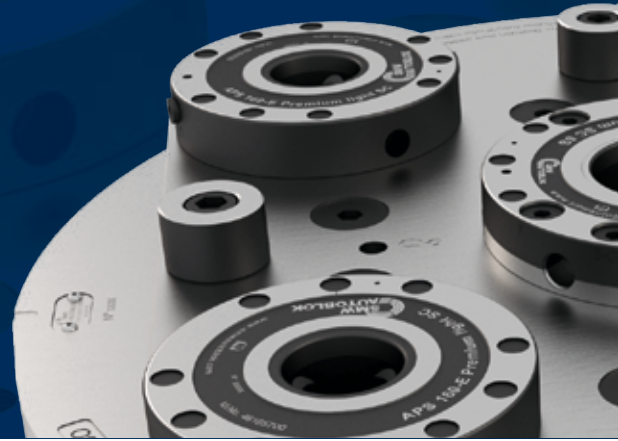


ROTARY PLATE

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 $\varnothing 202$

with APS 190 manual operation

Manual tooling fast set-up for $\varnothing 170$ and $\varnothing 210$ pallets and chucks



N. 2 PNEUMATIC CONNECTIONS FOR MANUAL OPENING AND TURBO COMMAND

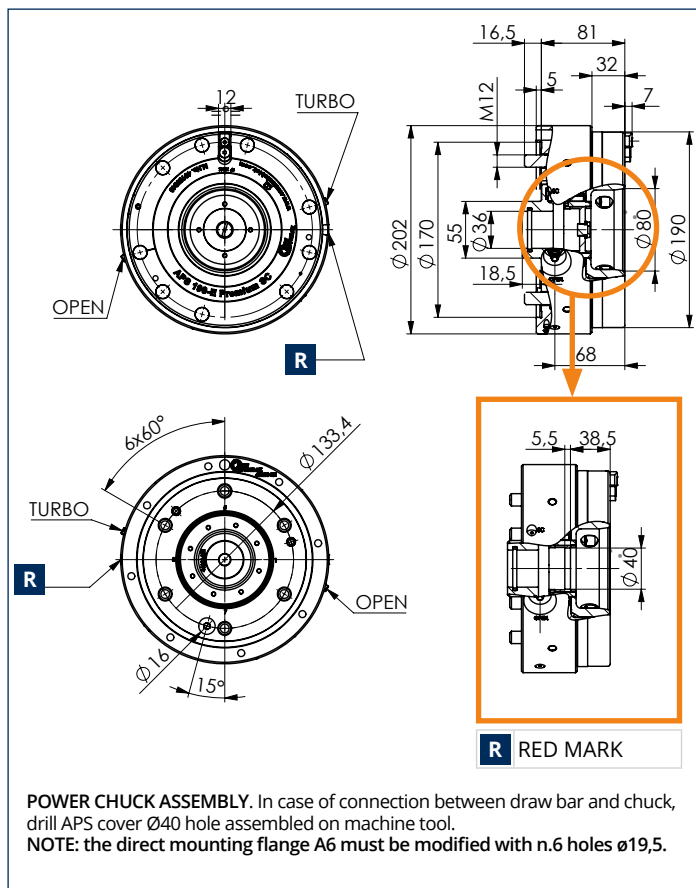
Applications/Customer Benefits

- Pallet/Tooling fast set-up
- Chucks fast set-up $\varnothing 170$ and $\varnothing 210$ on turning spindles, manual connection (with screw) between chuck and cylinder
- Positioning accuracy < 0,005 mm

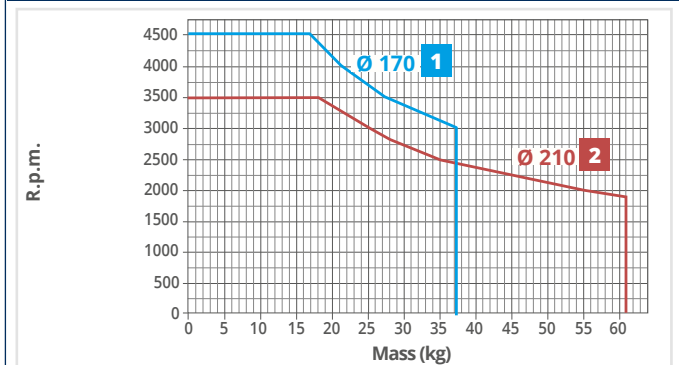
Technical features

- 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	$\varnothing 170$ CHUCK MAX RPM (*)	$\varnothing 210$ CHUCK MAX RPM (**)
$\varnothing 202$ MANUAL	46220450	0,005 mm	45 kN	6 bar	16	40 kN	20 kN	4500	3500



Weight/Speed diagram

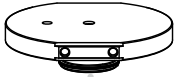


- (*) Diagram is showing the rpm speed depending from:
 - total max weight on rotary plate (pallet + chuck or fixture + workpiece).
 - max overall dimension on rotary plate $\varnothing 170$ and 190 mm total length
- (**) Diagram is showing the rpm speed depending from:
 - total max weight on rotary plate (pallet + chuck or fixture + workpiece).
 - max overall dimension on rotary plate $\varnothing 210$ and 220 mm total length

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

ROTARY PLATE Ø202: AVAILABLE PALLETS

46200015 **6,8 kg**
 (*) Pallet SMF
 Ø208 x 23



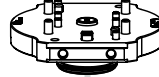
46200055 **6,2 kg**
 Pallet for SGSF
 Ø125 Ø160 Ø200

46200092 **7,4 kg**
 Pallet for HG-N
 Ø160

46200093 **7,8 kg**
 Pallet for HG-N
 Ø210

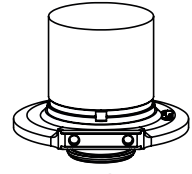


46200270 **6,7 kg**
 Pallet for
 vises IMG SINTEX ST5-2G

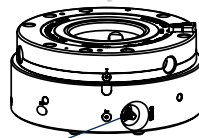


46200255
 SMF workpiece

46200250 **5,3 kg**
 Two-pieces
 pallet

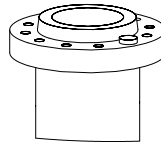


G1/8 71612801 female quick
 connection for pneumatic
 manual operation



46220450
 Manual Ø202 Rotary Plate
 + APS 190 module

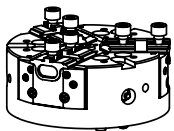
24XXXXXX
 ISO-A Flange



(*) special semi-finished pallets with female inlet
 location 71718105 are supplied upon request

ROTARY PLATE Ø202: USABLE CHUCKS SCHEME

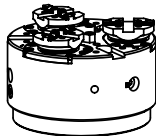
170 AP



M24x2/M12 *

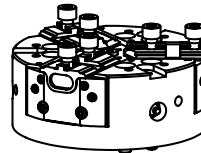
170 TS

170 TX



M28x1.5/M12 *

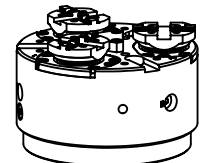
210 AP



M32x1.5/M16 *

210 TS

210 TX



M32x1.5/M16 *

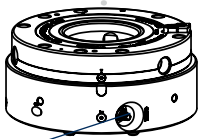
46201535 **6,3 kg**
 Pallet Ø140



46201545 **6,6 kg**
 Pallet Ø170

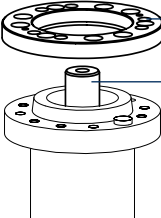


G1/8 71612801 female quick
 connection for pneumatic
 manual operation



46220450
 Manual Ø202 Rotary Plate
 + APS 190 module
NOTE: once mounted, make Ø40
 hole by drilling

24XXXXXX
 ISO-A Flange
 DRAW BAR

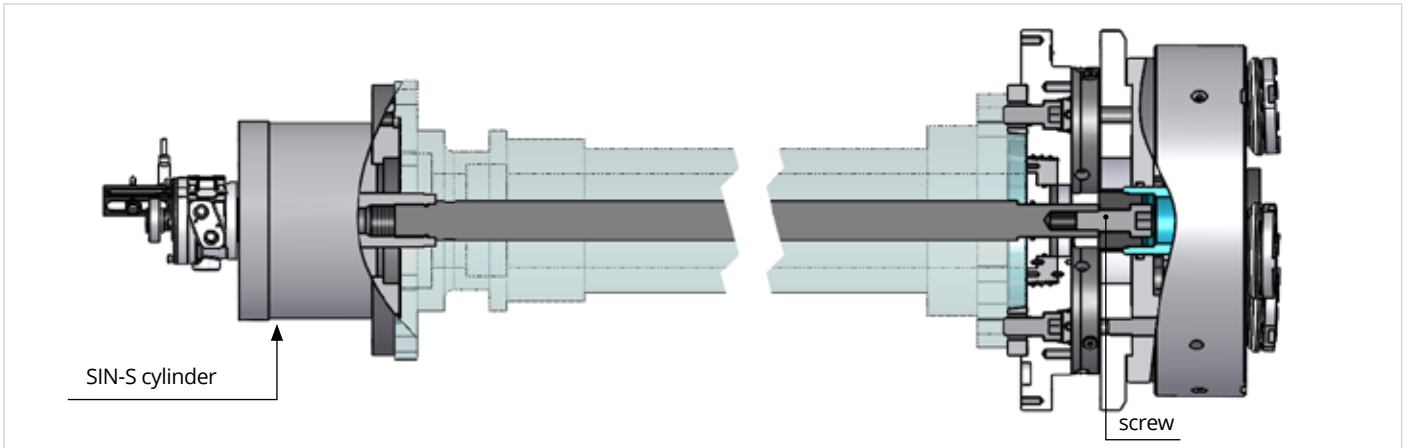


NOTE: all indicated chucks can have air sensing function as
 optional

* Special connection group

Recommended cylinders for ROTARY PLATE

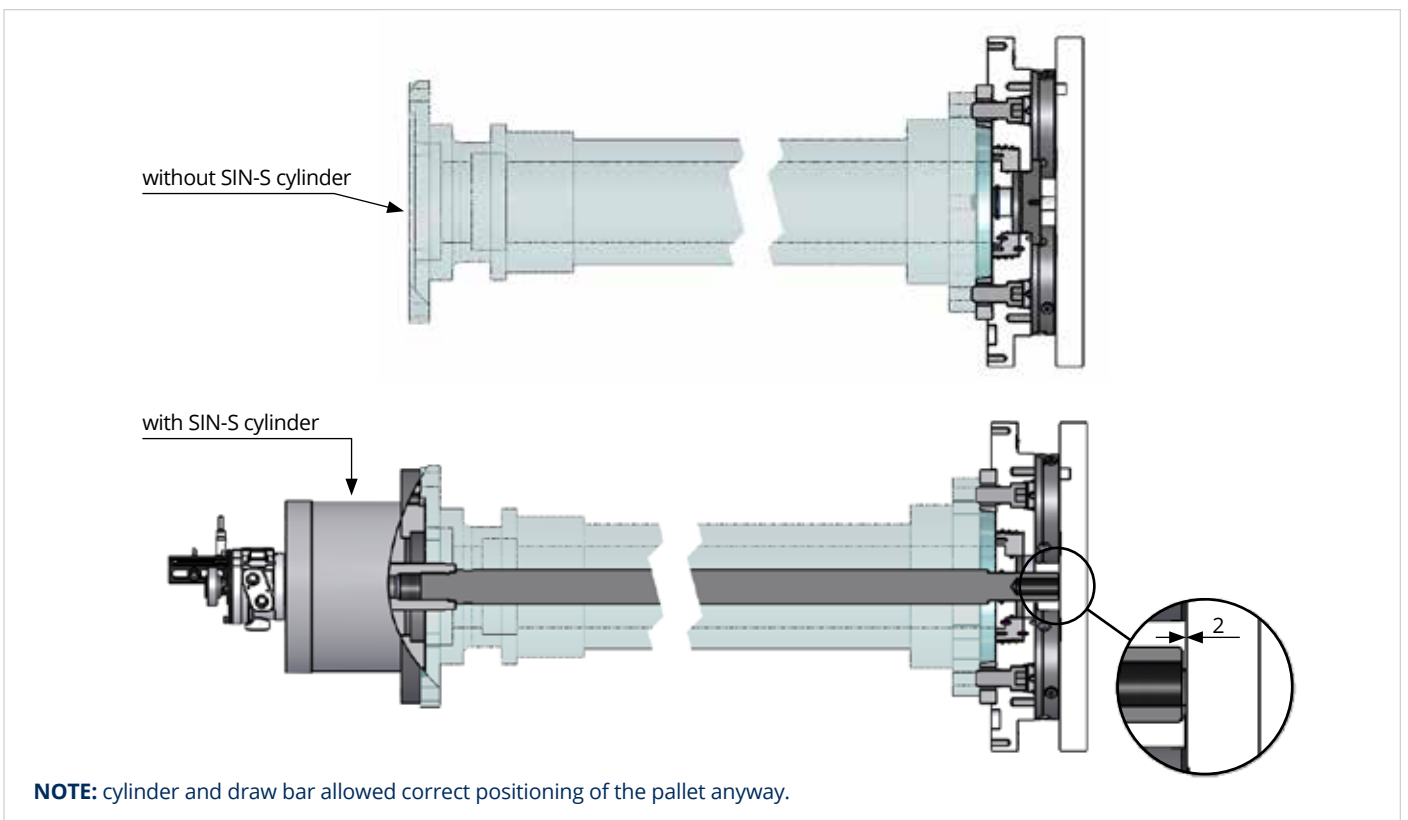
Manual pallet fast set-up with chucks.
Connection between the chuck and the draw bar is made by screw.



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



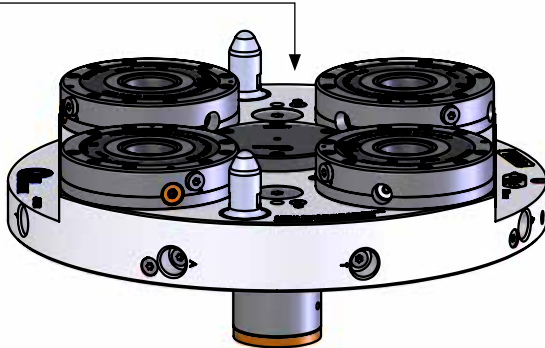
NOTE: cylinder and draw bar allowed correct positioning of the pallet anyway.

ROTARY PLATE ASSEMBLY LINE

Automatic operation APS modules

Manual or automatic pallet tooling fast set-up

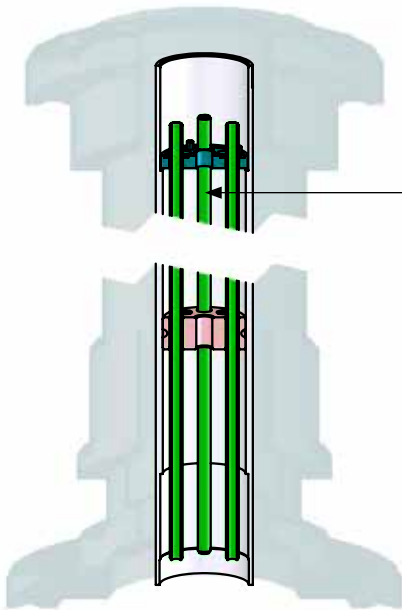
Pallet  FOR EACH SIZE, CHECK RELATED PALLETS



Mod. Id.No. AUTOMATIC ROTARY PLATE

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

ISO-A flange  [VIEW ACCESSORIES](#)



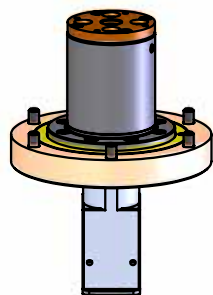
Pipe bundle

(to customize for each machine tool specifically)



Manifold flange

(to customize for each machine tool specifically)

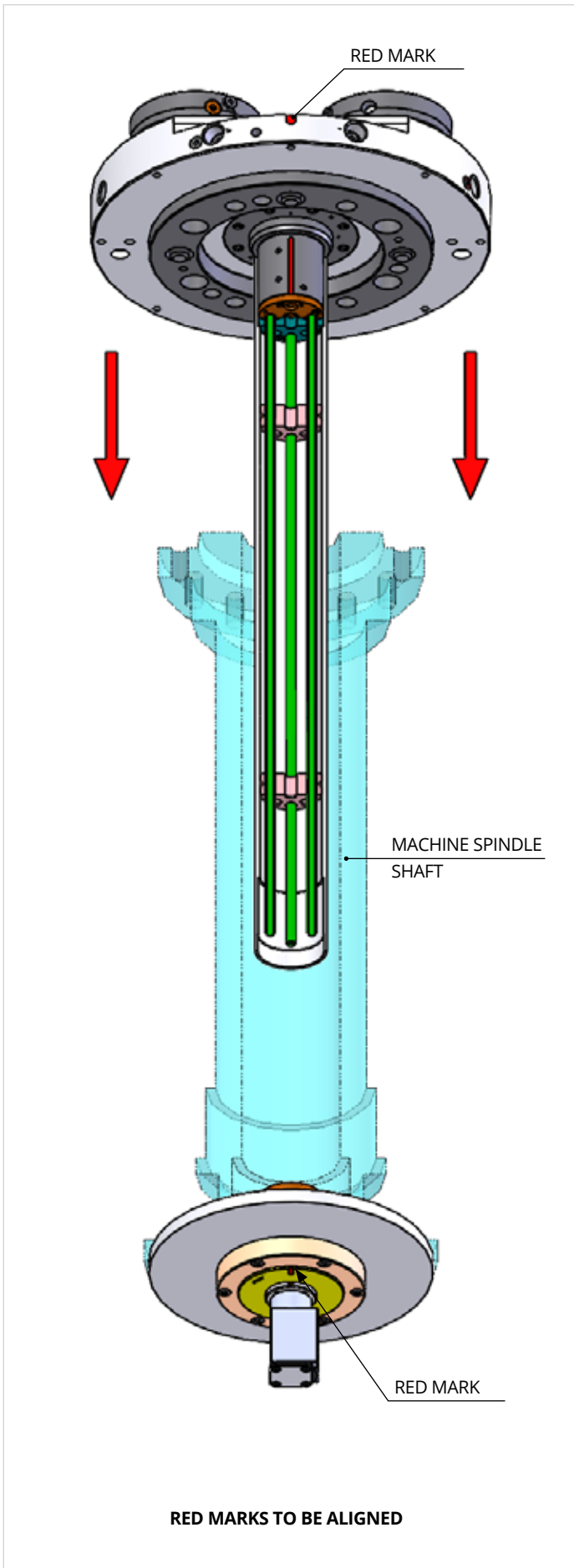


60580011  [VIEW ACCESSORIES](#)

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

