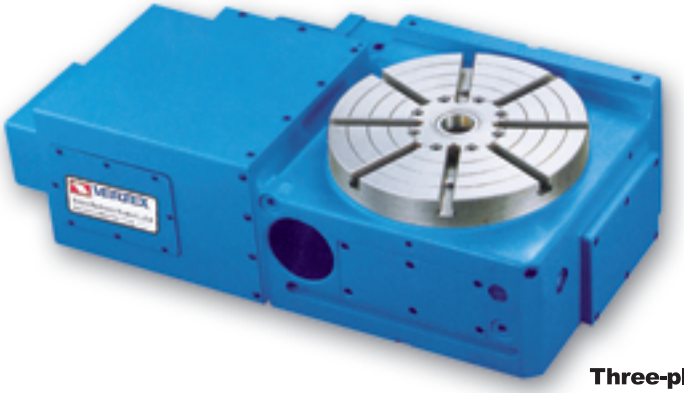
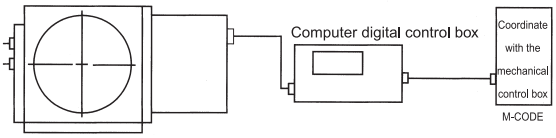
Hirth Coupling Type Super Cutting Indexer Table

Three-plate type plane gear positioning method



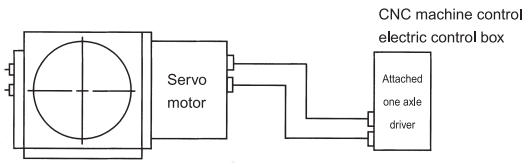
- Build-in 3 pieces hirth coupling, table will not lifting-up during rotating.
- Could be direct connected to the 4th. axis on machining-center. Also could be connected the M-code.
- Build-in 3pcs hirth coupling, ensure the indexing accuracy +/- 5 sec.

Oil pressure source(for cutting table tightening/loosening use)



The illustration when applied with CNC cutting center that use the M signal wiring. (Usually, to use tooling machine or specialty machine may also apply this method)

Oil pressure source(for cutting table tightening/loosening use)

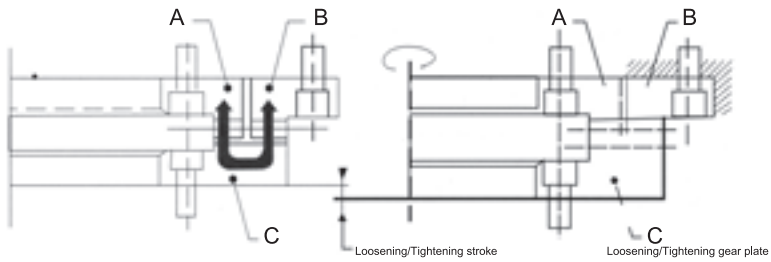


It can be directly installed to form the 4th axle of the CNC machine.

Three-plate type plane gear plate cutting table movement principle

- As illustrated, the three-plate plane gear plate can be divided into three parts, A gear plate(lock above the revolution plate) B gear plate(lock on the cutting table base), C gear plate(loosening/ tightening movement). The three pieces are combined together tightly.
- As Fig.b illustrated, when C gear plate is descending, the cutting table instantly turn to loosening condition, gear plate A supported tightly by bearing so that it can smoothly and precisely revolve on the revolution table when ascending is not required.
- When A gear plate completes cutting and reach the positioning site, C gear plate will move upwardly to combine A and B gear plates. It is shown on Fig.d. which from a high precision structure.
- C gear plate has sufficient width to combine A and B gear plates and precisely to line up A and B gear plates, the pressure angle of each gear plate is 30 degree. We assure you the longer you use the more the precision.

(Fig.a) (Fig.b)



SPECIFICATION TABLE

ORDER NO.		VNCS-250	VNCS-320	VNCS-400	VNCS-500
Cutting angle		Minimum cutting unit:5°	Standard model 5° for one cutting unit, special spec:1° for one cutting unit can be custom made.		
Table diameter		250	320	400	500
Overall height when horizontal fixed		200	240	265	300
Central height when vertical fixed		170	230	250	310
Central hole diameter		55Ø	100Ø	120Ø	120Ø
Through hole diameter		30Ø	80Ø	80Ø	90Ø
T slot width		12	14	14	18
The width of the correcting key		18	18	18	18
Servo motor spec.	Mitsubishi	HA-40C-S	HA-80C-S	HA-100C	HA-100C
	FANUC	α3	α6	α12	α12
Total reducing ratio		1/120	1/120	1/120	1/120
Max. revolution speed(min.) Motor 2,000 r.p.m.		16.6	16.6	16.6	16.6
The tightening force when fixed(kg.m) Oil pressure 35kg/cm^2		300	400	500	600
Allowable accumulating load(kg)	For horizontal use	300	350	500	600
	Load For vertical use	125	175	250	300
Allowable cutting torque(kg.m) Oil pressure 35Kg/cm^2		250	350	450	550
Accuracy		±5"	±5"	±5"	±5"
Machine weight(kg)		110	200	350	400
CODE NO.		4003-010	4003-011	4003-012	4003-013