

ROTARY PLATE

Pallet/Tooling fast set-up on turning spindles



▶ **CHUCK**

▶ **PALLET**

▶ **ROTARY PLATE**

▶ **ADAPTOR**



ROTARY PLATE

Rotating table which holds the workpiece in place during operations

CUSTOMER BENEFITS

- PALLET/TOOLING FAST SET-UP
- CHUCKS FAST SET-UP ON TURNING SPINDLES, MANUAL CONNECTION (WITH SCREW) BETWEEN CHUCK AND CYLINDER FOR MANUAL ROTARY PLATE
- TOOLING PRESENCE WITH AIR SENSING FUNCTION FOR AUTOMATIC ROTARY PLATE
- SC STROKE CONTROL FUNCTION
- POSITIONING ACCURACY < 0,005 mm
- 3 PNEUMATIC FEEDINGS (6 BAR) AVAILABLE ON PALLET FOR AUTOMATIC ROTARY PLATE+3FEEDINGS

TECHNICAL FEATURES

- CASE HARDENED MAIN COMPONENTS TO ASSURE BETTER ACCURACY AND LONG OPERATING LIFE
- PNEUMATIC OPENING
- CLOSING BY SPRING + TURBO FUNCTION
- OPENING/CLOSING APS MANUALLY OPERATED
- OPENING/CLOSING APS AUTOMATICALLY OPERATED
- G6.3 BALANCING DEGREE

Types	Size								Manual operation of APS modules	Automatic operation of APS modules	Automatic operation of APS modules + 3 feedings	APS central size		APS lateral size		Ø pallets and chucks usable on rotary plate
	202	260	330	420	520	650	1000	1400				190	250	140	160	
MANUAL ROTARY PLATE	202											1				170-210
		260											1			210-250-315
			330											3		250-315
				420										4		400
					520							1			4	500-650
						650						1			4	650-800
							1000						1		6	1000-1250
AUTOMATIC ROTARY PLATE								1400				1		8	1400-1600-1800	
	202											1			170-210	
		260											1		210-250-315	
			330											3	250-315	
				420										4	400	
					520							1			4	500
						650						1			4	650-800
AUTOMATIC ROTARY PLATE + 3 FEEDINGS	202											1			170-210	
		260											1		210-250-315	
			330											3	250-315	
				420										4	400	
					520							1			4	500
						650						1			4	650-800

Drawings and data are subject to change by SMW-Autoblok.

MANUAL OPERATION

APS MODULES

3
a

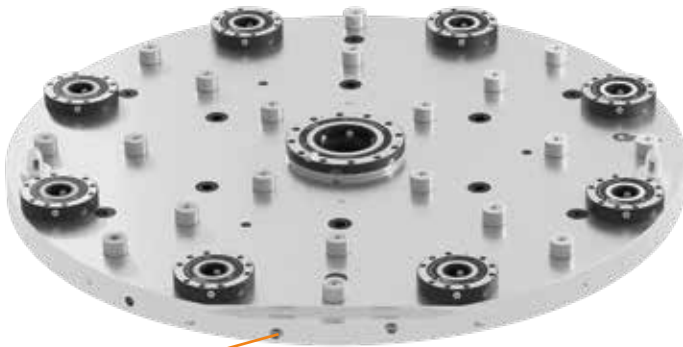


Drawings and data are subject to change by SMW-Autoblok.

ROTARY PLATE Ø1400

with APS 250 and 8 APS 160 manual operation

Manual tooling fast set-up for Ø 1400-1600 and Ø 1800 pallets and chucks



N. 2 PNEUMATIC CONNECTIONS FOR MANUAL OPENING AND TURBO COMMAND

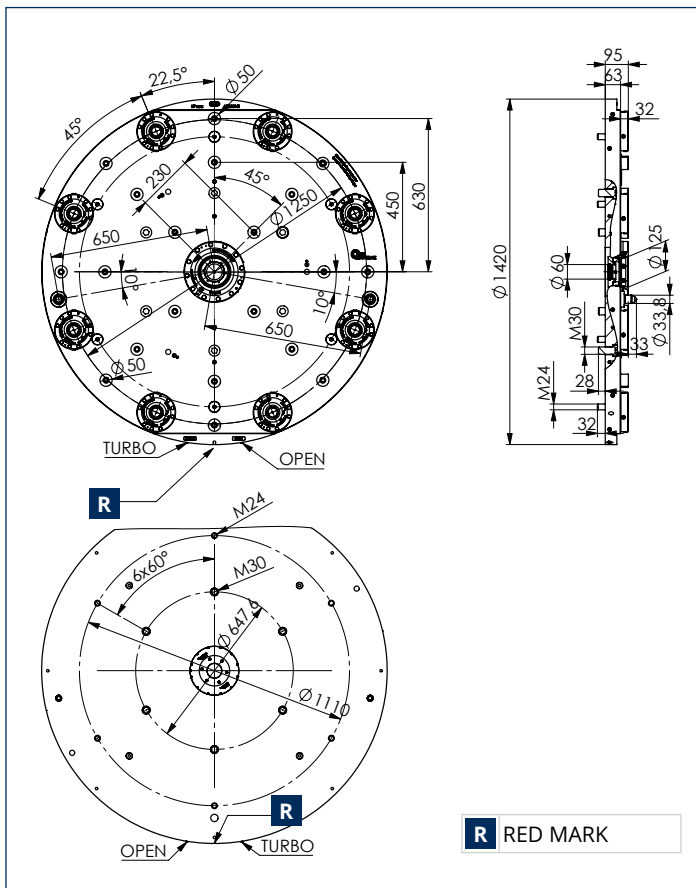
Applications/Customer Benefits

- Pallet/Tooling fast set-up
- Chucks fast set-up Ø1400, Ø1600 and Ø1800 on turning spindles, manual connection (with screw) between chuck and cylinder
- Positioning accuracy < 0,005 mm

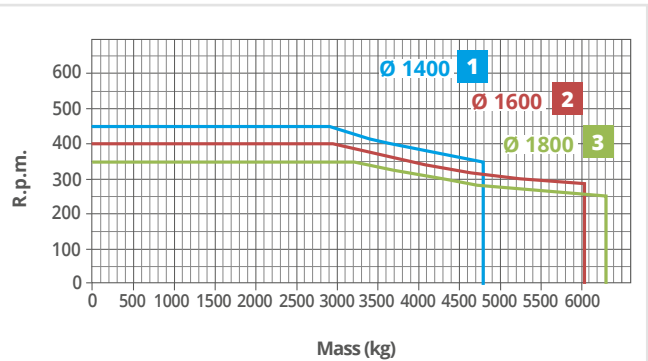
Technical features

- Case hardened main components to assure better accuracy and long operating life
- Pneumatic opening (OPEN)
- Closing by spring + Turbo function
- Opening/closing manually operated
- G6.3 balancing degree

ROTARY PLATE MODEL	ID.NO.	REPEATABILITY	CLAMPING FORCE BY TURBO FUNCTION AT 6 bar	MAX PRESSURE OPENING / CLOSING	WEIGHT Kg	CHUCK FEATURES				
						DRAW BAR MAX PULLING FORCE	DRAW BAR MAX PUSHING FORCE	Ø1400 CHUCK MAX RPM (*)	Ø1600 CHUCK MAX RPM (**)	Ø1800 CHUCK MAX RPM (***)
Ø1400 MANUAL	46220040	0,005 mm	295 kN	6 bar	790	200 kN	120 kN	450	400	350



Weight/Speed diagram



- (*) Diagram is showing the rpm speed depending from:
 - total max weight on rotary plate (pallet + chuck or fixture + workpiece).
 - max overall dimension on rotary plate Ø 1400 and 550 mm total length
- (**) Diagram is showing the rpm speed depending from:
 - total max weight on rotary plate (pallet + chuck or fixture + workpiece).
 - max overall dimension on rotary plate Ø 1600 and 550 mm total length
- (***) Diagram is showing the rpm speed depending from:
 - total max weight on rotary plate (pallet + chuck or fixture + workpiece).
 - max overall dimension on rotary plate Ø 1800 and 550 mm total length

(*) (**) (***) rpm max speed has to be reduced if used chuck type has lower rpm speed

Drawings and data are subject to change by SMW-Autoblok.

ROTARY PLATE Ø1400: AVAILABLE PALLETS

46220330

560
kg

Pallet SMF
Ø1420 x 45

46220340

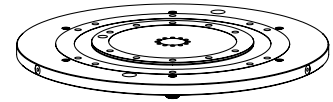
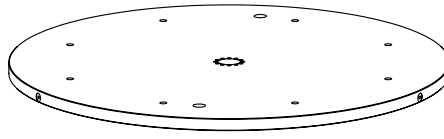
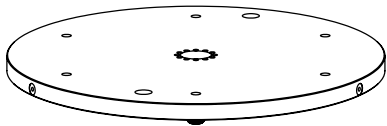
710
kg

Pallet SMF
Ø1600 x 45

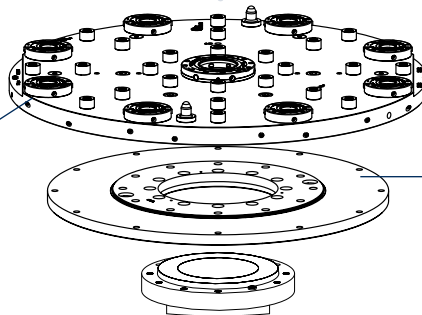
46220080

465
kg

Pallet Ø720
for PTF Ø1400 Ø1600



G1/8 71612801 female quick connection for pneumatic manual operation



46220040

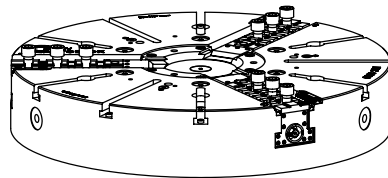
Manual Ø1400 Rotary Plate
+ APS 250
+ 8 APS 160 module

Special flange or direct assembly on machine spindle

ROTARY PLATE Ø1400: USABLE CHUCKS SCHEME

1400 IEP

1600 IEP



1400 IR

3-4-6 jaws

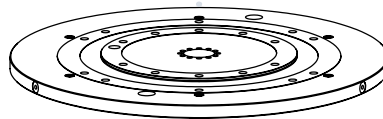
1600 IR

3-4-6 jaws

1800 IR

3-6 jaws

Special connection group

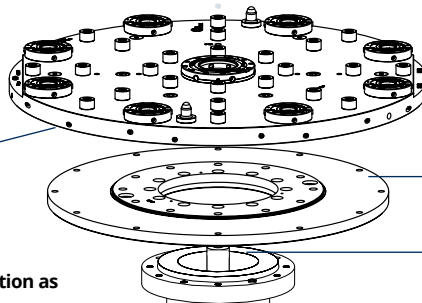


46220080

Pallet Ø720

465
kg

G1/8 71612801 female quick connection for pneumatic manual operation



46220040

Manual Ø1400 Rotary Plate
+ APS 250
+ 8 APS 160 module

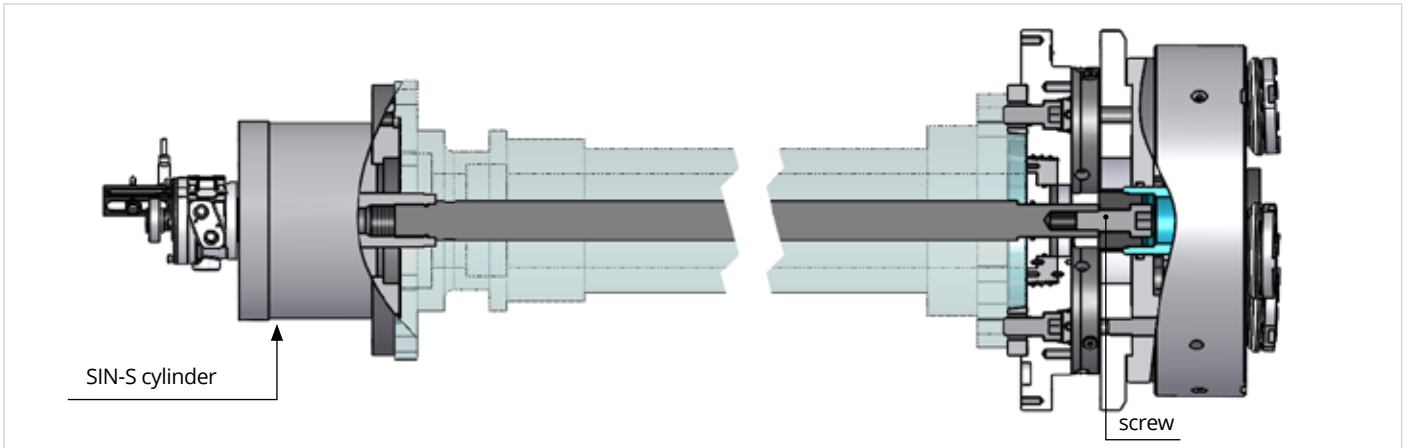
Special flange or direct assembly on machine spindle

DRAW BAR

NOTE: all indicated chucks can have air sensing function as optional

Recommended cylinders for ROTARY PLATE

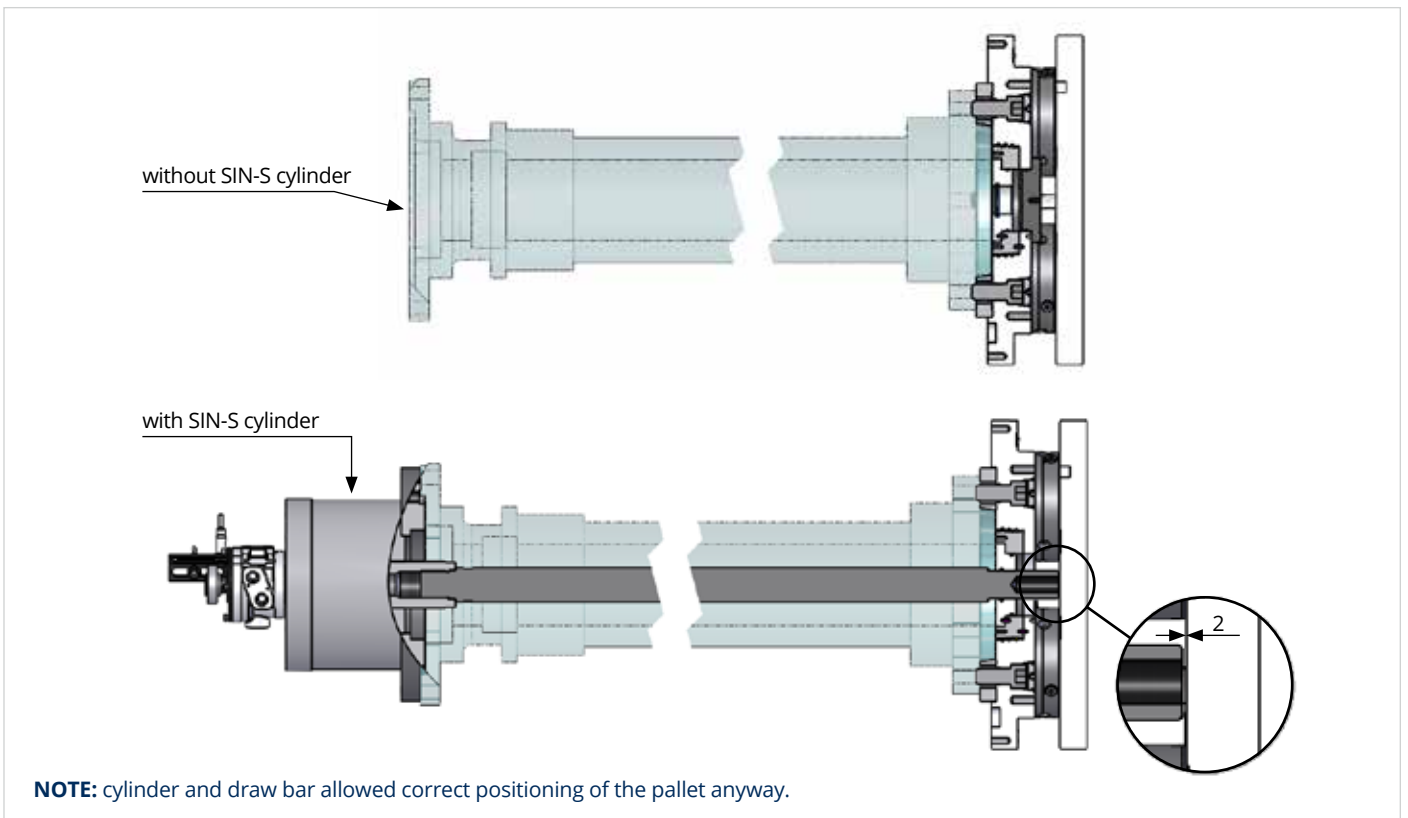
Manual pallet fast set-up with chucks.
Connection between the chuck and the draw bar is made by screw.



RECOMMENDED CYLINDERS								
ROTARY PLATE TYPE	TS / TX	➔ SIN	AP	➔ SIN	IR	/ IN	/ IEP	➔ SIN
Ø202	170	85 SIN-S	170	100 SIN-S	-	-	-	-
	210	100 SIN-S	210	125 SIN-S	-	-	-	-
Ø260	210	100 SIN-S	210	125 SIN-S	-	-	-	-
	210-315	125 SIN-S	250-315	150 SIN-S	-	-	-	-
Ø330	250-315	125 SIN-S	250-315	150 SIN-S	-	-	-	-
Ø420	400	150 SIN-S	400	175 SIN-S	-	-	-	-
Ø520	530-650	150 SIN-S	500-630	200 SIN-S	-	-	-	-
Ø650	650	175 SIN-S	630-800	200 SIN-S	-	-	-	-
Ø1000	-	-	-	-	1000-1250	1000-1250	1000-1250	200 SIN-S (*)
Ø1400	-	-	-	-	1400-1600-1800	-	1400-1600	200 SIN-S (*)

(*) 1000/1250/1400/1600/1800 IR/IN chucks have 50 mm reduced stroke of the wedge if used by the SIN-S 200 cylinder.

Manual tooling fast pallets set-up



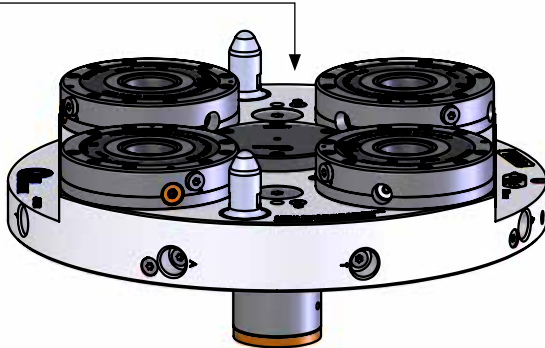
NOTE: cylinder and draw bar allowed correct positioning of the pallet anyway.

ROTARY PLATE ASSEMBLY LINE

Automatic operation APS modules

Manual or automatic pallet tooling fast set-up

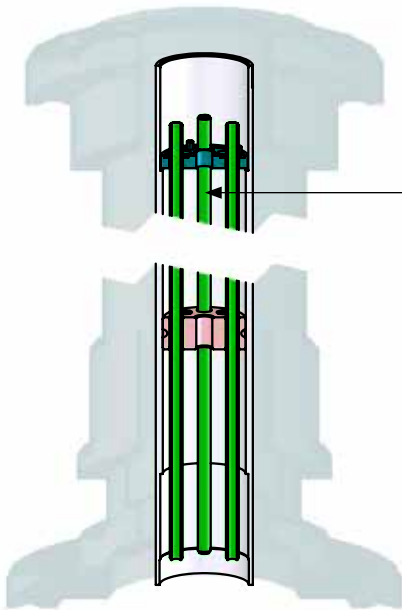
Pallet  FOR EACH SIZE, CHECK RELATED PALLETS



Mod. Id.No. AUTOMATIC ROTARY PLATE

Ø202	46220460
Ø260	46220500
Ø330	46220360
Ø420	46220400
Ø520	46220090
Ø650	46220140

ISO-A flange  [VIEW ACCESSORIES](#)



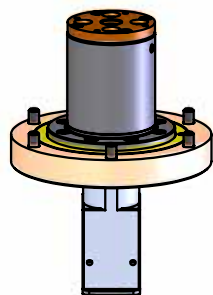
Pipe bundle

(to customize for each machine tool specifically)



Manifold flange

(to customize for each machine tool specifically)

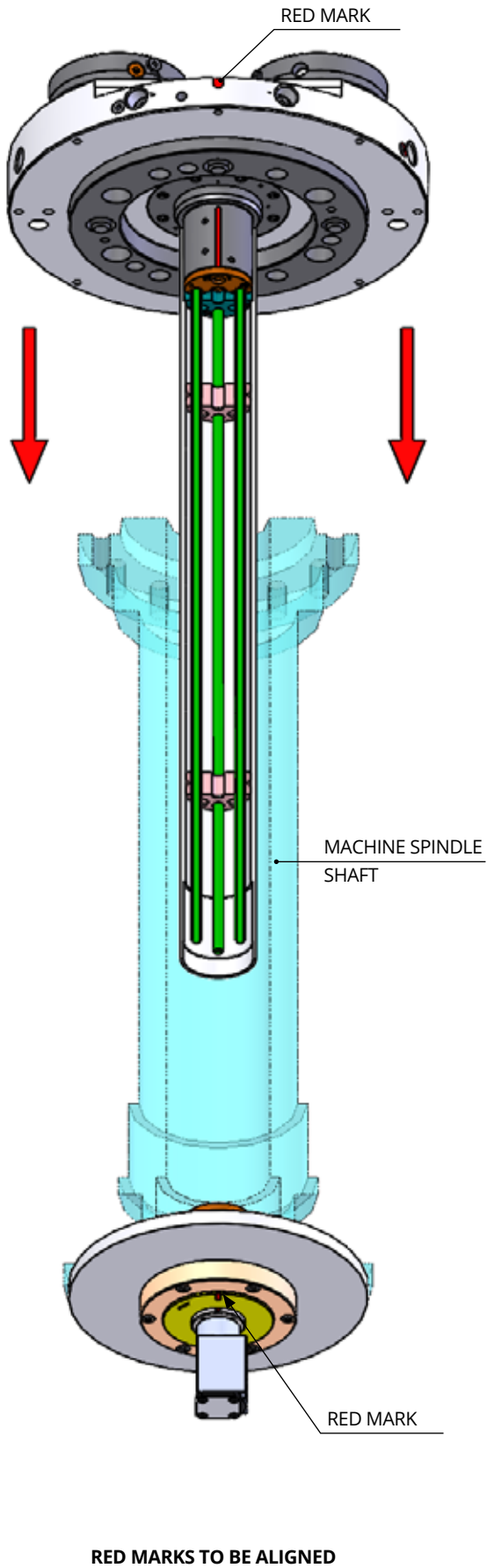


60580011  [VIEW ACCESSORIES](#)

3-pneumatic feedings manifold

PIPE BUNDLE for Automatic operation of APS modules

PIPE BUNDLE assembly from ROTARY PLATE side



PIPE BUNDLE assembly from MANIFOLD side

