

1. INTRODUCTION

Thank you for purchasing a "TSUDAKOMA" - NC Rotary Table, and welcome to the TSUDAKOMA family. We hope your experience with your new machine tool attachment will make you a lifetime TSUDAKOMA customer.

TSUDAKOMA products are backed by many years of experience in design and manufacture, based on feedback from technicians and engineers who use them daily. Our most important goal is your satisfaction.

We are convinced that these products will improve productivity in your shop. However, the NC Rotary Table is basically a precision machine, so it is important to recognize that its efficient, full-capacity and problem-free performance largely depends upon proper handling and maintenance. You must be sure the machine is handled correctly.

To achieve optimum performance, take the time to read this manual carefully. Handling instructions, tips for maintenance and inspection, and much more, are all here at your fingertips. They will help you maintain the machine's inherent accuracy for a longer period of time.

Specific methods for practical application of the TSUDAKOMA NC Rotary Table will vary infinitely according to the type and uniqueness of individual mated machining centers and tape-controlled machine tools. It is recommended that thorough prearrangements be made with a machine tool builder, and along with your own research and development, we hope you will develop your own know-how for handling the machine.

15. Servomotor	FANUC		MELDAS		YASNAC	OSP	
	DC 5M	DC 10M	HD81	HD-101	UGJMED-80MA	BL-80E-20	
AC 5	AC 10	HA 80	HA 100	USACED-12GG			
16. Total reduction ratio	1/360	1/180	1/360	1/180	1/180	1/256	
17. Minimum input increment	0.001°	0.001°	0.001°	0.001°	0.001°	0.001°	
18. Max. R.P.M.	rpm	rpm	rpm	rpm	rpm	rpm	
	Rotary table	5.5	8.3	5.5	8.3	8.3	7.8
	Motor	2000	1500	2000	1500	1500	2000

*1 Pneumatic clamping needs an air-hydro unit (optional).
This is only available only if ordered with the NC Rotary Table.

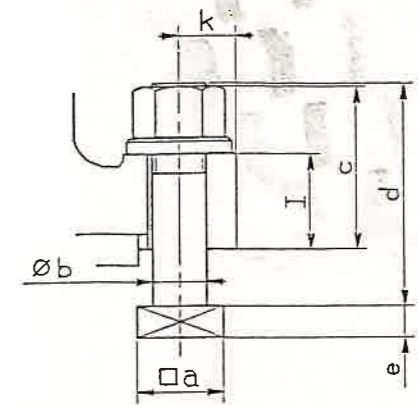
*2 Whenever the diameter of a workpiece or tool exceeds that of the turntable, always check the allowable work inertia, even if the load falls within the range of load capacity.

(Note) Motor cover

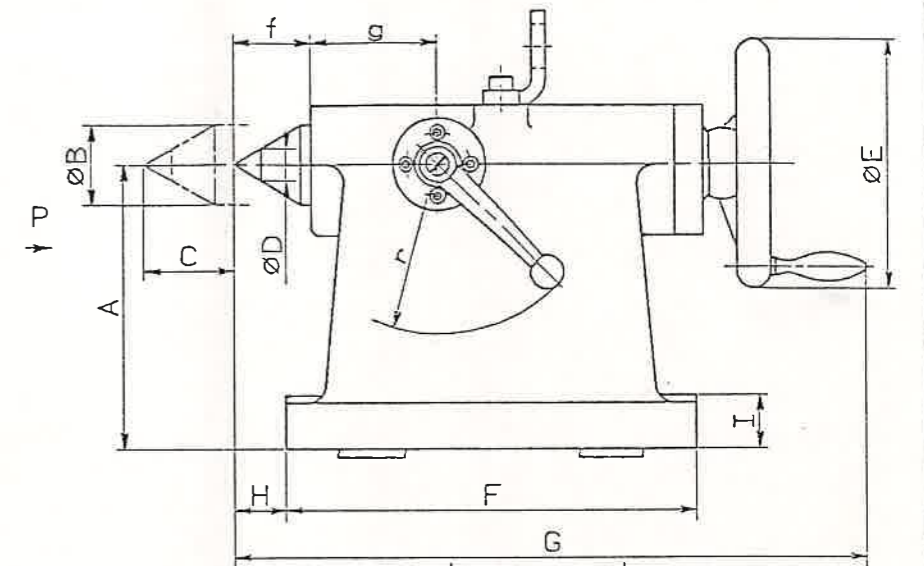
The standard motor cover is the drip-proof type.

01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000
01-200-20	2000	1500	2000	1500	1500	2000

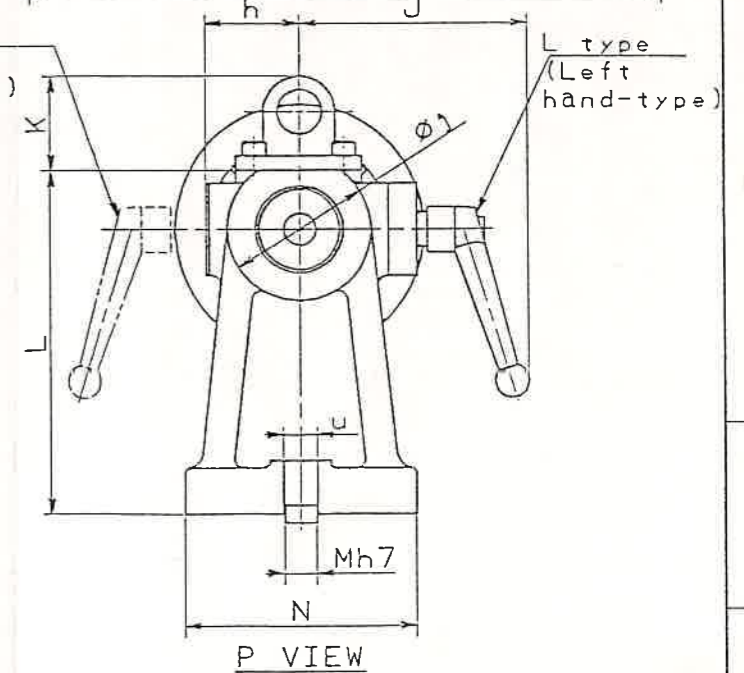
Center height A	110	135	160	190	210	235	255	280	310	400	530								
Applicable rotary table type	RNCV-150	DNC-250 RNCJ-151 RNCV-151 RS-250	DNC-300 RNCB-201 RNCB-251 RNCBK-201 RNCBK-251 RNCM-251 RNCV-201	TT-300	RNCB-301 RNCBK-301 RNCM-301 RNCV-301 RP-300 THNC-251 TTNC-201	THNC-301 TTNC-301	RNCB-401 RNCBK-401 RNCK-401 RNCM-401 RNCV-401 RP-400	TT-500	RNCB-501 RNCBK-501 RNCK-501 RNCM-501 RP-500	RNCB-631 RNCBK-631 RNCK-631 RNCM-631	RNCB-801 RNCV-801								
Center dia B	35	40	45			50			60		80								
Stroke C	50					55				70									
Carbide chip dia D	14			18					30										
Handle dia E	100	125	140			160			180		225								
Base dim FXN	190X100	215X120	230X130	230X140	230X146	270X160	270X170	315X200	315X220	315X240	410X290								
G	286	332	356			412			452		566								
H	25		30			35			40		40								
Height of clamping face I	20	25	30			35			40										
J	107	109	129			131			154		164								
K			53			65													
L	137	164	193	223	243	270	290	320	350	440	590								
Guide block widt M	14	16	18	14	16	18 (11/16')	22	16	18 (11/16')	20	22	18 (11/16')	20	22	24	28			
a	23	26	28	23	26	28	34	26	28	32	34	28	32	34	40	43			
b	12	16	16	12	16	16	20	16	16	18	20	16	18	20	22	24			
c	37	41	41	42	46	46	49	51	51	57	54	56	60	62	59	65	67	69	71
d	55	65	65	60	70	70	70	75	75	85	75	80	90	90	85	90	95	100	105
e	8	10	11	8	10	11	8	10	11	13	10	11	11	13	11	11	13	16	18
u	15	19	19	19			23	19		23	19		23		25				
f	35		40		45			50			60		75						
g	69			70			75			80		100							
h	42	44		52			54			62		72							
j	65	70		80			85			100		130							
k	14		17.5			20													
r	80			95			110												
Weight(kg)	10.2	14.5	21.8	16.0	26.0	30.0	37.8	57.2	62.8	75.2	137.9								



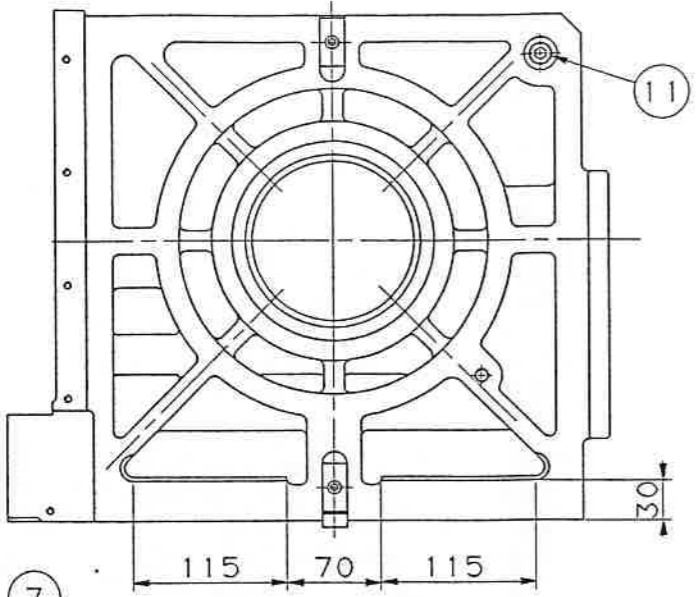
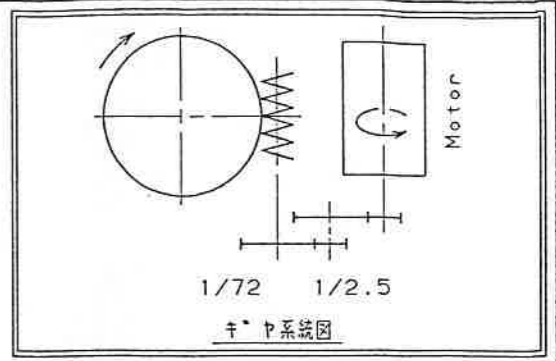
Clamping bolt



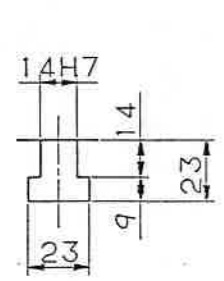
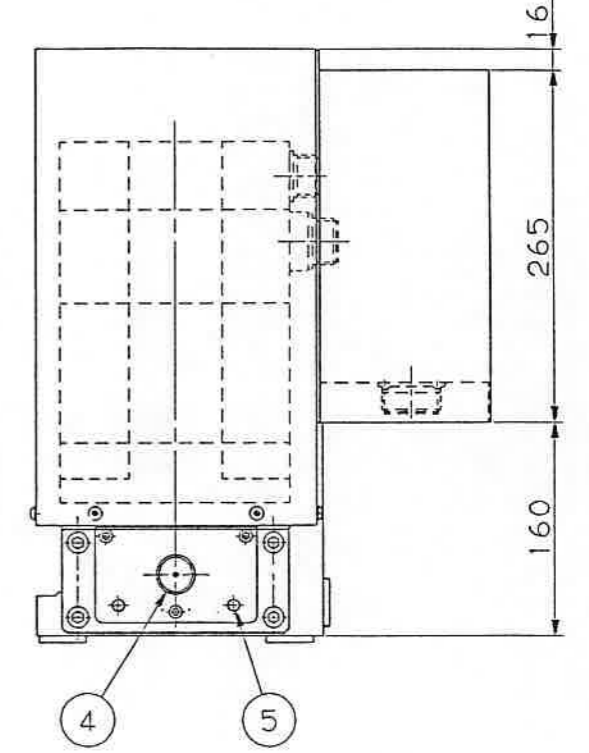
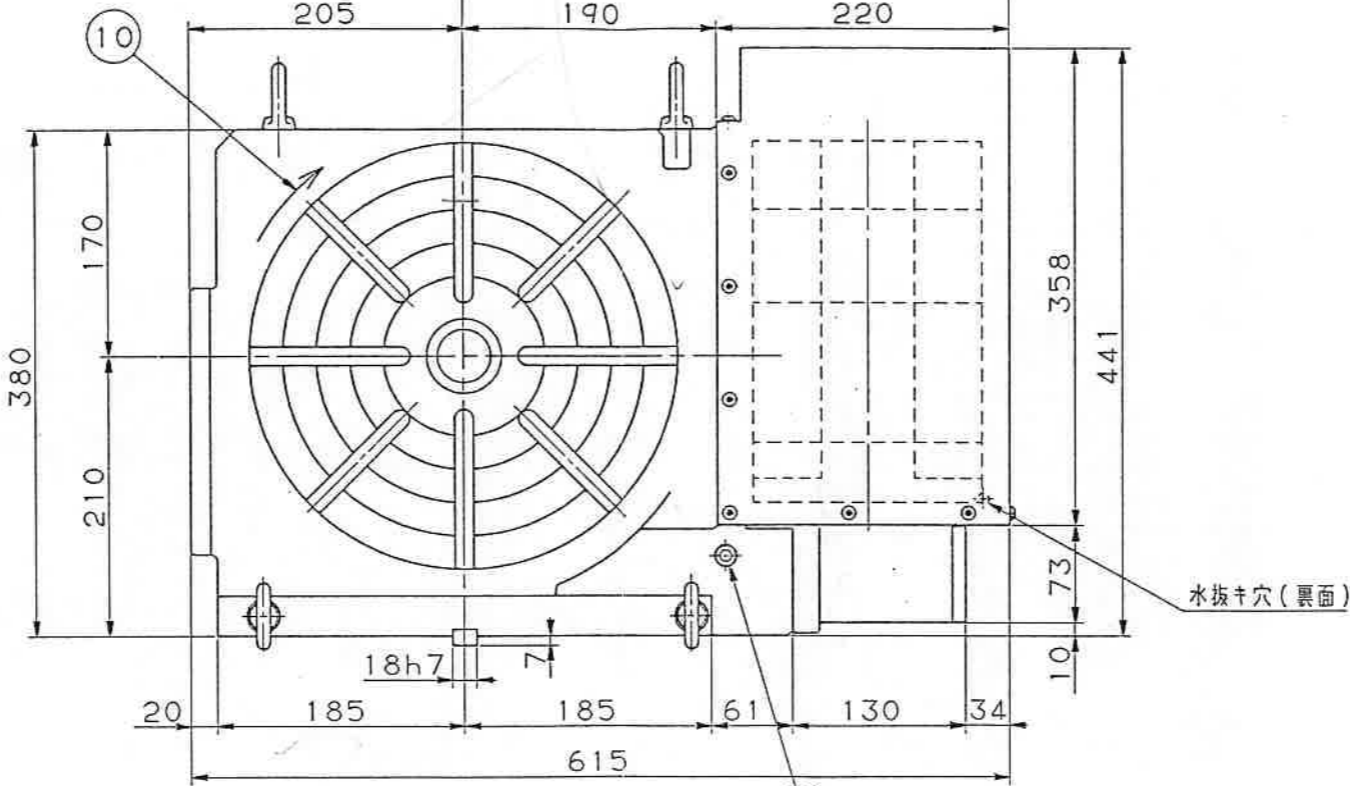
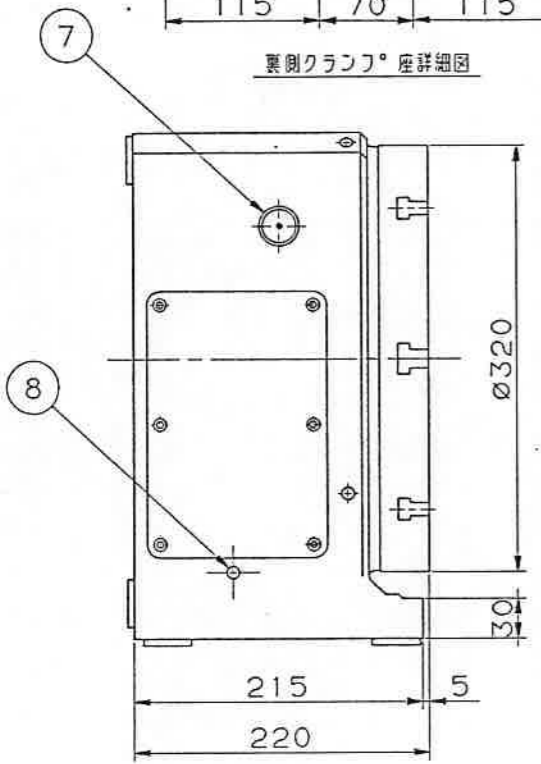
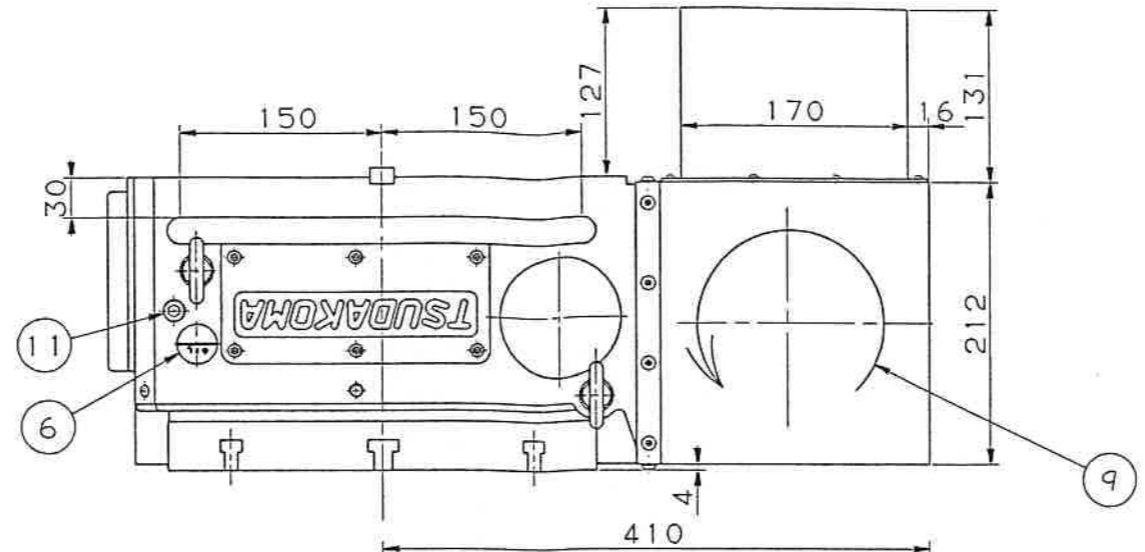
R type (Right handtype) L type (Left hand-type)



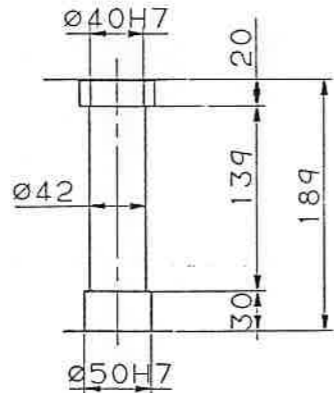
DRAWING NO.	L73666D, E	UNIT	MM
TITLE	Manual tel stock External drawing (Center height 110, 135, 160, 190, 210, 235, 255, 280, 310, 400, 530)		
DATE	Nov. 7, 86	SCALE	
APPROVED BY	M. Tani		
CHECKED BY	O. Mori		
DRAWN BY	M. Omori		



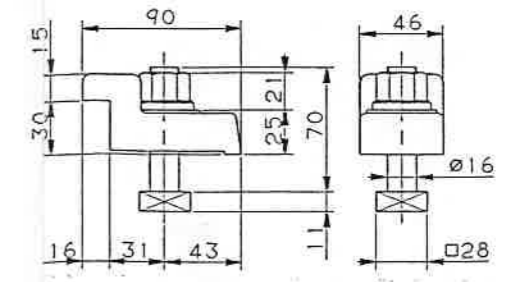
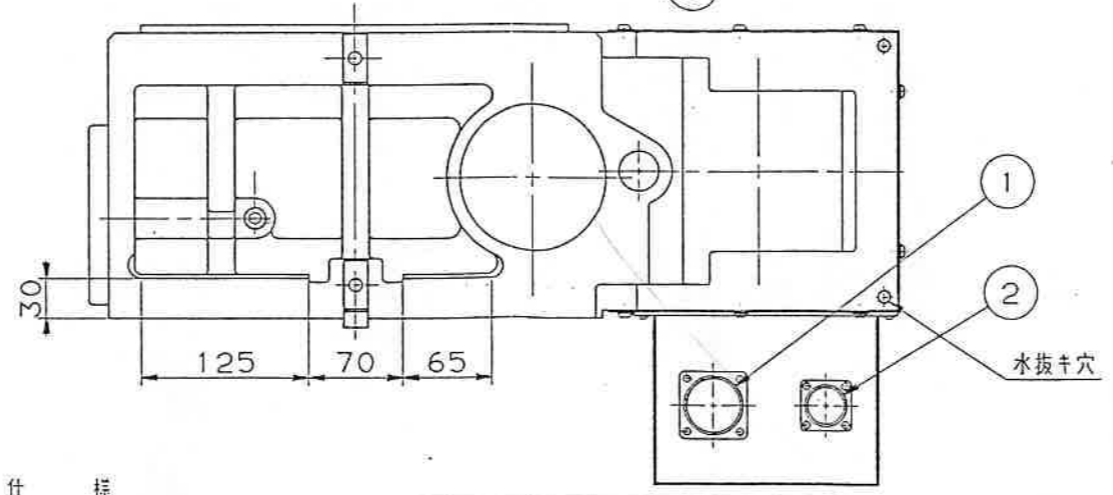
クランフ°座詳細図



T溝詳細図(1/2)



テ°ル主軸穴詳細図(1/4)



クランフ°座ロック、ホ°ルト詳細図(1/3)

指示箇所説明

仕様

1	リビ°ワトル MS3102A (動力用)	7	本体 オイルケ°ーシ°
2	リビ°ワトル MS3102A (検出器用)	8	本体 排油口
3	キ°ヤケース 注油口	9	モ°回転方向
4	キ°ヤケース オイルケ°ーシ°	10	原点復帰方向
5	キ°ヤケース 排油口	11	クランフ°油圧投入口 PT3/8
6	本体 注油口	12	

総減速比	1/180	新切削力	78 kg·m
最小設定単位	0.001°	許容ワ°クイナシ°	38.5kg·cm·sec ²
モ°型式	異社御交物品	積載質量	ヨコ型 350 kg タテ型 150 kg
最高回転数	11.1rpm (2000rpm)	製品重量	200 kg
クランフ°力	85 kg·m (35kg/cm ²)		

訂正記号	年月日	訂正事項	訂正者

AC-10S(INC)			
名称	RNCM-301R	1/180	油圧 R 1/4
永			89.11.22
記			L80569