

# 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

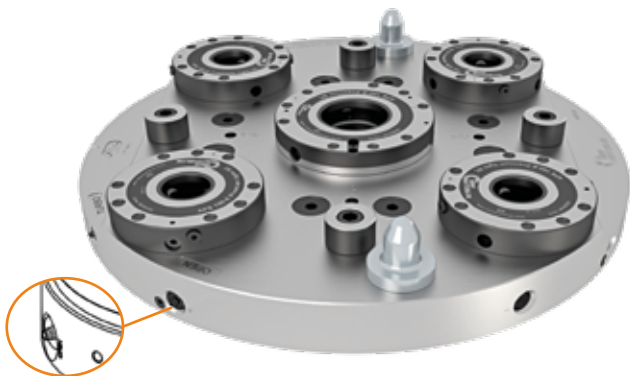
3  
a



# ROTARY PLATE Ø650

## with APS 190 and 4 APS 160 manual operation

Manual tooling fast set-up for Ø 650 and Ø 800 pallets and chucks



N. 2 PNEUMATIC CONNECTIONS FOR MANUAL OPENING AND TURBO COMMAND

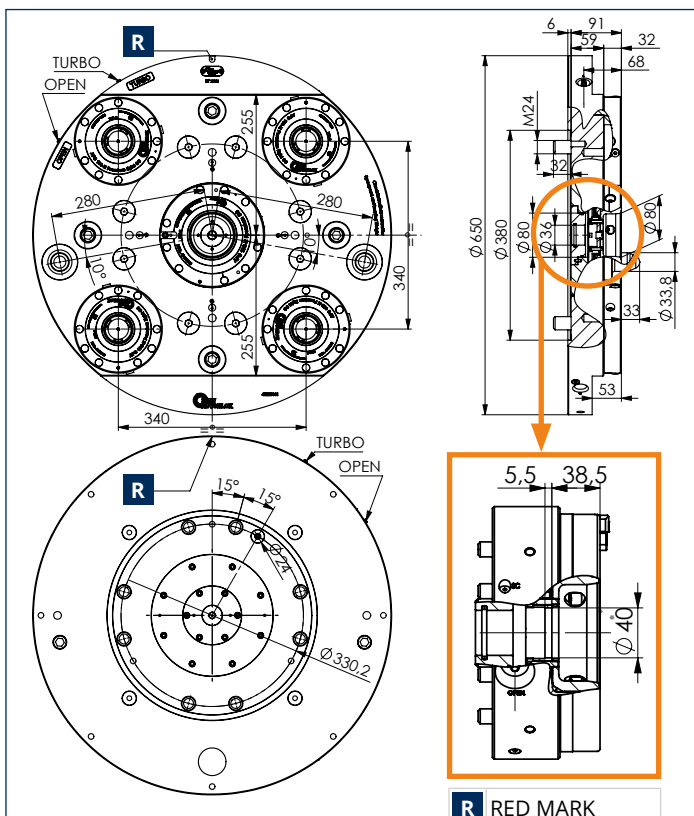
### Applications/Customer Benefits

- Pallet/Tooling fast set-up
- Chucks fast set-up Ø650 and Ø800 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

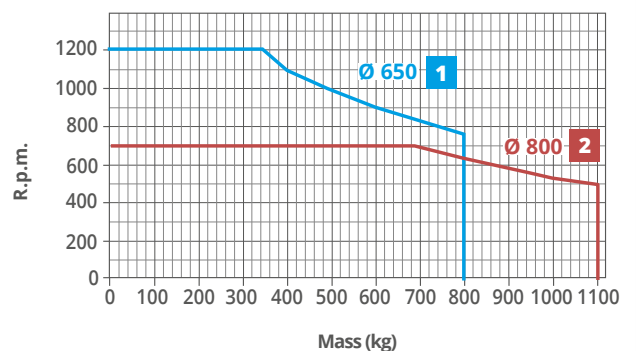
ROTARY PLATE MODEL	ID.NO.	REPEATABILITY	CLAMPING FORCE BY TURBO FUNCTION AT 6 bar	MAX PRESSURE OPENING / CLOSING	WEIGHT Kg	CHUCK FEATURES			
						DRAW BAR MAX PULLING FORCE	DRAW BAR MAX PUSHING FORCE	Ø650 CHUCK MAX RPM (*)	Ø800 CHUCK MAX RPM (**)
Ø650 MANUAL	46220100	0,005 mm	165 kN	6 bar	170	100 kN	60 kN	1200	700



R RED MARK

POWER CHUCK ASSEMBLY. In case of connection between draw bar and chuck, drill APS cover Ø40 hole assembled on machine tool.

### 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 650 and 450 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 800 and 450 mm total length

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

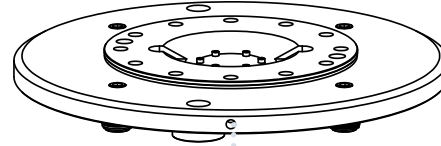
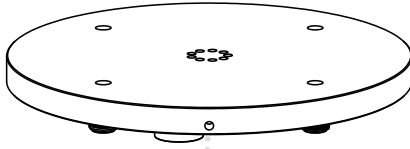
## ROTARY PLATE Ø650: AVAILABLE PALLETS

**46220300** **179 kg**  
 (\*) Pallet SMF  
 Ø800 x 45

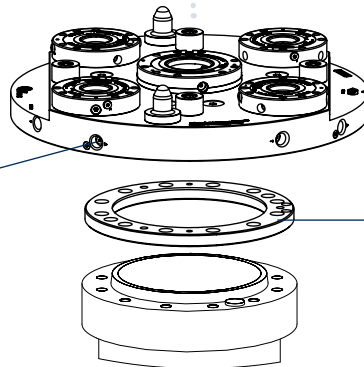
**46220290** **119 kg**  
 (\*) Pallet SMF  
 Ø650 x 45

**46220180** **99 kg**  
 Pallet Ø520  
 for PTF Ø800  
 for HG-NB Ø800

**46220060** **95 kg**  
 Pallet Ø380  
 for PTF Ø660  
 for HG-N Ø630



G1/8 71612801 female quick connection for pneumatic manual operation



**46220100**  
 Manual Ø650 Rotary Plate  
 + APS 190  
 + 4 APS 160 module

**24XXXXXX**  
 ISO-A flange

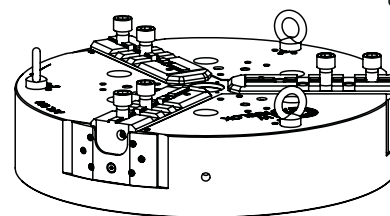
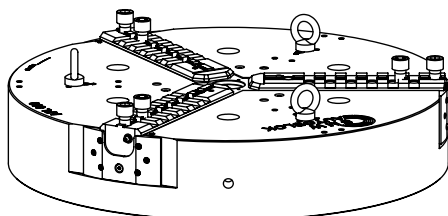
(\*) special semi-finished pallets with female inlet location 71718105 are supplied upon request

## ROTARY PLATE Ø650: USABLE CHUCKS SCHEME

**800 APL**

**630 APL\*\***

\*\* By special pallet, 650 TS chuck can be assembled



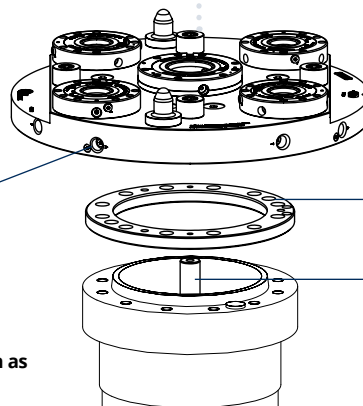
M60x1.5/M24 \*

M60x1.5/M24

**46220180** **99 kg**  
 Pallet Ø520

**46220060** **95 kg**  
 Pallet Ø380

G1/8 71612801 female quick connection for pneumatic manual operation



**46220100**  
 Manual Ø650 Rotary Plate  
 + APS 190  
 + 4 APS 160 module

**24XXXXXX**  
 ISO-A flange

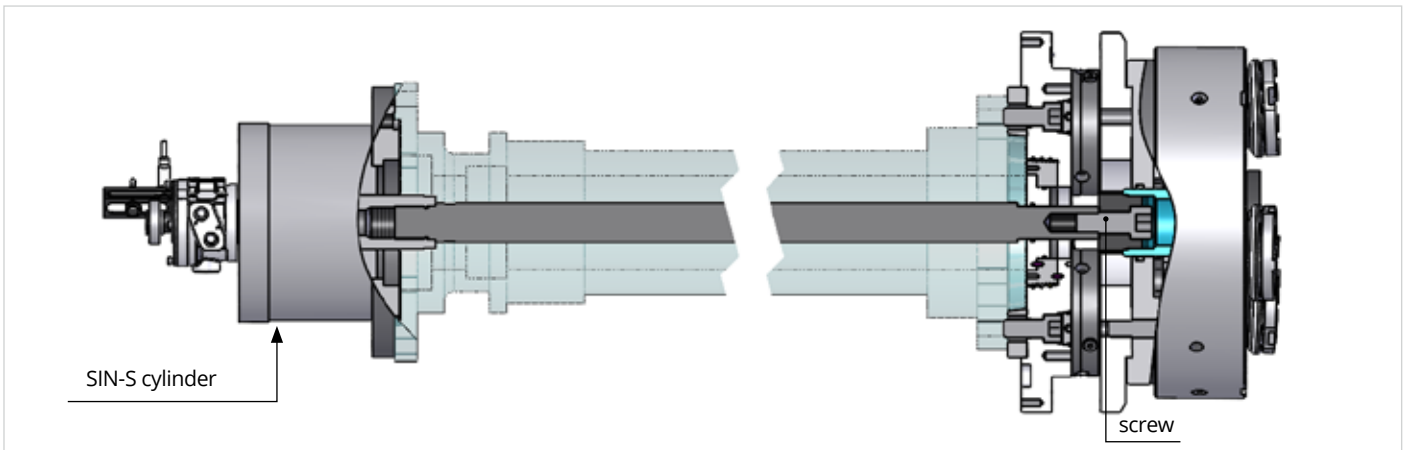
DRAW BAR

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

\* Special connection group

## Recommended cylinders for ROTARY PLATE

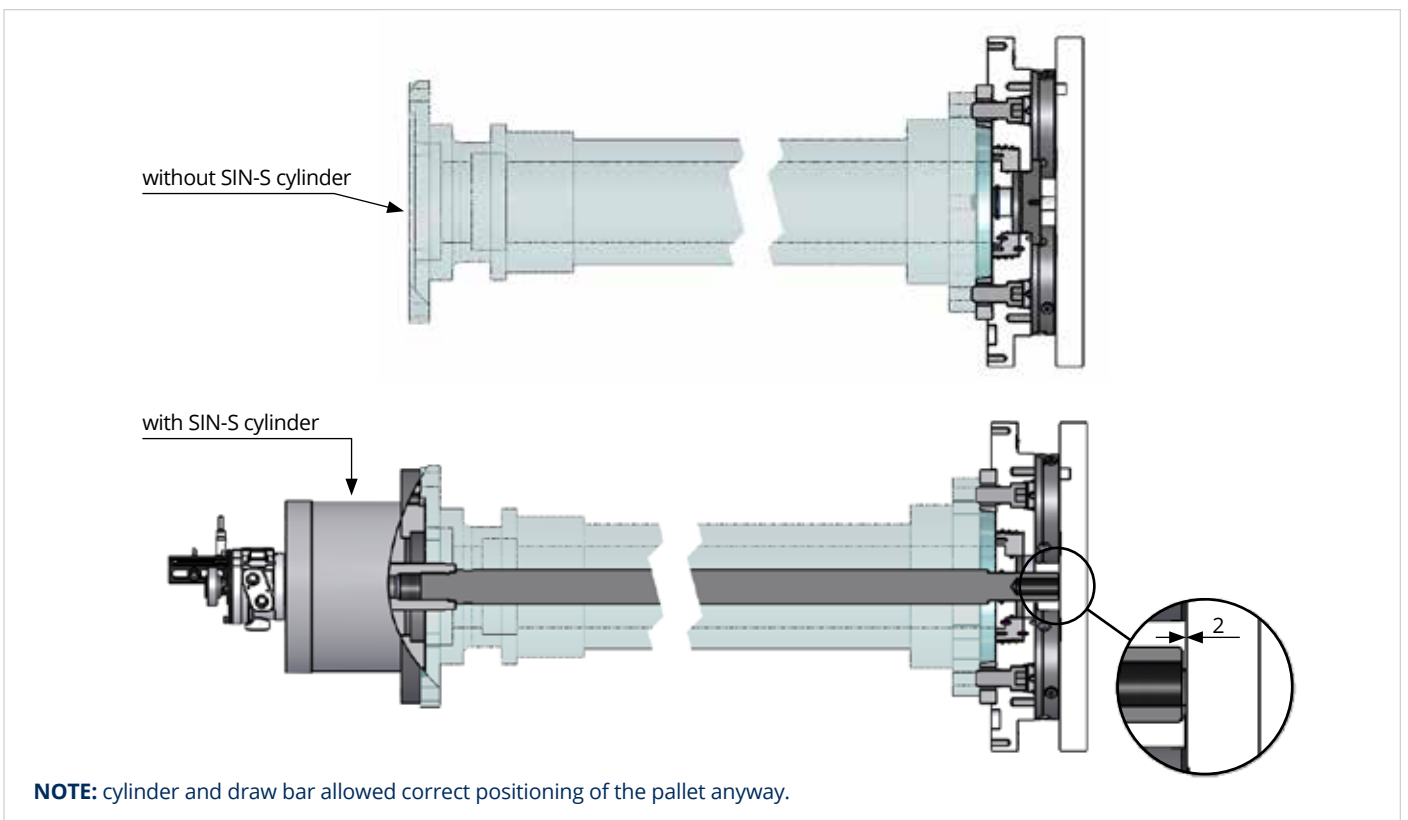
Manual pallet fast set-up with chucks.  
Connection between the chuck and the draw bar is made by screw.



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



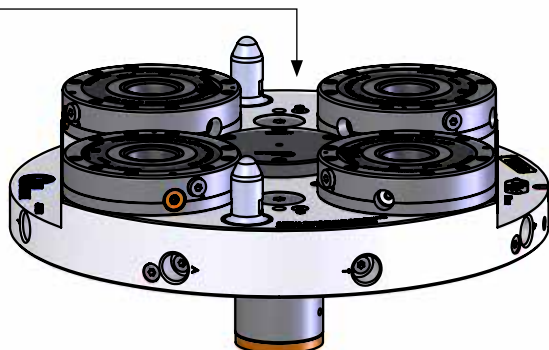
**NOTE:** cylinder and draw bar allowed correct positioning of the pallet anyway.

# ROTARY PLATE ASSEMBLY LINE

## Automatic operation APS modules

### Manual or automatic pallet tooling fast set-up

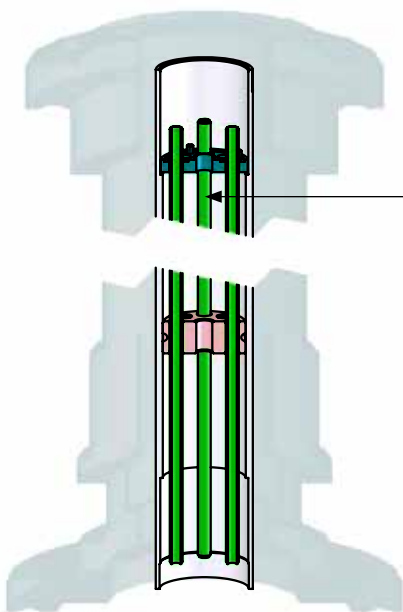
**Pallet**  FOR EACH SIZE, CHECK RELATED PALLETS



Mod. Id.No. AUTOMATIC ROTARY PLATE

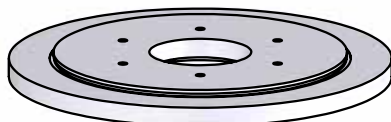
Ø202	<b>46220460</b>
Ø260	<b>46220500</b>
Ø330	<b>46220360</b>
Ø420	<b>46220400</b>
Ø520	<b>46220090</b>
Ø650	<b>46220140</b>

**ISO-A flange**  [VIEW ACCESSORIES](#)



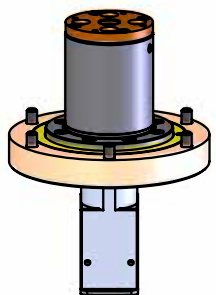
**Pipe bundle**

(to customize for each machine tool specifically)



**Manifold flange**

(to customize for each machine tool specifically)

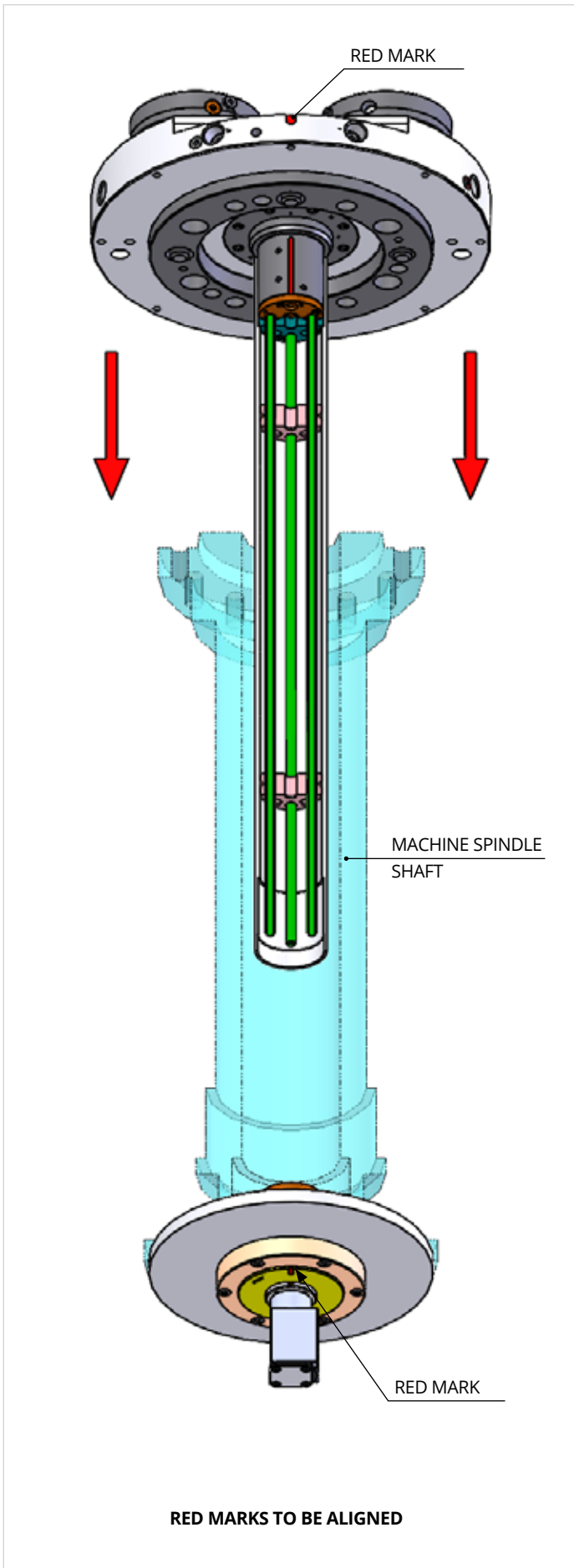


**60580011**  [VIEW ACCESSORIES](#)

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

