S242
The flexible Machine for grinding and turning operations.

Key data
The S242 is a flexible hard-fine machining centre for grinding, turning and milling operations on medium-sized workpieces. It has a distance between centres of up to 1000 mm. It can machine workpieces with a maximum weight of 60 kg.
The name STUDER stands for more than 100 years of experience in the development and production of precision cylindrical grinding machines. «The Art of Grinding.» is our passion, highest precision is our aim and top Swiss quality is our benchmark.

Our product line includes both standard machines, as well as complex system solutions in high-precision cylindrical grinding for machining small and medium-sized workpieces. In addition we offer software, system integration and a wide range of services. As well as receiving a complete tailor-made solution the customer also benefits from our 100 years of know-how in relation to the grinding process.

Our customers include companies from the machine tool industry, automotive engineering, tool and die makers, the aerospace industry, pneumatics/hydraulics, electronics/electrical engineering, medical technology, the watch industry and job order production. They value maximum precision, safety, productivity and longevity. 22 000 manufactured and delivered systems make us the market leader and are clear evidence of our technological leadership in universal, external, internal and noncircular grinding. Around 800 employees, including 75 apprentices, make it their goal every day to ensure that «The Art of Grinding.» will continue to be closely linked to the name STUDER in the future.
If you want to combine grinding and turning, we recommend the S242. Complete machining in a single clamping reduces error sources and increases precision during machining. The S242 produces small to medium-sized workpieces up to 180 mm in diameter and 1000 mm in length. External/internal grinding and hard turning in a single clamping will reduce primary processing and auxiliary times in your operation. You can optionally upgrade the S242 with powered tools for drilling and milling.
Characteristics

Dimensions
- Distance between centres 400/800/1000 mm (15.7”/31.5”/39.4”)
- Swing diameter 180 mm (7.1”)
- Max. workpiece weight 60 kg (132 lbs)

Hardware
- X axis: stroke 220 mm (9.1”); v_x 15 m/min; resolution 0.00001 mm
- Z axis: stroke 850/1600 mm (33.4”/62.8”); v_z 25 m/min; resolution 0.00001 mm
- 2 or 3 cross slides configured with either one External grinding spindle, up to 3 internal grinding spindles or a tool turret
- Grinding spindle: 6.8 kW, v_s 50 m/s; Position 0 deg or ± 25 deg; automatic balancing, grinding wheel diameter 400 x 50/63 mm (15.7” x 2”/2.5”)
- Rotating turret: 8/12 tool positions Option: driven tools for drilling and milling
- Workhead: motor spindle 10.5 kW; 7500 rpm, adapter for center MT4; autom. chuck, chuck fixture DIN 55026 A4
- W-axis (tailstock slide): Stroke 450/1050 mm (17.7”/41.2”); resolution 0.01 mm; v_w 15 m/min
- Tailstock version
  - Barrel tailstock option: Barrel Ø 60 mm; Stroke 45 mm; Adaptor for centers MK4; Programmable clamping force
  - Synchronous tailstock option: 10.5 kW, 7500 rpm; Adaptor for centers MK4/ DIN 55026 A4; Programmable clamping force
- In-process gauging: Length positioning, length and diameter measurements, multi-range in-process gauging with R-axis
- Full enclosure with sliding door
- Granitan® S103 mineral-casting machine base
- Extensive range of accessories
Software

- Extremely easy programming with StuderWIN on Fanuc 31i-A
- StuderGRIND programming software for producing grinding and dressing programs on a PC
- Standardized interfaces for loader and peripheral devices
- CAM turning software

Grinding – turning – milling for small to medium-sized workpieces with a maximum diameter of 180 mm and up to 1000 mm long.

The S242 combined machine tool ideally combines the technologies of cylindrical grinding and hard turning. Thanks to its design concept, it can easily cope with both processes. Consequently, it enables highly efficient hard fine machining of shafts and chucking components with a high manufacturing quality and production reliability, and is therefore the cost-optimal manufacturing method for machining high-precision hardened workpieces.

Short changeover times are a further strength of the S242. This makes it attractive for both large-scale production and for small batch sizes and single parts.

Lower unit costs – highest precision

The combination of different hard-fine machining methods produces the following advantages:
- Machining in one clamping
- Reduction of production and auxiliary times
- Optimization of grinding stock
- Function related surface structures
- Use of in-process gauging during grinding
- Reduction of logistic costs
The material structure developed by STUDER, which has proved its superb efficiency over many years, is produced in the company's own plant using the most modern industrial techniques.

- The excellent cushioning behavior of the machine base ensures outstanding surface quality of the ground workpieces. The service life of the grinding wheel is also increased, leading to reduced downtimes.
- Temporary temperature fluctuations are extensively compensated for by the favorable thermal behavior of Granitan®, resulting in high dimensional accuracy at all times. This provides high stability throughout the day.

- Vibration-damping
- Thermal stability
Cross-slides

Efficiency through short travels
An extremely rigid longitudinal slide with two independently controlled cross slides for the tool holders ensures short travels for combined machining and the flexible use of a large number of tools. The cross slides can be individually equipped with an external wheelhead, internal grinding attachment for max. 3 spindles or a tool turret for max. 12 tools. Highly dynamic axis drives with pre-tensioned linear guideways and linear measuring systems guarantee the highest precision.

External grinding unit

The grinding head is mounted in a fixed position on the cross slide and is non-swiveling. The following mounting brackets are possible:

1 Choice of possible combinations of external grinding, internal grinding and hard turning
2 External grinding unit 25 deg right
3 External grinding unit 0 deg left
4 External grinding unit -25 deg left
5 External grinding unit 25 deg right
6 Grinding wheel arrangement
The turrets are hydraulically clamped. As well as dry machining, the tools can be cooled with emulsion or compressed air. The supply is provided directly via the turret.

The internal grinding turret is automatically positioned and hydraulically clamped via a gear wheel. HF internal grinding motor spindles with up to 120,000 rpm are used.

A swiveling dresser with one dressing spindle or fixed dressers is available for dressing internal grinding wheels.
Flexible clamping and driving

The workhead is fitted with an efficient motor spindle. The tailstock is mounted on the W-axis. This can be automatically positioned over the entire clamping length.

The following tailstock versions with integrated cylindricity correction are available:

- Barrel tailstock
- Synchronous tailstock

The positioning of the dressing modules close to the machining process ensures simple handling and short auxiliary times. The workhead can be used with an automatic swivel axis.

1. Workpiece drive between centers with synchronous tailstock
2. Workpiece fixture in chuck/rotating steady-rest
3. Workpiece fixture with rotor tip in barrel tailstock
4. Workhead with dressing turbine
5. Workhead with automatic swivel axis
The S242 is equipped with a 31i-A series Fanuc control with integrated PC. The 15” touch screen facilitates intuitive operation and programming of the machine. The electrical cabinet is positioned behind the machine. The power and control compartments are spatially separated. The layout of the elements complies with the relevant safety norms and is EMC-tested. All controls are clearly and ergonomically arranged. An important role is played by the manual control unit, which facilitates setup close to the grinding process. A special function – the Sensitron electronic contact detection device – reduces downtimes to a minimum.
The user interface StuderWIN creates a stable programming environment and contributes to efficient use of the machine. The possibility of fully integrating the in-process gauging and sensor technology for process control as well as contact detection and automatic balancing systems in the operator interface enables standardized programming of the different systems. The software of an optional loading system is also integrated. The drive elements are optimally matched to the control system.

The sophisticated mechanical engineering concept of the S242 is completed by a grinding software program developed in-house by STUDER and which is continuously optimized in collaboration with users of the software. This software offers:

- StuderPictogramming: The operator strings the individual grinding cycles together – the control generates the ISO code.
- STUDEr Quick-Set: The software for grinding wheel alignment reduces resetting times by up to 90%.
- Microfunctions: Free programming of grinding and dressing process sequences for optimization of the grinding process.
- Integrated operating instructions assist safe machine operation.
- The software options for the grinding technology calculations, optimized dressing as well as the Contour-, Thread- and Formgrinding cycles increase the functionality of the machine.
- Offline CAM turning software designed for StuderWIN
STUDER cylindrical grinding machines should fulfil the customer’s requirements for as long as possible, work cost-effectively, function reliably and be available at all times. From «start up» through to «retrofit» – our Customer Care is there for you throughout the working life of your machine. 30 professional helplines and more than 60 service technicians are available in your area, wherever you are in the world.

- We will provide you with fast, uncomplicated support.
- We will help to increase your productivity.
- We work professionally, reliably and transparently.
- We will provide a professional solution to your problems.

### Customer Care

**Start up**  
Commissioning  
Warranty extension

**Qualification**  
Training  
Production support

**Prevention**  
Maintenance  
Inspection

**Service**  
Customer service  
Customer consultation  
HelpLine  
Remote service

**Material**  
Spare parts  
Replacement parts  
Accessories

**Rebuild**  
Machine overhaul  
Assembly overhaul

**Retrofit**  
Modifications  
Retrofits
## Technical Data

### Main dimension

<table>
<thead>
<tr>
<th>Distance between centres</th>
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<tr>
<td>Short version – 2 cross slides</td>
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<tr>
<td>Long version – 2 cross slides</td>
</tr>
<tr>
<td>Long version – 3 cross slides</td>
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<tr>
<td>Swing diameter</td>
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<tr>
<td>Max. workpiece weight</td>
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### Cross slide: X axis

| Max. travel                  | 220 mm (8.7") |
| Speed                        | 0.001–15000 mm/min (0.000,04–590 ipm) |
| Resolution                   | 0.00001 mm (0.000,002") |

### Longitudinal slide: Z axis

| Max. travel                  | 850/1600 mm (33.4"/62.8") |
| Speed                        | 0.001–25000 mm/min (0.000,04–984 ipm) |
| Resolution                   | 0.00001 mm (0.000,002") |

### Rotating turret

| 8 x Capto 5 fixed |
| 8 x VDI 40 fixed  |
| 12 x VDI 30 fixed |
| 12 x VDI 30 driven |
| Maximum drive speed | 4000 rpm |
| Drive power         | 2.5 kW (3.4 hp) |
| option: length measuring gauge (active) on turret head (Capto or VDI) |

### Wheelhead

| Wheelhead mounting angle | -25 deg/0 deg/+25 deg |
| Drive power vc 50 m/s    | 6.8 kW (9.2 hp) |
| Grinding wheel           | dia. 400 x 50/63 x 127 mm (15.7" x 2"/2.5" x 5") |

### Internal grinding attachment

| Number of spindle holders on swivelling ID attachment | 3 |
| Automatic positioning in 3 positions | 0 deg±45 deg |
| Spindle dia. | 1x dia. 100 mm (3.9") / 2x dia. 120 mm (4.7") |
| Speeds        | 24000–120000 rpm |

### Workhead swivelling

| Swivel range | 0–10 deg |
| Resolution   | 0– 0.0001 deg |
| Speed range  | 1– 4000 rpm |
| Drive power   | 4.5 kW (6.1 hp) |
| Tool holding fixture | MTS/DIN 55026 A6 |
| Load during live spindle grinding | 50 Nm |
| Roundness    | 0.0004 mm (0.000,016") |

### W-axis / Tailstock

| Max. travel                  | 450/1050 mm (17.7"/41.2") |
| Speed                        | 0.001–15000 mm/min (0.000,04–590 ipm) |
| Resolution                   | 0.01 mm (0.000,04") |
| Fine adjustment              | ± 40 µm (0.0016") |
| Optional barrel tailstock    | 60 mm (2.4") |
| Fitting taper                | MT4 |
| Barrel travel                | 45 mm (1.8") |
| Optional synchronous tailstock | Speed range 1– 7500 rpm |
| Drive power                  | 10.5 kW (14 hp) |
| Fitting taper                | MT4/DIN 55026 A4 |
| Dressing                     | Fixed dressing tool, MK1 short |
| Fixed dressing tool, MK1 short | Single point diamond/fliess |
| Dressing spindle with dressing wheel on swivelling dresser | max. dia. 58/90 mm (2.3"/3.5") |
| Dressing spindle with dressing wheel behind workhead | max. dia. 100 mm (3.9") |

### Control unit

| Fanuc 31 i – A |

### Connected loads

| Total connected loads | 45 kVA |
| Air pressure min.     | 5.5 bar (80 psi) |
| Total weight          | 7600/12000 kg (16500/26400 lbs) |
The information given is based on the technical levels of our machine at the time of this brochure going to print. We reserve the right to further develop our machines technically and make design modifications. This means that the dimensions, weights, colours, etc. of the machines supplied can differ. The diverse application possibilities of our machines depend on the technical equipment specifically requested by our customers. The equipment specifically agreed with the customer is therefore exclusively definitive for the equipping of the machines, and not any general data, information or illustrations.