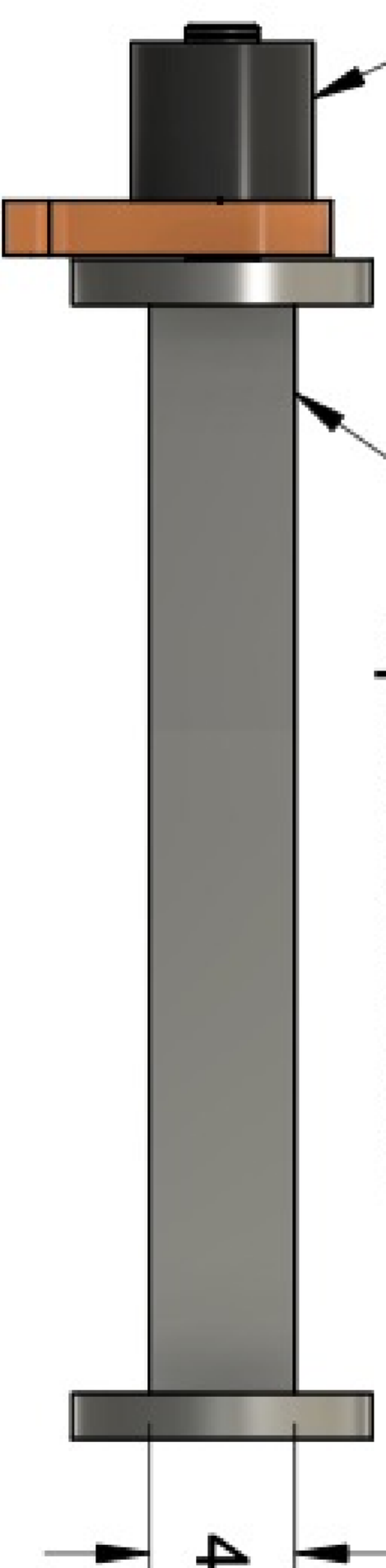
**STOP
HANDLING
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MACHINING.**



Optional braking system
for added rigidity

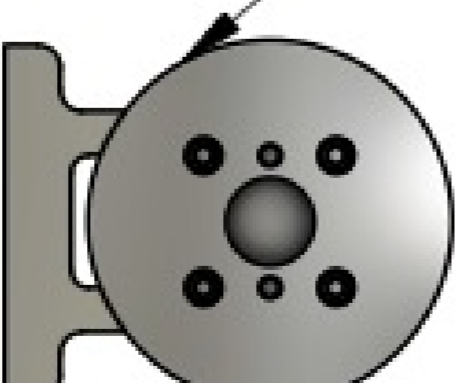


Hole in outboard to mount
to machine table



Ground flat and
square within .001

Outboard support made to match
rotary table center height



Bolt pattern and center plug
made for rotary table



Stallion 6" Tombstone Trunnion

Available Options



TS1200 Braking System



Workholding Systems



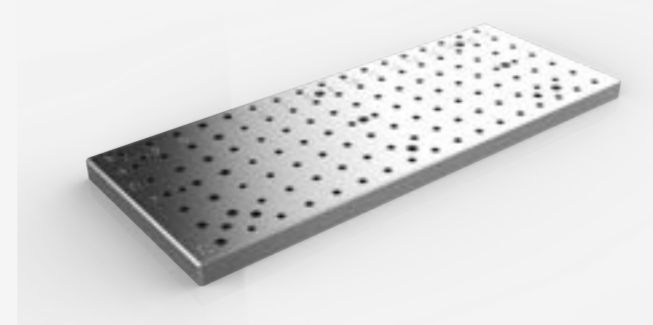
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

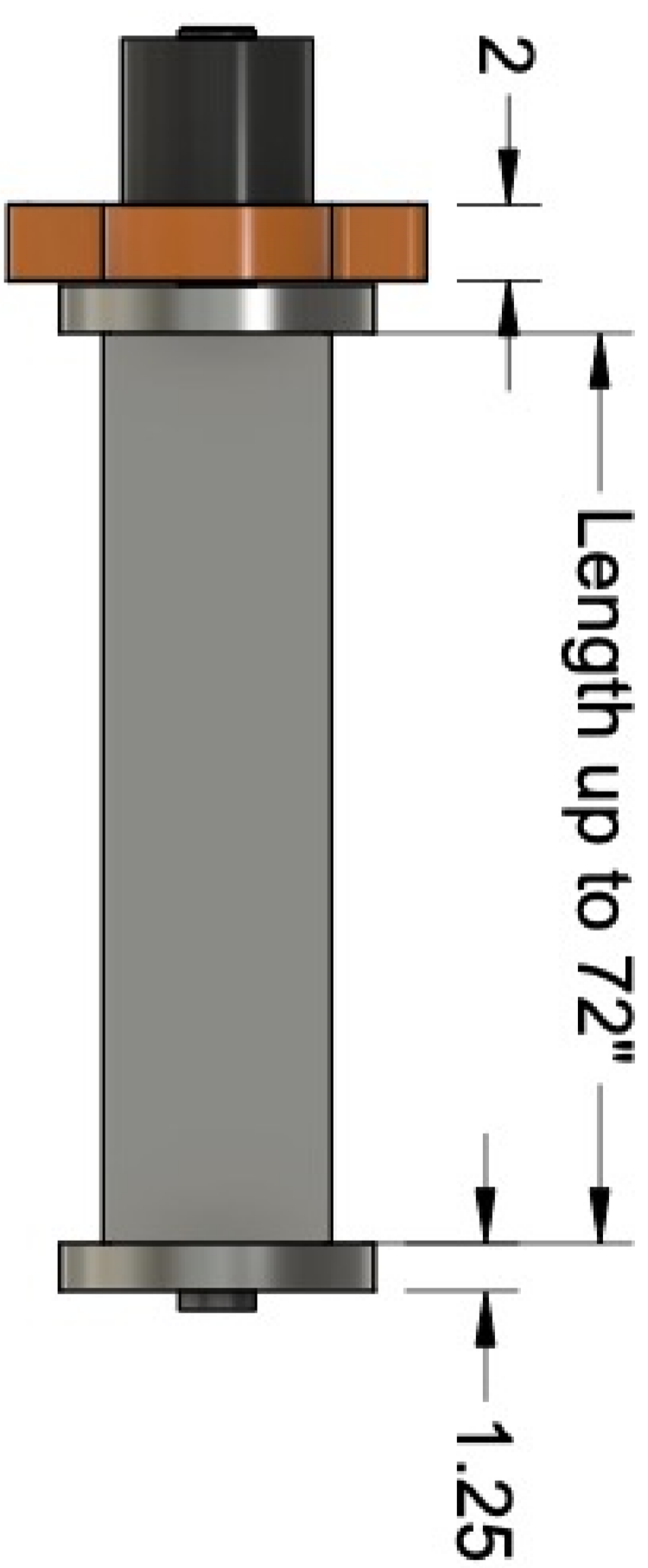


Foundation Plate

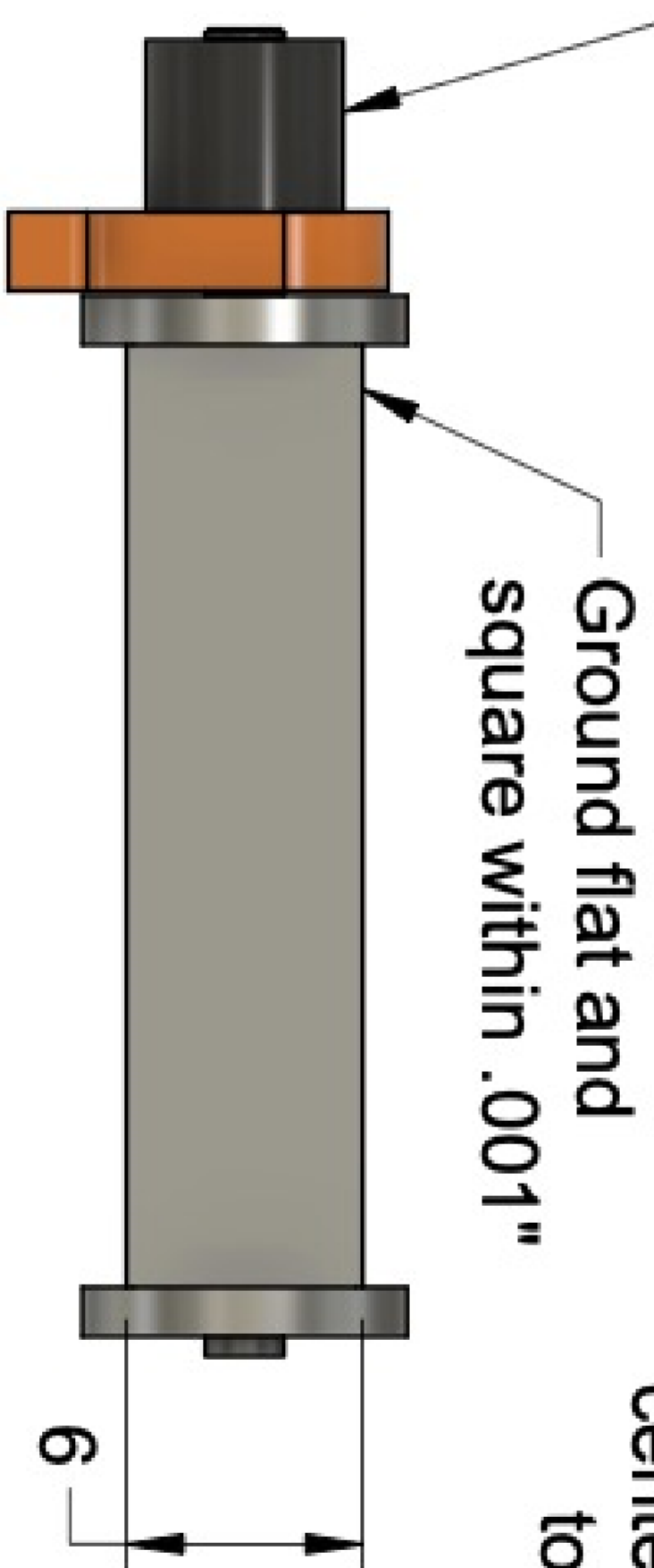
The Stallion 6" tombstone is designed for high-volume jobs and can be manufactured up to 70" in working surface length. This fixture is made from class #35 cast iron and can be outfitted with custom or standard grid patterns.

- 6" x custom length working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

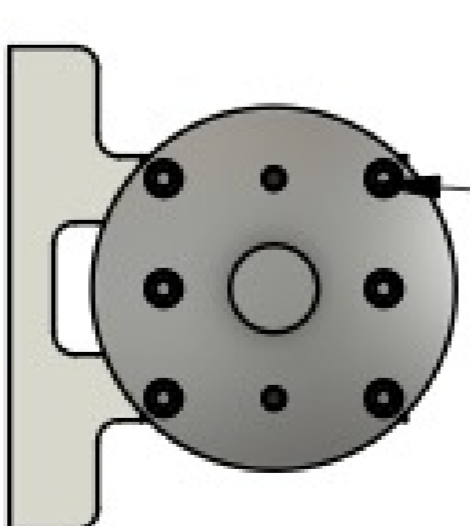
**STOP
HANDLING
START
MACHINING.**



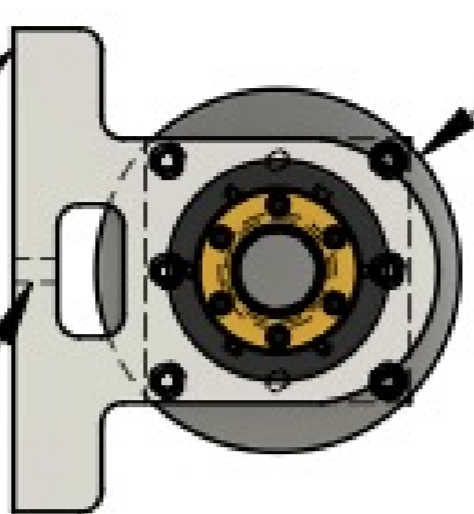
Optional brake for added rigidity



Bolt pattern and center plug made to rotary table

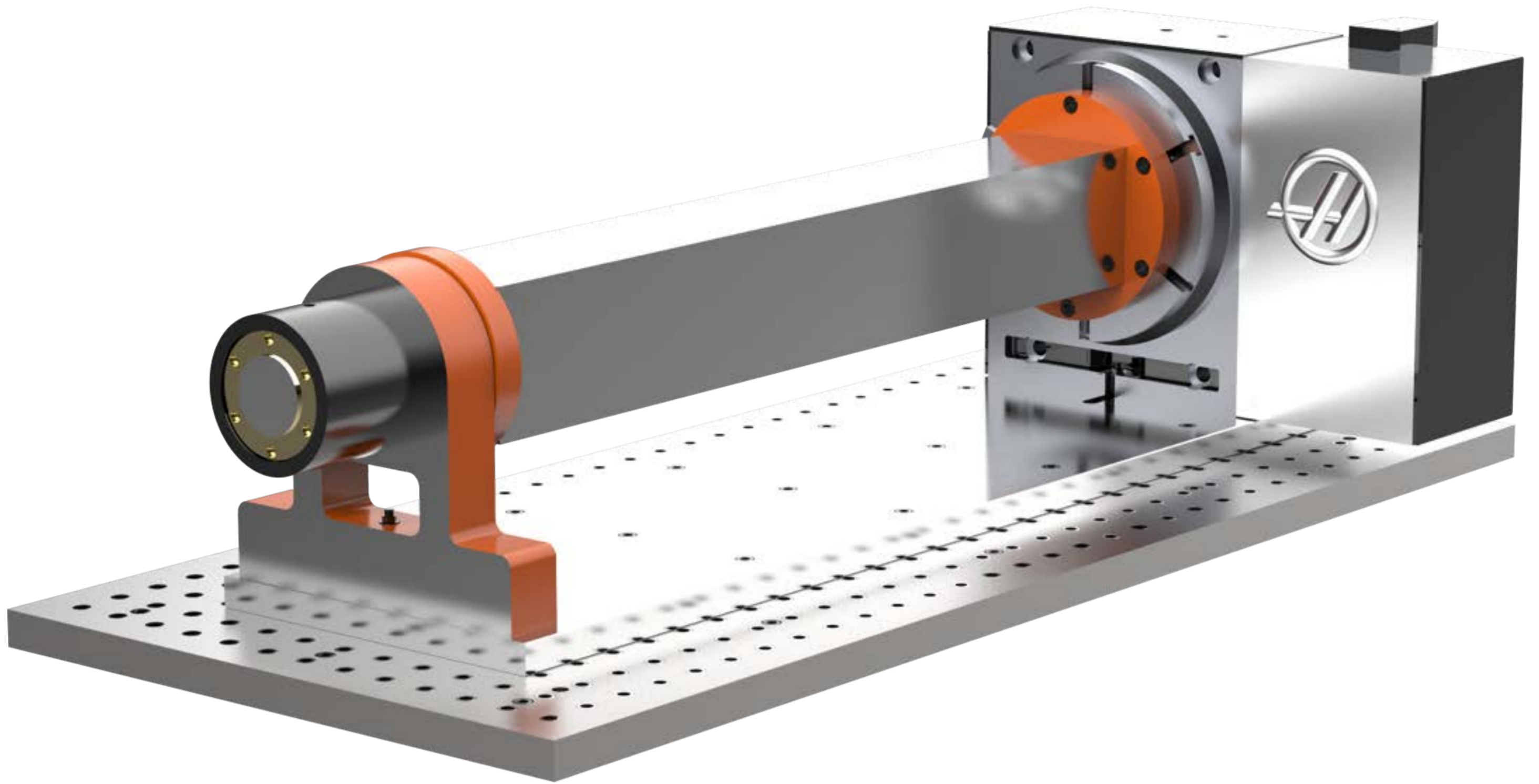


Ø8.25



Hole in outboard for mounting to machine table

Center height of outboard matched to rotary table



Stallion 8" Tombstone Trunnion

Available Options



TS3500 Braking System



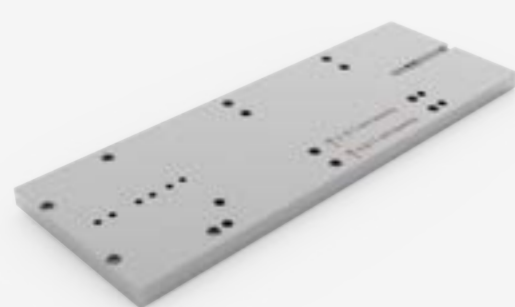
Workholding Systems



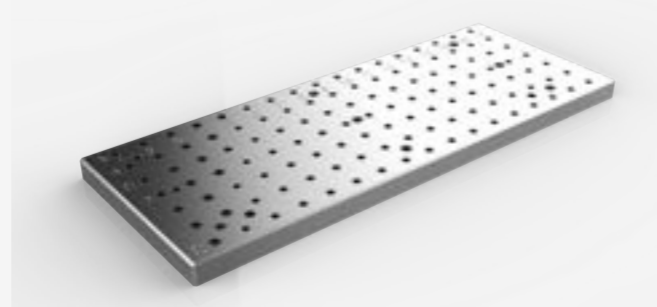
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

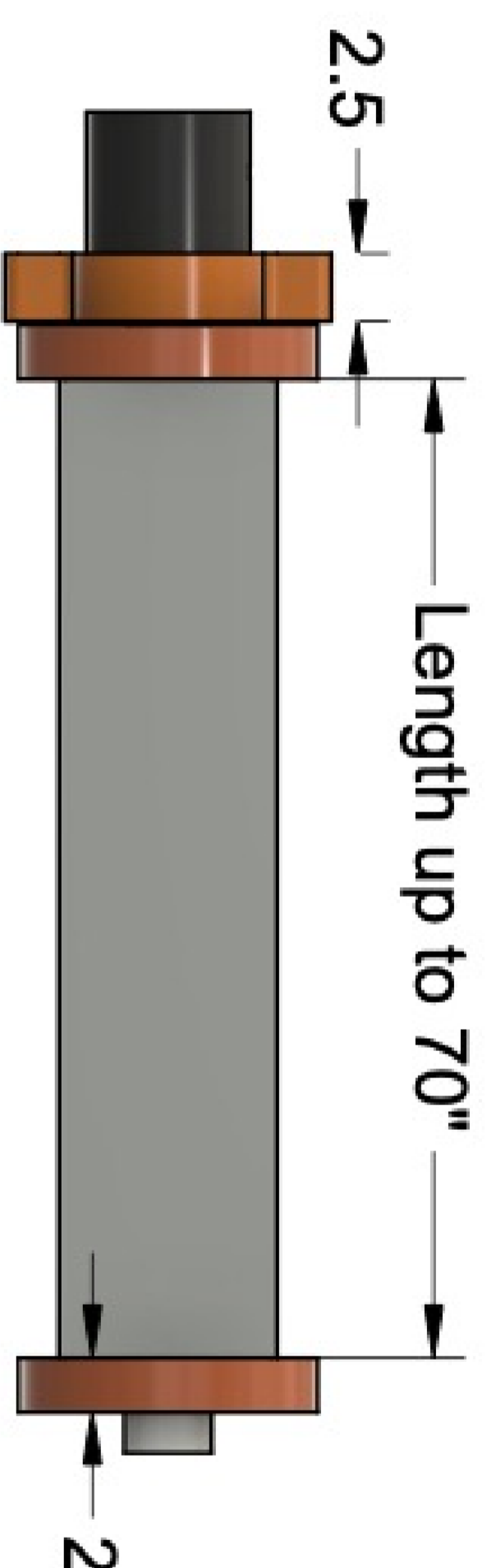


Foundation Plate

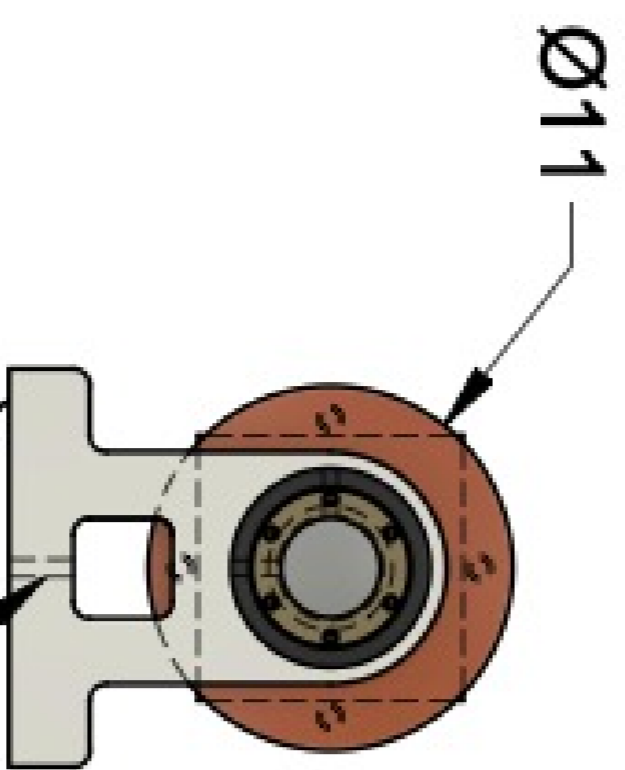
The Stallion 8" tombstone is designed for high-volume jobs and can be manufactured up to 70" in working surface length. This fixture is made from class #35 cast iron and can be outfitted with custom or standard grid patterns.

- 8" x custom length working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

**STOP
HANDLING
START
MACHINING.**

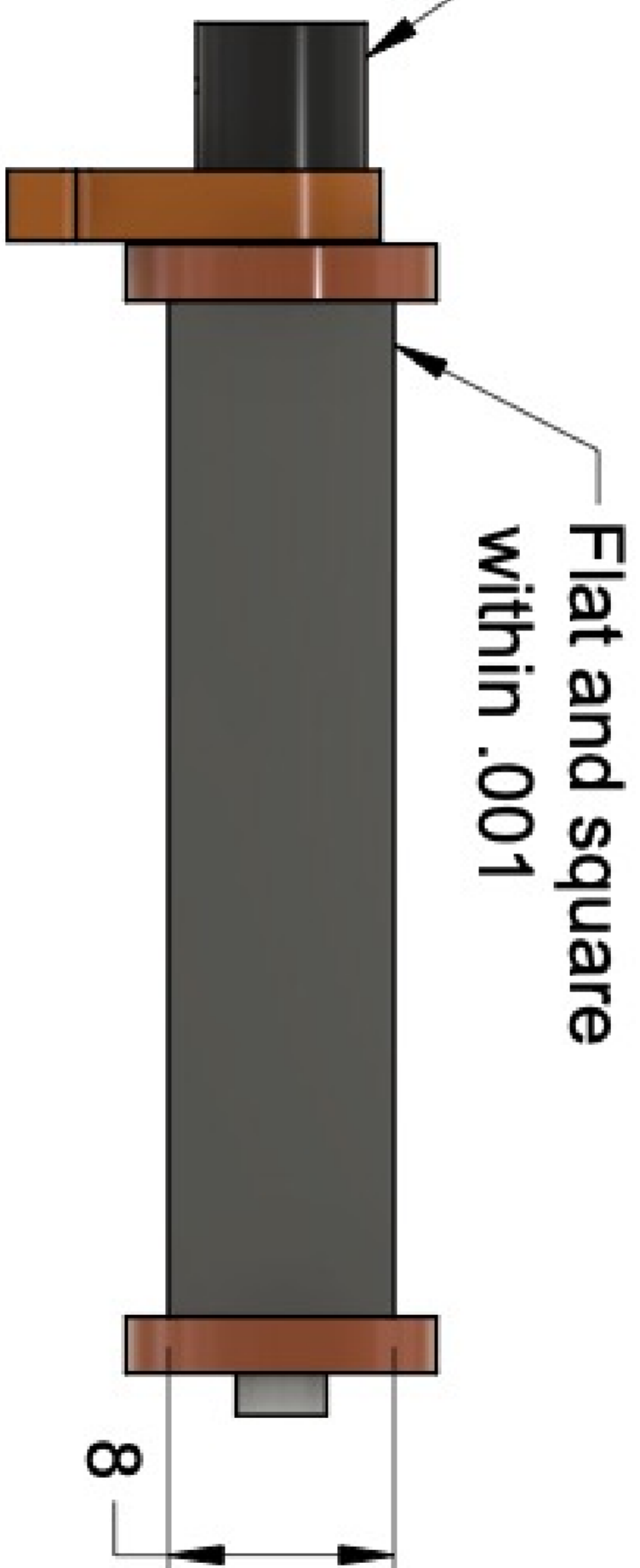


Optional braking system
for added rigidity

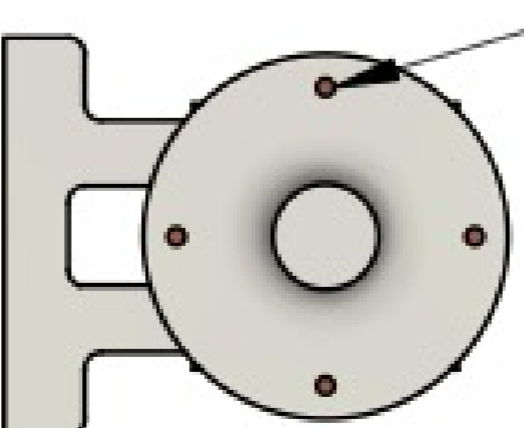


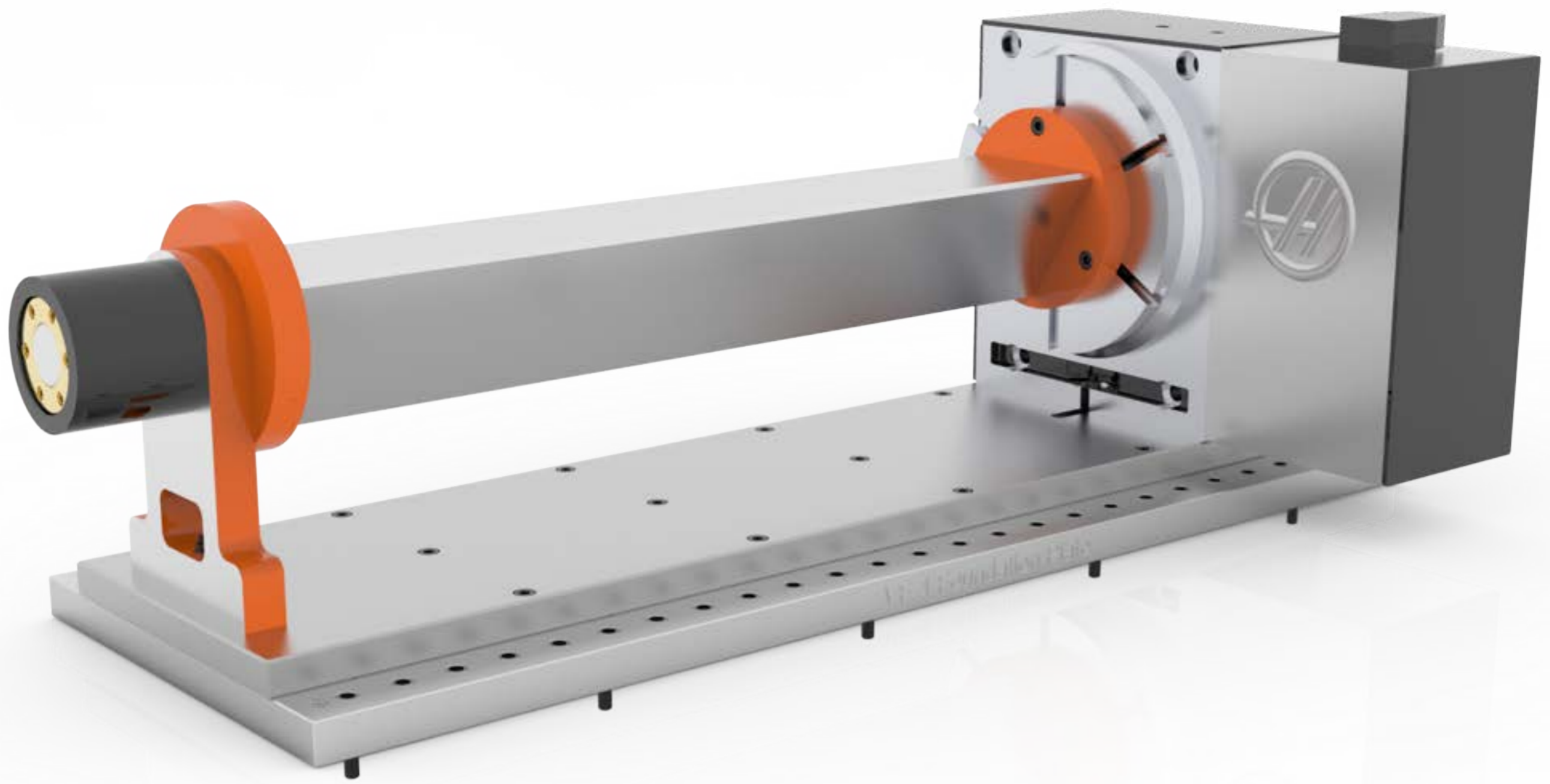
Hole in outboard support
for mounting to machine table

Outboard support made to rotary
table center height



Bolt pattern and
center plug made for
rotary table





Stallion Multisided Trunnion

Available Options



TS1200 Hydraulic Brake



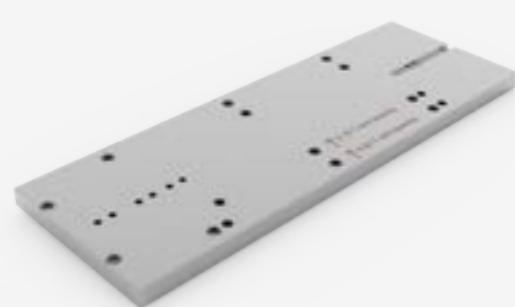
Workholding Systems



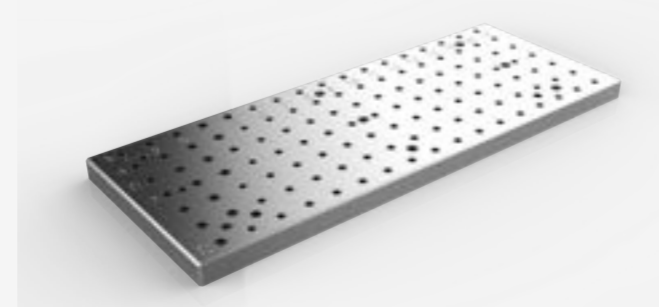
Grid Patterns



Ball Lock Fixture Plates



Universal Baseplate

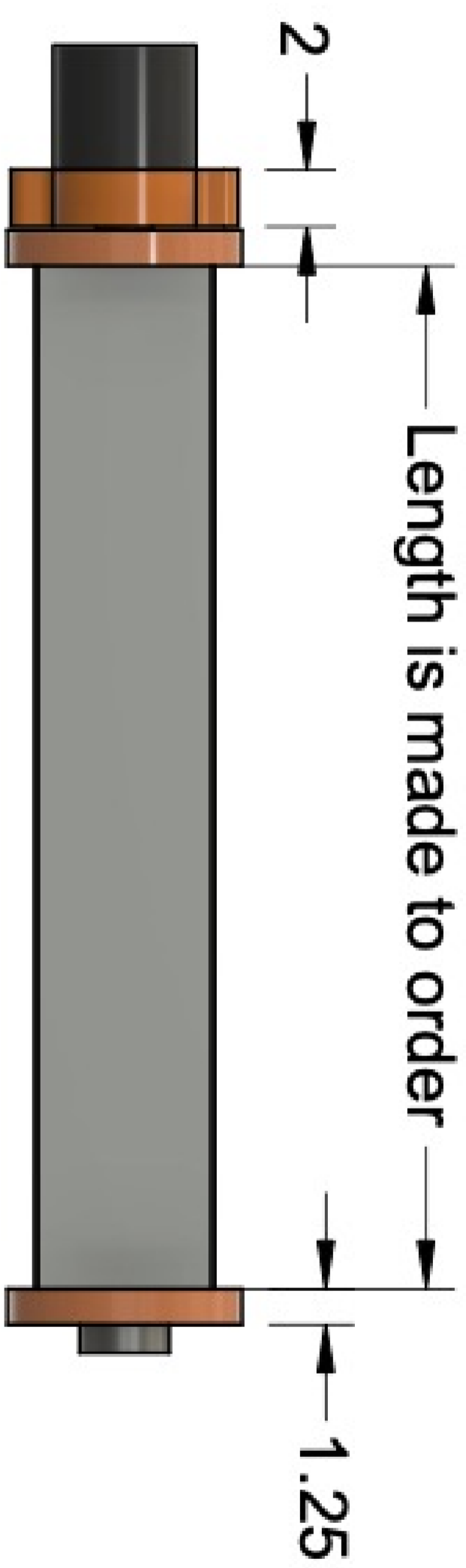


Foundation Plate

The Stallion Triangle presents the perfect blend of productivity and tool clearance. These fixtures are made to order and the dimensions are customizable within reason. 6 and 8 sided trunnions are also available.

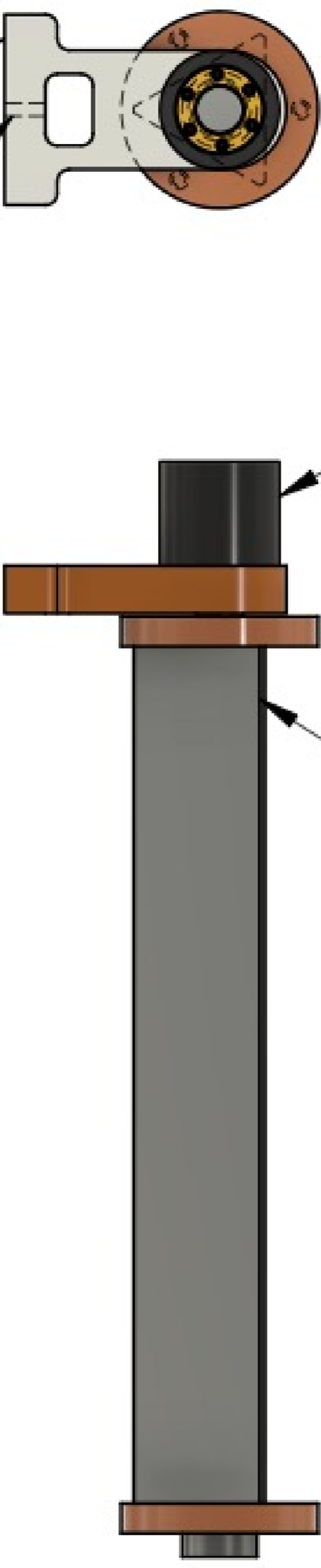
- Custom length and width of working surface
- Class #35 cast iron
- Matched to rotary table center height and mounting pattern

**STOP
HANDLING
START
MACHINING.**



Optional brake for added rigidity

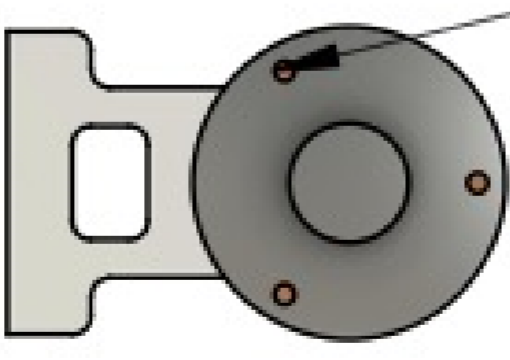
Surfaces of trunnion flat and square to faceplate



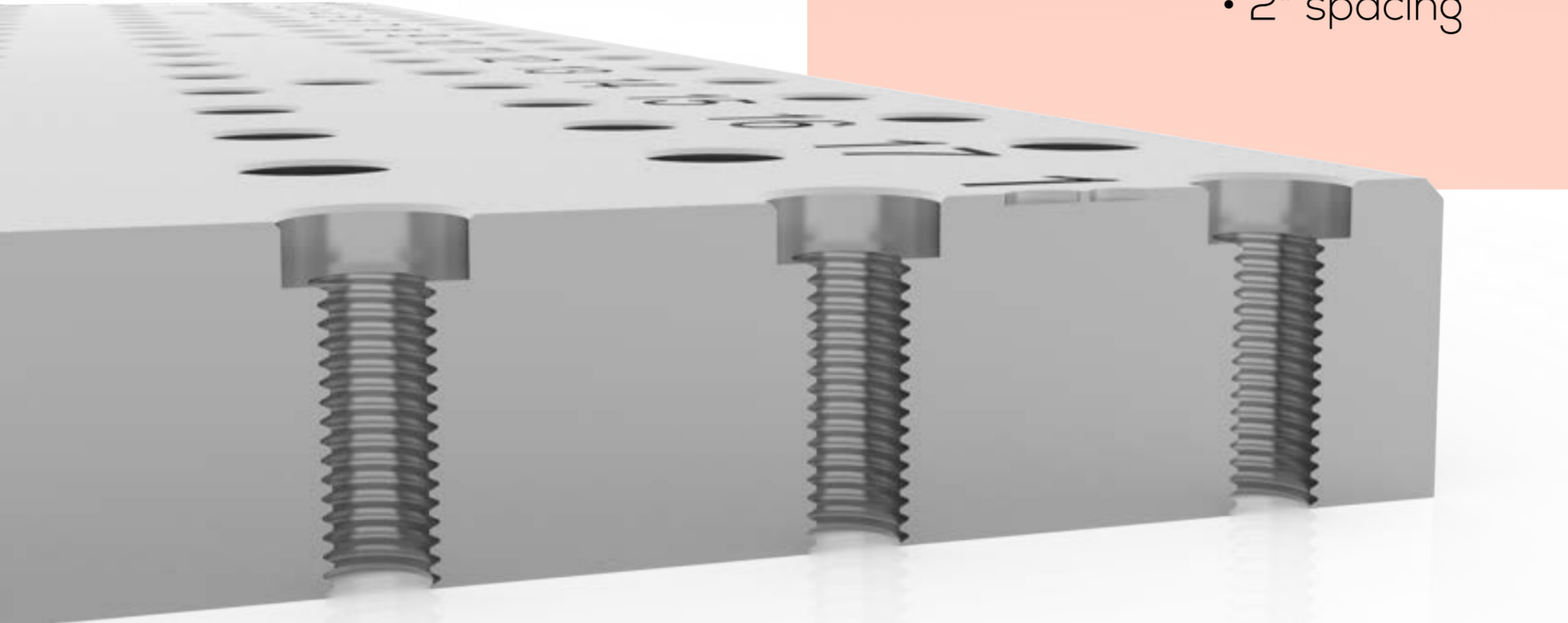
Hole in outboard for mounting to machine table

Outboard center height made to match rotary table

Bolt pattern and centering plug made for rotary table

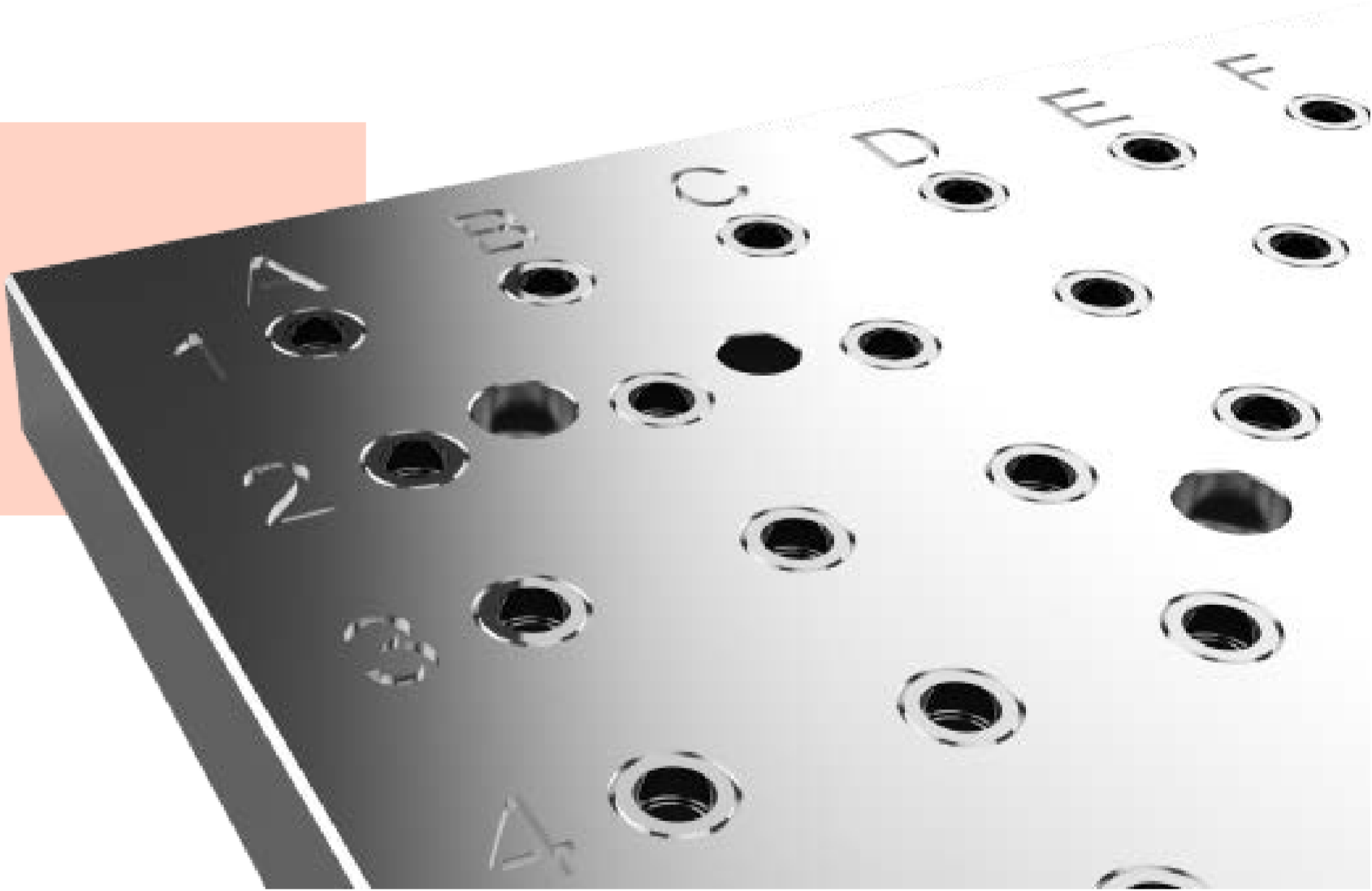


Foundation Plates for Vertical Machining Centers

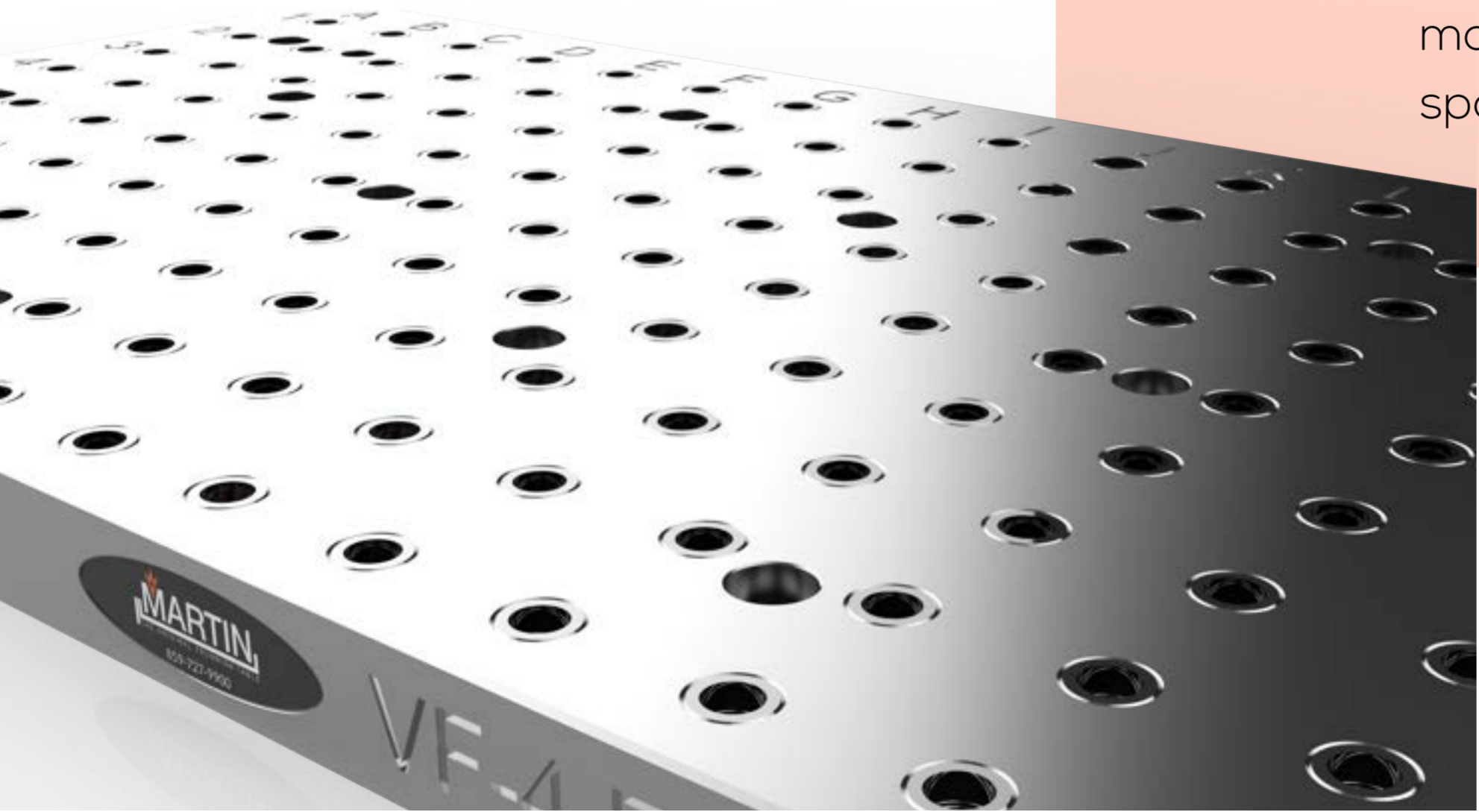


- 1/2-13 tapped holes
- .501 Id hardened bushings
- 2" spacing

- Alpha Numeric Labeling Included
- Flat and square within .001"

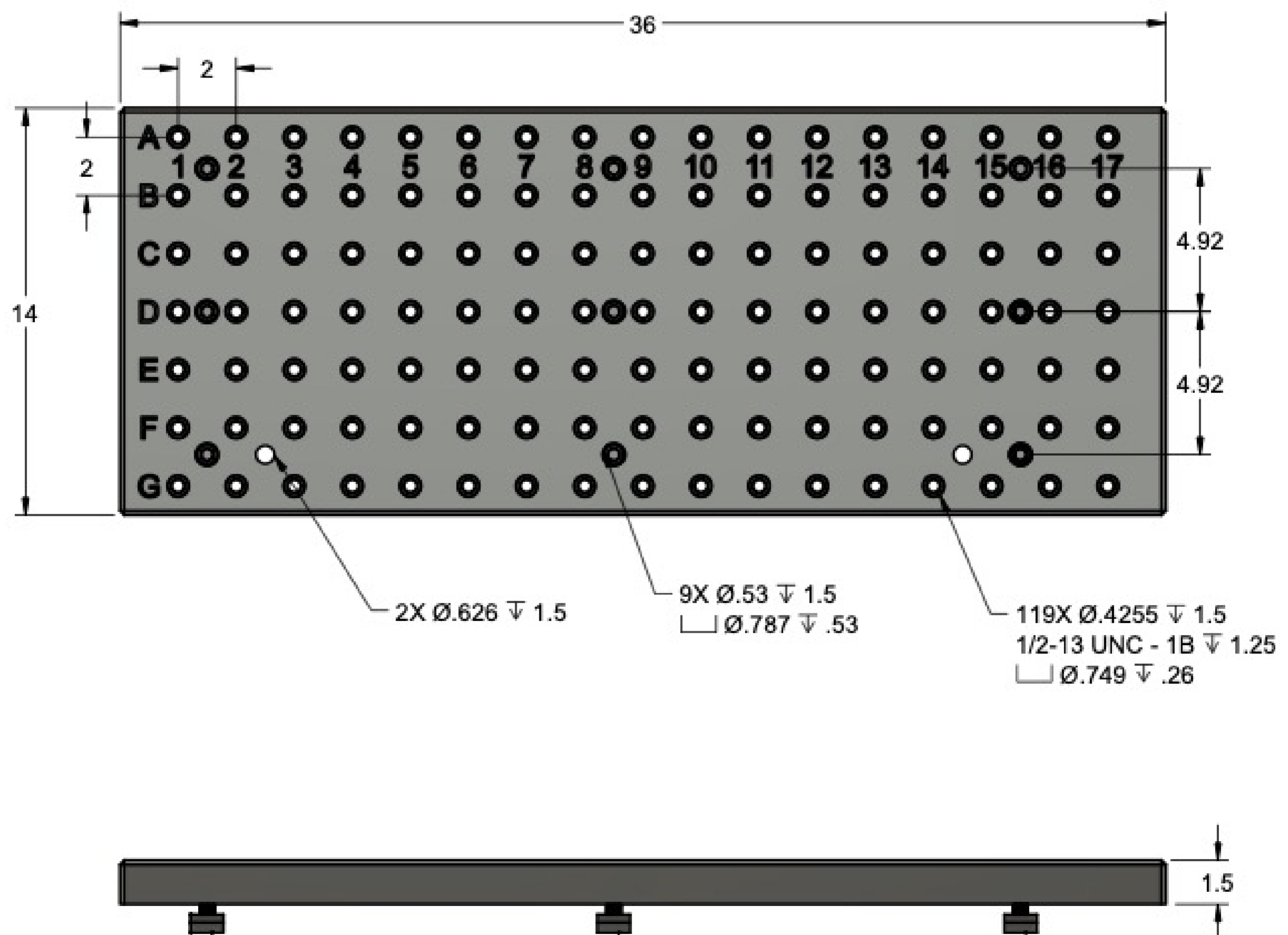


- Counterbored holes are matched to customer's T-slot spacing





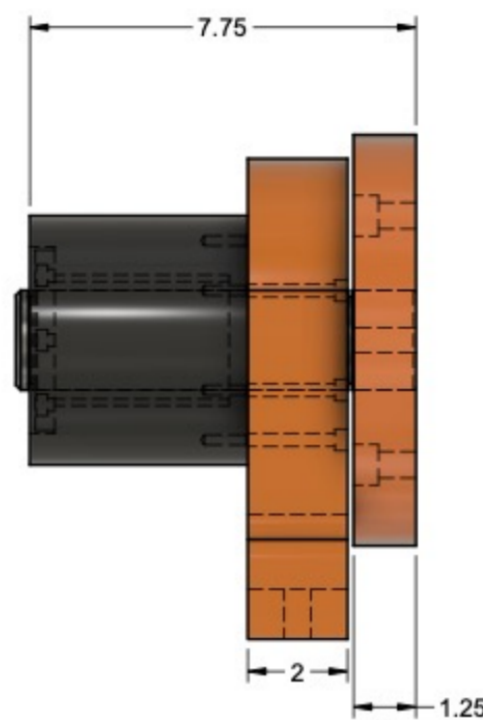
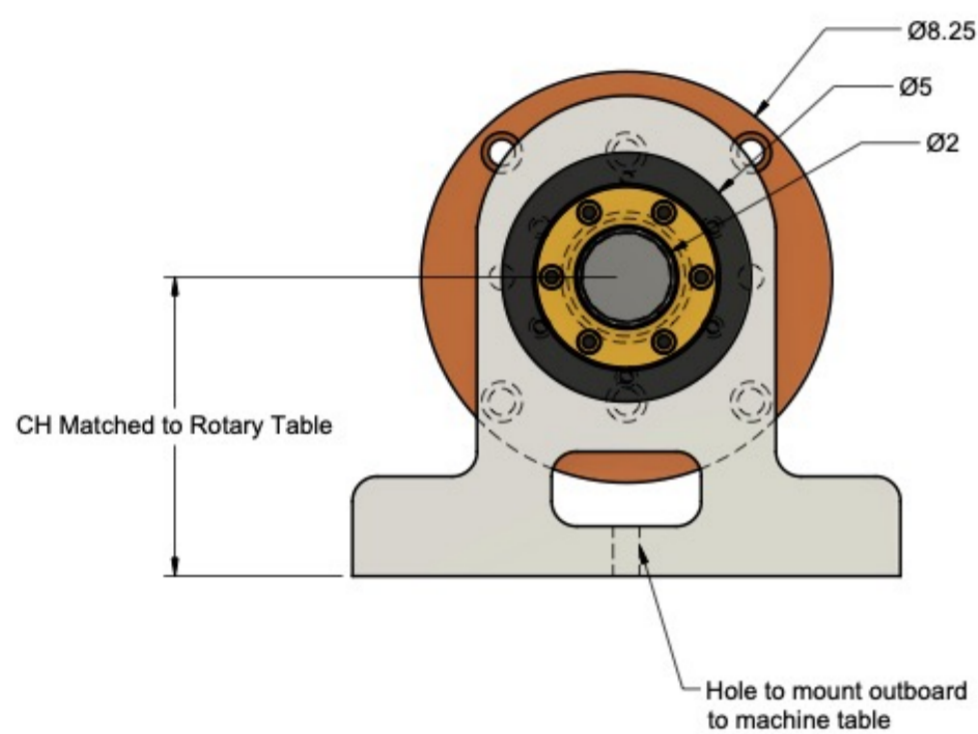
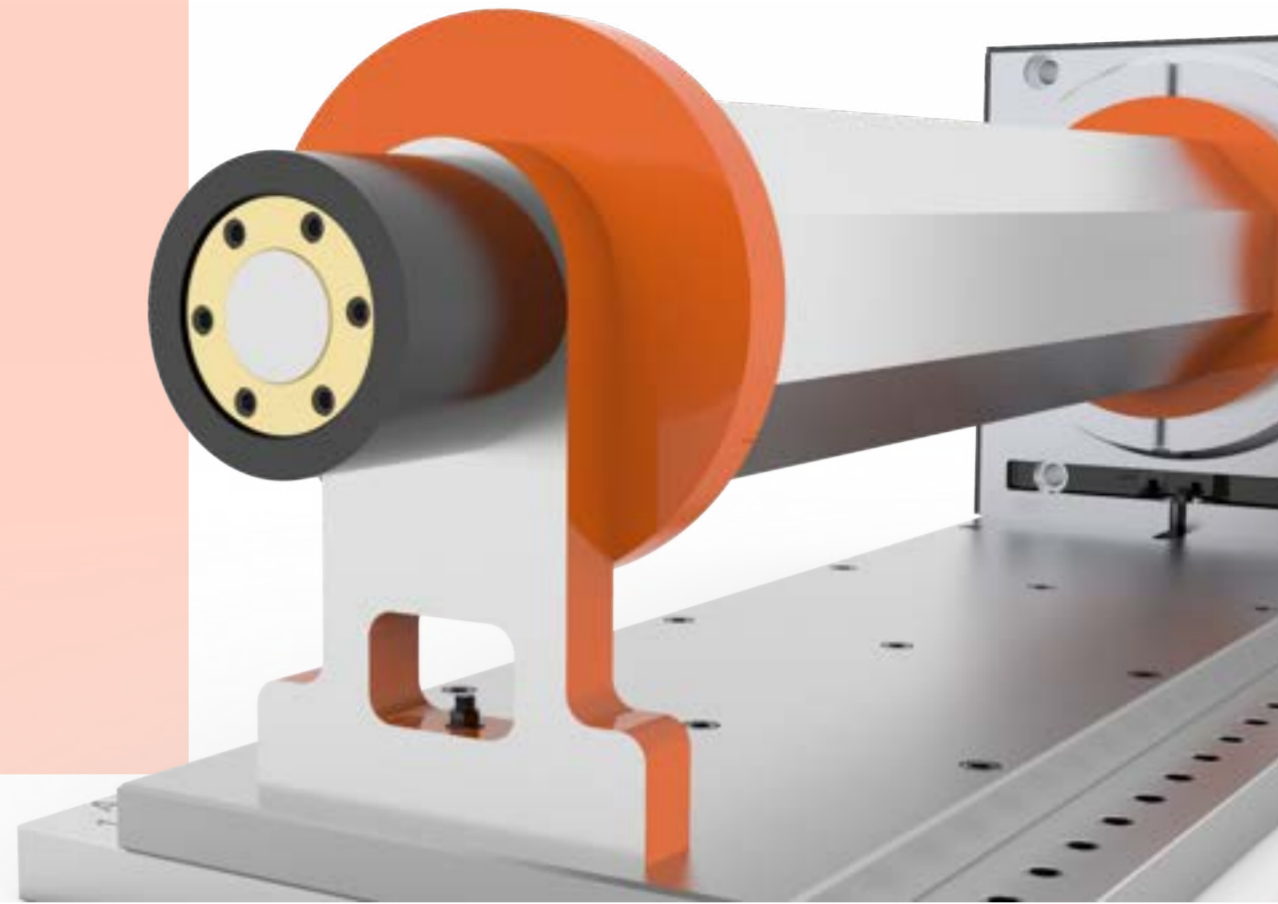
Ditch the T-Slots. Achieve ultimate modularity and repeatability in your CNC.



Braking Systems for CNC Rotary Tables

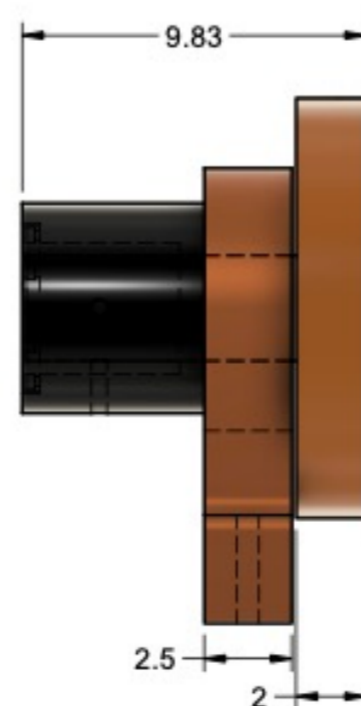
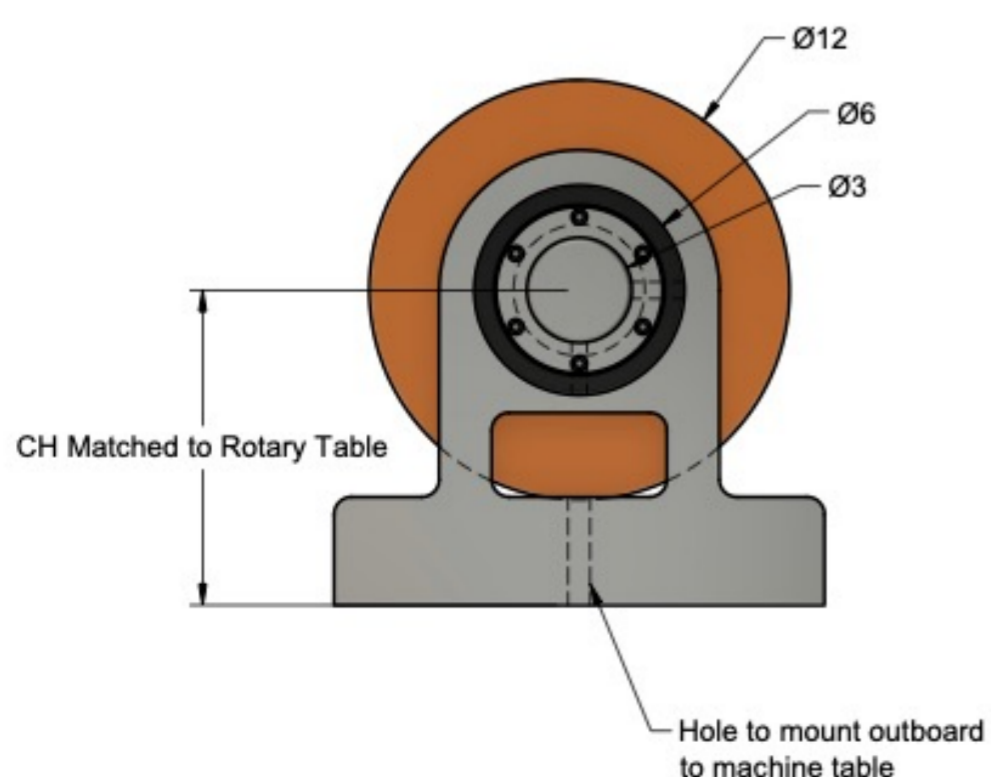
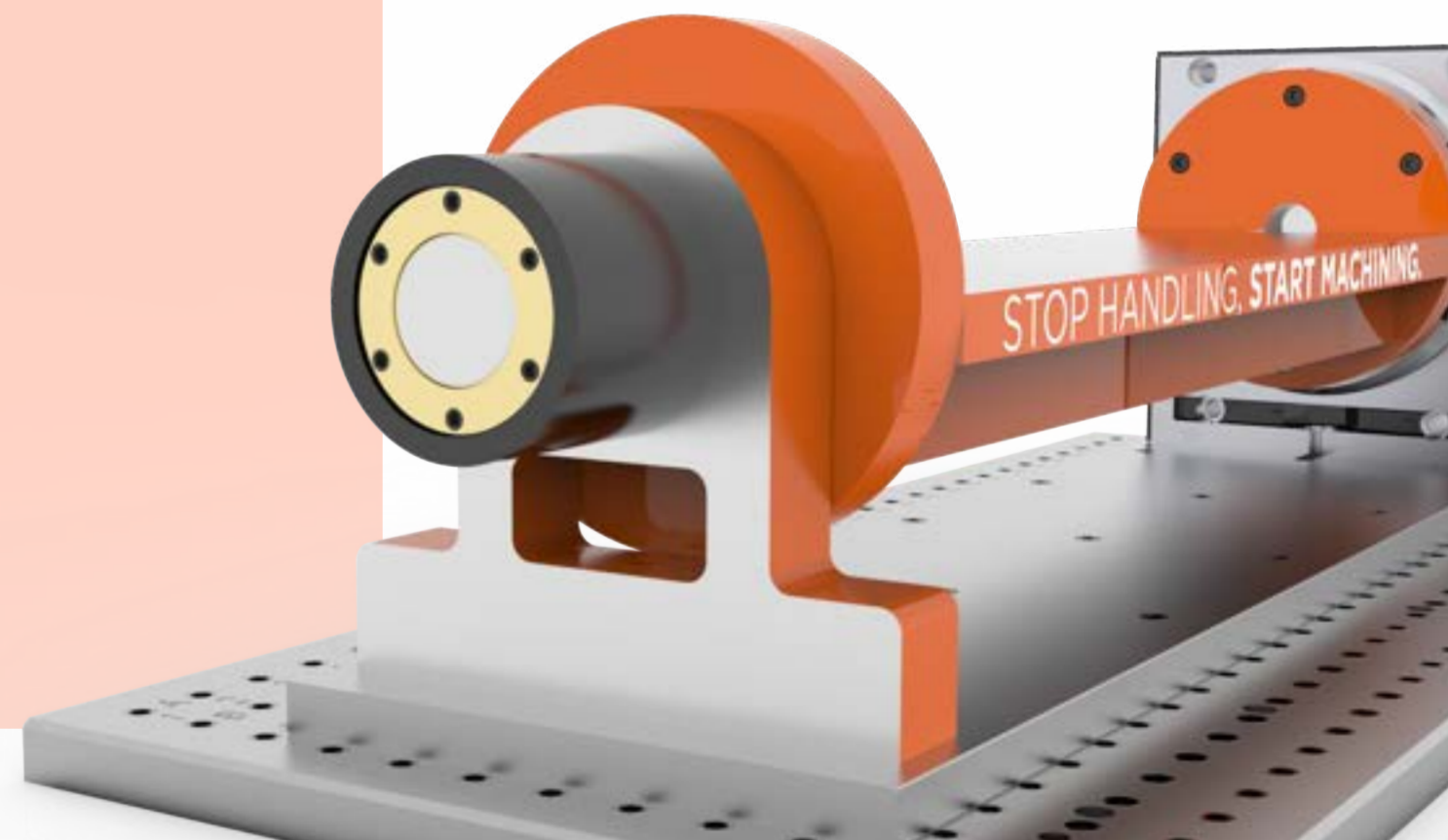
TS1200 Hydraulic Brake

- Utilizes an air-over oil booster for hydraulic pressure.
- Connects straight to the solenoid valve of the rotary table.
- 500 ft. lbs. of clamping torque at 100 psi.
- Clamps on 2" shaft.



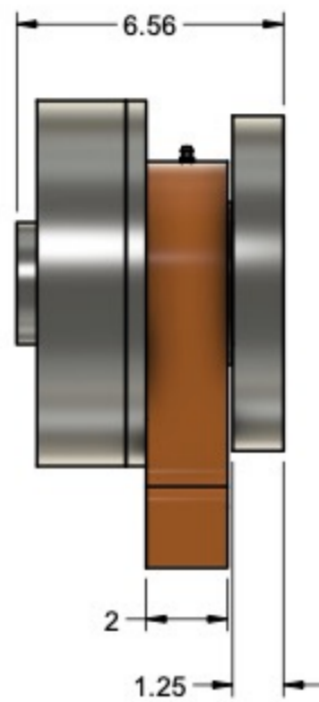
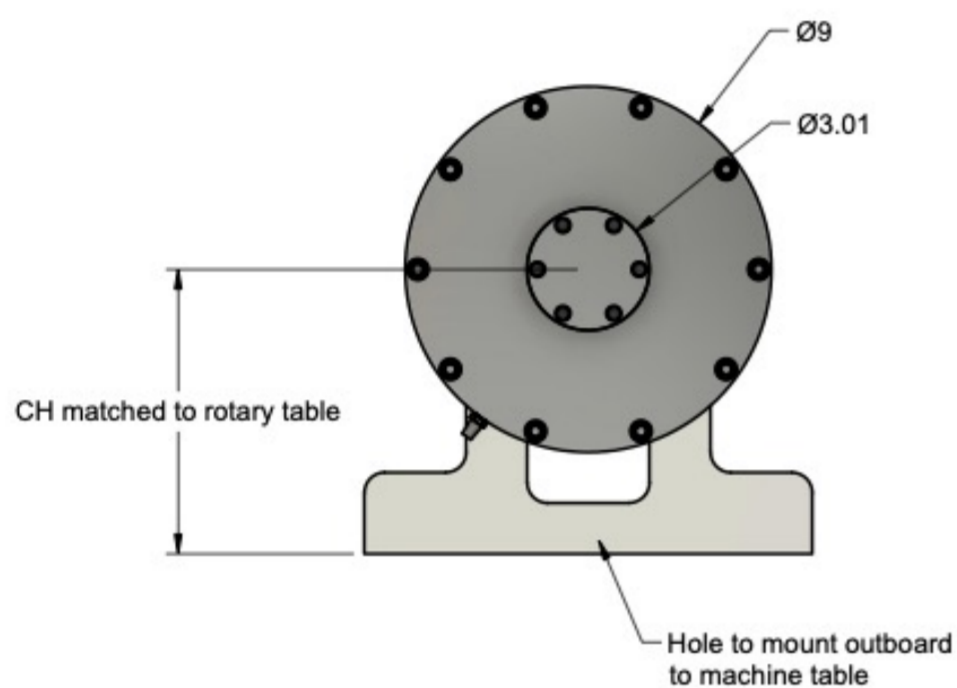
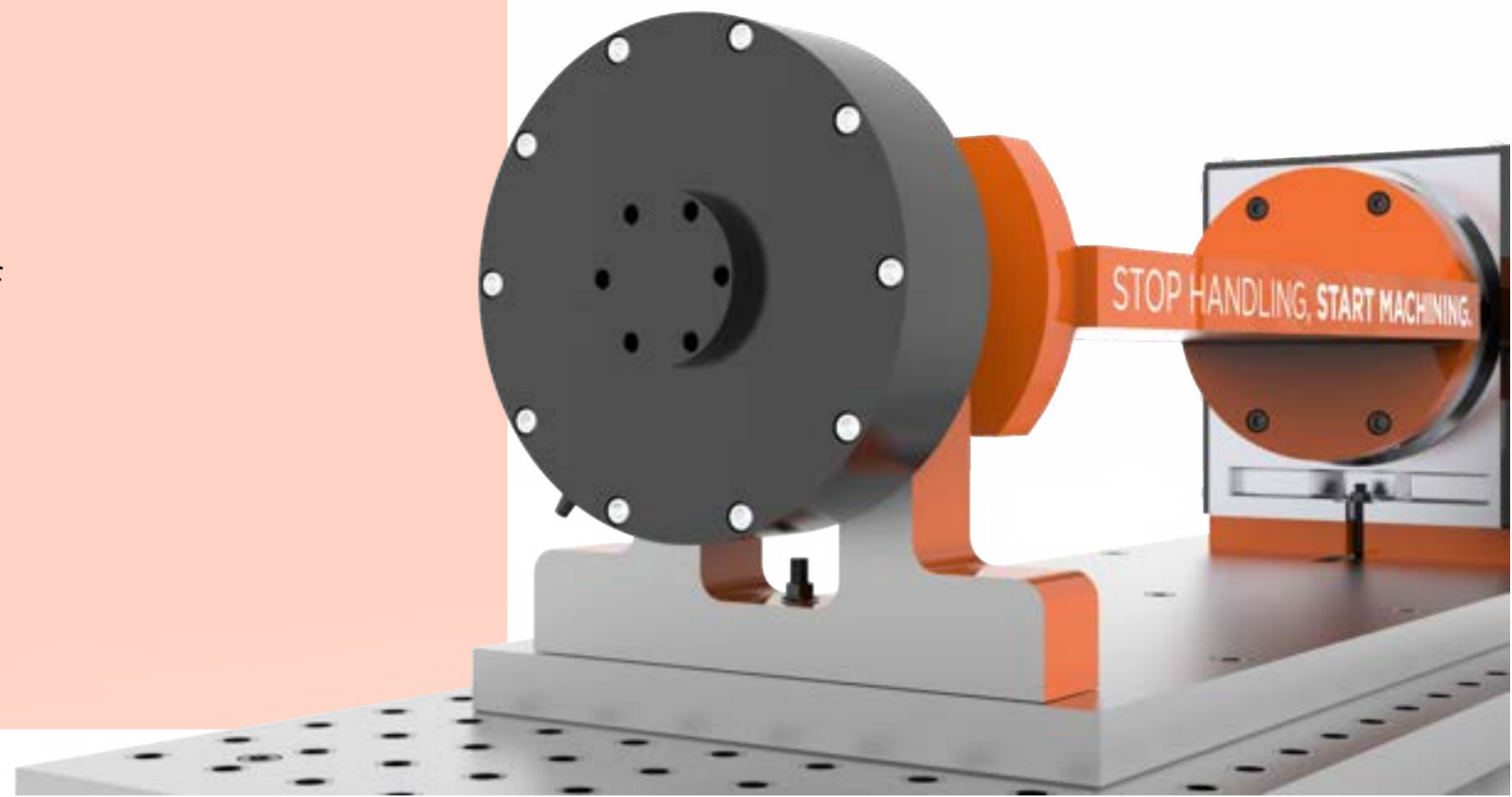
TS3500 Hydraulic Brake

- Utilizes an air-over oil booster for hydraulic pressure.
- Connects straight to the solenoid valve of the rotary table.
- 900 ft. lbs. of clamping torque at 100 psi.
- Clamps on 3" shaft.



TS400 Pneumatic Brake

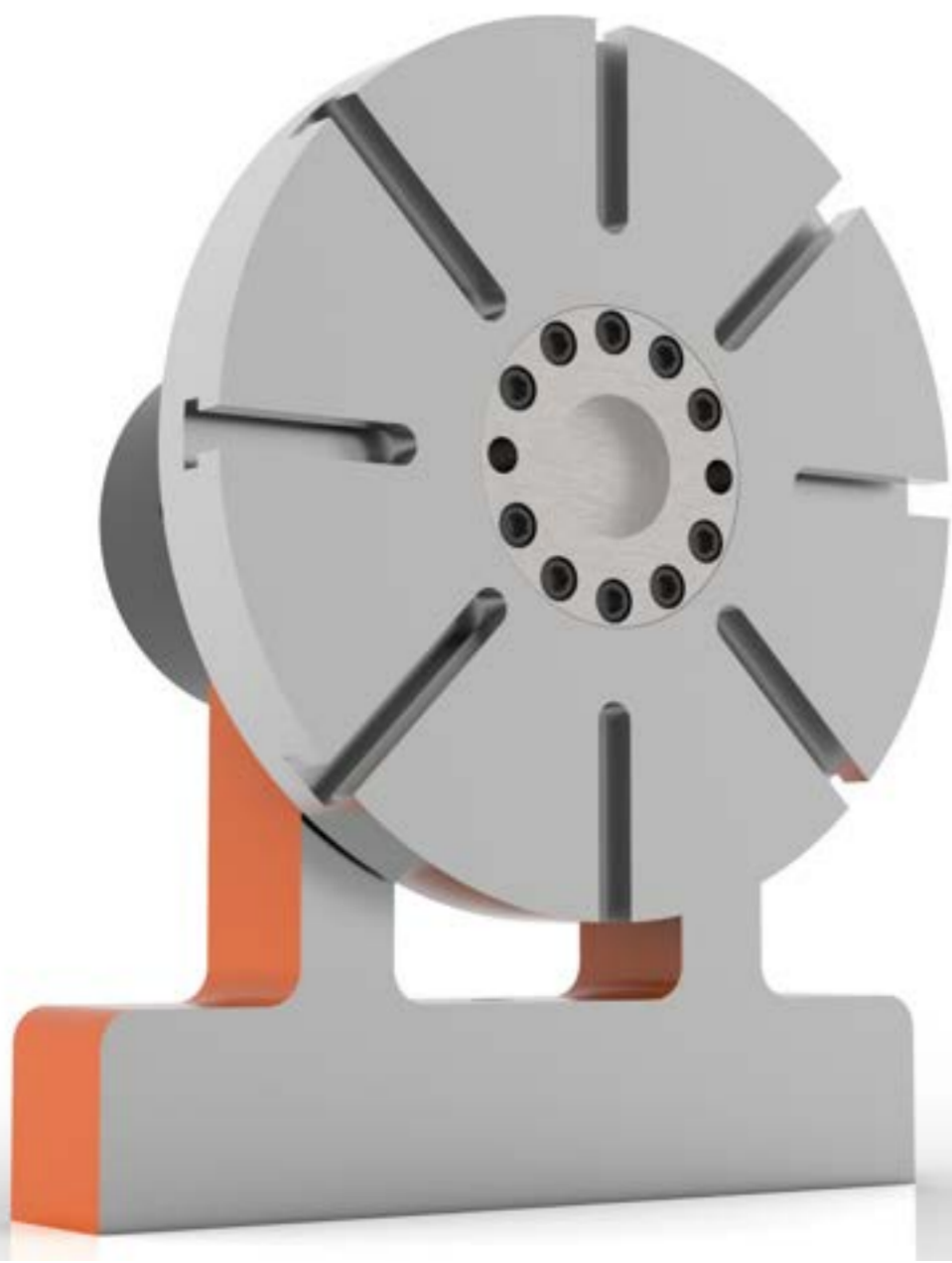
- Connects straight to the solenoid valve of the rotary table.
- 400 ft. lbs. of clamping torque at 100 psi.



Why Do I Need a Brake?

As trunnions or other fixtures increase in size, the rigidity of the standard rotary table brake often comes into question, especially if one is machining heavy, off-center features. Our braking systems aim to increase fixture rigidity during machining.

T-Slotted Faceplate Option



Hybrid Option



Comprehensive Automation Packages

1

Share your machine specs and project requirements

2

Our team creates a design proposal and quote

3

Complete solution is finalized

4

Workholding Assembly is manufactured

5

We work with you to ensure automation success



Vise mounting patterns are pre machined into the 4th axis trunnion table.



Vektek Rotary Union is mounted to rotary table for seamless pneumatics integration.



Pneumatic hardlines are mounted and tested by Martin Trunnion Tables.



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