DREAM NAVIGATOR
SINCE 1909

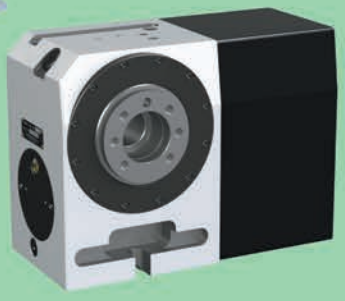
TSUDAKOMA

General Catalog

NC
Rotary Tables

TSUDAKOMA Corp.

Aerospace /Parts



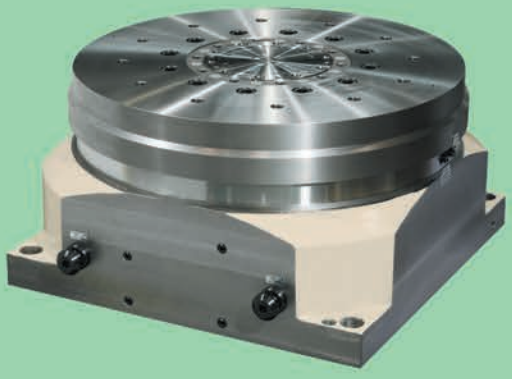
Productivity Innovation

Tsudakoma products are being used all over the world for high-precision machining in the automobile, aerospace, electronics and medical industries.

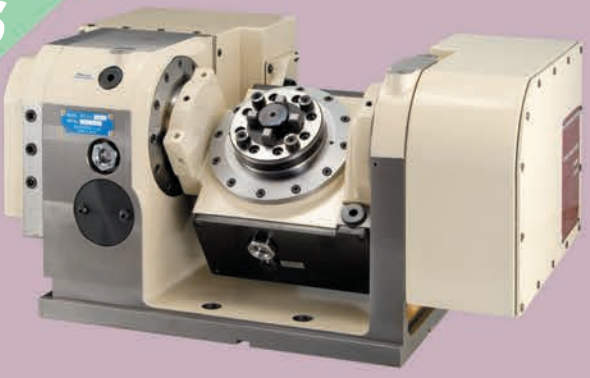
In pursuit of the ultimate in performance, productivity, and technical advantages, Tsudakoma always strives to develop innovative products.

We are always trying to create advantageous NC tables that will satisfy our customers' needs.

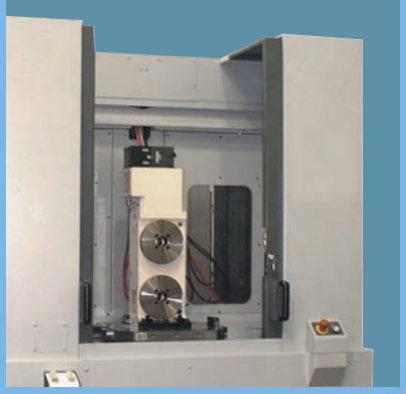
Automotive

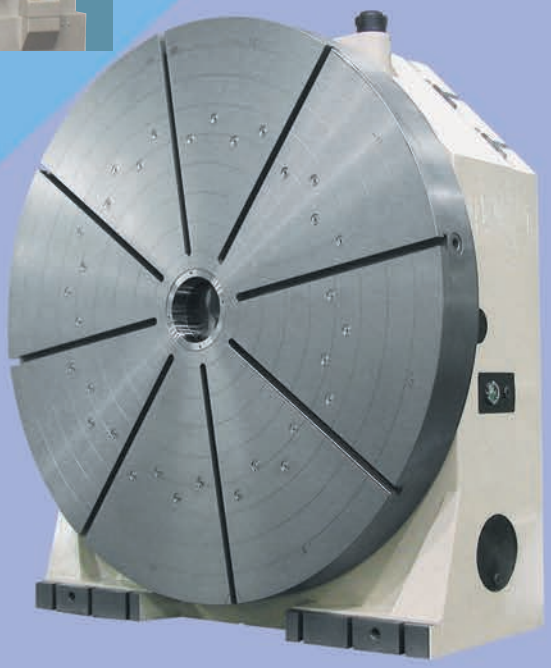


Electronics

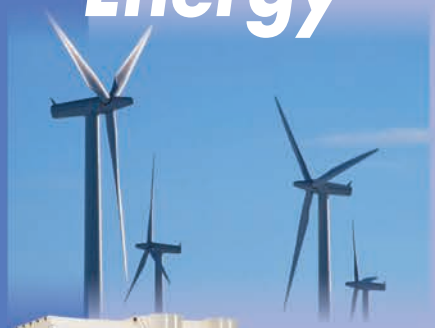


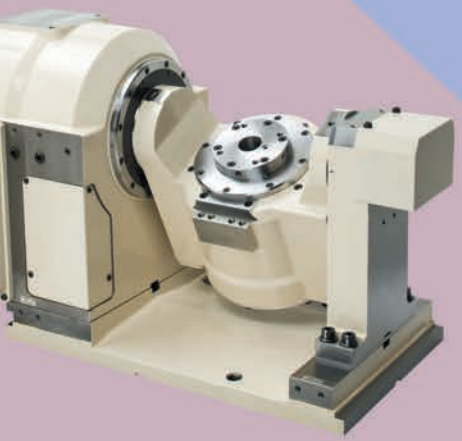
Medical





Energy





TSUDAKOMA

NC Rotary Tables

General Catalog

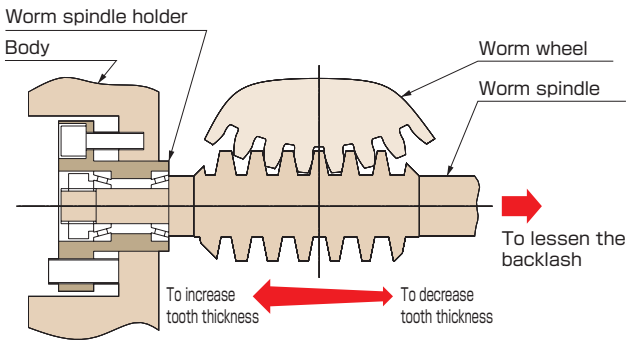
CONTENTS

EXCELLENT BALANCE OF SMOOTHNESS, POWER AND DURABILITY BY SPECIAL GEAR SYSTEM ASSURES THE ULTIMATE IN PERFORMANCE

TSUDAKOMA specially designed double-lead worm gears with full-depth teeth

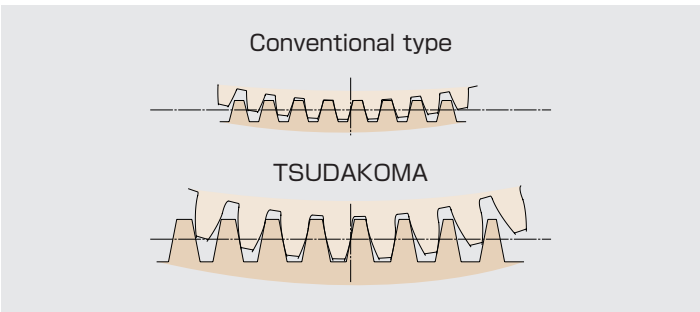
The setting of the lead amount on this gear system is different depending on the rotating direction of the worm wheel and the worm spindle. By moving the worm spindle axially, the tooth engagement can be changed successively. As the backlash between the worm wheel and the worm spindle can be adjusted while keeping them in their proper positions, the ideal tooth engagement is maintained.

gear system



Tooth profile

The adoption of full depth gear teeth, instead of standard teeth, results in higher strength equal to that of a gear of a size larger in module.



Materials

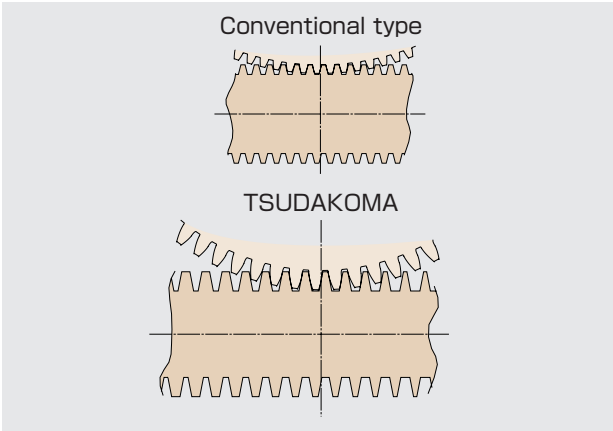
Worm spindle: Case-hardened alloy steel
Worm wheel: Special high-tensile brass equal in strength to a steel alloy

Torque transfer efficiency

The combination of iron and brass produces less friction. A more effective transfer of the motor torque is achieved compared with other combinations of materials.

Larger worm wheel

The worm wheel with a large pitch diameter creates a large engagement area and less pressure on the contact surface, resulting in high durability against wear compared with conventional gear systems.



HIGH-LEVEL PERFORMANCE PROVEN IN MACHINING FIELDS

TSUDAKOMA

NC Rotary Tables

Basic models

RNA-series

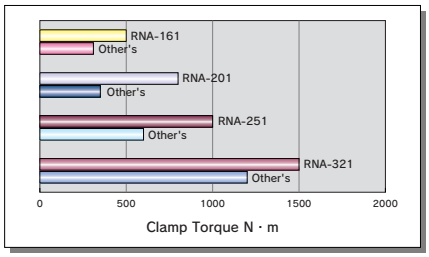
New standard for the ultimate in power and speed

High Speed

The specially designed double-lead worm gear system with full-depth teeth of increased torque transfer efficiency minimizes the speed reduction ratio, improving the indexing speed by 20% (RNA-201) more than that of a conventional table.
The machining cycle time is reduced.

Strong Clamp Torque

The newly developed clamp mechanism using pneumatic pressure realizes powerful clamping at least 2.5 times (RNA-201) more than that of a conventional table.
The cutting feed speed is increased.
Responsibility is also increased.



NC Rotary Tables

Big bore models

RBA-series

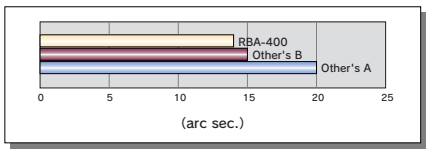
Flagship models of single-axis NC table

Dual Disc Clamp Mechanism

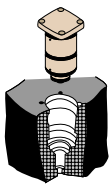
This unique clamping mechanism using dual discs can double the clamp torque compared with the capacity of our conventional type. As the mechanism is placed right under the table, the displacement of the table due to clamp movement is minimized.

Cumulative indexing accuracy of 14 sec., guaranteed

TSUDAKOMA has taken another step forward to elevate the indexing accuracy of NC rotary table, thanks to its high level of quality control.



Built-in Air-Hydraulic Booster Unit



This unit is a clamping booster which converts the pressure of the supplied air to hydraulic pressure 7 times higher than the air pressure. It is more compact than the conventional unit and can be contained in the frame. This unit is available even on a machine tool not provided with a hydraulic power source and, thus, saves the setting space. (* Optional)

Enhanced Security

All the switches and the solenoid valves are waterproofed and conform to CE standards. An air-purge function in the motor housing greatly facilitates maintenance.

NC Rotary Tables

Basic tilting models

TN-series

Best partner for five-axis machining

High Speed

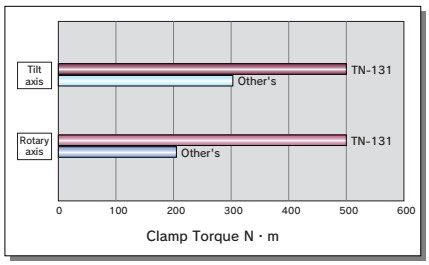
The specially designed double-lead worm gear system with full-depth teeth of increased torque transfer efficiency minimizes the speed reduction ratio, improving the indexing speed by 50% more than that of a conventional table.
The machining cycle time is reduced.

Variety of Options

In addition to the automatic work mounting and dismounting arrangements by a pull-stud device as well as pneumatic or hydraulic rotary joint, high precision specifications using a scale is also available.

Strong Clamp Torque

The newly developed clamp mechanism using pneumatic pressure realizes enables powerful clamping at least 2.5 times (TN-131) more than that of a conventional table. It is rigid enough for machining even at a position far from the tilting axis.

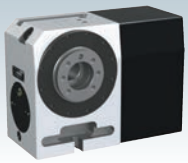


INDEX

Ball Drive System NC Rotary Table

It enables high indexing speed and super productivity with top quality thanks to no backlash and high rigidity.

Standard type
RG



RG-160
RG-250
RG-320

P.8

NC Rotary Tables

Powerful, Compact and Speedy!
Products for processes ranging from high-speed multi-axis drilling and tapping to cam machining.

Basic models

Best-selling models with strong clamp torque and outstanding water-proof structure

Standard type
RNA／RN

RNA-161
RNA-201
RNA-251
RNA-321
RN-100

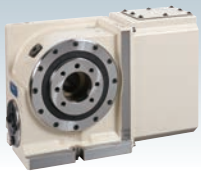
P.10

Rear motor mounting type
RNA-B／RNCV-B

RNA-161R,B
RNA-201R,B
RNA-251R,B
RNA-321R,B
RNCV-401R,B

P.14

Standard type
RNE



RNE-160
RNE-200
RNE-250
RNE-320

P.12

Vertical motor mounting type
RNCM

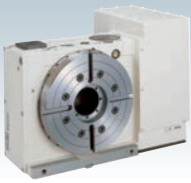
RNCM-251
RNCM-301
RNCM-401
RNCM-501
RNCM-631

P.16

Big bore models

Our flagship model Various types of labor-saving and automation devices can be attached through the large-diameter bore

Standard type
RBA



RBA-250
RBA-320
RBA-400
RBA-500

P.18

For horizontal machining centers
RBA-K RNCK

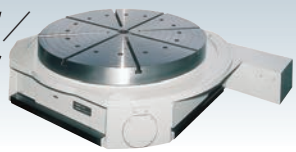
RBA-250K
RBA-320K
RBA-400K
RBA-500K
RNCK-631

P.20

Large models

A top-seller large-capacity model when combined with large-sized double column, or 5-face machining centers

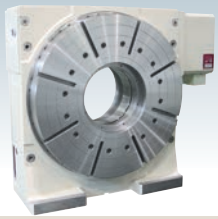
For horizontal setting
RCH／RNC



RCH-800
RCH-1000
RCH-1250
RNC-1501
RNC-2001

P.22

Horizontal motor mounting type
RCV／RNCV



RCV-800
RCV-1000
RCV-1250
RNCV-1501

P.24

Multi-spindle models

High-productivity model for multi-piece/multi-face machining

Multi-spindle type
RN-N

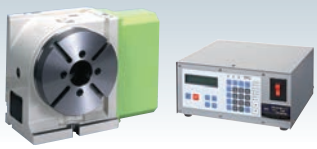
RN-100-2/3/4
RN-150-2
RN-200-2
RN-250-2
RN-300-2

P.26

NC Indexers

Economical model equipped with a user-friendly index controller

NC Indexer with Programmable Controller
RZ



RZ-161
RZ-201

P.28

Single-axis NC Controllers

NC table can be controlled with M-signals from the machining center.

For small NC rotary tables
TPC-Jr

TPC-Jr H2
TPC-Jr H3

P.46

For large NC rotary tables
TPC5

TPC5 SR6
TPC5 SR12
TPC5 SR30

P.48

NC Tilting Rotary Tables

Machining of aluminum components for automobiles electronic devices and blades for jet engines.

Basic models

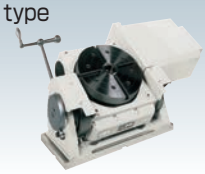
High speed indexing and strong clamp torque for five-axis machining

Standard type
TN

TN-101	TN-201
TN-131	TN-320
TN-161	TN-450

P.30

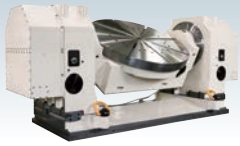
Manual Tilting type
THNC



THNC-251
THNC-301

P.34

Standard type
TTNC



TTNC-631
TTNC-1001
TTNC-1500

P.32

Multi-spindle models

Multi-work processing model for high productivity

Multi-spindle type
TTNC-N

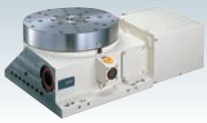
TTNC-102-2
TTNC-101-4
TTNC-151-2
TTNC-201-2

P.36

NC Rotary Tables developed for specific machines

Special model built in a flexible transfer line for automobile parts machining.

Horizontal setting type with rotary joint
RC



RC-250
RC-300
RC-400
RC-500

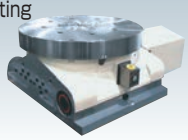
P.38

For vertical setting
RUA

RUA-251
RUA-321
RUA-400
RUA-500

P.40

For horizontal setting
RH



RH-400
RH-500
RH-600

P.38

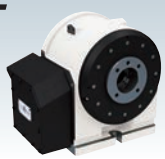
Support spindles
TSUA

TSUA-170
TSUA-210
TSUA-255
TSUA-310

P.42

DD Table・Special NC Rotary Table

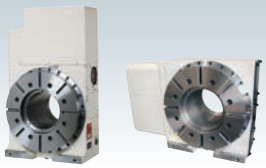
DD Table
RTV·RTT



RTV-202
ϕ500 Table
RTT-112

P.44

Highly rigid models with a super big bore
RTV



RTV-304
RTV-404
RTV-504
RTV-801

P.45

Accessories

P.58

Chuck

Scroll chuck

Power chuck

Tailstock

Manual tailstock

Hydraulic tailstock

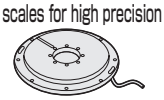
Support spindle

Face plate

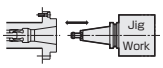
Optional Specifications

P.65

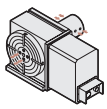
Rotary encoders and MP scales for high precision



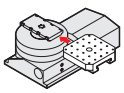
Pull-stud



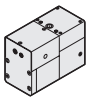
Rotary joint



Pallet clamp



Air-hydraulic Booster

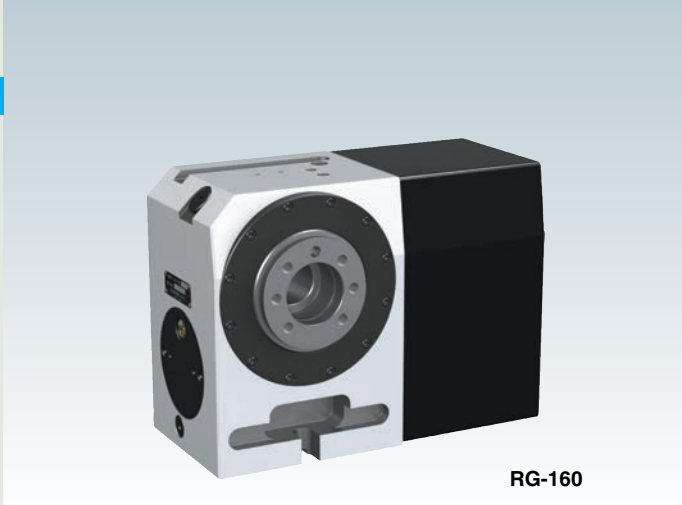


Standard type

RG

RG-160・250・320

The new technology, Tsudakoma Ball Drive System is adopted.
It enables high indexing speed which is two times faster than conventional model and super productivity with top quality thanks to no backlash and high rigidity.


RG-160

Specifications

Unit: mm

		RG-160	RG-250	RG-320
Handedness	R	○	○	○
	L	–	–	–
Spindle diameter		φ100	φ140	φ180
Table diameter *1		φ160 or φ200 (Option)	φ250 (Option)	φ320 (Option)
Center height		160	210	255
Center bore	Nose diameter	φ55H7x45	φ80H7x45	φ115H7x45
	Through-bore	φ40	φ50	φ85
Table T-slot width *1		12H8	12H8	14H8
Guide block width		14h7	18h7	18h7
Servo motors (for FANUC)		αiF4	αiF8	αiF12
Inertia converted into motor shaft	$\times 10^{-3}$kg·m^2	0.19	0.42	2.24
Net weight	kg	60	110	210
Speed reduction ratio		1/36	1/36	1/36
Table max. rpm (Motor rpm: 3,000min^{-1})	min^{-1}	83.3	83.3	83.3
Indexing accuracy (the sum)	sec	15	15	15
Repeatability	arc sec	4	4	4
Clamp system		Pneumatic	Pneumatic	Pneumatic
Clamp torque ／pneumatic pressure 0.49MPa	N·m	500	1,000	1,500
Allowable work weight: Vertical setting ( ) : with tailstock	kg	100 (200)	125 (250)	175 (350)
Allowable work weight: Horizontal setting	kg	200	250	350
Allowable load (when table is clamped): F	N	10,800	14,400	24,800
Allowable load (when table is clamped): F×L	N·m	500	1,000	1,500
Allowable load (when table is clamped): F×L	N·m	780	1,900	4,700
Allowable work inertia $J=\frac{W \cdot D^2}{8}$	kg·m^2	0.48	1.95	4.48

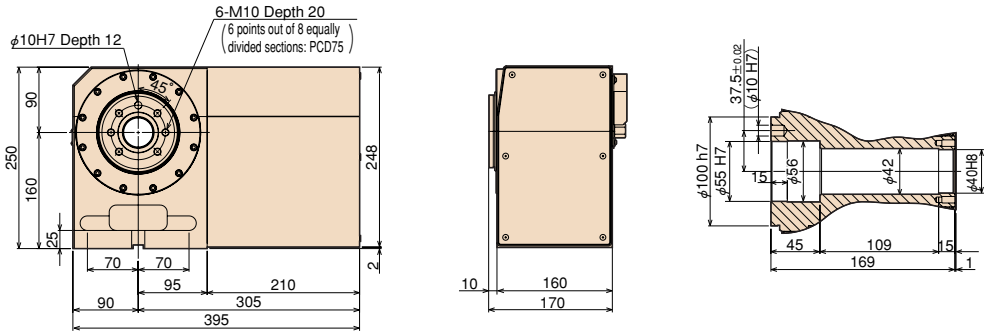
☞Servo motors of other manufacturers P.70 ☞When assembling a faceplate or a fixture with the main spindle P.80

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

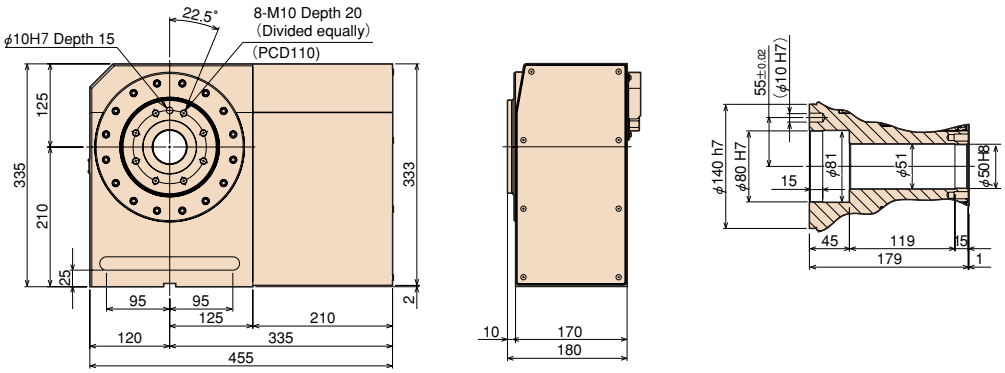
Dimensions

Unit: mm

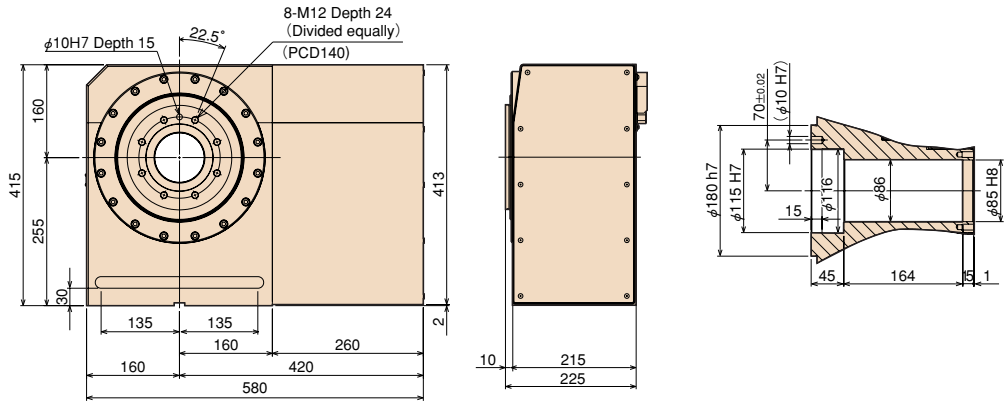
RG-160R



RG-250



RG-320



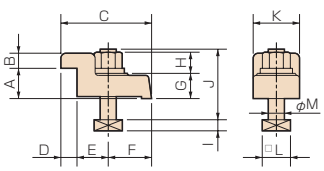
Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Clamping block and bolt

Unit: mm

	Q' ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RG-160	2	–	14	–	–	–	–	–	–	–	17	8	60	–	23	12
RG-250	4	40~120	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RG-320	4	55~147	18	30	15	90	16	31	43	25	21	11	70	46	28	16

Type I



Note 1: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

Standard type

RNA RNA-161・201・251・321
RN RN-100

The RNA series, an improvement on the best-selling RN series, has remarkably improved cost efficiency due to its high-speed operation for use in drill and tapping machines.

RNA-201R

Specifications

Unit: mm

		RNA-161		RNA-201	RNA-251	RNA-321	RN-100
Handedness	R	○		○	○	○	○
	L	○		○	○	○	○
Spindle diameter		φ100		φ120	φ140	φ180	φ80
Table diameter *1		φ160 or 200 (Option)		φ200 or 250 (Option)	φ250 (Option)	φ320 (Option)	φ135 (Option)
Center height		135		160	160	210	110
Center bore	Nose diameter	φ55H7×45		φ65H7×45	φ80H7×45	φ115H7×45	φ50H7×45
	Through-bore	φ40		φ45	φ50	φ85	φ30
Table T-slot width *1		12H8		12H8	12H8	14H8	10H8
Guide block width		14h7		18h7	18h7	18h7	14h7
Servo motors (for FANUC)		αiF2	αiF4	αiF4	αiF8	αiF8	αiF2
Inertia converted into motor shaft	$\times 10^{-3}$kg·m²	0.09	0.09	0.17	0.41	0.52	0.23
Net weight	kg	40	45	61	80	150	28
Speed reduction ratio		1/72		1/72	1/90 *2	1/120 *2	1/36
Table max. rpm (Motor rpm: 3,000min^{-1})	min^{-1}	41.6		41.6	33.3	25	83.3
Indexing accuracy (the sum)	sec	25		20	20	20	45
Repeatability	arc sec	4		4	4	4	4
Clamp system		Pneumatic		Pneumatic	Pneumatic	Pneumatic	Pneumatic
Clamp torque ／pneumatic pressure 0.49MPa	N·m	500		800	1,000	1,500	80
Strength of worm gears	N·m	206		288	596	939	176
Allowable work weight: Vertical setting  ( ) : with tailstock	kg	100 (200)		125 (250)	125 (250)	175 (350)	25 (50)
Allowable work weight: Horizontal setting 	kg	200		250	250	350	50
Allowable load (when table is clamped): F 	N	10,800		14,400	14,400	24,800	5,880
Allowable load (when table is clamped): F×L 	N·m	500		800	1,000	1,500	80
Allowable load (when table is clamped): F×L 	N·m	780		1,900	1,900	4,700	156
Allowable work inertia $J=\frac{W \cdot D^2}{8}$ 	kg·m²	0.64		1.25	1.95	4.48	0.10

☞Servo motors of other manufacturers P.70 ☞When assembling a faceplate or a fixture with the main spindle P.80

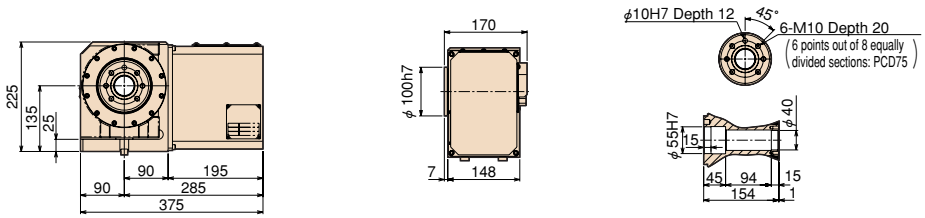
*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

*2 High speed models are available. Ask us for further information.
RNA-251: 321 (speed reduction ratio: 1:45) RNA-320: αiF12 or an equivalent motor should be used.

Dimensions

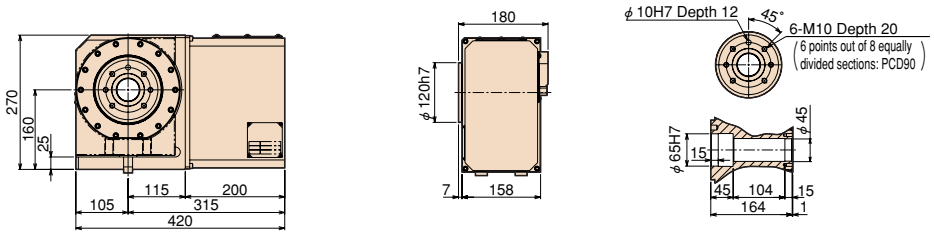
Unit: mm

RNA-161R ※When αiF2 is used



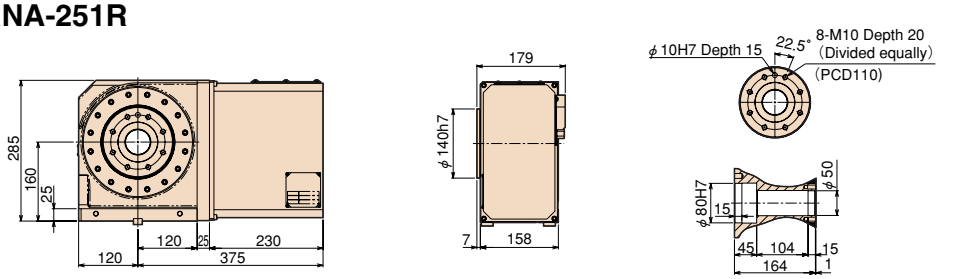

RNA-161R

RNA-201R



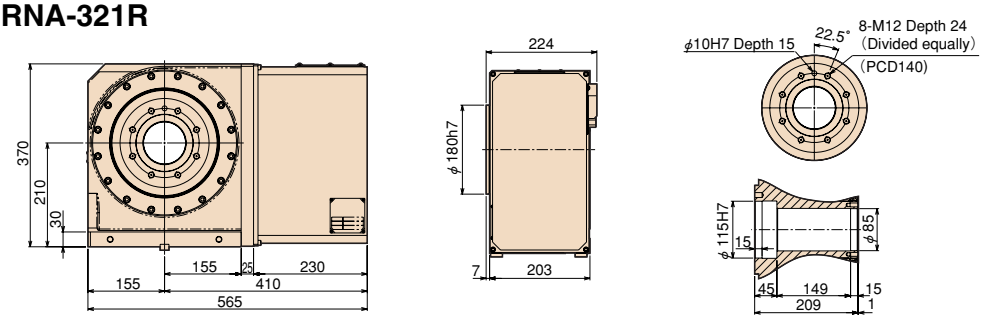

RNA-201R

RNA-251R



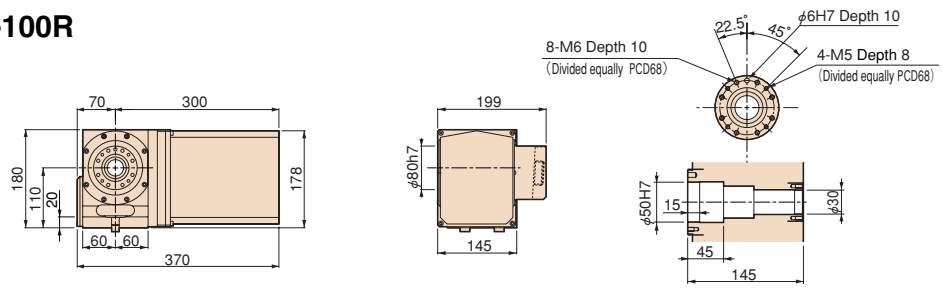

RNA-251R

RNA-321R




RNA-321R

RN-100R




RN-100R

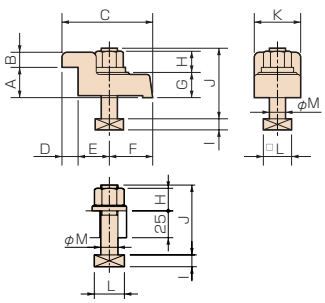
Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Clamping block and bolt

Unit: mm

	Type	Q'ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RNA-161	–	2	–	14	–	–	–	–	–	–	–	17	8	60	–	23	12
RNA-201	–	2	–	18	–	–	–	–	–	–	–	21	11	65	–	28	16
RNA-251	I	4	50~100	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RNA-321	I	4	50~132	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RN-100	–	2	–	14	–	–	–	–	–	–	–	17	8	55	–	23	12

Type I



Note 1: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)
Note 2: Clamping blocks are not included with the RNA-161 and RNA-201 and RN-100.

Standard type

RNE

RNE-160R・200R・250R・320R

RNE series are entry model which keeps Tsudakoma quality, but realizes affordable price.

RNE-160R

Specifications

Unit: mm

		RNE-160	RNE-200	RNE-250	RNE-320
Handedness	R	○	○	○	○
	L	○	○	–	–
Spindle diameter		φ100	φ120	–	–
Table diameter *1		φ160 or φ200 (Option)	φ200 or φ250 (Option)	φ250	φ320
Center height		135	160	160	210
Center bore	Nose diameter	φ55H7x45	φ65H7x45	φ75H7x20	φ110H7x25
	Through-bore	φ40	φ45	φ45	φ82
Table T-slot width *1		12H8 (Option)	12H8 (Option)	12H8	14H8
Guide block width		14h7	18h7	18h7	18h7
Servo motors (for FANUC)		αiF4	αiF4	αiF8	αiF12
Inertia converted into motor shaft	$\times 10^{-3}$kg·m^2	0.06	0.14	0.35	1.50
Net weight	kg	45	65	110	205
Speed reduction ratio		1/90	1/90	1/120	1/120
Table max. rpm (Motor rpm: 3,000min^{-1})	min^{-1}	33.3	33.3	25	25
Indexing accuracy (the sum)	sec	25	20	20	20
Repeatability	arc sec	7	7	7	7
Clamp system		Pneumatic	Pneumatic	Pneumatic	Pneumatic
Clamp torque ／pneumatic pressure 0.49MPa	N·m	250	400	600	1000
Strength of worm gears	N·m	206	288	596	939
Allowable work weight	Vertical setting  ( ) : with tailstock	75 (150)	100 (200)	100 (200)	150 (300)
	Horizontal setting 	–	–	–	–
Allowable load (when table is clamped)	F 	7,840	13,720	13,720	19,600
	F×L 	250	400	600	1,000
	F×L 	392	980	980	1,960
Allowable work inertia	$J=\frac{W \cdot D^2}{8}$ 	0.48	1.00	1.56	3.84

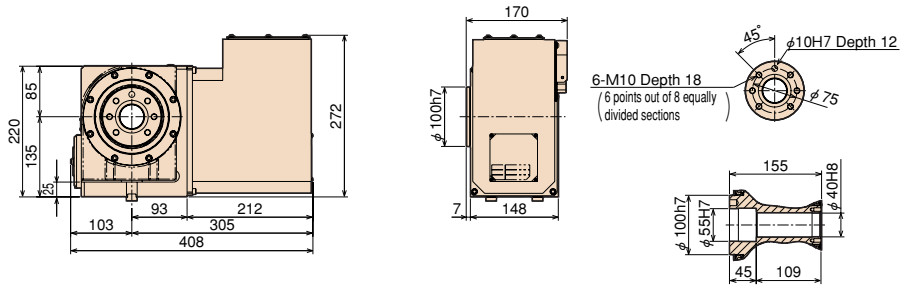
☞Servo motors of other manufacturers P.70 ☞When assembling a faceplate or a fixture with the main spindle P.80

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

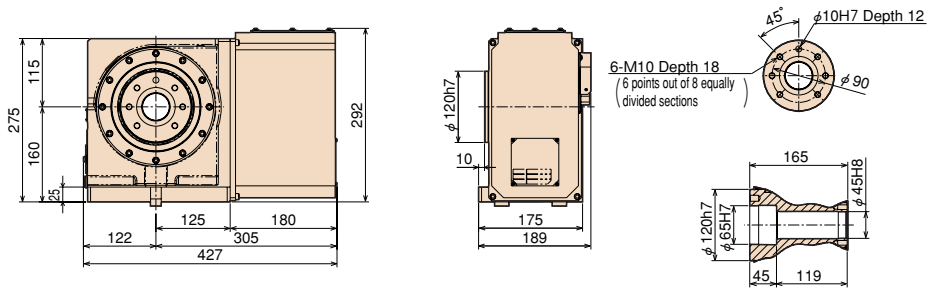
Dimensions

Unit: mm

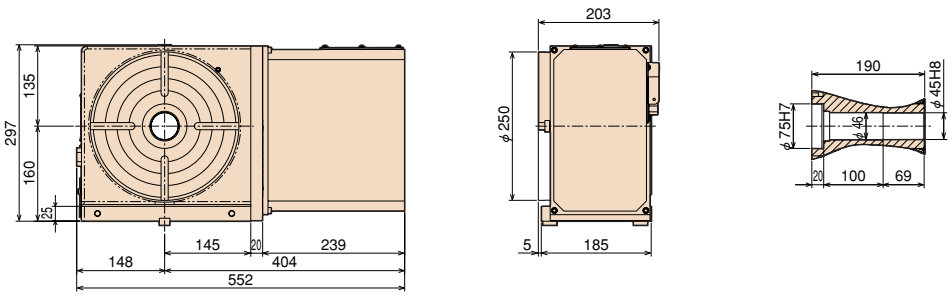
RNE-160R



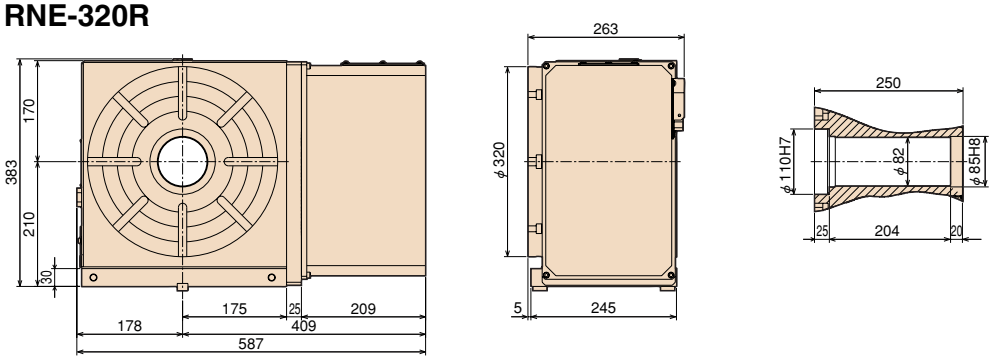
RNE-200R



RNE-250R



RNE-320R

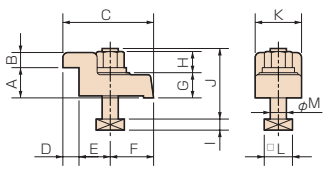


Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Clamping block and bolt

Unit: mm

	Q'ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RNE-160	2	–	14	–	–	–	–	–	–	–	17	8	60	–	23	12
RNE-200	2	–	18	–	–	–	–	–	–	–	21	11	60	–	28	16
RNE-250	4	40~120	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RNE-320	4	55~147	18	30	15	90	16	31	43	25	21	11	70	46	28	16



Note 1: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

Rear motor mounting type

RNA-B RNA-161R,B・201R,B 251R,B・321R,B

RNCV-B RNCV-401R,B

One of the most popular rear motor mounting type. Suitable for mounting on a compact machine tool for space saving.

RNA-251R,B

Specifications

Unit: mm

		RNA-161R,B	RNA-201R,B	RNA-251R,B	RNA-321R,B	RNCV-401R,B
Handedness	R	○	○	○	○	○
	L	—	—	—	—	—
Spindle diameter		φ100	φ120	φ140	φ180	—
Table diameter *1		φ160 or 200 (Option)	φ200 or 250 (Option)	φ250 (Option)	φ320 (Option)	φ400
Center height		135	160	160	210	255
Center bore	Nose diameter	φ55H7×45	φ65H7×45	φ80H7×45	φ115H7×45	φ40H7×21
	Through-bore	φ40	φ45	φ50	φ85	φ40
Table T-slot width *1		12H8	12H8	12H8	14H8	14H8
Guide block width		14h7	18h7	18h7	18h7	18h7
Servo motors (for FANUC)		αiF2 αiF4	αiF4	αiF8	αiF8	αiF12
Inertia converted into motor shaft	$\times 10^{-3}$kg·m²	0.56 0.56	0.64	0.97	0.84	4.01
Net weight	kg	55 58	77	95	165	330
Speed reduction ratio		1/72	1/72	1/90	1/120	1/180
Table max. rpm (Motor rpm: 3,000min⁻¹)	min⁻¹	41.6	41.6	33.3	25	11.1
Indexing accuracy (the sum)	sec	25	20	20	20	15
Repeatability	arc sec	4	4	4	4	4
Clamp system		Pneumatic	Pneumatic	Pneumatic	Pneumatic	Hydraulic or air-hydraulic (optional)
Clamp torque ／pneumatic pressure 0.49MPa	N·m	500	800	1,000	1,500	1,764 (Hydraulic pressure 3.5Mpa)
Strength of worm gears	N·m	206	288	596	939	1,666
Allowable work weight — Vertical setting (W) ( ) : with tailstock	kg	100 (200)	125 (250)	125 (250)	175 (350)	200 (500)
Allowable load (when table is clamped) — F (F)	N	10,800	14,400	14,400	24,800	39,200
Allowable load (when table is clamped) — F×L (F, L)	N·m	500	800	1,000	1,500	1,764
Allowable load (when table is clamped) — F×L (F, L)	N·m	780	1,900	1,900	4,700	2,450
Allowable work inertia $J=\frac{W \cdot D^2}{8}$ (φD, W)	kg·m²	0.64	1.25	1.95	4.48	9.7

☞Servo motors of other manufacturers P.70
☞When assembling a faceplate or a fixture with the main spindle (RNA-B-series) P.80

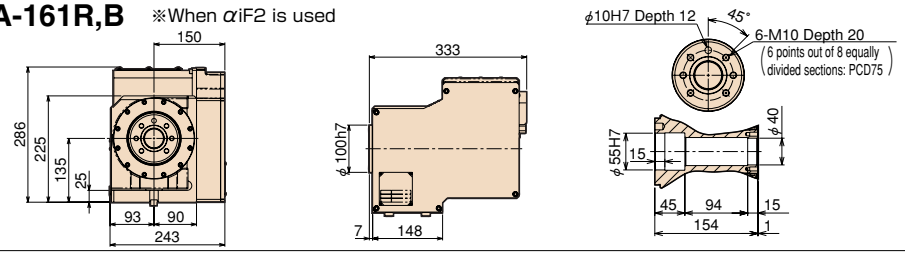
*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

Dimensions

Unit: mm

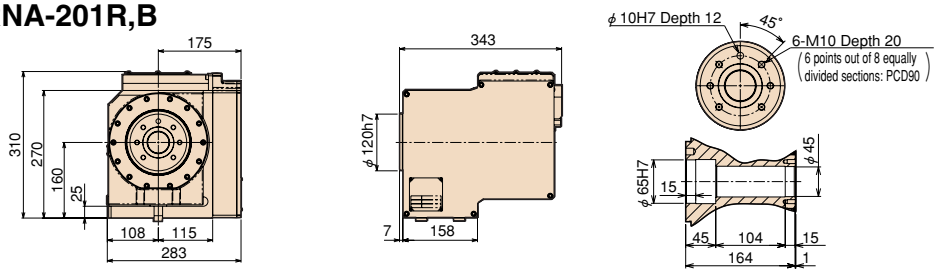
RNA-161R,B

※When αiF2 is used

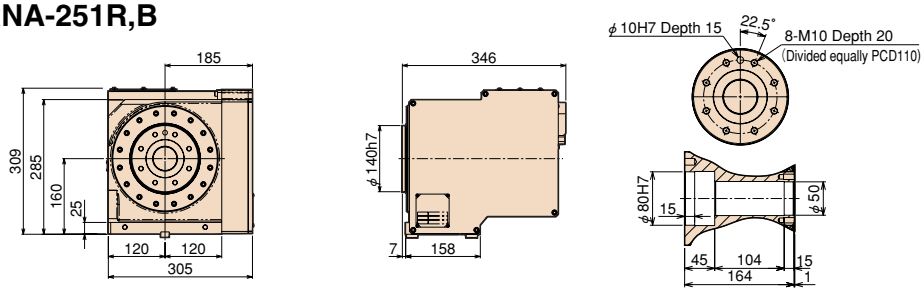


RNA-251R,B

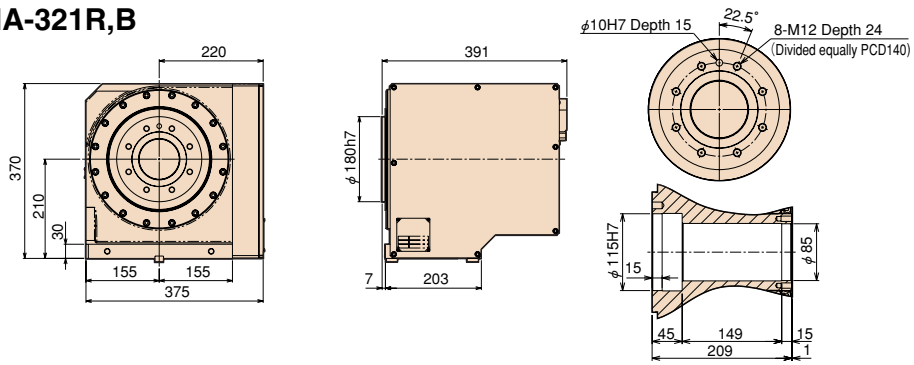
RNA-201R,B



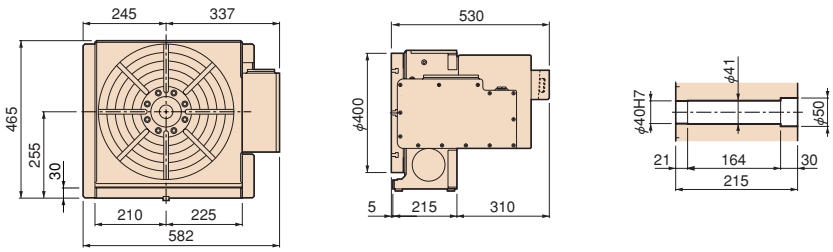
RNA-251R,B



RNA-321R,B



RNCV-401R,B



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Clamping block and bolt

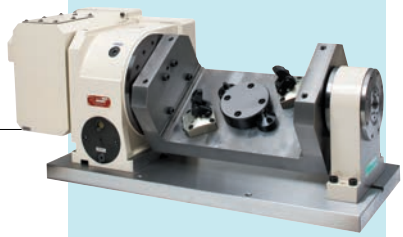
Unit: mm

	Type	Q'ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RNA-161R,B	–	2	–	14	–	–	–	–	–	–	–	17	8	60	–	23	12
RNA-201R,B	–	2	–	18	–	–	–	–	–	–	–	21	11	65	–	28	16
RNA-251R,B	I	4	50~100	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RNA-321R,B	I	4	50~132	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RNCV-401R,B	I	4	55~155	18	30	15	90	16	31	43	25	21	11	70	46	28	16

Note 1: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)
Note 2: Clamping blocks are not included wit the RNA-161R,B and RNA-201R,B.

With Support Spindle and Fixture Plate

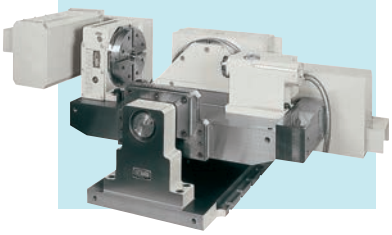
P.63



RNA-251R,B

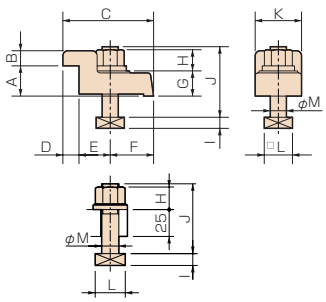
RT-22

Two-axis machining system by combining two NC rotary tables with a hydraulic tailstock.
Work: cutting tools, Automobile engine parts



RNCV-401R,B

Type I

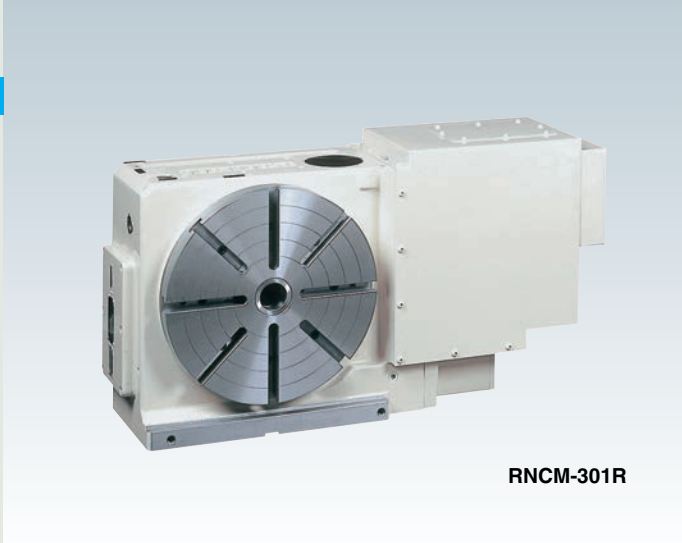


Vertical motor mounting type

RNCM

RNCM-251・301・401・501・631

Basic models with a motor horizontally mounted onto the side of the body.



RNCM-301R

Specifications

Unit: mm

		RNCM-251	RNCM-301		RNCM-401	RNCM-501	RNCM-631
Handedness	R	○	○		○	○	○
	L	○	○		○	○	○
Table diameter		φ250	φ320		φ400	φ500	φ630
Center height		160	210		255	310	400
Center bore	Nose diameter	φ40H7	φ40H7		φ40H7	φ50H7	φ60H6 *2
	Through-bore	φ32	φ40		φ40	φ50	φ60
Table T-slot width *1		12H7	14H7		14H7	18H7	18H7
Guide block width		18h7	18h7		18h7	18h7	18h7
Servo motors (for FANUC)		αiF4 or αiF8	αiF8	αiF12	αiF12	αiF12	αiF12
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.30 [3.01]	0.34 [3.43]	1.76 [17.9]	2.05 [20.9]	3.09 [31.9]	5.55 [56.6]
Net weight	kg	75	200		300	450	800
Speed reduction ratio		1/180	1/360	1/180	1/180	1/180	1/180
Table max. rpm (Motor rpm: 2,000min⁻¹)	min⁻¹	11.1	5.5	11.1	11.1	11.1	11.1
Indexing accuracy (the sum)	sec	15	15		15	15	15
Repeatability	arc sec	4	4		4	4	4
Clamp system		Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)		Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)
Clamp torque ／Hydraulic pressure 3.5Mpa [35kgf/cm²]	N·m [kgf·m]	490 [50]	Air-hydraulic pressure 274 [28]	833 [85]	1,764 [180]	2,450 [250]	4,410 [450]
Strength of worm gears	N·m [kgf·m]	470 [48]	764 [78]		1,666 [170]	2,450 [250]	4,116 [420]
Allowable work weight — Vertical setting (W) ( ) : with tailstock	kg	100 (250)	150 (350)		200 (500)	250 (600)	400 (1,000)
Allowable work weight — Horizontal setting (W)	kg	250	350		500	600	1,000
Allowable load (when table is clamped) — F (F)	N [kgf]	19,600 [2,000]	29,400 [3,000]		39,200 [4,000]	49,000 [5,000]	49,000 [5,000]
Allowable load (when table is clamped) — F×L (F, L)	N·m [kgf·m]	490 [50]	833 [85]		1,764 [180]	2,450 [250]	4,410 [450]
Allowable load (when table is clamped) — F×L (L, F)	N·m [kgf·m]	931 [95]	1,568 [160]		2,450 [250]	3,430 [350]	7,840 [800]
Allowable work inertia $J=\frac{W\cdot D^2}{8}$ (φD, W)	kg·m² [kgf·cm·sec²]	1.2 [12.3]	3.7 [38.5]		9.7 [99.8]	18.2 [185.2]	49.6 [506.2]

☞Servo motors of other manufacturers P.70

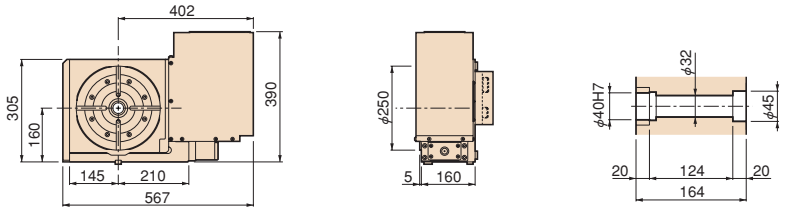
*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise.

*2 For model RNCM-631, a big bore type is also available. (center bore: φ180H7)

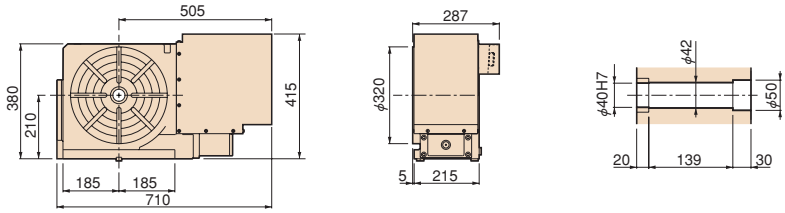
Dimensions

Unit: mm

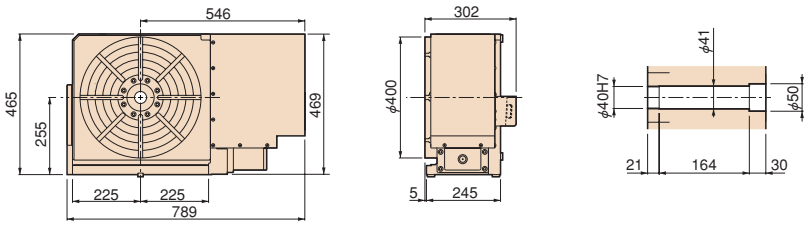
RNCM-251R



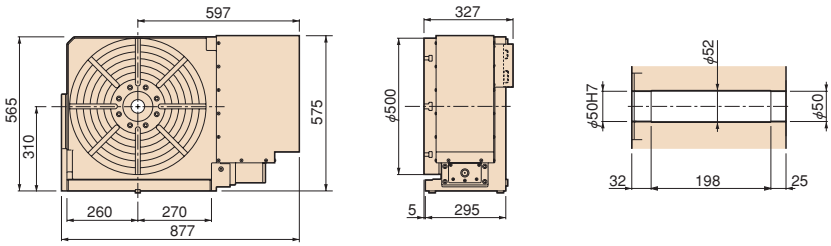
RNCM-301R



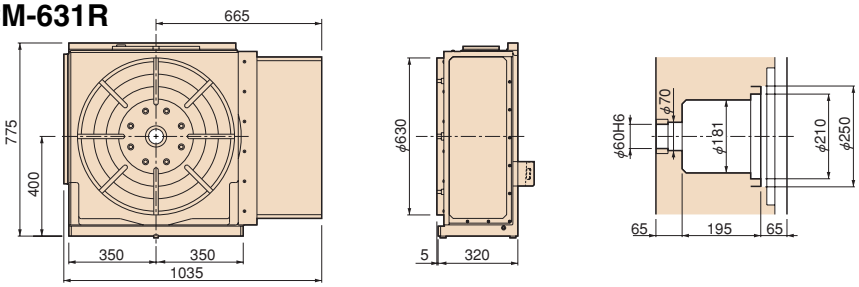
RNCM-401R



RNCM-501R



RNCM-631R

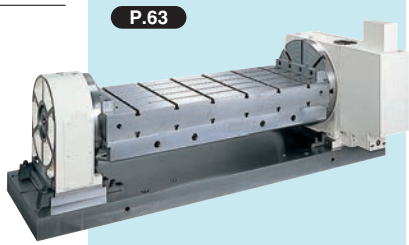


Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

With Hydraulic Power Chuck
P.60

RNCM-301R

With Support Spindle and Fixture Plate
P.63



RNCM-501R

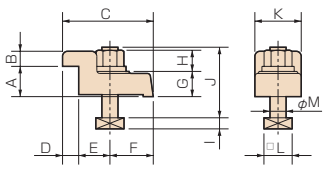
Clamping block and bolt

Unit: mm

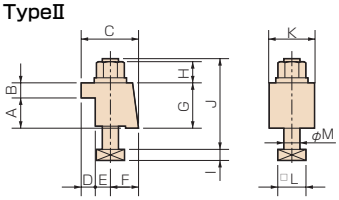
	Type	Q' ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RNCM-251	I	4	50~125	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RNCM-301	I	4	55~127	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RNCM-401	I	4	55~155	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RNCM-501	I	4	60~194	18	40	20	110	18	42	50	25	21	11	70	46	28	16
RNCM-631	II	4	90~255	18	40	18	63	18	15	30	58	21	11	105	60	28	16

Note: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

Type I



TypeII



Standard type

RBA

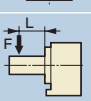
RBA-250・320・400・500

Our flagship models equipped with state-of-the-art Tsudakoma technology. Various types of labor-saving and automation devices can be attached through the large through-bore.

RBA-250R

Specifications

Unit: mm

		RBA-250	RBA-320	RBA-400	RBA-500
Handedness	R	○	○	○	○
	L	○	○	○	○
Table diameter		φ250	φ320	φ400	φ500
Center height		160	210	255	310
Center bore	Nose diameter	φ95H7	φ130H7	φ190H7	φ220H7
	Through-bore	φ71	φ101	φ151	φ182
Table T-slot width *1		12H7	14H7	14H7	18H7
Guide block width		18h7	18h7	18h7	18h7
Servo motors (for FANUC)		αiF8	αiF12	αiF12	αiF12
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.94 [9.58]	3.04 [31.0]	3.63 [37.0]	3.05 [31.1]
Net weight	kg	100	180	300	550
Speed reduction ratio		1/90	1/120	1/120	1/180
Table max. rpm (Motor rpm: 2,000min⁻¹)	min⁻¹	22.2	16.6	16.6	11.1
Indexing accuracy (the sum)	sec	14	14	14	14
Repeatability	arc sec	4	4	4	4
Clamp system		Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)
Clamp torque ／Hydraulic pressure 3.5Mpa [35kgf/cm²]	N·m [kgf·m]	1,000 [102]	2,450 [250]	4,200 [428]	6,100 [622]
Strength of worm gears	N·m [kgf·m]	581 [59]	939 [96]	1,666 [170]	3,276 [334]
Allowable work weight: Vertical setting  ( ) : with tailstock	kg	150 (300)	200 (400)	250 (500)	250 (600)
Allowable work weight: Horizontal setting 	kg	300	400	500	600
Allowable load (when table is clamped): F 	N [kgf]	19,600 [2,000]	29,400 [3,000]	39,200 [4,000]	49,000 [5,000]
Allowable load (when table is clamped): F×L 	N·m [kgf·m]	1,000 [102]	2,450 [250]	4,200 [428]	6,100 [622]
Allowable load (when table is clamped): F×L 	N·m [kgf·m]	980 [100]	3,626 [370]	5,880 [600]	13,132 [1,340]
Allowable work inertia $J=\frac{W\cdot D^2}{8}$ 	kg·m² [kgf·cm·sec²]	2.34 [23.8]	5.12 [52.2]	9.7 [98.9]	18.2 [185.2]

☞Servo motors of other manufacturers P.70

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise.

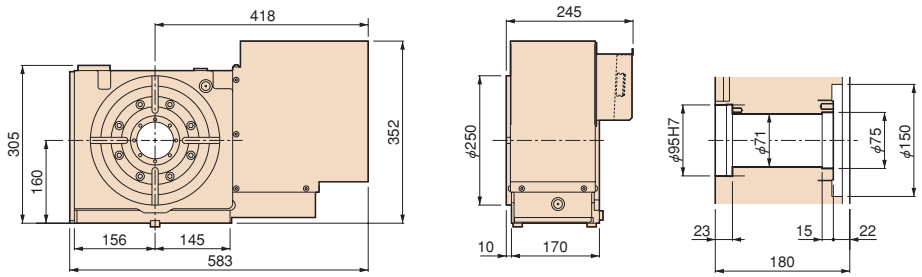
For tables with a diameter of 630 or more, please order a big bore type of the following models:

Tables diameter	Model	Center bore	Specifications
φ630	RNCM-631	φ180H7	P.16
φ800	RCV-800	φ250H7	P.24
φ1000	RCV-1000	φ300H7	P.24

Dimensions

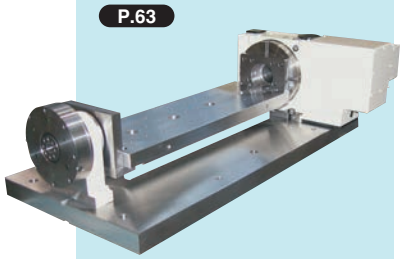
Unit: mm

RBA-250R



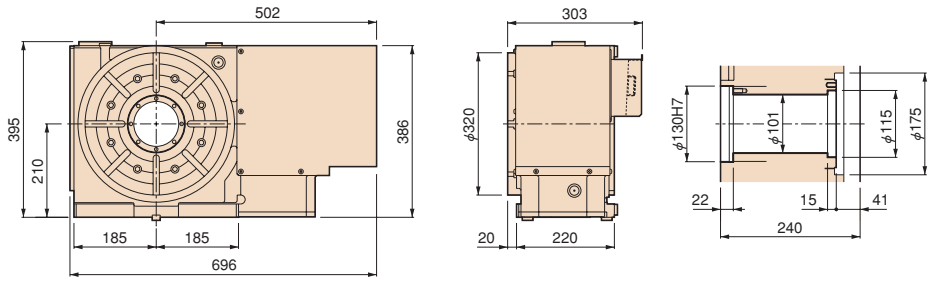
With Support Spindle and Fixture Plate

P.63



RBA-250R

RBA-320R

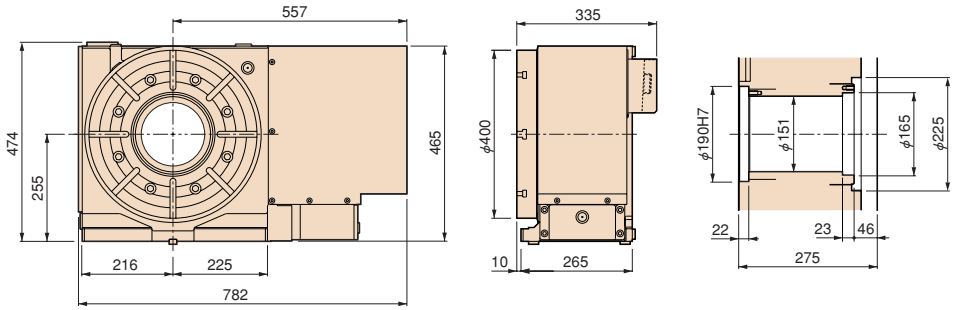


With #50 Pull Stud Unit

P.67

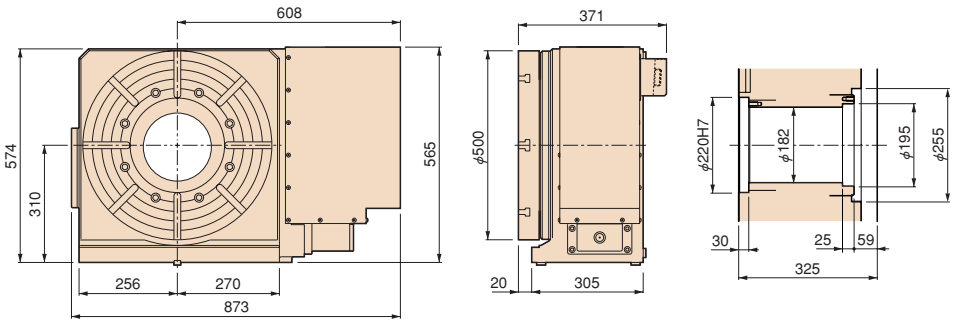
RBA-320R

RBA-400R



RBA-400R

RBA-500R



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

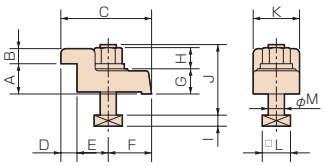
Clamping block and bolt

Unit: mm

	Type	Q'ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RBA-250	I	4	50~125	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RBA-320	I	4	73~162	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RBA-400	I	4	73~193	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RBA-500	I	4	73~233	18	40	20	110	18	42	50	25	21	11	70	46	28	16

Note: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

Type I

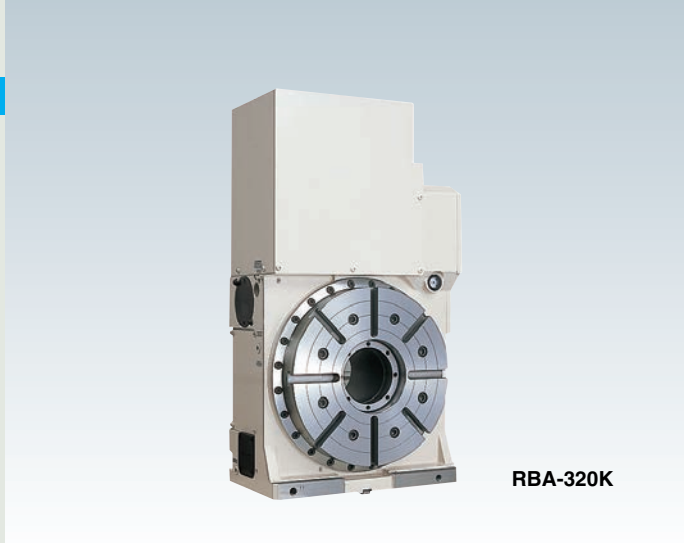


For horizontal machining centers

RBA-K RBA-250K・320K・400K・500K

RNCK RNCK-631

Another flagship model with highest-class specifications exclusively for horizontal machining centers. A popular model for the aircraft, automobile, and cutting tool industries. Various types of labor-saving and automation devices can be attached through the large through-bore.



RBA-320K

Specifications

Unit: mm

	RBA-250K	RBA-320K	RBA-400K	RBA-500K	RNCK-631
Table diameter	φ250	φ320	φ400	φ500	φ630
Center height	160	210	255	310	400
Center bore — Nose diameter	φ95H7	φ130H7	φ190H7	φ220H7	φ180H7
Center bore — Through-bore	φ71	φ101	φ151	φ182	φ180
Table T-slot width *1	12H7	14H7	14H7	18H7	18H7
Guide block width	18h7	18h7	18h7	18h7	18h7
Servo motors (for FANUC)	αiF8	αiF12	αiF12	αiF12	αiF12
Inertia converted into motor shaft $\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.94 [9.58]	3.04 [31.0]	3.63 [37.0]	3.00 [30.6]	5.55 [56.6]
Net weight kg	105	185	300	550	800
Speed reduction ratio	1/90	1/120	1/120	1/180	1/180
Table max. rpm min^{-1} (Motor rpm: 2,000min^{-1})	22.2	16.6	16.6	11.1	11.1
Indexing accuracy (the sum) sec	14	14	14	14	15
Repeatability arc sec	4	4	4	4	4
Clamp system	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)
Clamp torque N·m [kgf·m] ／Hydraulic pressure 3.5Mpa [35kgf/cm²]	1,000 [102]	2,450 [250]	4,200 [428]	6,100 [622]	4,410 [450]
Strength of worm gears N·m [kgf·m]	581 [59]	939 [96]	1,666 [170]	3,276 [334]	4,116 [420]
Allowable work weight — Vertical setting (W) kg ( ) : with tailstock	150 (300)	200 (400)	250 (500)	250 (600)	400 (800)
Allowable load (when table is clamped) — F (F) N [kgf]	19,600 [2,000]	29,400 [3,000]	39,200 [4,000]	49,000 [5,000]	49,000 [5,000]
Allowable load — F×L (F, L) N·m [kgf·m]	1,000 [102]	2,450 [250]	4,200 [428]	6,100 [622]	4,410 [450]
Allowable load — F×L (F, L) N·m [kgf·m]	980 [100]	3,626 [370]	5,880 [600]	13,132 [1,340]	7,840 [800]
Allowable work inertia $J=\frac{W\cdot D^2}{8}$ (φD, W) kg·m² [kgf·cm·sec²]	2.34 [23.8]	5.12 [52.2]	9.7 [98.9]	18.2 [185.2]	49.6 [506.2]

☞Servo motors of other manufacturers P.70

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise.

For tables with a diameter of 800 or more, please order a big bore type of the following models:

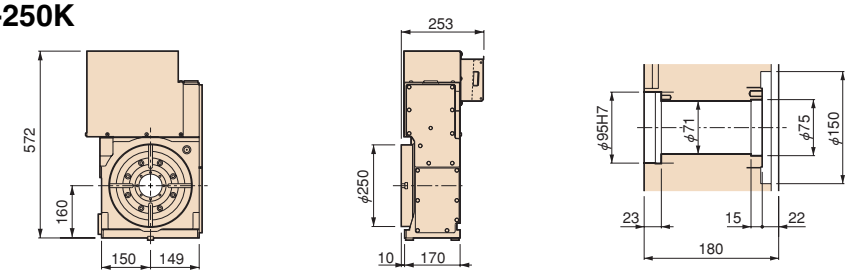
Tables diameter	Model	Center bore	Specifications
φ800	**RCV-800** (Upper class motor)	φ250H7	P.24
φ1000	**RCV-1000** (Upper class motor)	φ300H7	P.24

Note: For the RNCK-631, a basic model (for vertical machining centers) is also available. (for standard bore)

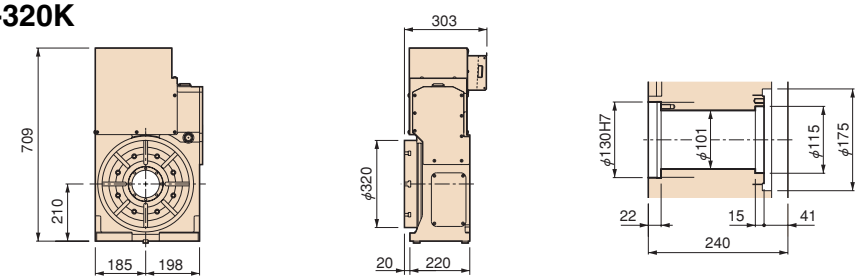
Dimensions

Unit: mm

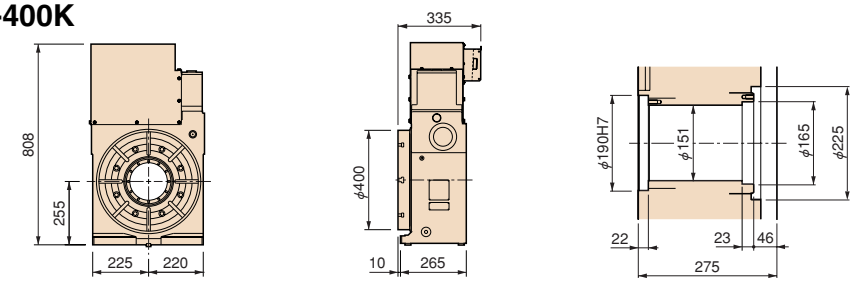
RBA-250K



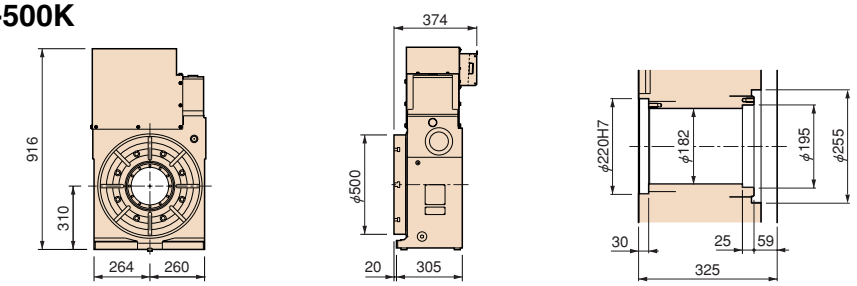
RBA-320K



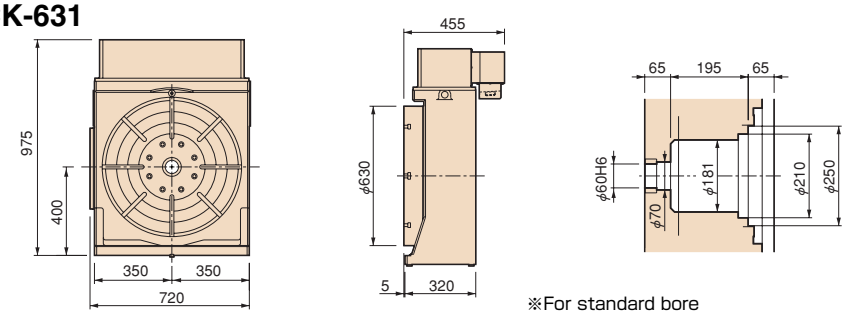
RBA-400K



RBA-500K



RNCK-631



※For standard bore

Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Clamping block and bolt

Unit: mm

	Type	Q' ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RBA-250K	I	4	50~125	18	25	12	80	12	33	35	22	21	11	65	40	28	16
RBA-320K	I	4	73~162	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RBA-400K	I	4	73~160	18	30	15	90	16	31	43	25	21	11	70	46	28	16
RBA-500K	I	4	73~200	18	40	20	110	18	42	50	25	21	11	70	46	28	16
RNCK-631	II	4	100~255	18	40	18	63	18	15	30	58	21	11	105	60	28	16

Note: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

With Rotary Joint

P.67

RBA-320K

With Swivel-type Connector Box

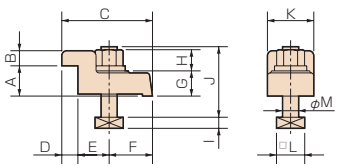
A swivel-type connector box (optional) is useful to prevent motor cables and connectors from being entangled because of the rotation of the machine pallet.

RBA-400K

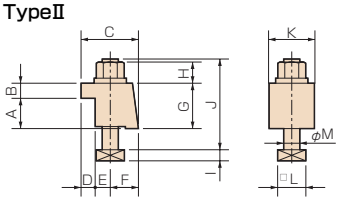
RT-147

For Twin-spindle Machining on Both-side Face Plates

Type I



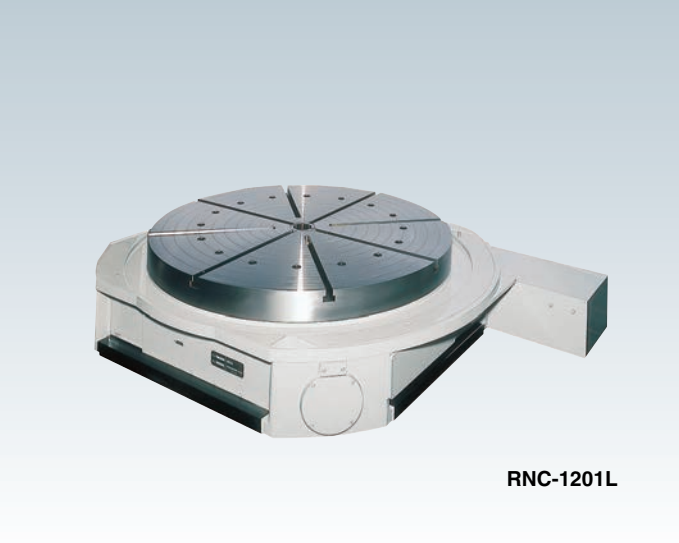
TypeII



For horizontal setting

RCH RCH-800・1000・1250
RNC RNC-1501・2001

Horizontal large-capacity model combined with large-sized double column, for 5-face machining centers. Has the high rigidity required for machining heavy workpieces.



RNC-1201L

Specifications

Unit: mm

	RCH-800	RCH-1000	RCH-1250	RNC-1501	RNC-2001
Table diameter ( ) : optional	φ800 (φ1,000)	φ1,000 (φ1,200)	φ1,250 (φ1,500)	φ1,500	φ2,000
Table height	320	330	410	400	620
Center bore Nose diameter	φ75H7×30	φ75H7×30	φ75H7×30	φ75H7	φ225H7
Table T-slot width *1	18H7	22H7	22H7	28H7	28H7
Guide block width	22h7	22h7	22h7	—	—
Servo motors (for FANUC)	αiF12	αiF22	αiF22	αiF22	αiF30
Inertia converted into motor shaft $\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	4.72 [48.2]	8.24 [84.1]	5.04 [51.4]	5.6 [56.6]	17.2 [175.3]
Net weight kg	1,150	1,700	3,100	3,600	8,000
Speed reduction ratio	1/360	1/360	1/720	1/720	1/720
Table max. rpm min^{-1} (Motor rpm: 2,000min^{-1})	5.5	5.5	2.7	2.7	2.7
Indexing accuracy (the sum) sec	15	15	15	15	15
Repeatability arc sec	4	4	4	4	4
Clamp system	Hydraulic or air-hydraulic (optional)	Hydraulic	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)	Hydraulic or air-hydraulic (optional)
Clamp torque ／Hydraulic pressure 3.5Mpa [35kgf/cm²] N·m [kgf·m]	7,000 [714]	20,000 [2,040]	33,000 [3,363]	9,800 [1,000]	19,600 [2,000]
Strength of worm gears N·m [kgf·m]	7,840 [800]	13,230 [1,350]	25,000 [2,548]	21,560 [2,200]	49,000 [5,000]
Allowable work weight Horizontal setting  kg	4,000	7,000	14,000	8,000	10,000
Allowable load (when table is clamped) F  N [kgf]	100,000 [10,204]	185,000 [18,878]	383,000 [39,041]	49,000 [5,000]	58,800 [6,000]
F×L  N·m [kgf·m]	7,000 [714]	20,000 [2,040]	33,000 [3,363]	9.800 [1,000]	19,600 [2,000]
F×L  N·m [kgf·m]	11,600 [1,184]	22,900 [2,337]	56,700 [5,779]	24.500 [2,500]	34,300 [3,500]
Allowable work inertia $J=\frac{W\cdot D^2}{8}$  kg·m² [kgf·cm·sec²]	320 [3,265]	874 [8,918]	2,734 [27,886]	2,255 [23,000]	4,900 [50,000]

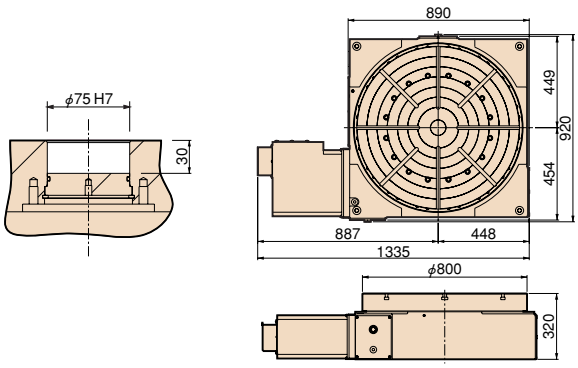
☞Servo motors of other manufacturers P.70

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise.

Dimensions

Unit: mm

RCH-800

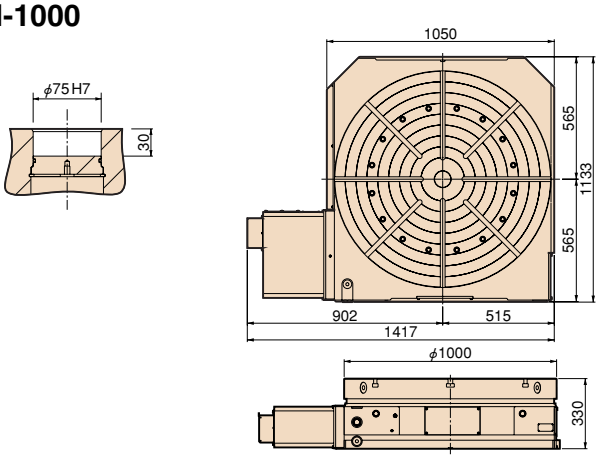


RNC-2001

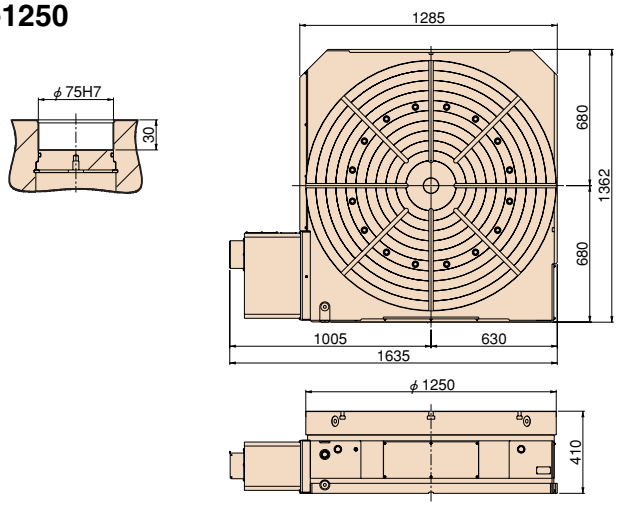
Large NC rotary table with a diameter of 2,000mm. Used for the position detecting device for controlling the posture of artificial satellites and other devices.

Indexing accuracy: ±3 sec
Minimal angular indication: 0.5 sec

RCH-1000



RCH-1250



(　　) : RNC-1501L

Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

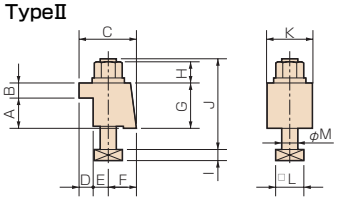
Clamping block and bolt

Unit: mm

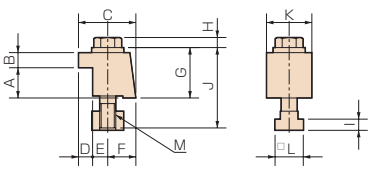
	Type	Q' ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RCH-800	Ⅱ	4	80~400	22	40	20	85	24	20	41	60	27	13	115	80	32	20
RCH-1000	Ⅱ	4~8	80~320	22	40	20	85	24	20	41	60	27	13	115	80	32	20
RCH-1250	Ⅱ	4~8	80~450	22	50	20	74	20	18	36	70	27	13	130	70	32	20
RNC-1501	Ⅳ	4~8	80~255	28	50	20	74	20	18	36	77	15	17.5	120	70	41.3	24

Note: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

TypeⅡ



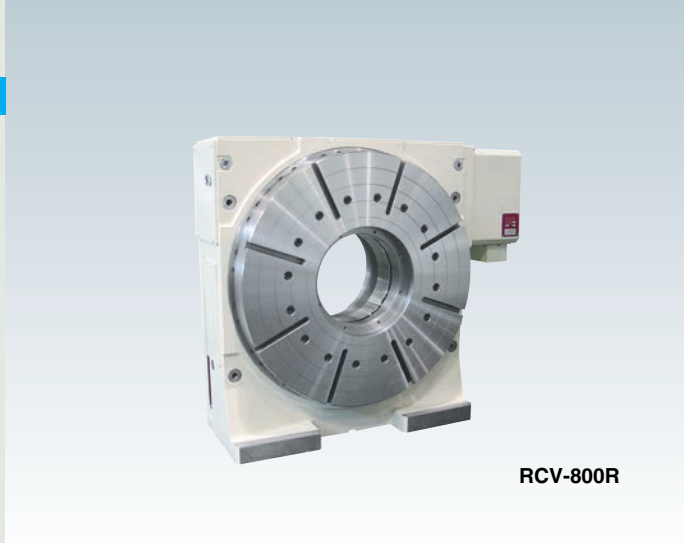
TypeⅣ



Horizontal motor mounting type

RCV RCV-800・1000・1250
RNCV RNCV-1501

Standard model with the motor mounted horizontally onto the side of the body. The unit is also equipped with a powerful hydraulic clamping mechanism.



RCV-800R

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

Specifications

Unit: mm

		RCV-800	RCV-1000	RCV-1250	RNCV-1501
Handedness	R	○	○	○	—
	L	—	—	—	○
	K	○	○	○	—
Table diameter ( ) : optional		φ800 (φ1,000)	φ1,000 (φ1,200)	φ1,250 (φ1,500)	φ1,500
Center height		530	625	775	950
Center bore	Nose diameter	φ360H7×45	φ410H7×75	φ500H7×25	φ75H7
	Through-bore	φ310	φ360	φ450	—
Table T-slot width *1		18H7	22H7	22H7	28H7
Guide block width		22h7	22h7	22h7	28h7
Servo motors (for FANUC)		αiF12	αiF22	αiF22	αiF22
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	4.89 [49.9]	8.24 [84.1]	5.04 [51.4]	12.8 [130.2]
Net weight	kg	1,350	2,500	4,200	7,000
Speed reduction ratio		1/360	1/360	1/720	1/720
Table max. rpm (Motor rpm: 2,000min⁻¹)	min⁻¹	5.5	5.5	2.7	2.7
Indexing accuracy (the sum)	sec	15	15	15	15
Repeatability	arc sec	4	4	4	4
Clamp system		Hydraulic or air-hydraulic (optional)	Hydraulic	油圧	Hydraulic or air-hydraulic (optional)
Clamp torque ／Hydraulic pressure 3.5Mpa [35kgf/cm²]	N·m [kgf·m]	7,000 [714]	20,000 [2,040]	33,000 [3,363]	17,650 [1,800]
Strength of worm gears	N·m [kgf·m]	7,840 [800]	13,230 [1,350]	25,000 [2,548]	21,560 [2,200]
Allowable work weight — Vertical setting  ( ) : with tailstock	kg	2,000 (4,000)	3,500 (7,000)	7,000 (14,000)	2,000 (5,000)
Allowable work weight — Horizontal setting 	kg	4,000	7,000	14,000	5,000
Allowable load (when table is clamped) — F 	N [kgf]	100,000 [10,204]	185,000 [18,878]	383,000 [39,041]	58,800 [6,000]
Allowable load (when table is clamped) — F×L 	N·m [kgf·m]	7,000 [714]	20,000 [2,040]	33,000 [3,363]	17,650 [1,800]
Allowable load (when table is clamped) — F×L 	N·m [kgf·m]	11,600 [1,184]	22,900 [2,337]	56,700 [5,779]	19,600 [2,000]
Allowable work inertia $J=\frac{W\cdot D^2}{8}$ 	kg·m² [kgf·cm·sec²]	320 [3,265]	874 [8,918]	2,734 [27,886]	2,255 [23,000]

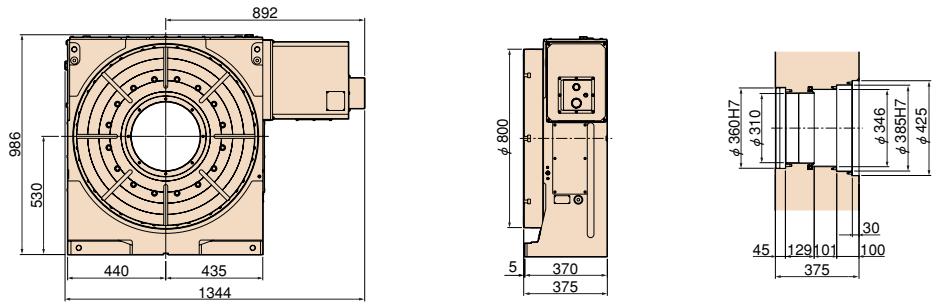
☞Servo motors of other manufacturers P.70

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise.

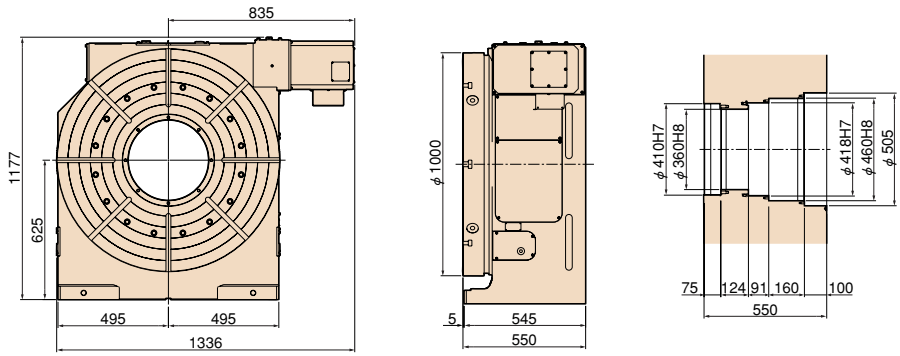
Dimensions

Unit: mm

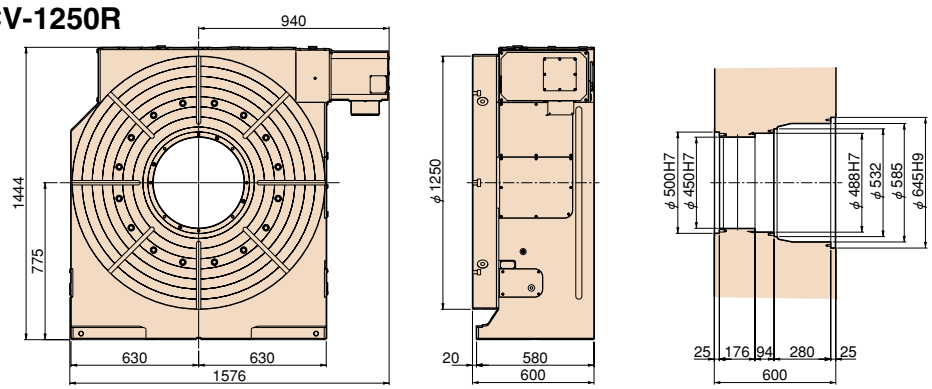
RCV-800R



RCV-1000R



RCV-1250R



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

RTV-801

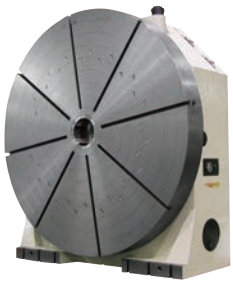
Table diameter: φ800mm
Through-bore diameter: φ420mm

☞Specifications P.45

RTV-902

Largest Vertical NC Rotary Table

Table diameter: φ2,000mm
Allowable work weight: 30t
(with support spindle)
Indexing accuracy: 15 sec
Available up to φ3,000 mm



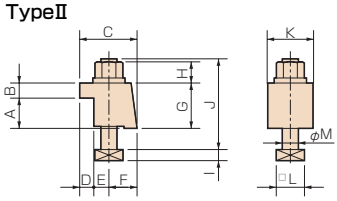
Clamping block and bolt

Unit: mm

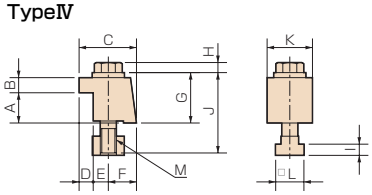
	Type	Q'ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RCV-800	Ⅱ	4	100~250	22	60	28	95	29	16	50	88	27	13	145	100	32	20
RCV-1000	Ⅱ	4	80~320	22	60	28	95	29	16	50	88	27	13	145	100	32	20
RCV-1250	Ⅱ	8	80~450	22	60	28	95	29	16	50	88	27	13	145	100	32	20
RNCV-1501	Ⅳ	8	150~600	28	70	35	95	29	16	50	112	15	17.5	160	100	41.3	24

Note: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

TypeⅡ



TypeⅣ



RN-N (multi-spindle type)

RN-100・150・200-2/3/4 (spindles)
RN-250・300-2/3 (spindles)

High-productivity model for multi-piece/multi-face machining. The RN-100, the smallest of the RN-series, assures the fastest operation, meeting the requirements for drilling and tapping machines.

RN-100R-4

Specifications

Unit: mm

		RN-100-2/3/4			RN-150-2	RN-200-2	RN-250-2	RN-300-2
Handedness	R	○			○	○	○	○
	L	○			—	—	—	—
Spindle diameter		φ80h7			φ100h7	φ120h7	—	—
Table diameter		φ115 (Option)			φ160 (Option)	φ200 (Option)	φ250	φ320
Center height		135			135	160	160	210
Center bore	Nose diameter	φ50H7 (φ50H7 With face plate)			φ55H7 (φ50H7 With face plate)	φ65H7 (φ60H7 With face plate)	φ75H7	φ110H7
	Through-bore	φ30			φ40	φ45	φ45	φ82
Minimum distance between table centers		120			215	250	300	380
Table T-slot width *1		10H8 (With face plate)			12H8 (With face plate)	12H8 (With face plate)	12H8	14H8
Guide block width		18h7			14h7	18h7	18h7	18h7
Servo motors (for FANUC)		αiF4			αiF4	αiF8	αiF8	αiF12
Number of axis		2-axis	3-axis	4-axis	2-axis	2-axis	2-axis	2-axis
Inertia converted into motor shaft (When spindle pitch is minimum)	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.64 [6.52]	0.92 [9.38]	1.06 [10.8]	0.42 [4.28]	0.55 [5.61]	0.84 [8.56]	2.09 [21.3]
Net weight (When spindle pitch is minimum and with base plate)	kg	70	90	110	120	160	240	480
Speed reduction ratio		1/36	1/36	1/36	1/90	1/90	1/120	1/120
Table max. rpm	min^{-1} (Motor rpm: 2,000min^{-1})	69.4/2,500	69.4/2,500	55.5/2,000	22.2	22.2	16.6	16.6
Clamp system		Pneumatic			Pneumatic	Pneumatic	Pneumatic	Pneumatic
Clamp torque /pneumatic pressure 0.49MPa [5kgf/cm²]	N·m [kgf·m]	80 [8]			156 [16]	294 [30]	441 [45]	880 [90]
Indexing accuracy (the sum)	sec	60			30	30	30	30
Strength of worm gears	N·m [kgf·m]	178 [18]			147 [15]	264 [27]	470 [48]	764 [78]
Allowable work weight	Vertical setting  ( ) : with tailstock	kg	25 (50)		75 (150)	100 (250)	100 (250)	150 (350)
	Horizontal setting 	kg	50		150	250	250	350
Allowable load (when table is clamped)	F 	N [kgf]	5,880 [600]		7,840 [800]	13,720 [1,400]	13,720 [1,400]	19,600 [2,000]
	F×L 	N·m [kgf·m]	80 *2 [8]		156 [16]	294 [30]	441 [45]	880 [90]
	F×L 	N·m [kgf·m]	156 [16]		392 [40]	980 [100]	980 [100]	1,960 [200]
Allowable work inertia (per single-axis)	$J=\frac{W\cdot D^2}{8}$ 	kg·m² [kgf·cm·sec²]	0.10 [1.0]		0.48 [4.9]	1.20 [12.3]	1.95 [20.0]	3.70 [38.5]

☞Servo motors of other manufacturers P.70

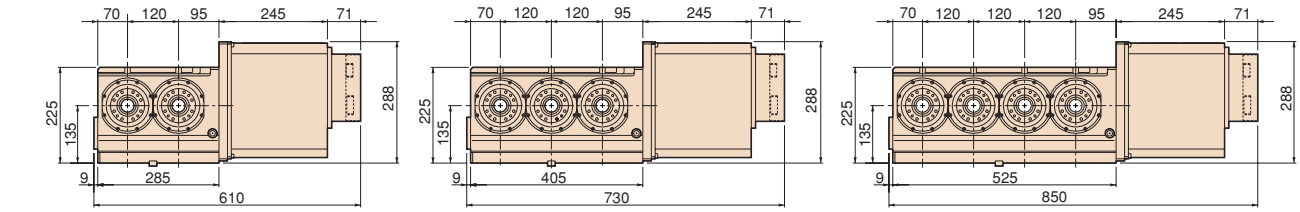
*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

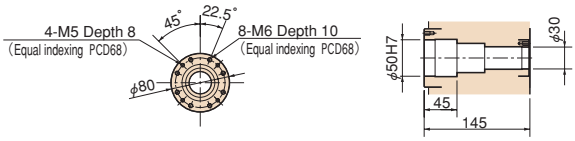
*2 The clamp torque is optionally increased, subject to applications.

Dimensions

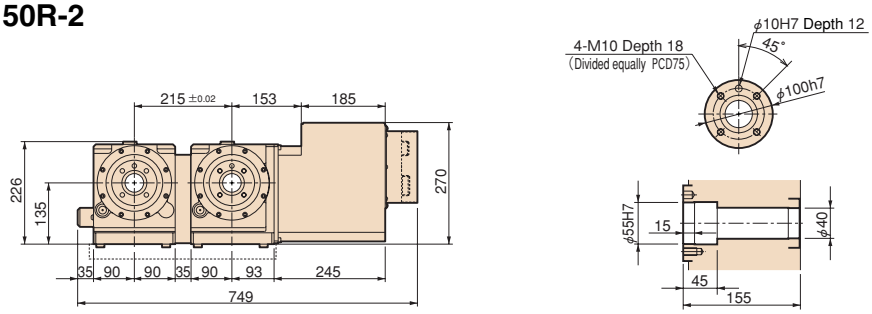
Unit: mm

RN-100R-2/3/4

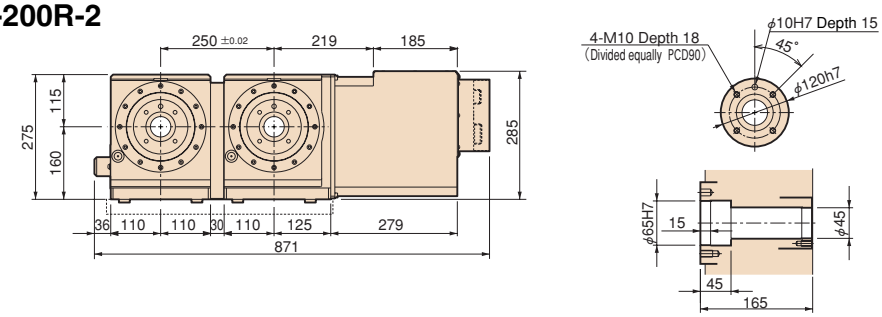




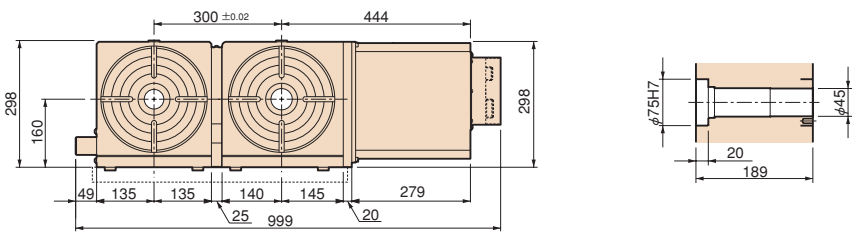
RN-150R-2



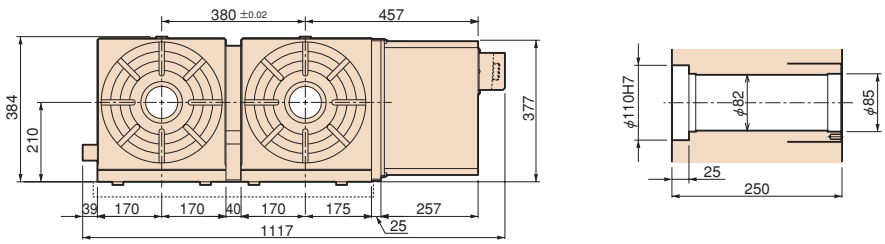
RN-200R-2



RN-250R-2



RN-300R-2



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

With 5C Collet Chuck

RN-100R-3

With Rotary Joint

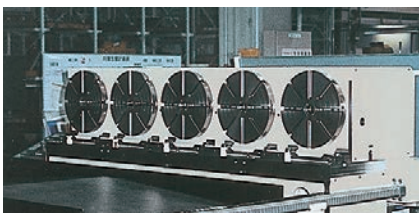
P.67

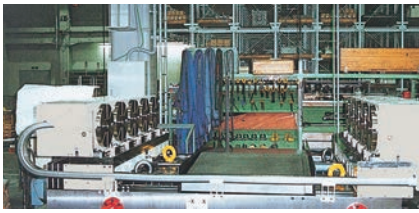
RN-150R-4

RT-54

5-spindle rotary tables with a φ300 diameter, set face-to-face, for machining turbine blades

In order to eliminate machining distortion on the blades, workpieces are pulled at a constant force using hydraulic cylinders, and the rotary tables are synchronously controlled to minimize errors.





NC Indexer with Programmable Controller

RZ

RZ-161・201

Simple structure ensures easy operation. Attractive pricing with many high-performance features.

RZ-201
With Face Plate
P.64

Specifications

Unit: mm

		RZ-161	RZ-201
Handedness	R	○	○
	L	—	—
Spindle diameter		φ100h7	φ120h7
Table diameter *1		φ160 or φ200 (Option)	φ200 or φ250 (Option)
Center height		135	160
Center bore	Nose diameter	φ55H7 (φ50H7 With face plate)	φ65H7 (φ60H7 With face plate)
	Through-bore	φ40	φ45
Table T-slot width *1		12H8 (With face plate)	12H8 (With face plate)
Guide block width		14h7	18h7
Controller (exclusive)		TPC-Jr	TPC-Jr
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.19 [1.90]	0.19 [1.98]
Net weight	kg	40	65
Speed reduction ratio		1/60	1/72
Table max. rpm	min^{-1} (Motor rpm: min^{-1})	33.3/2,000	33.3/2,400
Indexing accuracy (the sum)	sec	45	45
Repeatability	arc sec	4	4
Clamp system		Pneumatic	Pneumatic
Clamp torque ／pneumatic pressure 0.49MPa [5kgf/cm²]	N·m [kgf·m]	156 [16]	294 [30]
Strength of worm gears	N·m [kgf·m]	147 [15]	264 [27]
Allowable work weight	Vertical setting  ( ) : with tailstock	kg	75 (150)	100 (250)
	Horizontal setting 	kg	150	250
Allowable load (when table is clamped)	F 	N [kgf]	7,840 [800]	13,720 [1,400]
	F×L 	N·m [kgf·m]	156 [16]	294 [30]
	F×L 	N·m [kgf·m]	392 [40]	980 [100]
Allowable work inertia	$J=\frac{W\cdot D^2}{8}$ 	kg·m² [kgf·cm·sec²]	0.48 [4.9]	1.20 [12.3]

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞ Dimensions P.64

Controller (TPC-Jr) Specifications

Unit: mm

Control axis	Single-axis		
Servo motor	AC servo: ABS detector		
Command unit	0.001° (Decimal)		
Indexing number	Direct indexing	1 to 999999 even indexing	
	Arc-indexing	1 to 999 even indexing	
Max. command angle	±999.999°		
Command system	INC, ABS, Shortcut ABS, INC/ABS mixed system		
Input system	MDI		
Program control	Workpiece No. (W0000 to 9999)		
Program capacity	1,000 blocks (Total of main and sub programs)		
Cable supplied (standard)	Between rotary table and TPC-Jr (1 pc)		
	For Motor: 5m		
	Power cable: 5m		
	Interlocking cable: 5m		
Power	1φ200/220V±10% 50/60Hz		
Grounding (less than 100 ohm earth resistance)	Model	Power capacity	Fuse rating
	Jr H2 (for RZ-161)	1.2KVA	10A
	Jr H3 (for RZ-201)	1.9KVA	15A
External dimensions	Control box (Non-CE) Weight H2: 6.7kg、H3: 7.2kg		
	285mm (W)×255mm (D)×130mm (H)		

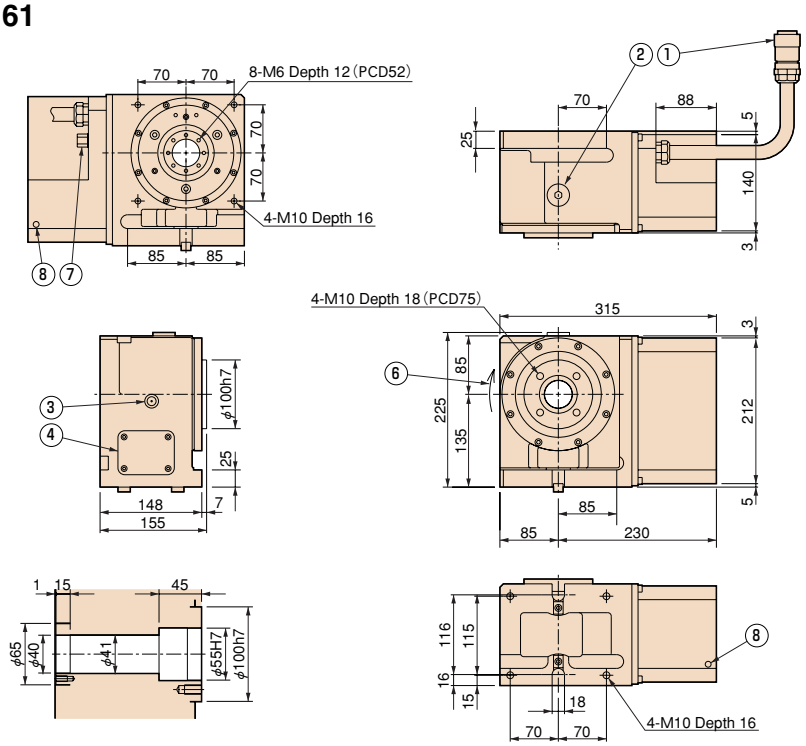
With Chuck P.58

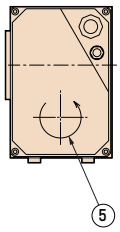
RZ-161

Dimensions

Unit: mm

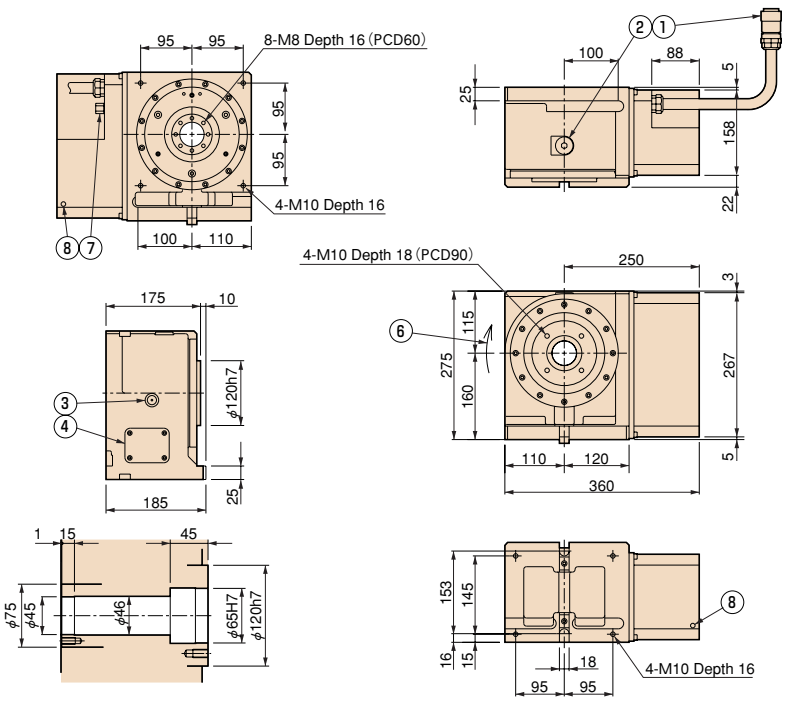
RZ-161

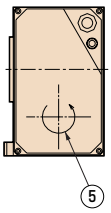




① Plug MS3106B (Power and detector)
(CE) CL1P3101 (Power and detector)
② Lubrication port
③ Oil gauge
④ Lubricant drain port
⑤ Motor revolution direction
⑥ Turn table revolution direction
⑦ Air pressure inlet port for clamping the table and air purge: RC1／4 (0.49MPa)
⑧ Exhaust port

RZ-201



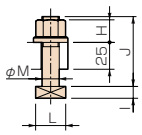


① Plug MS3106B (Power and detector)
(CE) CL1P3101 (Power and detector)
② Lubrication port
③ Oil gauge
④ Lubricant drain port
⑤ Motor revolution direction
⑥ Turn table revolution direction
⑦ Air pressure inlet port for clamping the table and air purge: RC1／4 (0.49MPa)
⑧ Exhaust port

Clamping bolt

Unit: mm

	Q'ty	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
RZ-161	2	—	14	—	—	—	—	—	—	—	17	8	60	—	23	12
RZ-201	2	—	18	—	—	—	—	—	—	—	21	11	65	—	28	16



Note 1: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)
Note 2: Clamping blocks are not included with the RZ-161 and RZ-201.

Standard type

TN

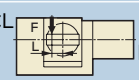
TN-101・131・161・201・320・450

Compact tables for speedy and powerful five-axis machining.
TN-101 and TN-131 are the most suitable models for drilling and tapping machines.


TN-101

Specifications

Unit: mm

	TN-101		TN-131		TN-161		TN-201		TN-320		TN-450	
Tilt range	−17°~+107°		−17°~+107°		−30°~+110°		−30°~+110°		−30°~+110°		−10°~+95°	
Spindle diameter	φ86h7		φ90h7		φ100h7		φ120h7		—		—	
Table diameter *1	φ135 (Option)		φ135 (Option)		φ160 or 200 (Option)		φ200 or 250 (Option)		φ320		φ450	
Table height at 0°position	180 (205 With face plate)		210 (235 With face plate)		235 (260 With face plate)		270 (300 With face plate)		355		425	
Center height at 90°position	135		150		180		210		255		425	
Center bore — Nose diameter	φ55H7 (φ40H7 With face plate)		φ55H7 (φ40H7 With face plate)		φ55H7 (φ50H7 With face plate)		φ65H7 (φ60H7 With face plate)		φ105H7		φ170H7	
Center bore — Through-bore	φ35		φ35		φ40		φ45		φ102		φ136	
Table T-slot width *1	12H8 (With face plate)		12H8 (With face plate)		12H8 (With face plate)		12H8 (With face plate)		14H7		14H7	
Guide block width	14h7		14h7		18h7		18h7		18h7		18h7	
Servo motors (for FANUC)	Rotary axis	Tilt axis	Rotary axis	Tilt axis	Rotary axis	Tilt axis	Rotary axis	Tilt axis	Rotary axis	Tilt axis	Rotary axis	Tilt axis
	αiF2	αiF2	αiF2	αiF2	αiF2	αiF2	αiF4	αiF4	αiF8	αiF8	αiF22	αiF22
Inertia converted into motor shaft $\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.072 [0.73]	0.078 [0.79]	0.074 [0.75]	0.072 [0.73]	0.17 [1.68]	0.18 [1.81]	0.38 [3.96]	0.45 [4.61]	0.82 [8.34]	0.45 [4.61]	5.34 [54.5]	3.00 [30.6]
Speed reduction ratio	1/60	1/120	1/60	1/120	1/72	1/120	1/45	1/90	1/120	1/240	1/90	1/180
Table max. rpm min⁻¹ (Motor rpm: 2,000min⁻¹)	41.6 (Motor rpm: 2,500min⁻¹)	16.6	41.6 (Motor rpm: 2,500min⁻¹)	16.6	27.7	16.6	44.4	22.2	16.6	8.3	22.2	11.1
Clamp system Supplied pressure	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]
Clamp torque N·m [kgf·m]	200 [20]	300 [30]	500 [51]	500 [51]	500 [51]	800 [82]	800 [82]	1,000 [102]	2,200 [224]	2,200 [224]	3,700	7,400
Indexing accuracy (the sum) arc sec	40	—	40	—	30	—	30	—	20	—	15	—
Repeatability arc sec	4	—	4	—	4	—	4	—	4	—	4	—
Tilting accuracy Tilt 0°~90° arc sec	—	45	—	45	—	45	—	45	—	45	—	90
Tilting repeatability arc sec	—	8	—	8	—	8	—	8	—	8	—	8
Net weight kg	69		80		127		191		440		1,200	
Strength of worm gears (Rotary axis) N·m [kgf·m]	152 [15.5]		152 [15.5]		200 [20.4]		450 [45.9]		931 [95]		1,940 [198]	
Allowable work weight 0° (Horizontal)  kg	35		35		60		120		150		500	
Allowable work weight 0°~90° (Tilting)  kg	20		20		40		70		100		300	
Allowable work moment W×L  N·m [kgf·m]	24 [2.4]		24 [2.4]		39.2 [4.0]		53.7 [5.5]		163.3 [16.6]		288.2 [29.4]	
Allowable load (when table is clamped) F  N [kgf]	3,920 [400]		3,920 [400]		7,840 [800]		13,720 [1,400]		19,600 [2,000]		39,200 [4,000]	
Allowable load F×L  N·m [kgf·m]	200 [20]		500 [51]		500 [51]		800 [82]		2,200 [224]		3,700 [377.6]	
Allowable load F×L  N·m [kgf·m]	300 [30]		500 [51]		800 [82]		1,000 [102]		2,200 [224]		7,400 [755.1]	
Allowable work inertia $J=\frac{W\cdot D^2}{8}$  kg·m² [kgf·cm·sec²]	0.08 [0.87]		0.08 [0.87]		0.19 [1.94]		0.59 [6.02]		1.53 [15.6]		9.38 [95.68]	

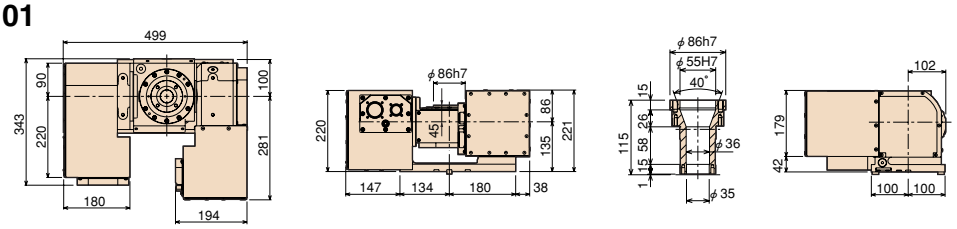
☞Servo motors of other manufacturers P.70 ☞When assembling a faceplate or a fixture with the main spindle P.80

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

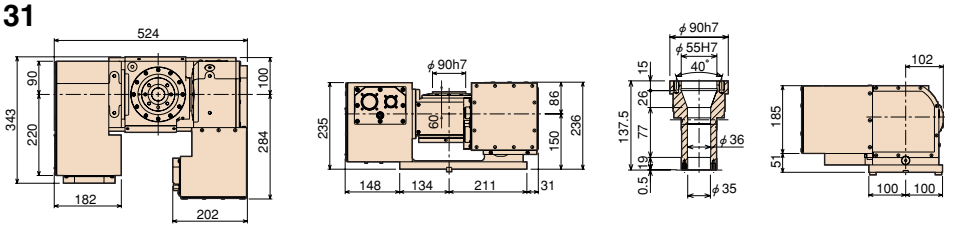
Dimensions

Unit: mm

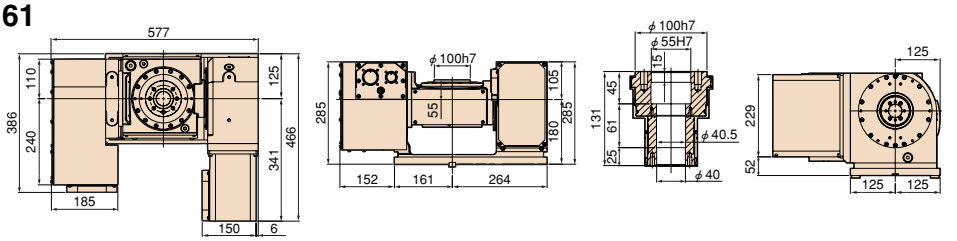
TN-101



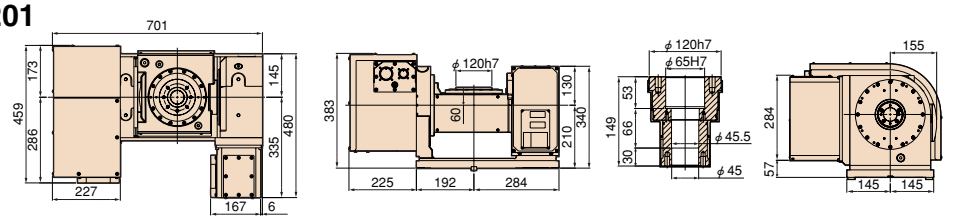
TN-131



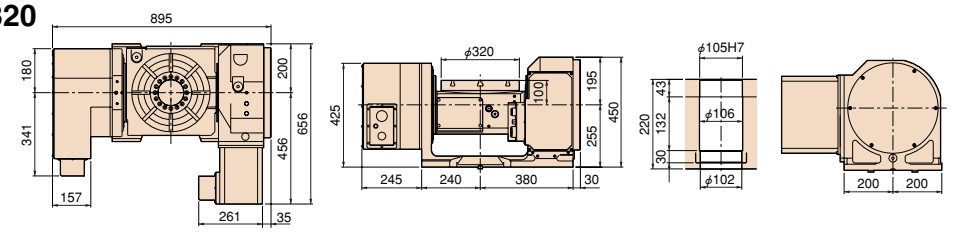
TN-161



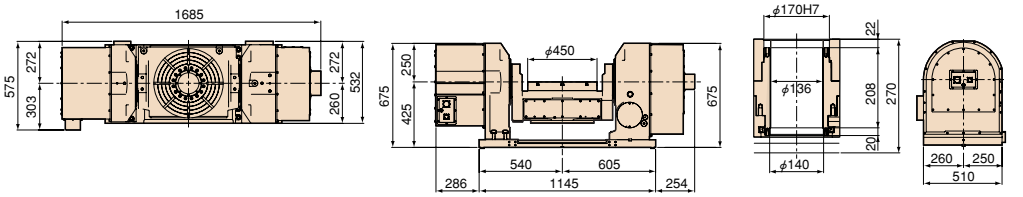
TN-201



TN-320



TN-450



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Clamping block and bolt

Unit: mm

	Type	Q'ty	Layout	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
TN-101	I	4	a b	40~160 *	14	20	12	70	10	35	25	20	12	8	50	35	23	12
TN-131	I	4	a b	40~190 *	14	20	12	70	10	35	25	20	17	8	55	35	23	12
TN-161	I	4	a b	78~150 63~117	18	20	12	70	10	35	25	17	15	11	55	35	28	16
TN-201	I	4	a b	80~180 78~125	18	25	12	80	12	33	35	22	21	11	65	40	28	16
TN-320	I	4	a b	140~190 95~180	18	25	12	80	12	33	35	22	21	11	65	40	28	16
TN-450	Ⅳ	4	a b	80~250 *	18	50	20	74	20	18	36	75	10	11	105	70	28	16

Note 1: *In the case of layout b, contact us for the details about mounting.
Note 2: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

Example of scroll chuck use P.58

TN-101

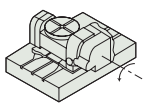
With Rotary Joint P.67

TN-131

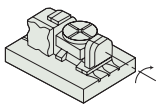
TN-161

TN-450

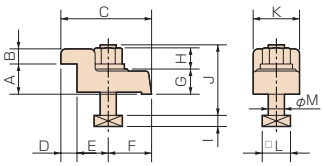
Layout a



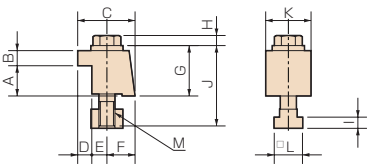
Layout b



Type Ⅰ



TypeⅣ

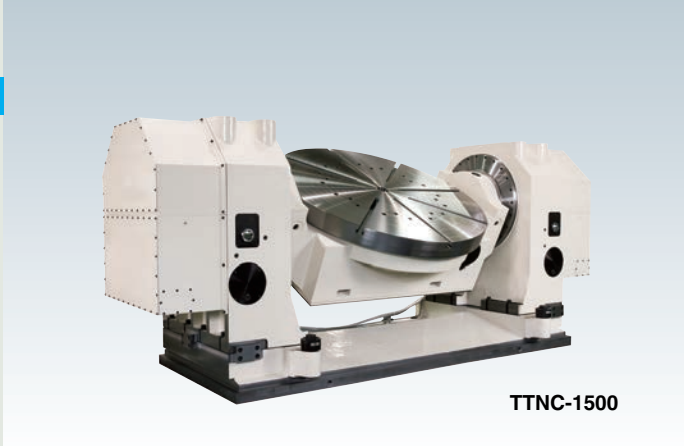


Standard type

TTNC

TTNC-631・1001・1500

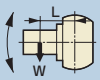
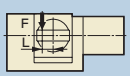
Large tilting models that enable 5-face machining and slanted-hole machining with single chucking of workpiece. Suitable for machining of component parts for heavy industries such as aircraft, power generator and construction machine industry.



TTNC-1500

Specifications

Unit: mm

		TTNC-631		TTNC-1001		TTNC-1500 *2	
Tilt range		−10°~+95°		−20°~+110°		−5°~+95°	
Spindle diameter		—		—		—	
Table diameter		φ630		φ1,000		φ1,500	
Table height at 0°position		585		900		1,155	
Center height at 90°position		450		700		1,055	
Center bore	Nose diameter	φ180H6		φ75H7		φ75H7	
	Through-bore	φ180		—		—	
Table T-slot width *1		18H7		22H7		28H7	
Guide block width		18h7		—		—	
Servo motors (for FANUC)		Rotary axis	Tilt axis	Rotary axis	Tilt axis	Rotary axis	Tilt axis
		αiF12	αiF12	αiF22	αiF30	TPC3-SR30	TPC3-SR30
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	5.42 [55.3]	3.77 [38.5]	4.37 [44.6]	4.1 [41.8]	5.37 [54.8]	7.46 [76.2]
Speed reduction ratio		1/180	1/360	1/360	1/1,440	1/720	1/1,440
Table max. rpm	min⁻¹ (Motor rpm: 2,000min⁻¹)	11.1	4.1 (Motor rpm: 1,500min⁻¹)	5.5	1.3	1.39 (Motor rpm: 1,000min⁻¹)	0.7 (Motor rpm: 1,000min⁻¹)
Clamp system Supplied pressure		Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 6.9MPa [70kgf/cm²]	Hydraulic 6.9MPa [70kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]
Clamp torque	N·m [kgf·m]	4,410 [450]	2,352 [240]	9,800 [1,000]	19,600 [2,000]	12,000 [1,224]	25,000 [2,551]
Indexing accuracy(the sum)	arc sec	15	—	15	—	20	—
Repeatability	arc sec	4	—	4	—	4	—
Tilting accuracy Tilt 0°~90°	arc sec	—	60	—	60	—	45
Tilting repeatability	arc sec	—	4	—	4	—	8
Net weight	kg	1,700		4,600		12,000	
Strength of worm gears (Rotary axis)	N·m [kgf·m]	3,284 [335]		13,230 [1,350]		21,560 [2,200]	
Allowable work weight	0° (Horizontal)  kg	600		2,500		2,500	
	0°~90° (Tilting)  kg	300		1,500		1,500	
Allowable work moment	W×L  N·m [kgf·m]	980 [100]		7,840 [800]		7,840 [800]	
Allowable load (when table is clamped)	F  N [kgf]	24,500 [2,500]		29,400 [3,000]		49,000 [5,000]	
	F×L  N·m [kgf·m]	4,410 [450]		9,800 [1,000]		12,000 [1,224]	
	F×L  N·m [kgf·m]	2,352 [240]		19,600 [2,000]		25,000 [2,551]	
Allowable work inertia	$J=\frac{W\cdot D^2}{8}$  kg·m² [kgf·cm·sec²]	35.3 [360]		312.6 [3,188.7]		2,255 [23,001]	

☞Servo motors of other manufacturers P.70

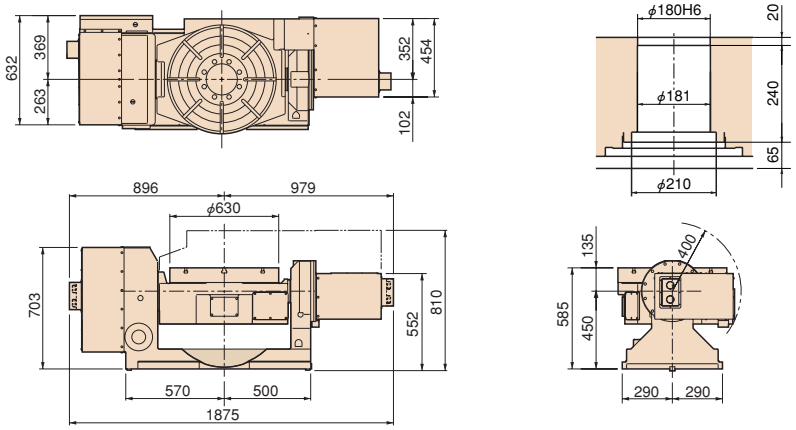
*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise.

*2 Above specifications are for one of experienced production. Those might be changed depending on use conditions.

Dimensions

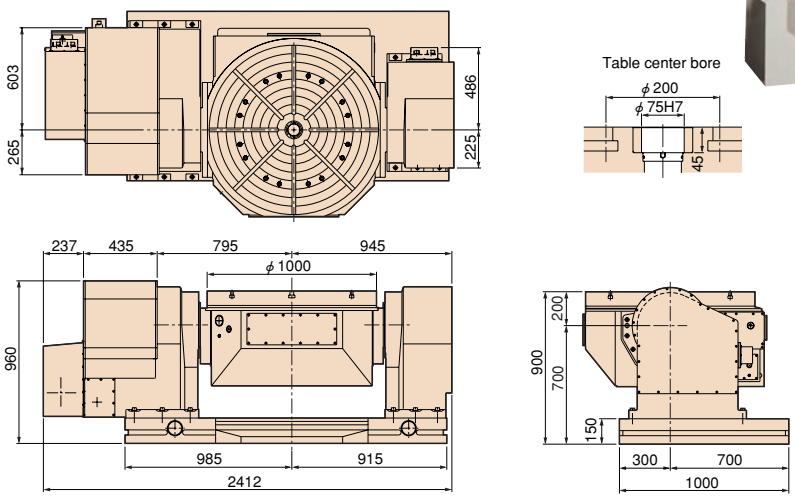
Unit: mm

TTNC-631

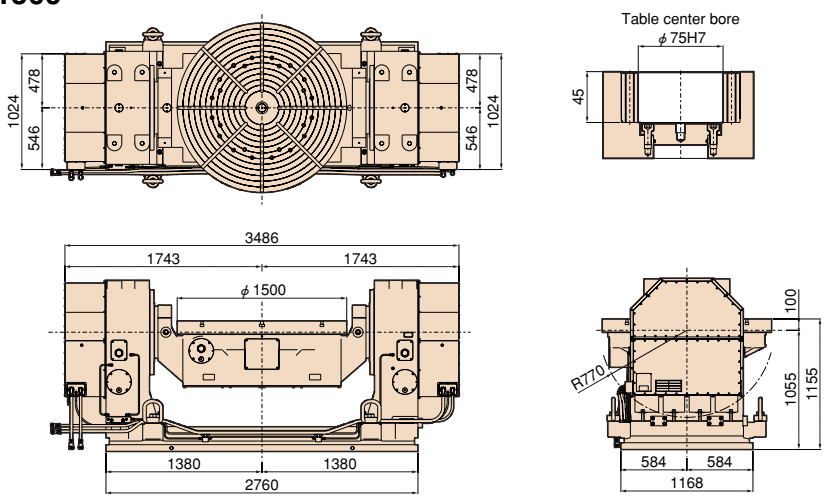


TTNC-1001

TTNC-1001



TTNC-1500



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

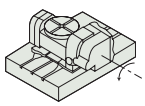
Clamping block and bolt

Unit: mm

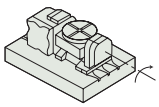
	Type	Q'ty	Layout	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
TTNC-631	I	4	a b	168~450 80~267	18	40	20	110	18	42	50	25	21	11	70	46	28	16
TTNC-1001	II	8	—	—	24	50	20	74	20	18	36	70	29	16	130	70	40	22
TTNC-1500	II	10	—	—	28	60	28	95	29	16	50	95	22	17.5	146	100	41.3	24

Note 1: *In the case of layout b, contact us for the details about mounting.
Note 2: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

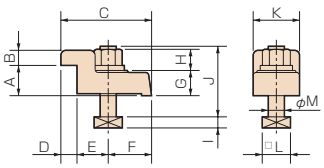
Layout a



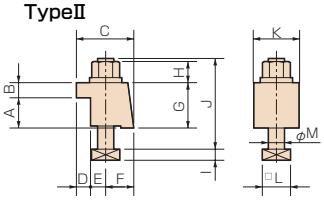
Layout b



Type I



TypeII



Manual Tilting type

THNC

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

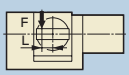
THNC-251・301

Manual tilt adjustment type with a highly rigid body and a powerful hydraulic clamp system.

THNC-251

Specifications

Unit: mm

		THNC-251		THNC-301	
Tilt range		0°~+93°		0°~+93°	
Table diameter *1		φ250		φ320	
Table height at 0°position		230		265	
Center height at 90°position		210		235	
Center bore	Nose diameter	φ40H7		φ40H7	
	Through-bore	φ32		φ40	
Table T-slot width *1		12H7		14H7	
Guide block width		18h7		18h7	
Servo motors (for FANUC)		Rotary axis	Tilt axis	Rotary axis	Tilt axis
		αiF4	Manual	αiF8	Manual
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.20 [2.0]	—	0.25 [2.6]	—
Speed reduction ratio		1/180	—	1/180	—
Table max. rpm	min⁻¹ (Motor rpm: 2,000min⁻¹)	11.1	—	11.1	—
Clamp system Supplied pressure		Hydraulic 3.5MPa [35kgf/cm²]	Manual 19.6N·m [2kgf/m]	Hydraulic 3.5MPa [35kgf/cm²]	Manual 35.3N·m [3.6kgf/m]
Clamp torque	N·m [kgf·m]	490 [50]	490 [50]	833 [85]	1,862 [190]
Indexing accuracy(the sum)	sec	15	60	15	60
Repeatability	arc sec	4	—	4	—
Net weight	kg	125		180	
Strength of worm gears (Rotary axis)	N·m [kgf·m]	470 [48]		764 [78]	
Allowable work weight	0° (Horizontal)  kg	80		200	
	0°~90° (Tilting)  kg	40		100	
Allowable load (when table is clamped)	F  N [kgf]	6,860 [700]		9,800 [1,000]	
	F×L  N·m [kgf·m]	490 [50]		833 [85]	
	F×L  N·m [kgf·m]	490 [50]		1,862 [190]	
Allowable work inertia	$J=\frac{W\cdot D^2}{8}$  kg·m² [kgf·cm·sec²]	0.62 [6.3]		2.25 [23]	

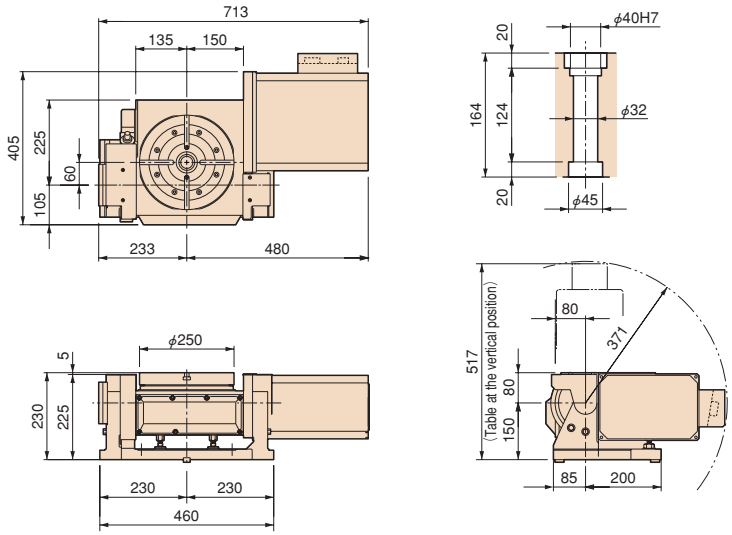
☞Servo motors of other manufacturers P.70

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞Dimensions P.64

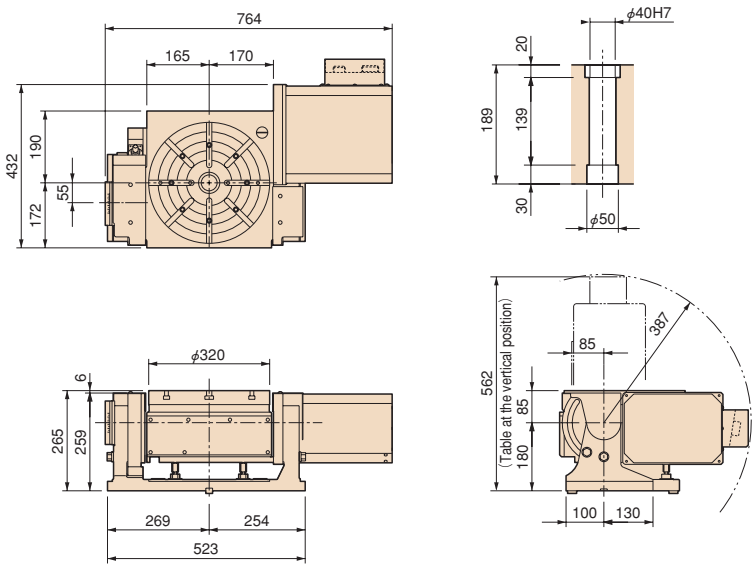
Dimensions

Unit: mm

THNC-251



THNC-301



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

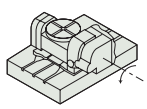
Clamping block and bolt

Unit: mm

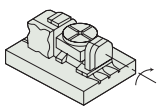
	Type	Q'ty	Layout	T-slot pitch	T-slot width	A	B	C	D	E	F	G	H	I	J	K	L	M
THNC-251	I	4	a b	40~100 40~65	18	25	12	80	12	33	35	22	21	11	65	40	28	16
THNC-301	II	4	a b	40~130 40~80	18	25	15	52	12	15	25	40	21	11	85	40	28	16

Note: When using a machine with a T-slot pitch other than the above, use suitable clamping blocks and bolts that are available on the market, or order custom-made ones from TSUDAKOMA. (Optional)

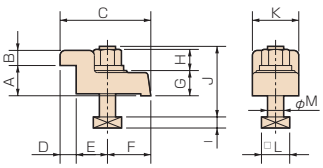
Layout a



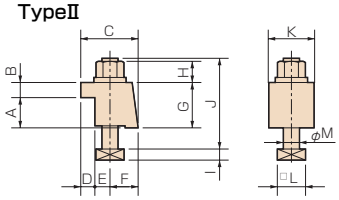
Layout b



Type I



TypeII



TTNC-N (spindles)

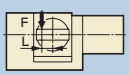
TTNC-102-2 (spindles) • 101-4 (spindles)
TTNC-151-2 (spindles) • 201-2 (spindles)

Fully numerically controlled tilt adjustment type enables highly productive machining, in which simultaneous machining of multiple workpieces with complex shapes or five faces is possible.


TTNC-151-2

Specifications

Unit: mm

	TTNC-102-2		TTNC-101-4		TTNC-151-2		TTNC-201-2	
Tilt range	−17°~+107°		−110°~+110°		−110°~+110°		−110°~+110°	
Spindle diameter	φ90h7		φ80h7		—		—	
Table diameter *1	φ135 (Option)		φ115 (Option)		φ160		φ225	
Table height at 0°position	230 (255 With face plate)		275 (300 With face plate)		270		350	
Center height at 90°position	160		200		200		260	
Center bore — Nose diameter	φ55H7 (φ40H7 With face plate)		φ50H7 (φ50H7 With face plate)		φ35H7		φ40H7	
Center bore — Through-bore	φ35		φ30		φ35		φ32	
Minimum distance between table centers	140		120		250		304.8	
Table T-slot width *1	12H8 (With face plate)		10H8 (With face plate)		12H7		12H7	
Guide block width	14h7		18h7		18h7		18h7	
Servo motors (for FANUC)	Rotary axis αiF2	Tilt axis αiF2	Rotary axis αiF8	Tilt axis αiF8	Rotary axis αiF4	Tilt axis αiF8	Rotary axis αiF8	Tilt axis αiF12
Inertia converted into motor shaft ×10⁻³kg·m² [×10⁻³kgf·cm·sec²]	0.16 [1.6]	0.06 [0.6]	0.52 [5.3]	1.08 [11.0]	0.45 [4.6]	1.09 [11.1]	0.48 [4.9]	3.2 [32.8]
Speed reduction ratio	1/90	1/180	1/60	1/90	1/90	1/90	1/90	1/120
Table max. rpm min⁻¹ (Motor rpm: 2,000min⁻¹)	22.2	11.1	33.3	22.2	22.2	22.2	22.2	16.6
Clamp system Supplied pressure	Pneumatic 0.49MPa [5kgf/cm²]	Pneumatic 0.49MPa [5kgf/cm²]	*2 Pneumatic 0.49MPa [5kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	*2 Pneumatic 0.49MPa [5kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]	Hydraulic 3.5MPa [35kgf/cm²]
Clamp torque N·m [kgf·m]	127 [13]	284 [29]	80 *2 [8]	980 [100]	78 [8]	1,000 [102]	490 [50]	2,450 [250]
Indexing accuracy(the sum) arc sec	40	—	60	—	30	—	20	—
Repeatability arc sec	4	—	8	—	4	—	4	—
Tilting accuracy Tilt 0°~90° arc sec	—	45	—	60	—	60	—	60
Tilting repeatability arc sec	—	4	—	4	—	4	—	4
Net weight kg	100		370		340		550	
Strength of worm gears (Rotary axis) N·m [kgf·m]	93.1 [9.5]		176 [18]		147 [15]		470 [48]	
Allowable work weight — 0° (Horizontal)  kg	35		25		40		50	
Allowable work weight — 0°~90° (Tilting)  kg	20		25		40		50	
Allowable work moment W×L  N·m [kgf·m]	54.8 [5.6]		176 [26]		156.8 [16]		254.8 [26]	
Allowable load (when table is clamped) F  N [kgf]	1,960 [200]		1,960 [200]		6,860 [700]		9,800 [1,000]	
Allowable load F×L  N·m [kgf·m]	127 [13]		80 *2 [8]		78 [8]		490 [50]	
Allowable load F×L  N·m [kgf·m]	284 [29]		980 [100]		980 [100]		2,450 [250]	
Allowable work inertia (per single-axis) $J=\frac{W \cdot D^2}{8}$  kg·m² [kgf·cm·sec²]	0.08 [0.86]		0.05 [0.5]		0.19 [2.0]		0.63 [6.4]	

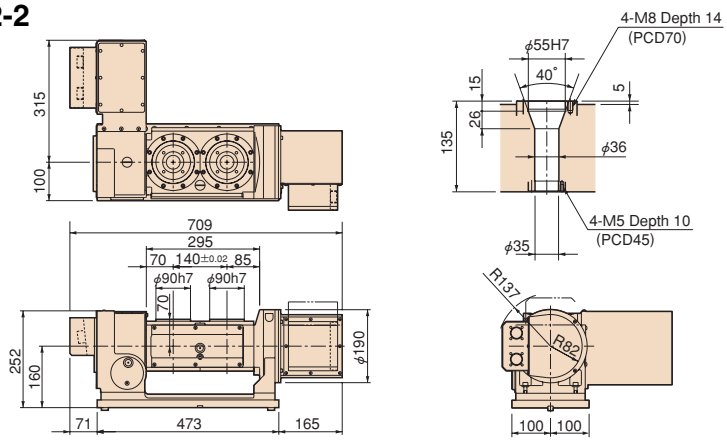
☞ Servo motors of other manufacturers P.70

*1 The tolerance of the table T-slot width is applicable to four standard slots arranged crosswise. ☞ Dimensions P.64 *2 Tables with increased clamp torque are available according to the applications.

Dimensions

Unit: mm

TTNC-102-2

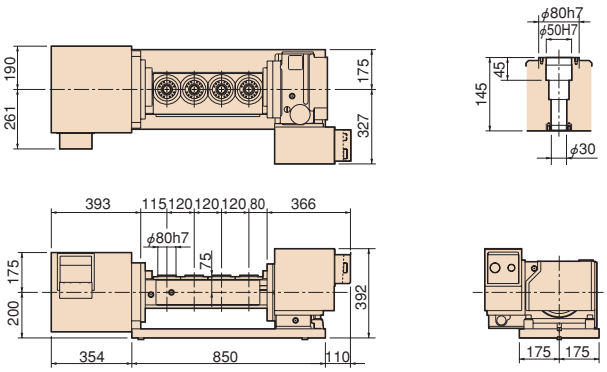


TTNC-102-2

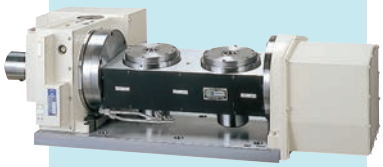
With Power Chuck P.66

TTNC-101-4

TTNC-101-4

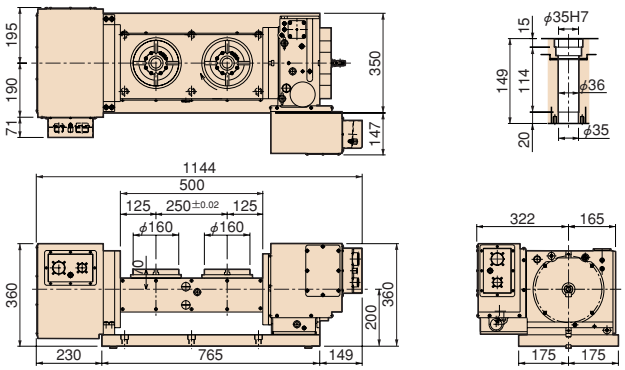


With Rotary Joint P.67



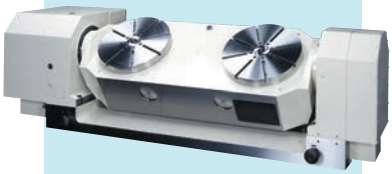
TTNC-151-2

TTNC-151-2

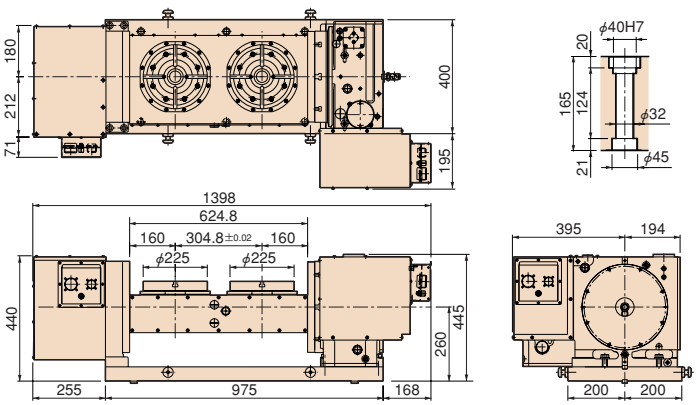


RT-161

This twin-spindle type NC tilting table has the world's largest diameter of 450mm.



TTNC-201-2



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

Horizontal setting type with rotary joint

RC

RC-250・300・400・500

High-performance NC rotary tables developed for specific machines requiring high rigidity and durability. Used mainly for processing workpieces or jigs. Equipped with a rotary joint unit having 8 ports (for pneumatic and hydraulic pressure) and 1 port (for coolant) as standard features.

RC-300

Specifications

Unit: mm

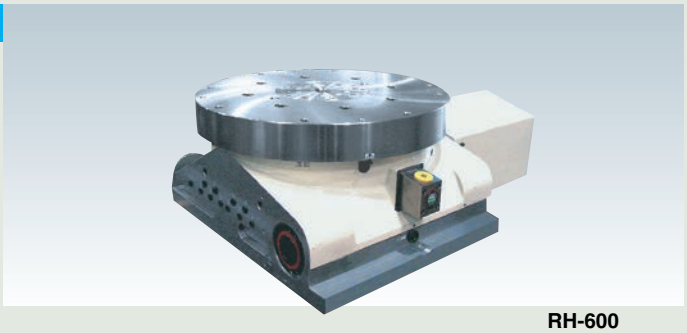
	RC-250	RC-300	RC-400	RC-500
Table diameter	φ250	φ320	φ400	φ500
Table height	230	250	260	270
Servo motors (for FANUC)	αiF8	αiF12	αiF22	αiF22
Inertia converted into motor shaft $\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	0.68 [6.94]	1.36 [13.9]	2.30 [23.5]	3.60 [36.7]
Net weight kg	130	200	290	390
Speed reduction ratio	1／36	1／45	1／45	1／90
Table max. rpm min⁻¹ (Motor rpm: 2,000min⁻¹)	55.5	44.4	44.4	22.2
Indexing accuracy(the sum) sec	25	25	25	25
Repeatability arc sec	4	4	4	4
Clamp system	Hydraulic	Hydraulic	Hydraulic	Hydraulic
Clamp torque N·m [kgf·m] ／Hydraulic pressure 3.5Mpa [35kgf/cm²]	540 [55]	900 [91]	1,900 [193]	3,400 [346]
Strength of worm gears N·m [kgf·m]	660 [67]	966 [98]	1,535 [156]	2,815 [287]
Allowable work weight  kg	300	450	650	650
Eccentric load  N·m	350	700	960	960
Allowable load (when table is clamped) F  N [kgf]	19,600 [2,000]	29,400 [3,000]	39,200 [4,000]	39,200 [4,000]
Allowable load (when table is clamped) F×L  N·m [kgf·m]	540 [55]	900 [91]	1,900 [193]	3,400 [346]
Allowable load (when table is clamped) F×L  N·m [kgf·m]	931 [95]	2,000 [204]	4,000 [408]	4,000 [408]
Allowable work inertia $J=\frac{W\cdot D^2}{8}$  kg·m² [kgf·cm·sec²]	2.36 [24.0]	7.1 [69.5]	10.9 [106.8]	33.5 [328.3]

☞Servo motors of other manufacturers P.70

For horizontal setting

RH RH-400・500・600

Available for horizontal setting only. Used mainly for rotating and positioning operations on items like cradle jigs which have a comparably large turning radius. Tables equipped with a powerful clamp system have excellent loading capacity and moment rigidity.

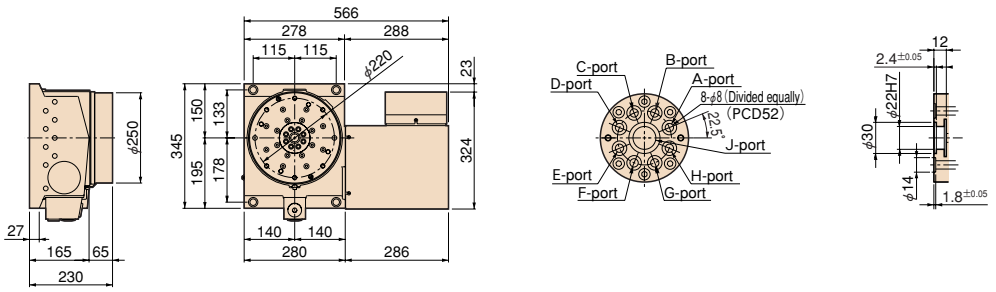


RH-600

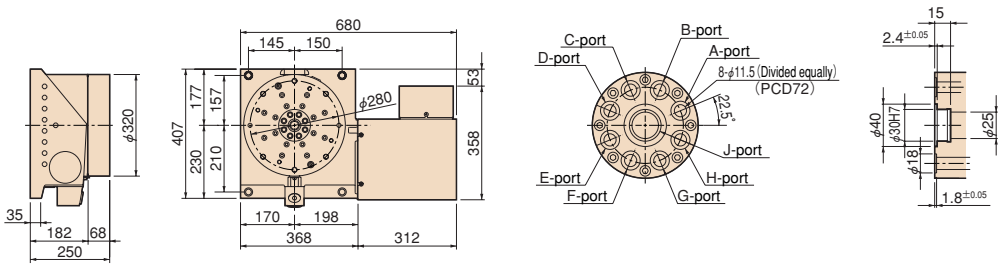
Dimensions

Unit: mm

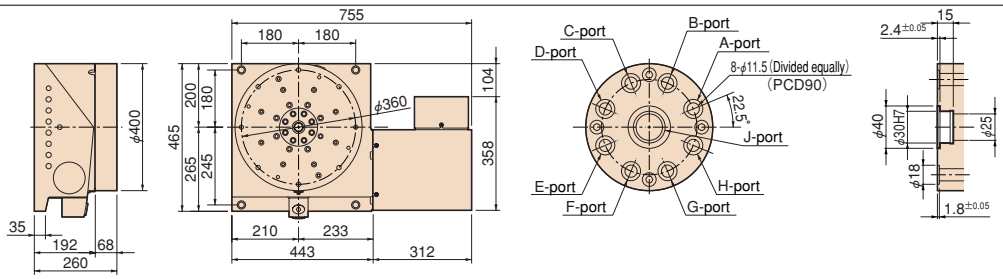
RC-250



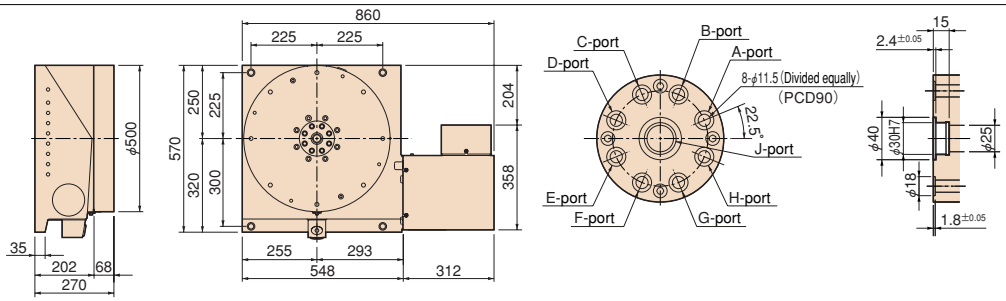
RC-300



RC-400

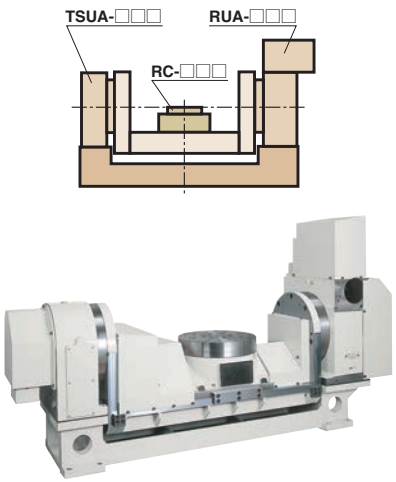
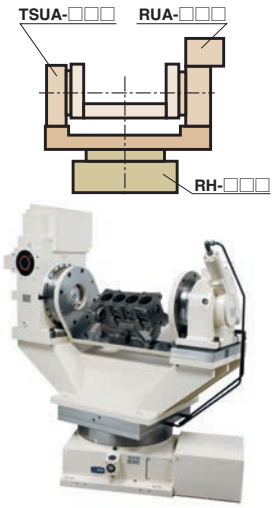
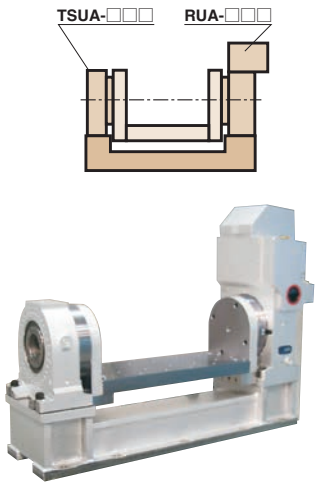


RC-500



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

■Examples of Combined Use

Turn & Tilt System	Tilt & Turn System	Cradle System
		

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

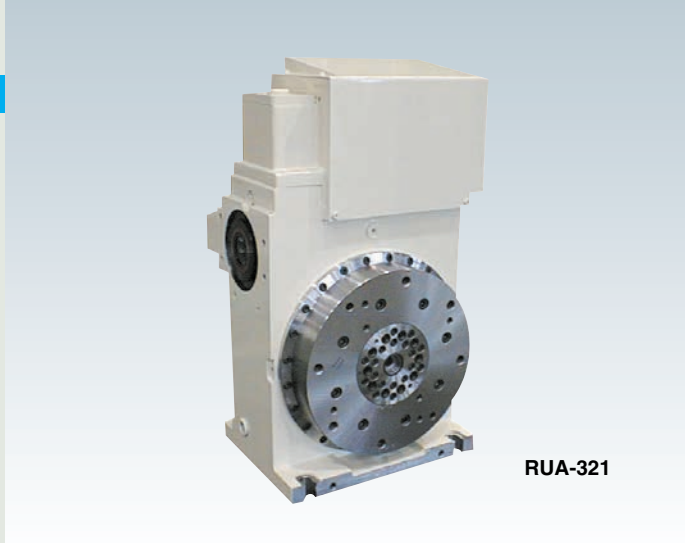
For vertical setting

RUA

RUA-251・321・400・500

Available for vertical setting only. Used mainly as a tilting device. An optional 8~12-port rotary joint* is available. Tables equipped with a powerful dual disc clamp system have excellent eccentric load rigidity, powerful wheel torque and cutting resistance.

* Number of ports may vary depending upon models.

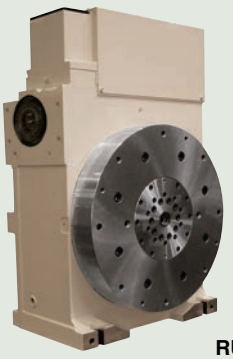


RUA-321

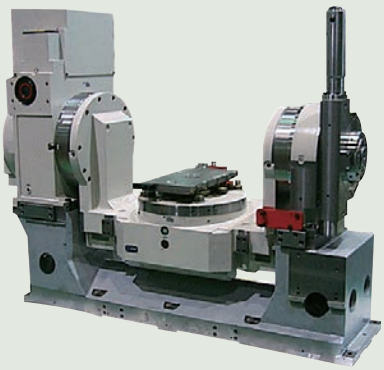
Specifications

Unit: mm

		RUA-251	RUA-321	RUA-400	RUA-500
Setting	Vertical/Horizontal	Vertical setting	Vertical setting	Vertical setting	Vertical setting
Table diameter		φ250	φ320	φ400	φ500
Center height		170	210	255	310
Center bore	Nose diameter	φ105H7	φ140H7	φ190H7	φ220H7
	Through-bore	φ71	φ101	φ151	φ182
Servo motors (for FANUC)		αiF8/3,000	αiF12/3,000	αiF22/3,000	αiF30/3,000
Inertia converted into motor shaft	$\times 10^{-3}$kg·m²	0.40	2.07	2.38	2.46
Net weight	kg	120	270	390	620
Speed reduction ratio		1/180	1/240	1/240	1/360
Table max. rpm (Motor rpm: 2,000min⁻¹)	min^{-1}	11.1	8.3	8.3	5.5
Indexing accuracy (the sum)	sec	30	30	25	25
Repeatability	arc sec	4	4	4	4
Clamp system		Hydraulic	Hydraulic	Hydraulic	Hydraulic
Clamp torque	⁄Hydraulic pressure 3.5 Mpa N·m	1,000	2,450	4,200	6,100
	⁄Hydraulic pressure 4.9 Mpa N·m	1,500	4,200	6,300	9,200
Strength of worm gears	N·m	938	1,942	3,276	4,930
Allowable work weight	kg	120	160	200	250
Allowable load (when table is clamped)	F N [kgf]	19,600 [2,000]	29,400 [3,000]	39,200 [4,000]	49,000 [4,000]
	F×L N·m [kgf·m]	1,000 [102]	2,450 [250]	4,200 [428]	6,100 [622]
	F×L N·m [kgf·m]	980 [100]	3,626 [370]	5,880 [600]	13,132 [1,340]
Allowable work inertia	$J=\frac{W \cdot D^2}{8}$ kg·m² [kgf·cm·sec²]	6.0 [59]	17.8 [174]	29.9 [293]	74.2 [727]



RUA-500



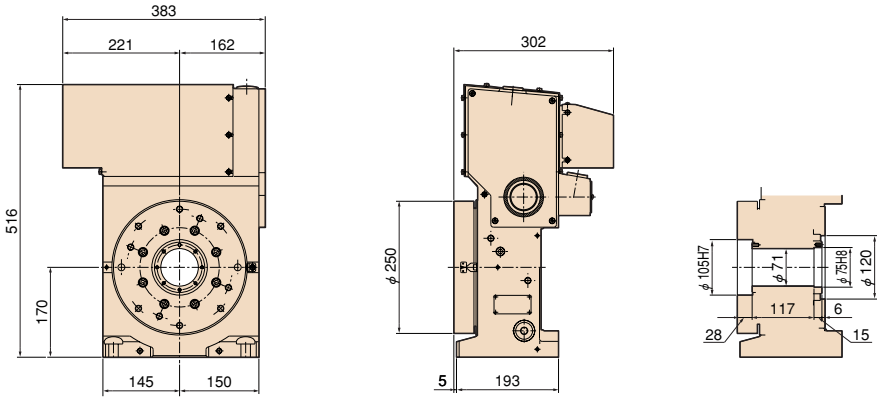
RTT-501

・Table square size:□500
・When using support spindle with balance cylinder

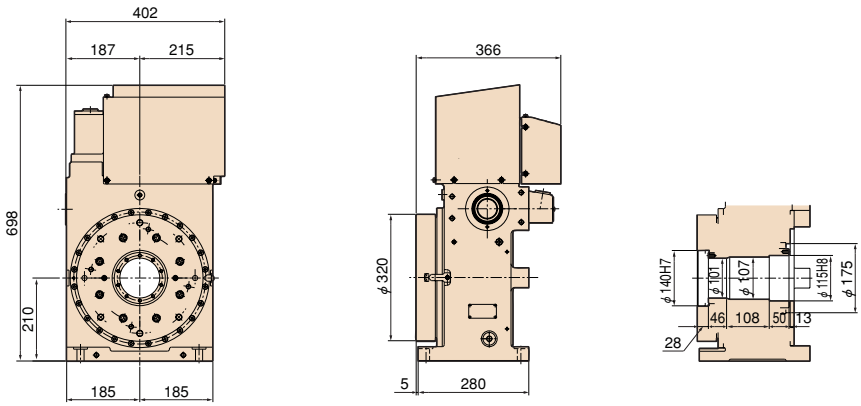
Dimensions

Unit: mm

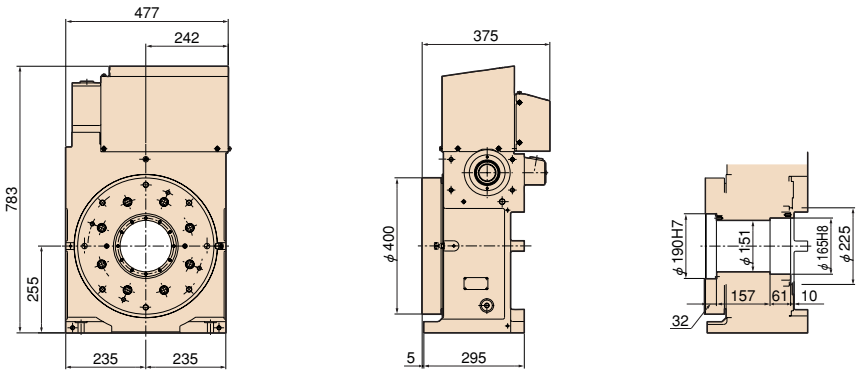
RUA-251



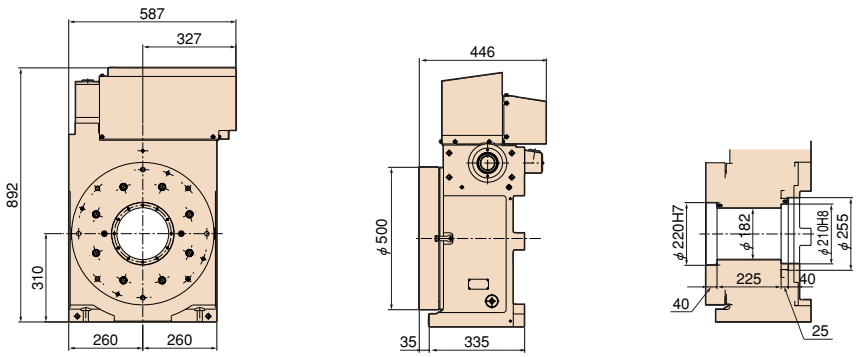
RUA-321



RUA-400



RUA-500



Note: The above dimensions are for FANUC servo motors. The dimensions of servo motors of other manufacturers may be larger.

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

Support spindles

TSUA

TSUA-170・210・255・310

Used as a supporter for a tilting device. An 8-port rotary joint and a balancer to support an eccentric load are available. Comes with a powerful dual disc clamp mechanism.

TSUA (without balance cylinder) **TSUA** (with balance cylinder)

Specifications

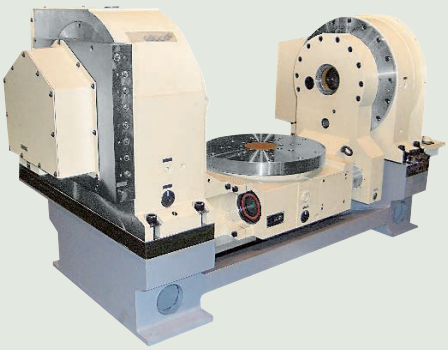
Unit: mm

			TSUA-170	TSUA-210	TSUA-255	TSUA-310
Suitable model of NC rotary table			RUA-250	RUA-320	RUA-400	RUA-500
Center bore	Nose diameter		φ105H7	φ140H7	φ190H7	φ190H7
	Through-bore		φ71	φ101	φ151	φ151
Center height			170	210	255	310
Clamp system			Hydraulic	Hydraulic	Hydraulic	Hydraulic
TSUA Clamp torque	/Hydraulic pressure 3.5 Mpa	N・m	1,000	2,450	4,200	4,200
	/Hydraulic pressure 4.9 Mpa	N・m	1,500	4,200	6,300	6,300
TSUA * balance torque	/Hydraulic pressure 3.5 Mpa	N・m	281	550	754	754
	/Hydraulic pressure 4.9 Mpa	N・m	394	770	1,077	1,077
Swing range for balancer		degree	±45	±45	±45	±45
TSUA Net weight	without balance cylinder	kg	70	140	270	300
	with balance cylinder	kg	100	180	300	330
Allowable work weight	W	kg	860	1,300	1,730	1,950
Eccentric load	L W	N・m	169	374	627	1,036
Allowable load (when table is clamped under 3.5Mpa hydraulic pressure)	F	N	16,954	25,480	34,000	42,532
	F×L	N・m	2,000	4,900	8,400	10,300

*TSUA with balance cylinder.

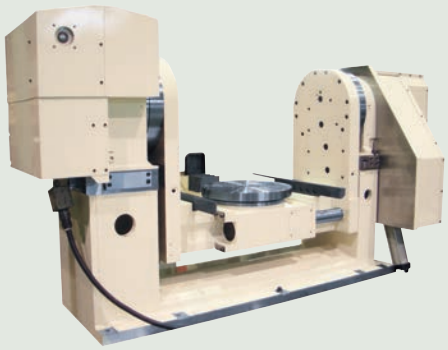
RTT-411

・Table diameter:φ400



RTT-504

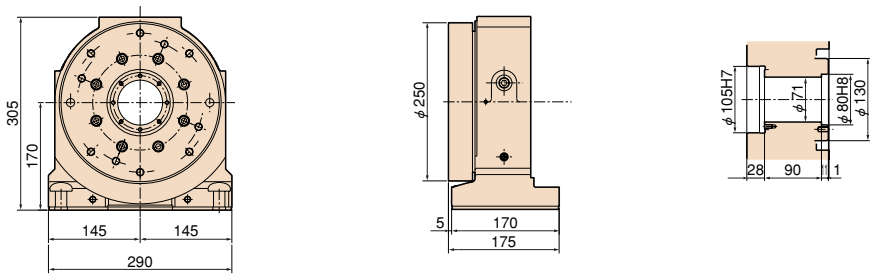
・Max. swing diameter:φ1000
・To lower the upper surface of a rotary table by employing the original support mechanism for an unbalanced load



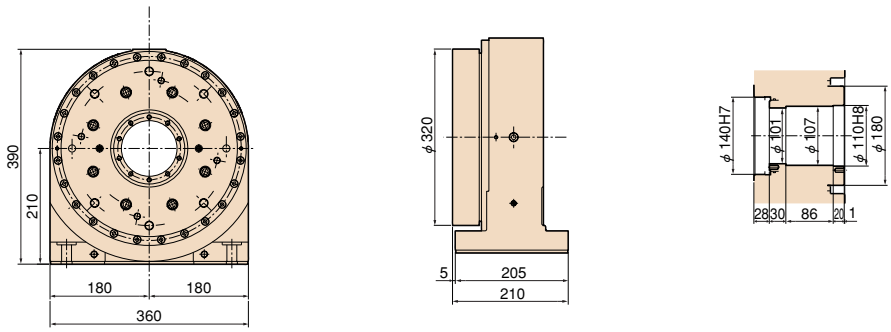
Dimensions

Unit: mm

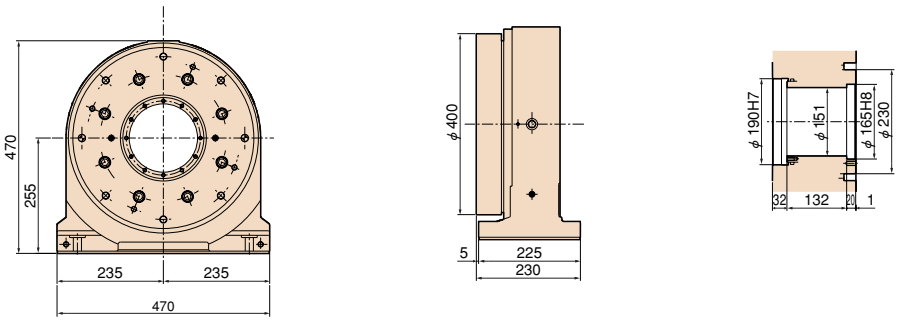
TSUA-170



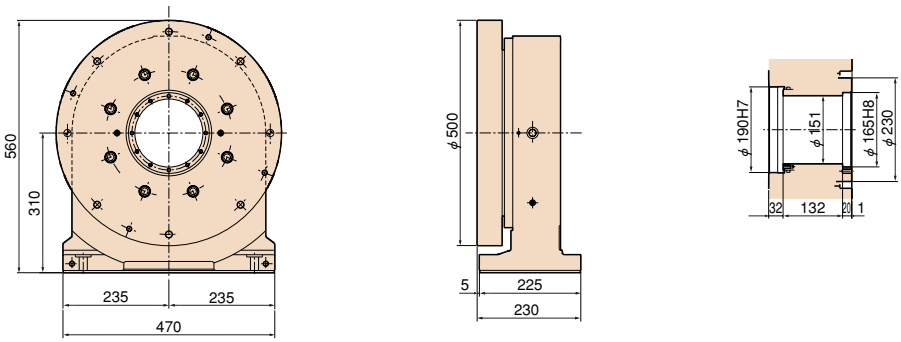
TSUA-210



TSUA-255



TSUA-310



DD Table

RTV·RTT

RTV-202・ϕ500 Table
RTT-112

DD (Direct Drive) motors realize high speed, high acceleration and backlash-free operation.
Most suitable for high speed and high quality machining for various impellers, blades and medical equipment, and for high speed indexing operation for automotive parts.
Provides optimum ideas and products based upon versatile applications as well as their sales record.


RTV-202

Specifications

Unit: mm

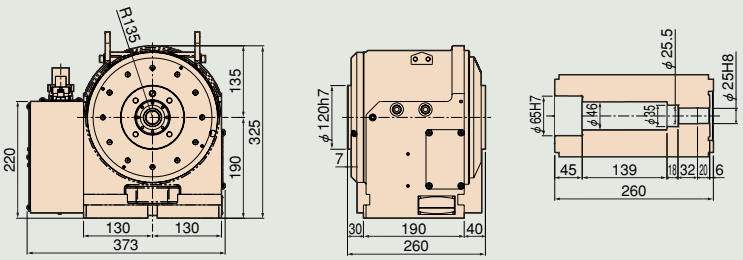
		RTV-202	ϕ500 Table	RTT-112	
Controll axis		1-axis	1-axis	2-axis	
		Vertical setting only	Horizontal setting only	Rotary axis	Tilt axis
Table diameter (Spindle diameter)	mm	(ϕ120)	ϕ537	ϕ100	ϕ100
Servo motors (for FANUC)		Dis260/300	—	Dis60/400	Dis150/300
Type of scale		αCZi512S	RCN226	αCZi512A	αCZi512A
Table max. rpm	min^{-1}	150	60	150	100
Clamp torque	N·m	300 (Pneumatic pressure 0.49MPa)	3,800 (Hydraulic pressure 4.9MPa)	—	80 (Pneumatic pressure 0.49MPa)
Center height	mm	190	—	280	
Rotary joint		—	9P+1P	—	
Allowable work weight	kg	50	700	30	
Net weight	kg	90	485	190	

*Contact us for the following models. Vertical type DD Table ϕ100~ϕ500 Horizontal type DD Table ϕ300~ϕ630
Tilting type DD Table ϕ100~ϕ630
*Applicable for various kinds of DD motors which depend upon the type of controllers. Contact us for details.

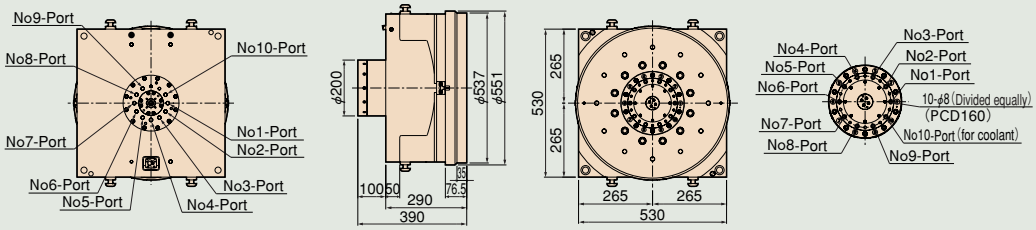
Dimensions

Unit: mm

RTV-202

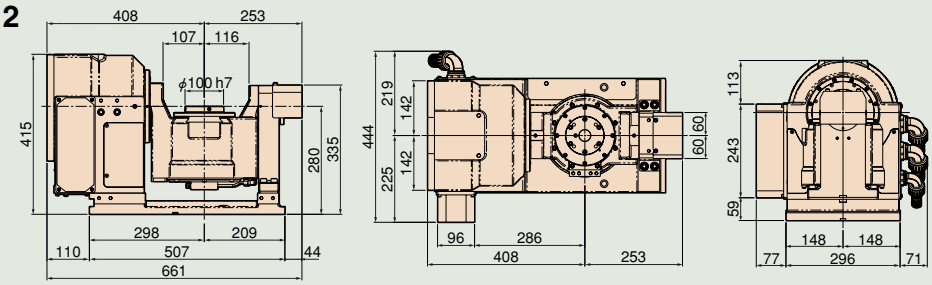


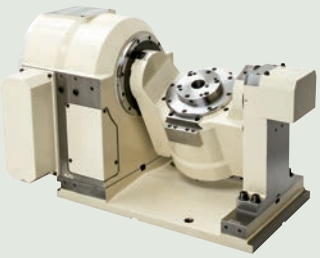
ϕ500DD Table




ϕ500 DD Table

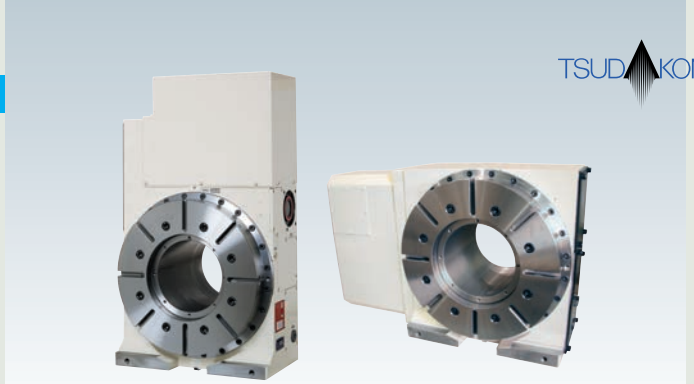
RTT-112




RTT-112

RTV RTV-304·404·504·801

Main spindle with highly rigid bearings and table with high overall rigidity enable machining of hard materials such as aircraft components.
Vertical and horizontal setting types are available. Machining at a position closer to the face plate is made possible by inserting the workpiece through the large bore.



RTV-404 (Top motor application)　RTV-404 (Side motor application)

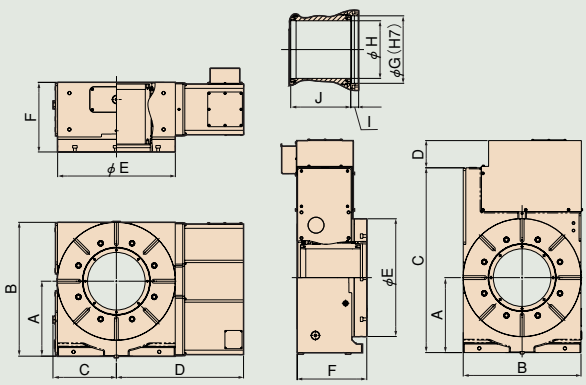
Specifications

Unit: mm

		RTV-304	RTV-404	RTV-504	RTV-801
Handedness	R	○	○	○	○
	L	○	○	○	○
	Top	○	○	○	○
Table diameter		φ350	φ450	φ550	φ800
Center height		235	280	350	530
Center bore	Nose diameter	φ190H7	φ250H7	φ315H7	φ460H7
	Through-bore	φ160	φ209	φ269	φ420
Table T-slot width		14H7	14H7	18H7	18H7
Guide block width		18h7	18h7	18h7	22h7
Servo motors (for FANUC)		αiF12	αiF22	αiF22	αiF12
Inertia converted into motor shaft	$\times10^{-3}$kg·m² [$\times10^{-3}$kgf·cm·sec²]	2.7 [27.54]	4.05 [41.31]	6.01 [61.30]	4.35 [44.37]
Net weight	kg	180	430	590	1,370
Speed reduction ratio		1/90	1/90	1/120	1/360
Table max. rpm	min⁻¹ (Motor rpm: 2,000min⁻¹)	22.2	22.2	16.6	5.5
Indexing accuracy (the sum)	sec	15	15	15	15
Repeatability	arc sec	4	4	4	4
Clamp system		Hydraulic	Hydraulic	Hydraulic	Hydraulic
Clamp torque / hydraulic pressure 3.5MPa [35kgf/cm²]	N·m [kgf·m]	2,700 [102]	4,600 [469]	5,800 [591]	14,500 [1,479]
Strength of worm gears	N·m [kgf·m]	1,370 [139]	2,630 [268]	4,200 [428]	7,840 [800]
Allowable work weight	Vertical setting ( ) : with tailstock	300 (500)	350 (700)	500 (1,000)	600 (1,500)
	Horizontal setting	500	700	1,000	1,500
Allowable load (when table is clamped)	F	29,400 [3,000]	45,000 [4,590]	54,000 [5,508]	64,400 [6,568]
	F×L	2,700 [275]	4,600 [469]	5,800 [591]	14,500 [1,479]
	F×L	3,626 [370]	8,000 [816]	15,132 [1,543]	27,000 [2,754]
Allowable work inertia	$J=\frac{W\cdot D^2}{8}$	10.0 [102]	20.0 [204]	30.0 [306]	120.0 [1,224]

Dimensions

Side motor application　Top motor application



Unit: mm

	Motor position	A	B	C	D	E	F	G	H	I	J
RTV-304	Right or Left	235	435	221	481	350	265	190	160	22	234
	Top	235	423	668	123	350	265	190	160	22	234
RTV-404	Right or Left	280	525	266	577	450	300	250	209	30	256
	Top	280	510	748	133	450	300	250	209	30	256
RTV-504	Right or Left	350	625	296	594	550	325	315	269	30	280
	Top	350	554	863	134	550	325	315	269	30	280
RTV-801	Right	530	981	429	759	800	375	460	420	48	318

Single-axis NC controller equipped with advanced functions for M-signal

Single axis NC table controller that operates by means of M-signals from the machining center. Operation can be programmed by machining centers under "remote mode + M" specification.

For small-sized rotary tables

TPC-Jr

H2／H3

■Single-axis NC controllers that operate small-sized TSUDAKOMA NC rotary tables by means of M-signals from machining centers.

■TSUDAKOMA rotary tables equipped with super-compact AC servo motors are the most compact among similar models.

■Operation can be programmed by machining centers.

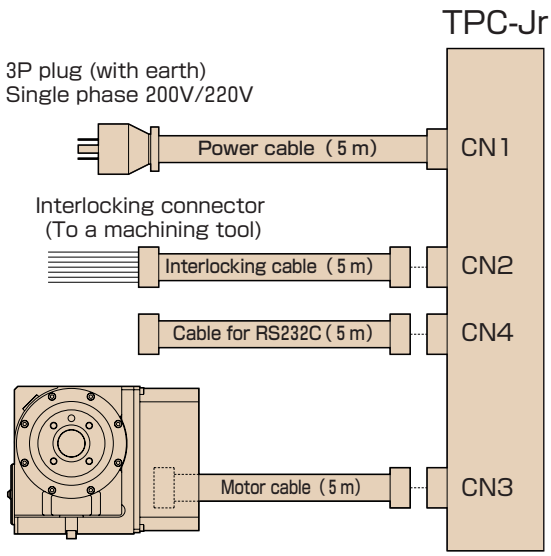
With "remote mode + M" specification (Parameter change)

※Corresponding to Cable option ☞ P.52

Applicable models

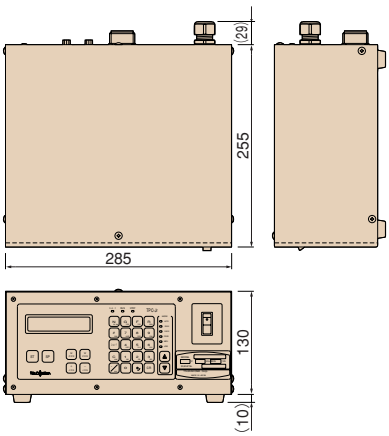
	H2	H3
RN-100	●	
RNA-161	●	
RNA-201		●
RNA-251		●
RNA-321		●
RN-100-2(Axis)/3(Axis)/4(Axis)		●
RN-150R-2(Axis)		
TN-101	●	
TN-131	●	
TN-161	●	
TN-201		●
RNE-160	●	
RNE-200		●
RNE-250		●
RNE-320		●

Cables



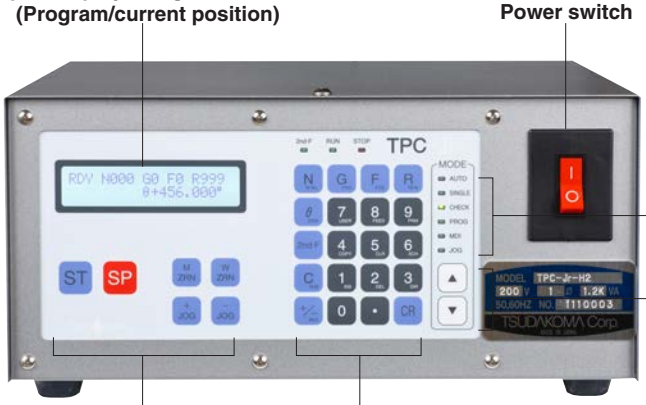
Note: The cable for RS232C is an optional item.

Dimensions



TPC-Jr FUNCTIONS

Operation panel



OPERATION MODE

AUTO AUTO:
Automatic operation by an M signal from the machining center.

SINGLE SINGLE:
Single operation of TPC-Jr. By pressing ST, the indexing is done one time.

CHECK CHECK:
Block number call, program check and self-diagnosis.

PROG Program mode:
For inputting and editing the program.

MDI MDI mode:
For setup operation. Ten blocks of programs can be carried out.

JOG JOG mode:
For manual feed and step feed.

Program edit keys

2nd·F + N W No. Workpiece No. (Program No.)
0000～ 9999
100 programs registerable

N W No. Block No.
000～999

G PRO Operation command
G0～G4: Movement command
G5 to G9: Assistance function

F POS Feed rate select command
F0: Rapid positioning speed
F1～ F9: Cutting feed rate

R REM Assistance code for codes

θ DGN Travel distance command
(angle, divided number)
Block No./Sub-program No.

G-code		R-code		θ-code	
No.	Command	No.	Command	Command	Setting
G0	Direct angle command	001～999	Number of repetitions (INC)	Command angle	±000.001°～999.999°
		000	(ABS)	Command angle	±000.000°～360.000°
G1	Direct indexing number command	001～999	Number of repetitions	Number of divisions for 360°	±1～999999div.
G2	Arc-indexing number command	001～999	Number of divisions, Number of repetitions	Arc-angle indexed	±000.001°～360.000°
G3	Lead cutting command	000～100	Number of table rotations	Command angle	±0°～360.000°
G4	Zero point return command	000	1st zero point return (mechanical zero point)	Not required	
		001	2nd zero point return		
		002	3nd zero point return		
G5	Sub-program call command	001～999	Number of repetitions	Sub-program No.	0000～9999
G6	Subprogram return command	Not required		Not required	
G7	Program end command	Not required		Target address	000～999
G8	Workpiece coordinate system setting command	Not required		Reference coordinate	±0°～360.000°
G9	Declaration command	000	No operation	Not required	
		001/002	Clamp OFF/ON		
		003/004	Dowel OFF/ON	Dwell time	000～999 (×10m sec)
		005/006	Indexing group control OFF/ON	Not required	
		007/008	Directional positioning OFF/ON		
		009/010	Completion signal control command OFF/ON	Completion signal selection	
		011	Program display selection command	Not required	
		012	Current position display selection command		
		013	Remaining angle display selection command		

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

For large-sized tables

TPC5

SR6／SR12／SR30

■Single-axis NC controllers automatically start large-sized TSUDAKOMA NC rotary tables by receiving M-signals from machining centers.

■Easy programming by simple input of the interactive system.
In increments of 0.001°(standard), 0.0001°or 1 sec.

■Ready to set optional functions easily.

★With an optional function of B signal, the workpiece number, block number and tilting angle command can be entered from a machining center.

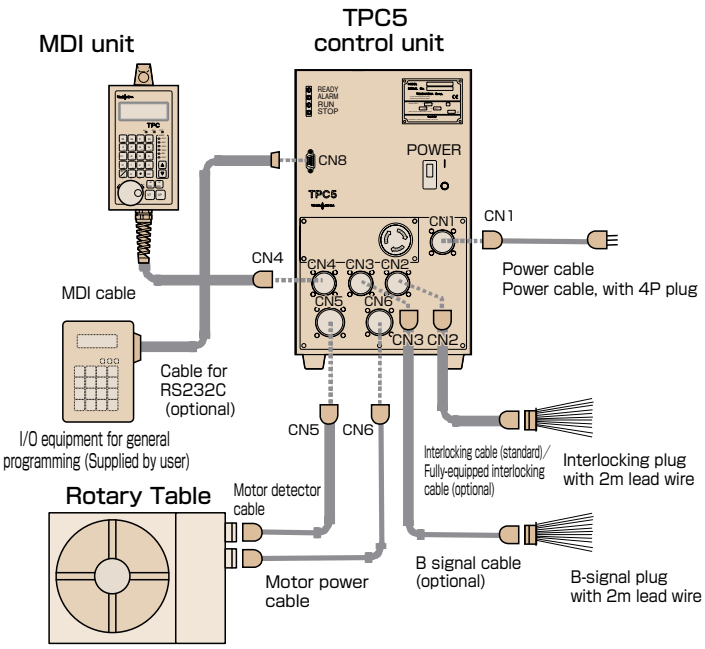
★With "remote mode + M specification", operation can be programmed by a machining center.

☞ P.52

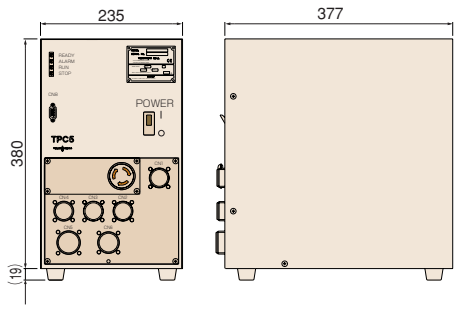
Applicable models

	SR6	SR12	SR30
RNCM-251	●		
RNCM-301～631		●	
RBA-250	●		
RBA-320,400		●	
RCV-800		●	
RCV-1000			●
RNCV-1201,1501			●
TN-320	●		
TN-450			●
THNC-251	●		
THNC-301	●		
TTNC-631		●	
RG-160	●		
RG-250	●		
RG-320		●	

Cables



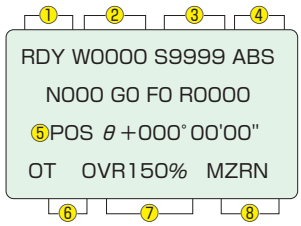
Dimensions



TPC5 FUNCTIONS

Operation panel

Indicator



←Status display line
←Program display line
←Program/Current position
←Control display line

Status display line: ①TPC status ②Workpiece number ③Subprogram number ④Command system

Program display line: TPC5 program in 2 lines ⑤Current position/remaining (POS/REM)

Control display line: ⑥Overtravel ⑦Override/machine lock/manual interrupt ⑧Zero point return MZRN/WZRN/TZRN

LED displays

LED for operational mode

Program edit keys

Operation mode change key

Multiple jog dial

Operation keys

OPERATION MODE

AUTO AUTO:
Automatic operation interlocked with machining center

SINGLE SINGLE:
Single operation of TPC5

CHECK CHECK:
Program check and self-diagnosis

PROG Program mode:
Program entry

MDI MDI mode:
Setup operation

HANDLE Handle mode:
Manual pulse operation/jog mode

Program edit keys

2nd·F + N (W No.) Workpiece No. (Program No.)
0000～ 9999
100 programs registerable

N (W No.) Block No.
000～999

G (PRO) Operation command
G0～G4: Movement command
G5 to G9: Assistance function

F (POS) Feed rate select command
F0: Rapid positioning speed
F1～ F9: Cutting feed rate

R (REM) Assistance code for codes

θ (DGN) Travel distance command (angle, divided number)

G-code		R-code		θ-code	
No.	Command	No.	Command	Command	Setting
G0	Direct angle command	0001～9999	Number of Repetition (INC command)	Command angle	±000.001°～999.999°
		0000	(ABS command)	Command angle	±000.000°～360.000°
G1	Direct indexing number command	0001～9999	Number of repetitions	Number of divisions for 360°	±1～999999div.
G2	Arc-indexing number command	0001～9999	Number of divisions, Number of repetitions	Arc-angle indexed	±000.001°～360.000°
G3	Lead cutting command	0000～0100	Number of table rotations	Command angle	±0°～360.000°
G4	Zero point return command	0000	1st zero point return (mechanical zero point)	Not required	
		0001	2nd zero point return		
		0002	3nd zero point return		
G5	Sub-program call command	0000～9999	Number of repetitions	Sub-program No.	0000 (0001) ～9999
G6	Subprogram return command	Not required		Not required	
G7	Program end command	Not required		Target address	000～999
G8	Workpiece coordinate system setting command	Not required		Reference coordinate	±0°～360.000°
G9	Declaration command	0000	No operation	Not required	
		0001/0002	Clamp OFF/ON		
		0003/0004	Dowel OFF/ON	Dwell time	001～999 (×10m sec)
		0005/0006	Indexing group control OFF/ON	Not required	
		0007/0008	Directional positioning OFF/ON		
		0009/0010	Completion signal control command OFF/ON	Completion signal selection	
		0011	Program display selection command	Not required	
		0012	Current position display selection command		
		0013	Remaining angle display selection command		

Specifications of TPC

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

	TPC-Jr	TPC5
Control axis	1 axis	
Servo motor	AC servo: ABS detector	
Command unit	0.001°(Decimal)	1 sec,0.001°,0.0001°(Decimal)
Indexing number: Direct indexing	1~999999 even indexing	
Indexing number: Arc-indexing	1~999 even indexing	1~9999 even indexing
Max. command angle	±999.999°	±999°59'59",±999.999°,±999.9999°
Command system	INC, ABS, Shortcut ABS, INC/ABS mixed system	
Input system	MDI	
Program control	Workpiece No.(W0000 to 9999)	
Program capacity	1,000 blocks (Total of main and sub programs)	2,000 blocks (Total of main and sub programs)
Positioning speed	Max, motor rotation speed: 3,000rpm	Max, motor rotation speed: 2,000rpm
Operation Mode	AUTO: Operation interlocked with a machining center SINGLE: Single operation of TPC CHECK: Program check and call PROG: Program edit MDI: Setup operation JOG: Manual feed, step feed	AUTO: Operation interlocked with a machining center SINGLE: Single operation of TPC CHECK: Program check and call PROG: Program edit MDI: Setup operation HANDLE: Manual pulse operation
Display	Liquid crystal display 20 figures×2lines	Liquid crystal display 20 figures×4lines
Direct indexing number command	Move angle is directly commanded	
Repetition	Command of number of move amount repetitions 999(TPC-Jr) 1~9999(TPC5)	
Direct indexing number command	Indexing number of six digits for 360 degrees	
Arc-indexing number command	Command of arbitrary 3-digit angle(TPC-Jr) or 4-digit angle(TPC5)	
Lead cutting command	Interlocked operation with one axis of the machining center in the open loop status	
Zero point return command	Allows return to the first, second or third-zero point	
Feedrate command	F0: positioning speed F1~9: cutting feedrate	
Feedrate setting	1. By radius and surface speed setting 2. By move amount per second	
Sub-program	Up to eight levels of nesting are possible	
Workpiece coordinate system setting	Allows a workpiece coordinate to be set at any point	
Dwell	Allows output of a positioning completion signal to be delayed	
Single directional positioning	Allows positioning in one direction	
Backlash compensation	In increments of 0.001°	Setting by command unit
Soft limit function	Sets a soft limit measured from the 1st zero position	
Automatic setting at power ON	1. Mode selection, AUTO/CHECK 2. Workpiece number setting 3.Block number setting	
Edit function	1. Insert 2. Delete 3. COPY	
Alarm	1. Program format errors 2. Program memory errors 3. Communication errors 4. Soft limit alarms 5. Overtravel 6. Servo motor alarms 7. Overheat in the cabinet(TPC5)	
Override function	×	5~200% 5% steps
JOG/HANDLE feeding	Jog feed, step feed	Manual pulse feed, jog feed
Overtravel	The rotation range of the rotary table can be limited by limit switches. (Standard tilting axis)	
Manual 2nd zero setting	Enables the 2nd zero position to be set and changed at any point in the JOG(HANDLE) mode	
Input/output signal check	○	
Contrast	The concentration on the LCD screen can be adjusted	
Power Earth (less than 100 ohm earth resistance)	1φ200/220V±10% 50/60Hz Model / Power capacity / Fuse rating Jr H2 / 1.2KVA / 10A Jr H3 / 1.9KVA / 15A	3φ200/220V±10% 50/60Hz Model / Power capacity / Fuse rating TPC5-SR6 / 2.3KVA / 10A TPC5-SR12 / 4.0KVA / 15A TPC5-SR30 / 5.9KVA / 20A
Environmental conditions	Ambient temperature: 0-40 degree Relative humidity: 20-80%(no condensation) Vibration: 0.3G or less, No corrosive gas	
Weight	**Jr H2 unit** Weight: 6.7kg 285mm(W)×255mm(D)×130mm(H) **Jr H3 unit** Weight: 7.2kg 285mm(W)×255mm(D)×130mm(H)	**Control unit** Weight: 15kg 235mm(W)×377mm(D)×380mm(H) **MDI unit** Weight: 0.5kg 111mm(W)×30mm(D)×199mm(H)
External output signal	From TPC to machining center Contact ratings: DC24V, 0.1A or less	

	TPC-Jr	TPC5
FIN1	Positioning completion signal during interlocking operation	
	●	●
FIN2	Output of G7 completion or workpiece number setting completion (selectable by parameters)	
	●(AUTO mode)	◇
FIN3	Output of G7 completion or workpiece number setting completion (selectable by parameters)	
	×	◇
FIN4	Output of zero position (selectable by parameters)	
	×	◇
Workpiece number setting completion	Output at workpiece number setting completion (selectable by parameters)	
	●	◇
In AUTO mode	Output in AUTO mode	
	×	◇
LEVEL	Output during positioning (selectable by parameters)	
	●(Rotary table zero position)	◇
ALARM	Output in AUTO mode	
	●	◇
External input signal	From machining center to TPC (External power DC24V is also available.)	
START	Positioning start signal during interlocking operation (M-signal)	
	●	●
STOP	Input to stop rotary table	
	●	●
INTERLOCK	Input to interlock rotary table	
	×	◇
Selection of outer program	Workpiece number can be set externally	
	●	◇
BF (Strobe signal)	Strobe signal for setting workpiece number externally	
	●	◇
M-signal	M signal data fixed input system	
	●(6 points)	◇(16 points)
MDI lock	Input for locking MDI key operation	
	×	◇
Zero point return	1st zero return command	
	●	◇
Manual pulse generator	Manual operation can be performed with a manual pulse generator	
	×	●(Movement magnification:X1,X10,X100)
Full-closed feedback control	×	Enable full-closed control (highly precise) with the Inductsyn or rotary encoder
MP scale	Detecting unit 0.0001°(360poles) or 0.00005°(720poles)	
	×	◆
Encoder	Detecting unit 0.0001°or 0.00005°	
	×	◆
Serial channel	TPC program, feed rate and parameters can be stored in an external device	
	Format: ISO	Format: ISO
	◆(RS232C)	◆(RS232C)
Cable supplied (standard)	Between rotary table and TPC-Jr(1 pc) For Motor: 5m	Between rotary table and TPC5(2 pcs.) For motor power supply: 5m For motor detector: 5m
	—	Between TPC5 and MDI unit: 7m
	Power cable: 5m	Power cable: 5m
	Interlocking cable: 5m	Interlocking cable: 5m
Cable supplied (Option)	Cables of different length are available	
	RS232C cable: 5m	Interlocking cable: 5m
	—	B signal cable: 5m
	—	RS232C cable: 5m

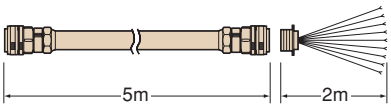
● : Standard
◇ : Optional interlocking cables are supplied
◆ : Optional units and parts are supplied

TPC Option

TPC5

Full-featured interlocking cable

☞ P.55



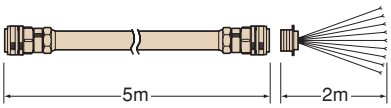
Required for the following functions:

- Stop or interlock input signal
- Positioning completion 2,3,4
- AUTO mode
- Positioning
- Alarm signal

●Full-featured interlocking cable
(Standard length: 5m)

TPC5

B signal cable



Required for the following functions:

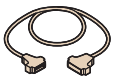
- External input of workpiece numbers
- External input of angles
- Fixed data input through M-signal

※For using B signal cable,internal harness shall be added.

●B signal cable
(Standard length: 5m)

TPC-Jr
TPC5

RS232C cable



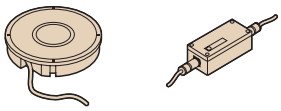
Input and output of program, parameter and feed data for TPC5 and TPC-Jr, and data printout are carried out through external equipment, which is to be prepared by the customer. Also, the cables can be arranged by the customer.

●RS232C cable
(Standard length: 5m)

TPC5

High Resolution Capability
Rotary Encoder Type

☞ P.65



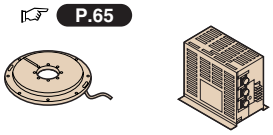
Fully-closed loop control is possible by the feed-back from the rotary encoder.

●Rotary encoders
●IBV unit
(by HEIDENHAIN)
●TPC5 RE

TPC5

High Resolution Capability
MP Scale type

☞ P.65

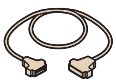


Fully-closed loop control is possible by the feed-back from the MP scale.

●MP scale
●A/D converter
(Mitsubishi Heavy Industries)
●TPC5 RE

TPC-Jr
TPC5

"Remote Mode" Specification



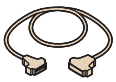
Available for measuring system construction. To be connected with a personal computer using serial channel.

●RS232C cable

TPC-Jr
TPC5

"Remote Mode + M" Specification

☞ P.52



To unify the program to start the rotary table by M-signal, by feeding a command for the indexing angle from the RS232C port at the NC controller of the machining center.

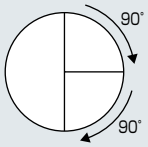
Note: This function may not be available for some machining centers. For details, ask the manufacturer.

●RS232C cable

TPC Machining Program Examples by TPC Controller

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

Direct angle command:G0



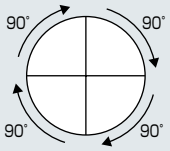
N 000 G 0 F 0 R 002 θ 90.000 CR
Quick / Number of Repetition / Indexing angle/time

N 001 G 7 θ 000 CR
End of program

Positioning at 90° twice

Return to N 000 at the program end

Direct indexing number command(even indexing): G1



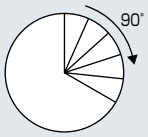
N 000 G 1 F 0 R 004 θ 000004d CR
360° is divided into quarters

N 001 G 7 θ 000 CR

Dividing 360° by 4, four times

Return to N 000 at the program end

Arc-indexing number command(even indexing by an arbitrarily-set angle): G2



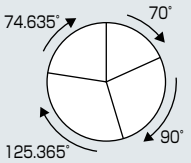
N 000 G 2 F 0 R 005 θ 120.000 CR
Indexing number / Angle for indexing

N 001 G 7 θ 000 CR

Dividing 120° by 5, five times

Return to N 000 at the program end

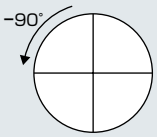
Uneven indexing



N 000 G 0 F 0 R 001 θ 70.000 CR
N 001 G 0 F 0 R 001 θ 90.000 CR
N 002 G 0 F 0 R 001 θ 125.365 CR
N 003 G 0 F 0 R 001 θ 74.635 CR
N 004 G 7 θ 000 CR

Positioning at 70° once
Positioning at 90° once
Positioning at 125.365° once
Positioning at 74.635° once
Return to N 000 at the program end

(−) direction indexing



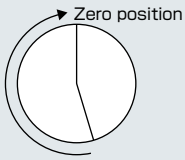
N 000 G 0 F 0 R 001 θ −90.000 CR
Reverse

N 001 G 7 θ 000 CR

Positioning at −90° once

Return to N 000 at the program end

Zero point return command: G4



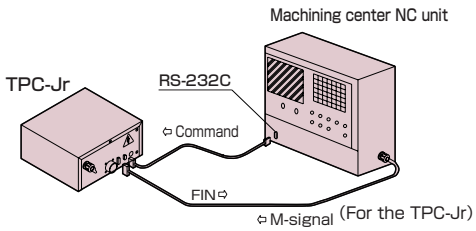
N 000 G 4 R 000
Zero return / To 1st zero position

Return to 1st zero position

Remote mode + M specification(Parameter change) ※corresponding to Cable option

The rotary table is controlled via TPC with M-signal sent from a machining center through RS232C.

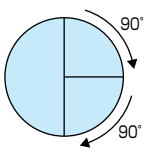
Note: This function may not be available for some machining centers. For details, ask the manufacturer.



Machining center:

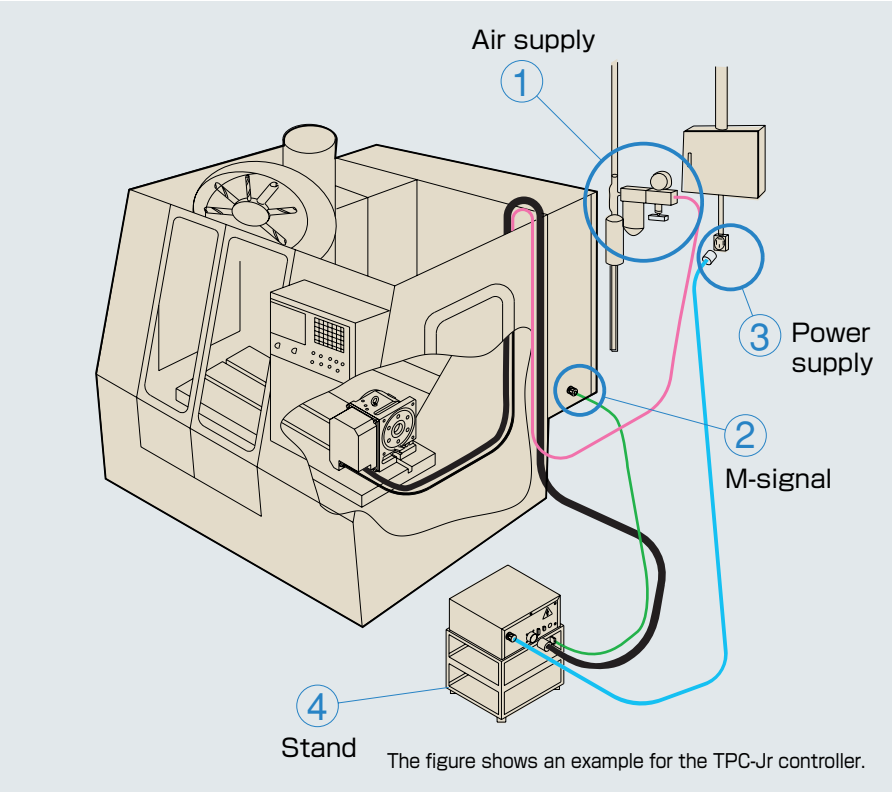
Program using Custom Macro

Necessary equipment
TPC-Jr: Software for remote mode
RS232C/interlock cable, RS232C cross cable
NC unit for a machining tool: RSS232C connector and Custom Macro B (optional) (for FANUC).
For details, ask the machine manufacturer.



POPEN;	RS232C port opens
DPRINT[/MOVA90.];	Command of absolute positioning at 90 is transmitted to TPC
M70;	Positioning starts
G01Z100.F200;	Machining center in operation
DPRINT[/MOVA180.];	Command of absolute positioning at 180 is transmitted to TPC
M70;	Positioning starts
G01Z100.F200;	Machining center in operation
PCLOS;	RS232C port closes

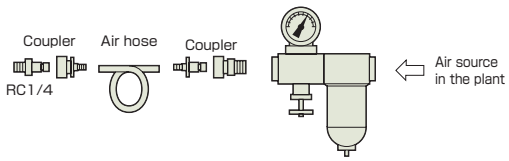
Installation of TPC controller



The figure shows an example for the TPC-Jr controller.

To be provided by customers

①Air supply

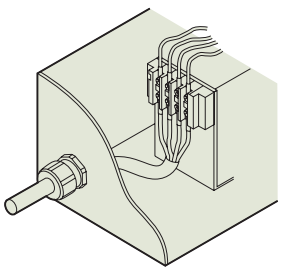


A pneumatic or air-hydraulic clamp system is available for an NC rotary table mounted with the TPC5 or TPC-Jr controller, and an air supply is required.

The following are to be provided by customers:
- ●Air filter and regulator (Air pressure:0.49 MPa)
- ●Air hose or air tube
- ●Joint coupler (RC 1/4 for the table)

Some models need a 6mm diameter tube for connection.

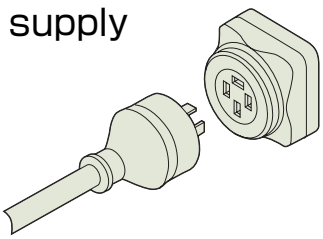
②M-signal



When the machining center controls the rotary table, it uses M-signals. Be sure to confirm with the machine manufacturer that M-signals or M-signal completion signals are transferred to the terminal block of the machine controller. If not, ask the manufacturer to do the required work.

☞ For the connection with an interlocking cable, refer to the examples shown on P.54

③Power supply



A socket for the TPC controller is necessary. A 3P plug is equipped with the TPC controller, and is recommended. The outlet for the connection is required.

TPC side connector WF4420(Panasonic)
Outer power supply connector WF1420 or the others(Panasonic)
In case of the different type of connector,shall be arranged by the customer.

☞ For the power capacity of each controller, refer to P.50

Conduct grounding (less than 100 ohm earth resistance)

④Stand

A stand for the TPC controller is to be provided by the customer.

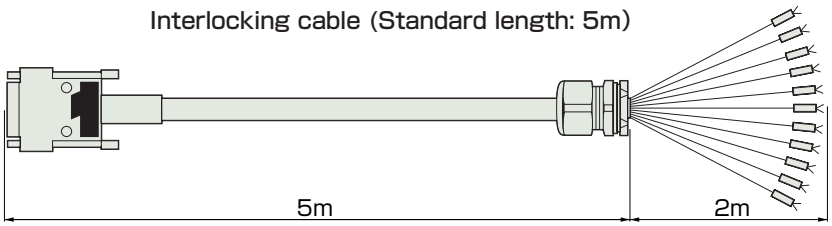
☞ For the dimensions and weight of the controller, refer to P.46~48 P.50

TPC Controllers to Interlock with Machining Tools

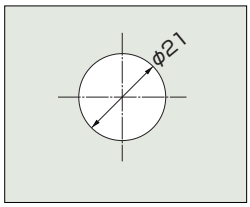
RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

TPC-Jr

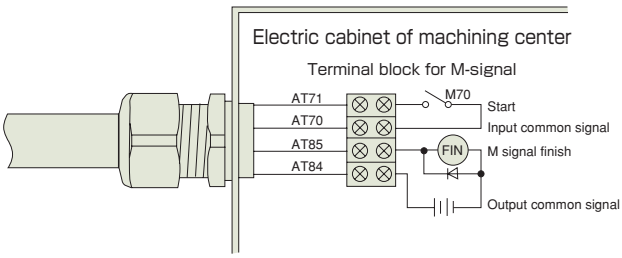
Interlocking cable (Standard length: 5m)



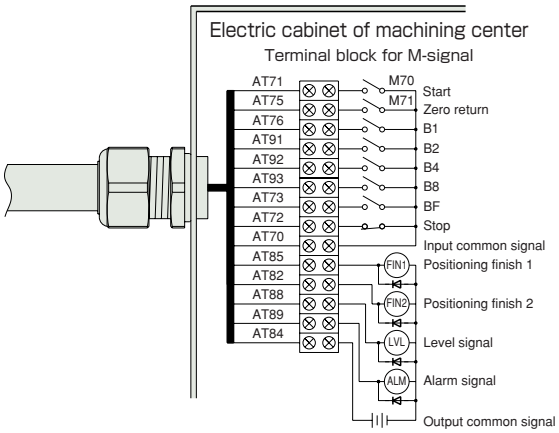
Connector dimension
(on machining center)



a) When a start signal and an indexing completion signal are used:



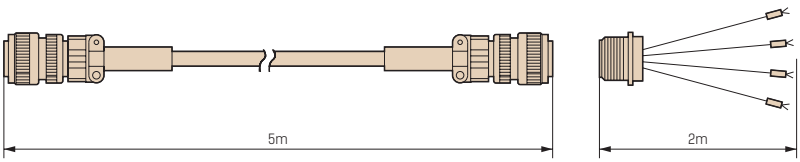
b) When all the signals through interlocking cables are used:



Note 1: When completion signals are received by a relay, the power supply should be 24VDC. Do not apply 100VAC or 200VAC.
Note 2: By changing the switch in the controller, a start signal is also available with the external power supply of DC24V.
Note 3: Be sure to take countermeasures against electric noise by attaching surge protectors to relays for a machining center.

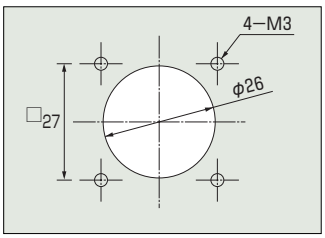
TPC5

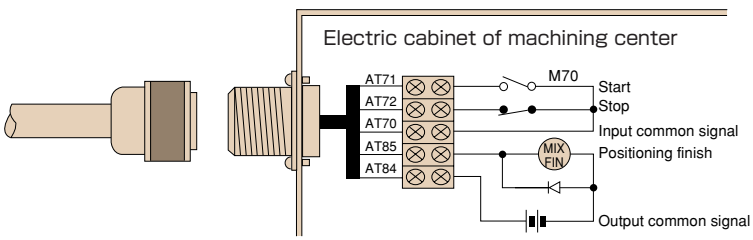
Interlocking cable(Standard length: 5m)



a) Standard interlock cable　For interlocking only with M-signal and the completion signal

Connector dimension
(To machining center)

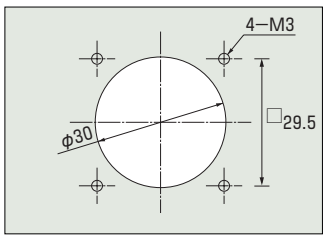


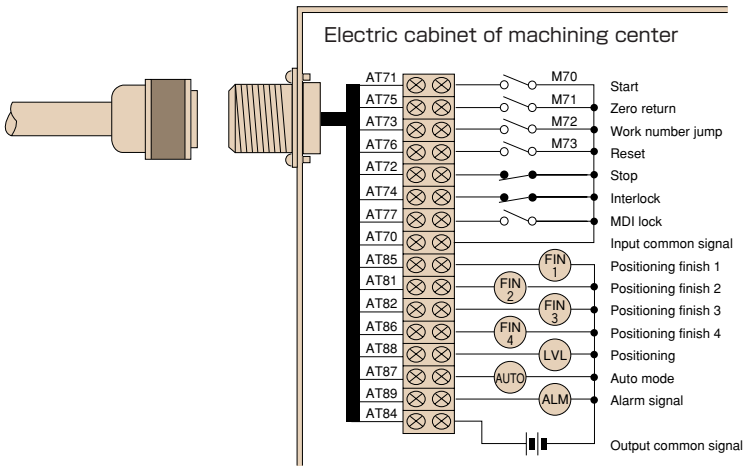


b) Fully-equipped interlocking cable (optional)

A variety of signals such as a stop or interlock input signal and a level or alarm output signal are available with this cable.
B signal cable is required when the setting functions for the workpiece number and angle data are used, or when the fixed indexing angle input system by an M-signal is used.
If you want to see some examples of the connections with this cable, please contact Tsudakoma.

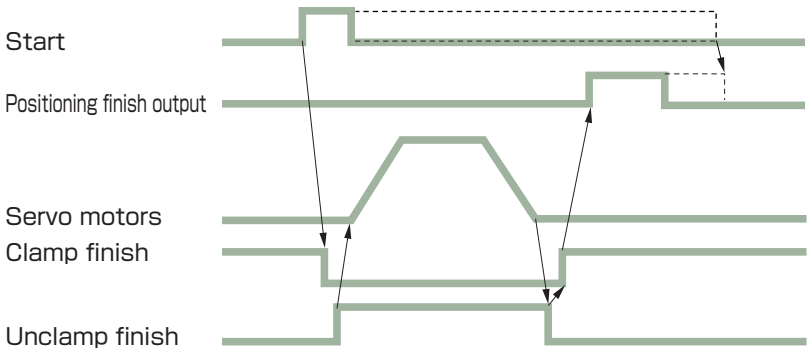
Connector dimension
(To machining center)





Note 1: When completion signals are received by a relay, the power supply should be 24VDC.Do not apply 100VAC or 200VAC.
Note 2: By changing the switch in the controller, a start signal is also available with the external power supply of DC24V.
Note 3: Be sure to take countermeasures against electric noise by attaching surge protectors to relays for a machining center.

Time Chart



Note 1: A start input signal, in the form of either a pulse signal (of more than 10 msec) or level signal, can be accepted.
Note 2: During the interlocking operation with a machining center carried out through an M-signal, the M-signal should be completed by the positioning completion signal.

TPC Standard Cable Specifications

The table below shows the maximum outer diameter and the curved radius of standard cables which are supplied with the rotary table ready for the TPC5 or TPC-Jr controller.

Unit: mm

	Cable	Order Code	Max. outer dia	Min. curved radius
TPC5	Motor power cable	NS#20 (SANKEI MANUFACTURING CO.,LTD.)	20	90
	Motor signal cable			
TPC-Jr	Motor cable	NS#25 (SANKEI MANUFACTURING CO.,LTD.)	25	100

Model number, maximum outer diameter and curved radius may differ depending on specifications.

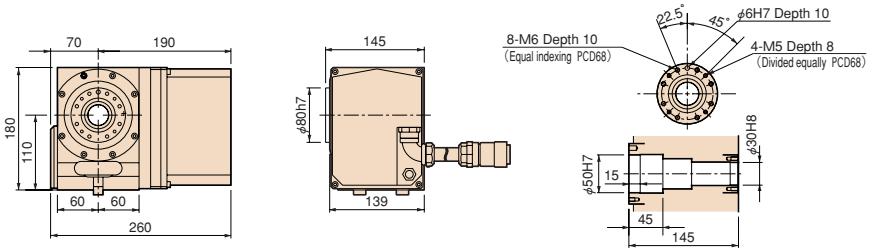
NC Rotary Tables／TPC-Jr Dimensions and Specifications

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

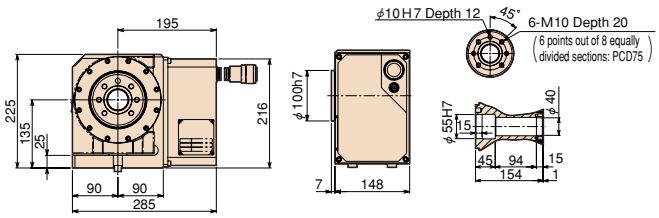
NC Rotary Tables／TPC-Jr

Unit: mm

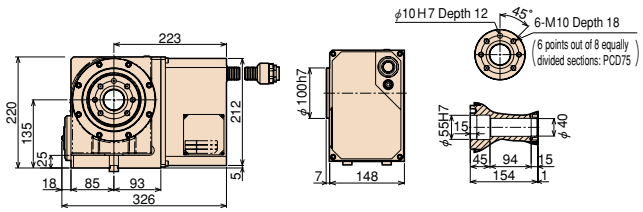
RN-100R／TPC-Jr H2



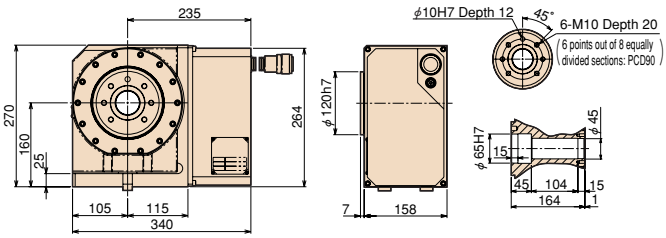
RNA-161R／TPC-Jr H2



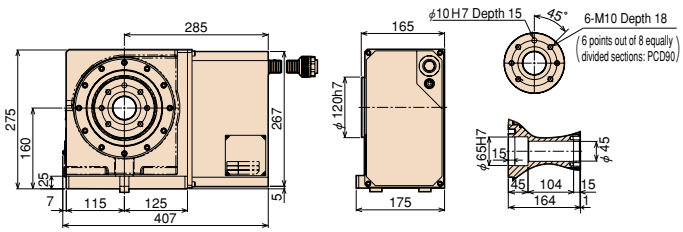
RNE-160R／TPC-Jr H2



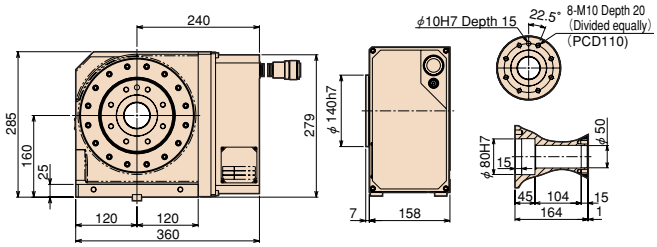
RNA-201R／TPC-Jr H3



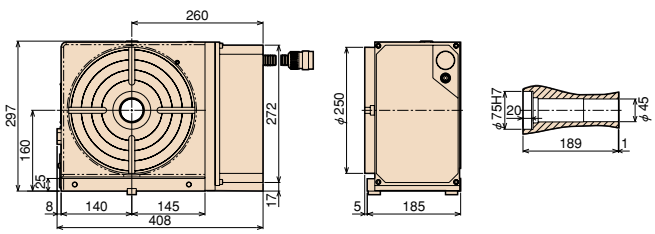
RNE-200R／TPC-Jr H3



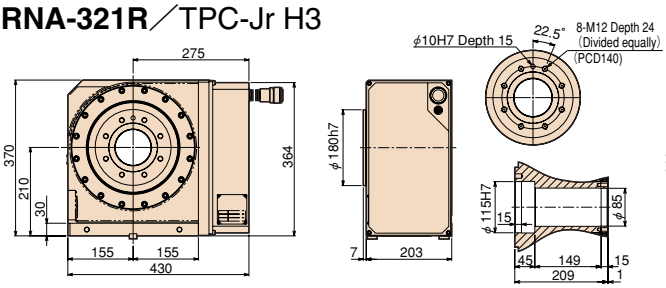
RNA-251R／TPC-Jr H3



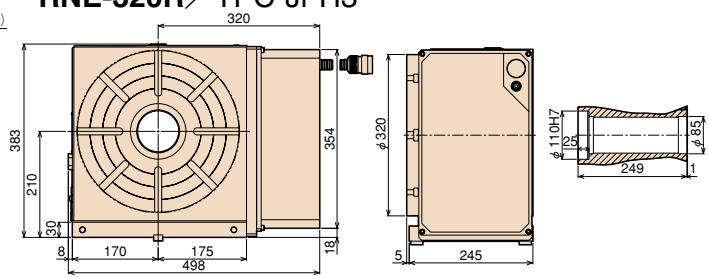
RNE-250R／TPC-Jr H3



RNA-321R／TPC-Jr H3



RNE-320R／TPC-Jr H3



NC Table Specifications (with TPC−Jr)

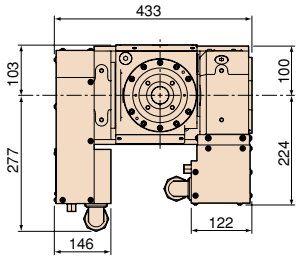
	RN-100	RNA-161	RNA-201	RNA-251	RNA-321	RNE-160	RNE-200	RNE-250	RNE-320	RN-100-2	RN-100-3	RN-100-4
TPC-Jr	H2	H2	H3	H3	H3	H2	H3	H3	H3	H3	H3	H3
Reduction ratio	1/36	1/72	1/72	1/120	1/180	1/90	1/90	1/180	1/240	1/36	1/60	1/60
Max. rpm min^{-1}	66.6/ Motor 2,400	41.6/ Motor 3,000	41.6/ Motor 3,000	25/ Motor 3,000	16.6/ Motor 3,000	33.3/ Motor 3,000	33.3/ Motor 3,000	11.1/ Motor 2,000	12.5/ Motor 3,000	55.5/ Motor 2,000	50/ Motor 3,000	50/ Motor 3,000

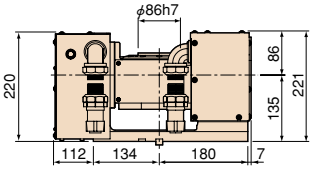
Note 1: Other specifications P.10 P.26
Note 2: Consult us before an eccentric load is applied to the table due to continuous cutting feed or jigs.

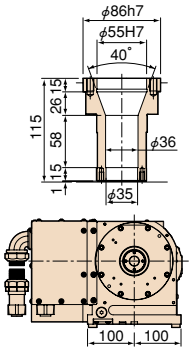
NC Tilting Rotary Table／TPC-Jr

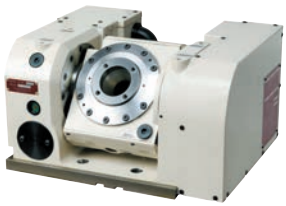
Unit: mm

TN-101／TPC-Jr H2

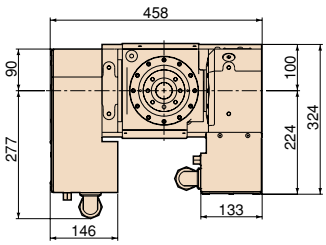


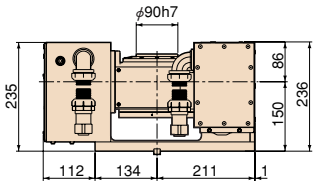


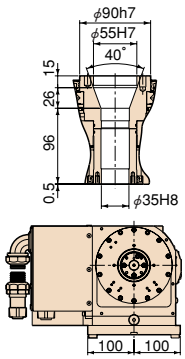




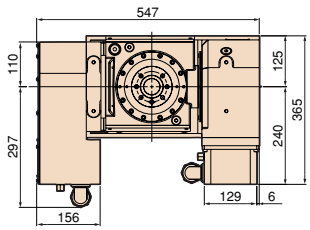
TN-131／TPC-Jr H2

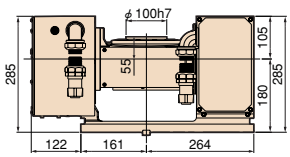


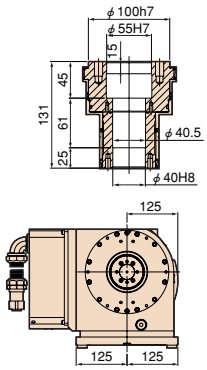


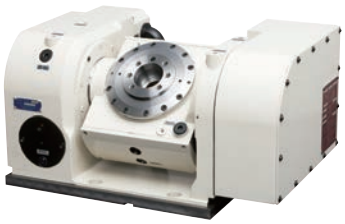


TN-161／TPC-Jr H2

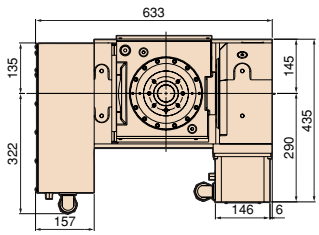


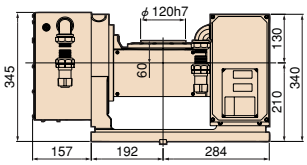


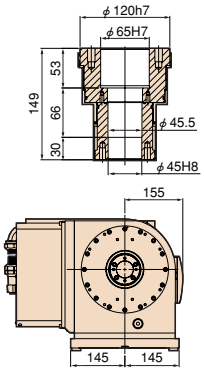


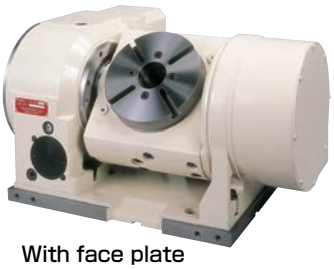


TN-201／TPC-Jr H3









With face plate
(Option)

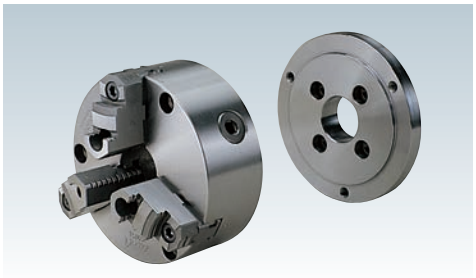
NC Tilting Table Specifications (with TPC−Jr)

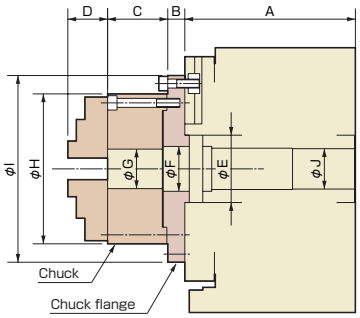
	TN-101		TN-131		TN-161		TN-201	
Control axis	Revolution	Tilt	Revolution	Tilt	Revolution	Tilt	Revolution	Tilt
TPC-Jr	H2		H2		H2		H3	
Reduction ratio	1/60	1/120	1/60	1/120	1/72	1/120	1/45	1/90
Max. rpm min^{-1}	41.6/Motor 2,500	16.6/Motor 2,000	41.6/Motor 2,500	16.6/Motor 2,000	41.6/Motor 3,000	16.6/Motor 2,000	44.4/Motor 2,000	22.2/Motor 2,000

Note 1: Other specifications P.30
Note 2: Consult us before an eccentric load is applied to the table due to continuous cutting feed or jigs.

Chuck

Scroll Chuck





Chuck size (inch)	Chuck type	Outer chucking range (mm)	Inner chucking range (mm)
4	TC110F	2～106	36～102
5	TC130F	3～130	42～123
6	TC165F	3～156	52～148
7	TC190F	3～184	56～174
9	TC230F	4～214	64～202
10	TC273F	10～246	72～230
12	TC310F	10～275	82～265
15	TC385F	15～345	100～327
18	TC460F	15～410	152～436

Note 1: The values in the table above are the dimensions with hardened jaws. (Soft jaws are optional.)
Note 2: Some workpieces, even in the chucking range, may not be chucked due to jaw configuration.

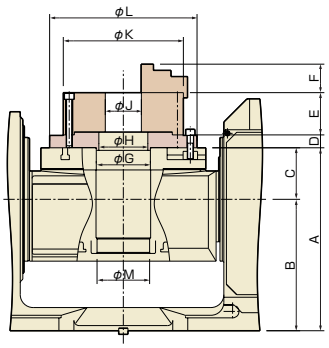
Unit: mm

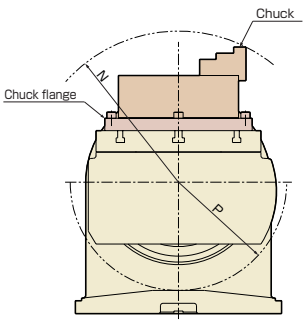
	Chuck size(inch)	A	B	C	D	E	F	G	H	I	J
RG-160	4	170	18	58	31.3	55	45	24	112	112	40
	5			60	37.3			32	132	132	
	6			66	44.3			44	167	167	
	7		18	75	46.3			54	192	192	
RG-250	5	180	18	60	37.3	80	65	32	132	132	50
	6		18	66	44.3			44	167	167	
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
RG-320	6	225	18	66	44.3	115	100	44	167	167	85
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
	10		25	86	53.3			100	274	274	
	12		25	92	59.3			110	310	310	
RN-100	4	145	10	58	31.3	50	50	24	112	112	30
	5			60	37.3			32	132	132	
RZ-161	5	155	18	60	37.3	55	45	32	132	132	40
	6			66	44.3			44	167	167	
	7			75	46.3			54	192	192	
RZ-201	6	175	18	66	44.3	65	55	44	167	167	45
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
RNA-161	4	155	18	58	31.3	55	45	24	112	112	40
	5			60	37.3			32	132	132	
	6			66	44.3			44	167	167	
	7			75	46.3			54	192	192	
RNA-201	5	165	18	60	37.3	65	55	32	132	132	45
	6		18	66	44.3			44	167	167	
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
RNA-251	5	165	18	60	37.3	80	65	32	132	132	50
	6		18	66	44.3			44	167	167	
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
RNA-321	6	210	18	66	44.3	115	100	44	167	167	85
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
	10		25	86	53.3			100	274	274	
	12		25	92	59.3			110	310	310	
RNE-160	4	155	18	58	31.3	55	45	24	112	112	40
	5			60	37.3			32	132	132	
	6			66	44.3			44	167	167	
	7			75	46.3			54	192	192	
RNE-200	5	165	18	60	37.3	60	55	32	132	132	45
	6		18	66	44.3			44	167	167	
	7		18	75	46.3			54	192	192	
	9		25	82	55.3			70	233	233	
RNE-250	5	190	18	60	37.3	75	65	32	132	168	45
	6		18	66	44.3			44	167	208	
	7		18	75	46.3			54	192	196	
	9		25	82	55.3			70	233	233	
RNE-320	6	250	18	66	44.3	110	100	44	167	216	82
	7		18	75	46.3			54	192	246	
	9		25	82	55.3			70	233	286	
	10		25	86	53.3			100	274	318	
	12		25	92	59.3			110	310	318	

Unit: mm

	Chuck size(inch)	A	B	C	D	E	F	G	H	I	J
RNCM-251	5	165	20	60	37.3	40	30	32	132	168	32
	6		20	66	44.3			44	167	167	
	7		20	75	46.3			54	192	198	
	9		25	82	55.3			70	233	233	
RNCM-301	6	220	20	66	44.3	40	30	44	167	208	40
	7		20	75	46.3			54	192	238	
	9		25	82	55.3			70	233	233	
	10		25	86	53.3			100	274	274	
	12		25	92	59.3			110	310	318	
RNCM-401	7	250	20	75	46.3	40	30	54	192	238	40
	9		25	82	55.3			70	233	233	
	10		25	86	53.3			100	274	274	
	12		25	92	59.3			110	310	318	
RNCM-501	9	300	25	82	55.3	50	40	70	233	288	50
	12			92	59.3			110	310	378	
RBA-250	6	180	18	66	44.3	95	65	44	167	208	71
	7		18	75	46.3		65	54	192	236	
	9		25	82	55.3		76	70	233	233	
RBA-320	6	240	18	66	44.3	130	101	44	167	216	101
	7		18	75	46.3			54	192	246	
	9		25	82	55.3			70	233	286	
	10		25	86	53.3			100	274	318	
	12		25	92	59.3			110	310	318	
RBA-400	7	275	20	75	46.3	190	151	54	192	286	151
	9		25	82	55.3			70	233	286	
	10		25	86	53.3			100	274	336	
	12		25	92	59.3			110	310	370	
	15		30	100	70.3			150	385	385	
RBA-500	9	325	25	82	55.3	220	170	70	233	356	182
	12		25	92	59.3		210	110	310	386	
	15		30	100	70.3		210	150	385	460	
	18		35	114	79.8		210	180	460	500	

Note 1: The above dimensions refer to power chucks by KOBAYASHI IRON WORKS CO., LTD. Note 2: The flange type and the method of attaching the flange fixing bolt differ depending on the rotary table and the chuck size.





Unit: mm

Order Code	Chuck size (inch)	A	B	C	D	E	F	G	H	J	K	L	M	N	P
TN-101	4	180	135	45	15	58	31.3	55	45	24	112	112	35	R164	R106
	5					60	37.3			32	132	132		R177	
TN-131	5	210	150	60	18	60	37.3	55	45	32	132	132	35	R193	R114
TN-161	4	235	180	55	18	58	31.3	55	45	24	112	112	40	R176	R135
	5					60	37.3			32	132	132		R189	
	6					66	44.3			44	167	167		R208	
	7					75	46.3			54	192	192		R226	
TN-201	5	270	210	60	18	60	37.3	65	55	32	132	132	45	R200	R148
	6					66	44.3			44	167	167		R219	
	7					75	46.3			54	192	192		R236	
	9				25	82	55.3			70	233	233		R258	
TN-320	6	355	255	100	18	66	44.3	105	95	44	167	256	102	R254	R210
	7					75	46.3			54	192	256		R271	
	9				25	82	55.3			70	233	286		R294	
	10					86	53.3			100	274	318		R303	
	12					92	59.3			110	310	318		R323	
TN-450	9	425	425	0	25	82	55.3	170	150	70	233	316	136	R213	R375
	10					86	53.3			100	274	336		R222	
	12					92	59.3			110	310	370		R244	
	15				30	100	70.3			150	385	445		R288	

Note 1: The above dimensions refer to power chucks by KOBAYASHI IRON WORKS CO., LTD.
Note 2: The flange type and the method of attaching the flange fixing bolt differ depending on the rotary table and the chuck size.

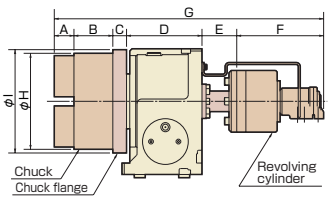
☞Example P.31

Chuck

Power chuck

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

Chuck size (inch)	Chuck type	Outer chucking range (mm)	Hydraulic cylinder type	Pneumatic cylinder type
4	H01MA 4	6 ~ 110	HH4C 63	H05CH100
5	H01MA 5	15 ~ 135	HH4C 63	H05CH150
6	H01MA 6	20 ~ 165	HH4C 80	H05CH200
8	H01MA 8	18 ~ 210	HH4C100	H05CH250
10	H01MA10	24 ~ 254	HH4C125	H05CH300



Example of pneumatic power chuck use

Hydraulic cylinder dimensions

Unit: mm

	Chuck size (inch)	A	B	C	D	E	F	G	H	I
RNCM-251	4	27	52	20	165	61	175	500	110	160
	5	27	52	20				500	135	185
	6	43	72	24				540	165	215
RNCM-301	6	43	72	24	220	36	175	570	165	225
	8		85	35		36	190	609	210	270
	10		95	35		39	197	629	254	315
RNCM-401	8	43	85	35	250	36	190	639	210	270
	10		95			39	197	659	254	315

☞Example P.17

Pneumatic cylinder dimensions

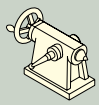
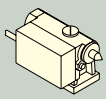
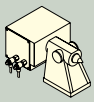
Unit: mm

	Chuck size (inch)	A	B	C	D	E	F	G	H	I
RG-160	4	27	52	18	170	50	182	484	110	–
	5	27	52			64	190	506	135	
	6	43	72			64	200	552	165	
RG-250	4	27	52	20	180	67	182	513	110	–
	5	27	52			64	190	518	135	
	6	43	72			64	200	564	165	
RG-320	6	43	72	24	225	76	200	625	165	–
	8		85	35			243	695	210	
	10		95	35			258	717	254	
RNA-161	4	27	52	18	155	50	182	484	110	–
	5	27	52			64	190	506	135	
	6	43	72			64	200	552	165	
RNA-201 RNA-251	4	27	52	20	165	67	182	513	110	–
	5	27	52			64	190	518	135	
	6	43	72			64	200	564	165	
RNA-321	6	43	72	24	210	76	200	625	165	–
	8		85	35			243	692	210	
	10		95	35			258	717	254	
RNE-160	4	27	52	18	155	50	182	484	110	–
	5	27	52			64	190	506	135	
	6	43	72			64	200	552	165	
RNE-200	4	27	52	20	165	67	182	513	110	–
	5	27	52			64	190	518	135	
	6	43	72			64	200	564	165	
RNE-250	4	27	52	20	190	67	182	513	110	–
	5	27	52			64	190	518	135	
	6	43	72			64	200	564	165	
RNE-320	6	43	72	24	250	76	200	625	165	–
	8		85	35			243	695	210	
	10		95	35			258	717	254	
RNCM-251	4	27	52	20	165	67	182	513	110	160
	5	27	52	20		64	190	518	135	185
	6	43	72	24		64	200	568	165	215
RNCM-301	6	43	72	24	220	34	200	593	165	225
	8		85	35		39	243	665	210	270
	10		95	35		44	258	695	254	315
RNCM-401	8	43	85	35	250	39	243	695	210	270
	10		95			44	258	725	254	315

Note: The above dimensions refer to power chucks by HOWA MACHINERY, LTD. A front-mounting pneumatic chuck is also available.

Tailstock

Compatible Rotary Tables

NC Rotary Table \ Tailstock type	Manual	Hydraulic	Pneumatic
			
RN-100	TL-110M	—	—
RNA-161, RNE-160 RZ-161	TL-135M	TLH-135	TLP-135
RG-160 RNA-201, 251 RNE-200, 250 RNCM-251 RBA-250, RZ-201	TL-160M	TLH-160	TLP-160
RG-250 RNA-321, RNE-320 RNCM-301 RBA-320, RBA-320K	TL-210M	TLH-210	—
RG-320 RNCM-401 RBA-400K	TL-255M	TLH-255	—
RNCM-501	TL-310M	—	—
RNCM, RNCK-631	TL-400M	—	—
RCV-800	TL-530M	—	—
THNC-251	TL-210M	TLH-210	—
THNC-301	TL-235M	—	—

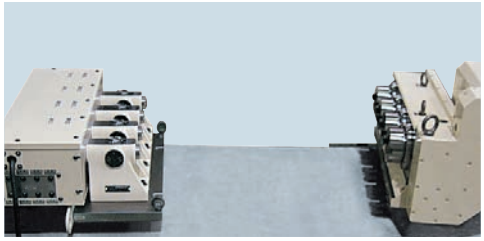
Order Code

T L □ - 1 6 0 M

Center height

Alphabet	Type
なし	Manual
H	Hydraulic
P	Pneumatic

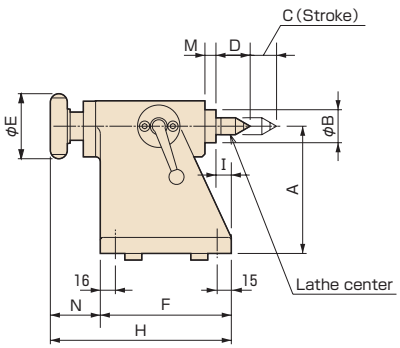
Example of use

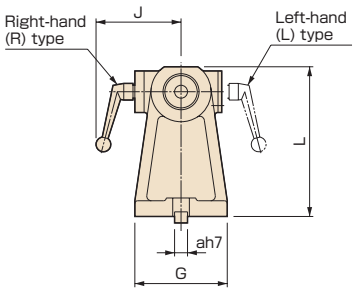


Manual Tailstock

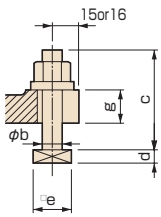
TL-110M,135M

TL-135M



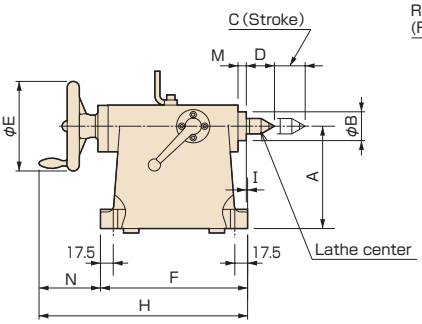


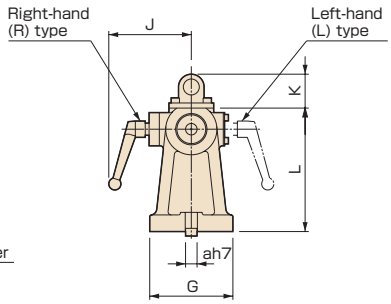
Clamping bolt



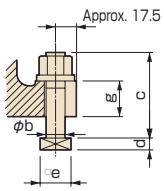
TL-□□□M

TL-160M





Clamping bolt



Tailstock

Dimensions

Unit: mm

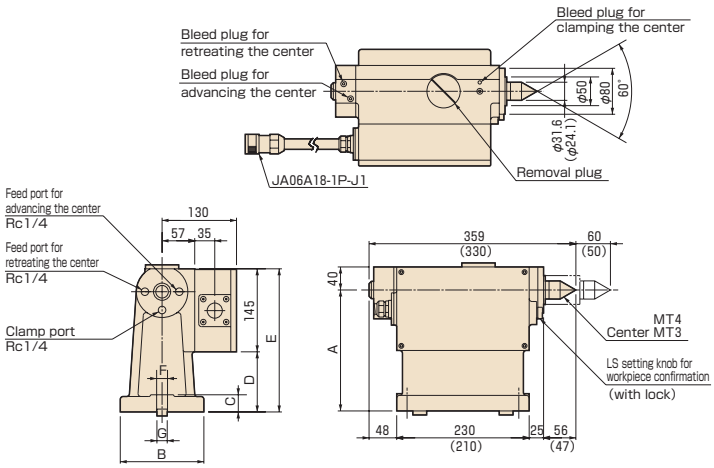
Order Code	Morse taper	Center height A	Center dia B	Stroke C	Lathe center D	Handle dia E	Base dimensions F×G	H	I	J	K	L	M	N	a	b	c	d	e	g	Weight kg
TL-110M	MT2	110	35	28	36	69	139×100	192	16	92	–	137	12	53	14	12	55	8	23	20	8
TL-135M	MT2	135	35	28	36	69	139×100	192	16	92	–	162	12	53	14	12	55	8	23	20	9
TL-160M	MT3	160	45	48	44	140	230×130	326	2	129	53	193	13	96	18	16	75	11	28	30	22
TL-190M	MT3	190	45	48	44	140	230×140	326	2	129	53	223	13	96	18	16	75	11	28	30	24
TL-210M	MT3	210	45	48	44	140	230×146	326	2	129	53	243	13	96	18	16	75	11	28	30	26
TL-235M	MT4	235	50	53	52.5	160	270×160	383	12	131	53	270	8	113	18	16	80	11	28	35	30
TL-255M	MT4	255	50	53	52.5	160	270×170	383	12	131	53	290	8	113	18	16	80	11	28	35	38
TL-310M	MT4	310	60	53	52.5	180	315×220	417	15	154	65	350	10	102	18	16	85	11	28	40	63
TL-400M	MT4	400	60	53	52.5	180	315×240	417	15	154	65	440	10	102	18	16	85	11	28	40	76
TL-530M	MT4	530	80	68	52.5	225	410×290	532	30	164	65	590	5	122	22	20	95	13	32	40	138

Example of use

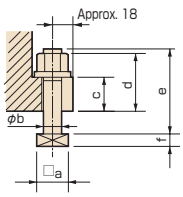
Hydraulic Tailstock

TLH-□□□

TLH-160



Clamping bolt



Note 1: Dimensions in parentheses are for the TLH-135.
Note 2: Specify the cable length when placing an order.

Dimensions and specifications

Unit: mm

Order Code	A	B	C	D	E	F	Carbide center	Hydraulic MPa[kgf/cm²]	Center thrust force N 【kgf】	Center clamp torque 【kgf】	Weight kg
TLH-135	135	110	25	30	175	19	MT3	1.5~6.8 【15~70】	1,670 【170】	2,450 【250】	28
TLH-160	160	130	30	55	200	19	MT4		2,352 【240】		33
TLH-210	210	146	30	105	250	19	MT4		2,352 【240】		36
TLH-255	255	170	35	150	295	19	MT4		2,352 【240】		40

＊The table above shows the center thrust force and clamp torque when the hydraulic pressure is 3.5MPa (35kgf/cm²).

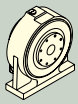
Clamping bolt dimensions

Unit: mm

Order Code	G	a	b	d	e	f
TLH-135	14	23	12	42	60	8
	16	26	16	46	70	10
	18	28	16	46	70	11
TLH-160 TLH-210	14	23	12	47	65	8
	16	26	16	51	75	10
	18	28	16	51	75	11
TLH-255	16	26	16	56	75	10
	18	28	16	56	80	11
	20	32	18	60	90	11

Support Spindle

Compatible Rotary Tables

Support spindle type / NC Rotary Table	No clamp	Pneumatic clamp	Hydraulic clamp
			
RNA-161, RNE-160 RZ-161	TS-135	TS-135P	—
RG-160 RNA-201, 251 RNE-200, 250 RNCM-251 RBA-250, RZ-201	TS-160	TS-160P	TSH-160
RG-250 RNA-321, RNE-320 RNCM-301 RBA-320, RBA-320K	TS-210	TS-210P	TSH-210
THNC-251	—	—	TSH-210

Order Code

T S H - 1 6 0 P

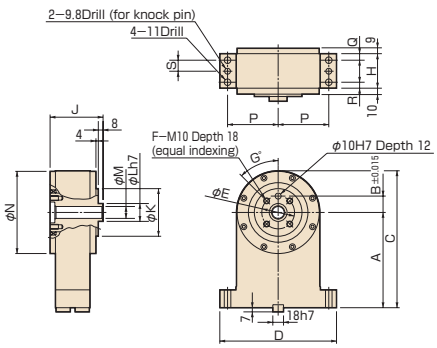
Center height

Alphabet	Clamp
No	No clamp, Pneumatic pressure
H	Hydraulic

Alphabet	Clamp
No	No
P	Pneumatic

TS-□□□ (No clamp)

TS-135



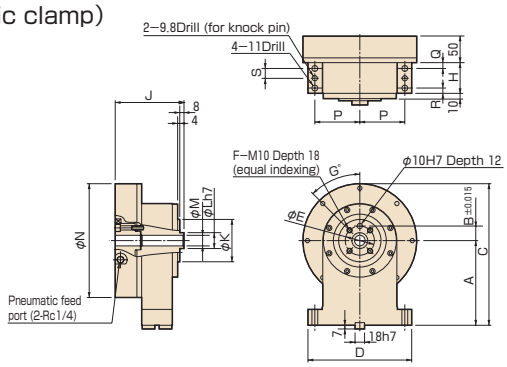
Example of use

Unit: mm

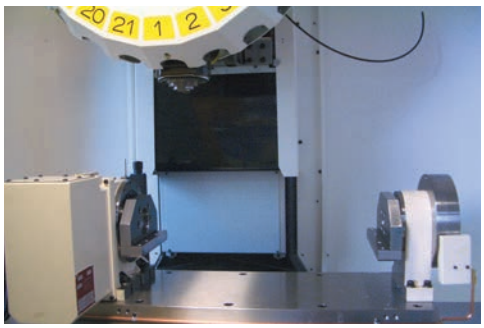
Order Code	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R	S	Weight kg
TS-135	135	27.5	205	196	55	4	45	58	89	80	30	20	138	85	11	10	18.5	13
TS-160	160	27.5	230	196	55	4	45	58	89	80	30	20	138	85	11	10	18.5	15
TS-210	210	37.5	295	226	75	6	30	67	101	100	50	40	168	100	11	11	22.5	29

TS-□□□P (Pneumatic clamp)

TS-160P



Example of use



Unit: mm

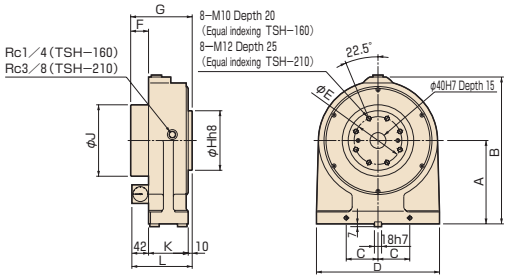
Order Code	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R	S	Clamping Torque (N·m) (0.49MPa)	Weight kg
TS-135P	135	27.5	218.5	196	55	4	45	58	130	80	30	20	167	85	11	10	18.5	156.9	20
TS-160P	160	27.5	267.5	196	55	4	45	58	130	80	30	20	215	85	11	10	18.5	383.7	27
TS-210P	210	37.5	337.5	226	75	6	30	67	141	100	50	40	255	100	11	11	22.5	779.1	45

Support Spindle

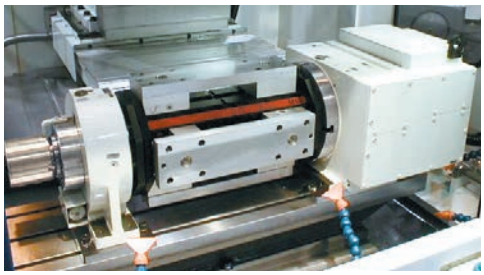
RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

TSH-□□□ (Hydraulic clamp)

TSH-160



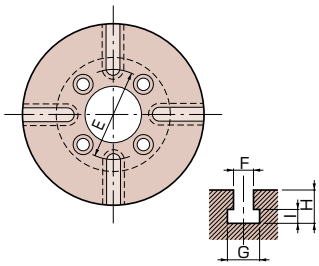
Example of use

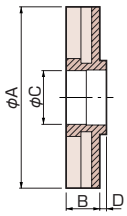


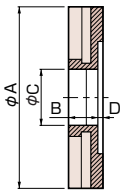
Unit: mm

Order Code	A	B	C	D	E	F	G	H	J	K	L	Clamping Torque (N·m) (3.5MPa)	Weight kg
TSH-160	160	290	70	260	110	42	142	130	150	90	142	490	45
TSH-210	210	370	77	310	120	45	155	150	180	100	152	833	75

Face Plate







For RN-100
TN-161, TN-201
TND-160, TND-200

Unit: mm

	A Face plate diameter	B	C	D	E	F	G	H	I
RN-100	135	25	φ50H7	5	φ68	10H8	16^{+2}_{0}	17	7^{+1}_{0}
RG-160 RNA-161	160 200	30	φ50H7	3	φ75	12H8	19^{+2}_{0}	19	8^{+1}_{0}
RNA-201	200 250	30	φ60H7	3	φ90	12H8	19^{+2}_{0}	19	8^{+1}_{0}
RG-250 RNA-251	250	30	φ75H7	5	φ110	12H8	19^{+2}_{0}	19	8^{+1}_{0}
RG-320 RNA-321	320	40	φ110H7	5	φ140	14H8	23^{+2}_{0}	23	9^{+1}_{0}
RNE-160	160 200	30	φ50H7	3	φ75	12H8	19^{+2}_{0}	19	8^{+1}_{0}
RNE-200	200 250	30	φ50H7	3	φ90	12H8	19^{+2}_{0}	19	8^{+1}_{0}
RZ-161	160 200	30	φ50H7	5	φ75	12H8	19^{+2}_{0}	19	8^{+1}_{0}
RZ-201	200 250	30	φ60H7	3	φ90	12H8	19^{+2}_{0}	19	8^{+1}_{0}
TN-101	135	25	φ40H7	5	φ70	12H8	19^{+2}_{0}	19	8^{+1}_{0}
TN-131	135	25	φ40H7	5	φ70	12H8	19^{+2}_{0}	19	8^{+1}_{0}
TN-161	160 200	25	φ50H7	5	φ75	12H8	19^{+2}_{0}	19	8^{+1}_{0}
TN-201	200 250	30	φ60H7	5	φ90	12H8	19^{+2}_{0}	19	8^{+1}_{0}

Example of use

High-precision Specification by Rotary Encoders or MP Scales

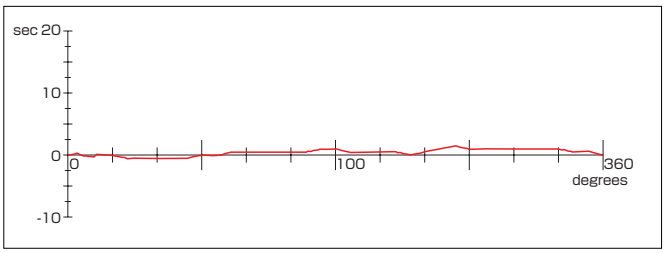
Indexing accuracy can be upgraded by attaching a rotary encoder or MP scale to the spindle of the rotary table. The sum of the cumulative indexing accuracy of the rotary encoder or the MP scale and electrically divided errors of the pre-amplifier or the waveform shaping unit is referred to as the indexing accuracy of the rotary tables with scales. The indexing accuracy is guaranteed by TSUDAKOMA.

Model Description

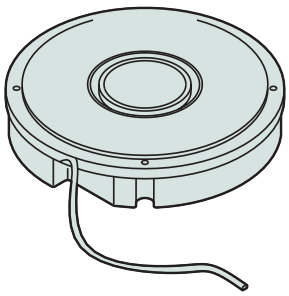
"RNCM-□□□R,□□"

- **RE** (Rotary encoders)
- **RI** (MP scales)

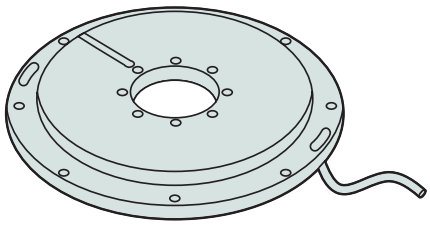
Example of measurement indexing accuracy with scale



Rotary encoder



MP scale



Indexing accuracy with scale

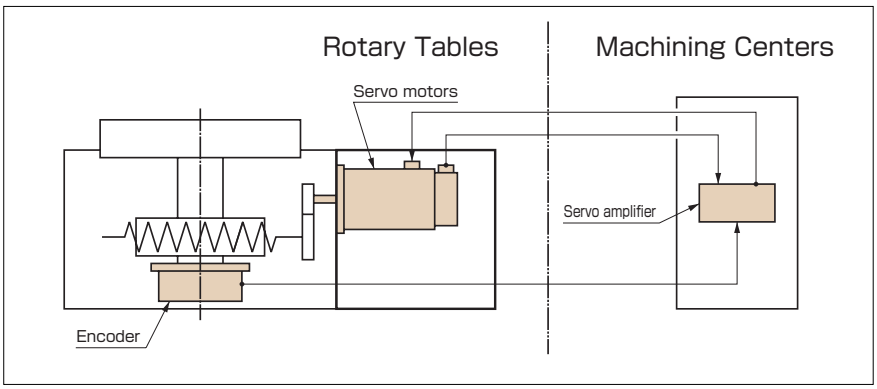
		Rotary encoders		MP scales	
		Order Code	Accuracy with scale	Order Code	Accuracy with scale
RG-160 RNA-161 RNA-201	Rotary axis	RCN23*0 or RU77-4096A	15sec	MPI 536A	15sec
RG-250, 320 RNA-251 RNA-321	Rotary axis	RCN83*0, RCN85*0 or RS97-1024	10sec／RCN83*0, RS97-1024 6sec／RCN85*0	MPI 736B	10sec
RNCM-251, 301 RBA-250, RBA-250K	Rotary axis	RCN83*0, RCN85*0 or RS97-1024	10sec／RCN83*0, RS97-1024 6sec／RCN85*0	MPI 736B	10sec
RBA-320, RBA-320K	Rotary axis			MPI 1072B	8sec
RBA-400, RBA-400K RBA-500, RBA-500K RNCM-401～631 RNCK-631 RNCV-801～1501	Rotary axis			MPI 1272B	8sec
TN-131	Rotary axis Tilt axis	RCN23*0 or RU77-4096A	15sec	MPI 536A	15sec
TN-161	Rotary axis Tilt axis				
TN-201	Rotary axis Tilt axis				
TN-320	Rotary axis Tilt axis	RCN83*0, RCN85*0 or RS97-1024	10sec／RCN83*0, RS97-1024 6sec／RCN85*0	MPI 736B MPI 1072B	10sec 10sec
TN-450	Rotary axis Tilt axis			MPI 1272B	8sec
TTNC-631	Rotary axis Tilt axis	RCN83*0, RCN85*0 or RS97-1024	10sec／RCN83*0, RS97-1024 6sec／RCN85*0	MPI 736B MPI 736B	10sec 15sec
TTNC-1001	Rotary axis Tilt axis			MPI 1272B MPI 1272B	8sec 15sec

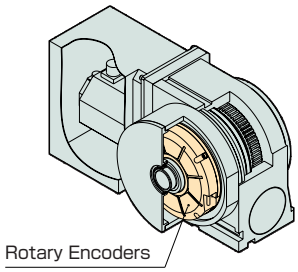
☞For other accuracy standard. P.75～

Accuracy differs depending on the specifications of the tables. Ask us for further information.

High-precision Specification by Rotary Encoders or MP Scales

■Specifications of rotary encoders (by HEIDENHAIN)





Heidenhain

Rotary Encoders	RON886	RCN23*0	RCN83*0	RCN85*0
Interface unit	IBV102	Not required	Not required	Not required
Recommended resolution	0.0005°	26bit ABS	29bit ABS	29bit ABS

■ Model RCN and corresponding Interface

RCN 23 △ 0 □

Interface	△	□
FANUC	9	F
MITSUBISHI ELECTRIC	9	M
EnDat 2.2	1	—

Magnescale

Rotary Encoders	RU77-4096A	RS97-1024
Recommended resolution	23bit ABS	23bit ABS

■ Model RU77 and corresponding Interface

RU77-4096A ☆ G

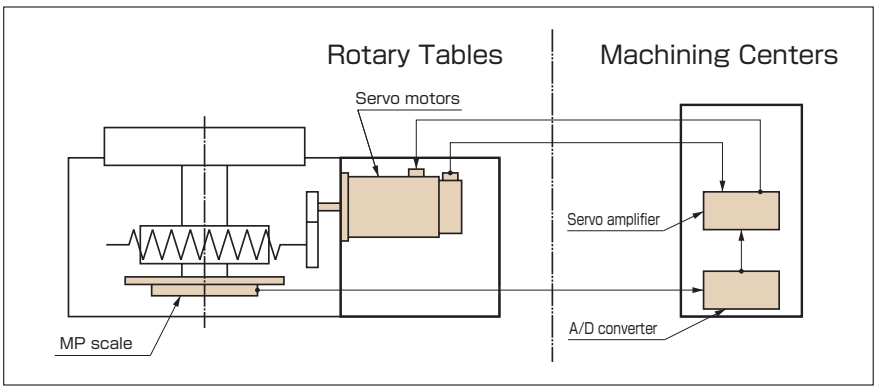
Interface	☆
FANUC	A
MITSUBISHI ELECTRIC	D
YASKAWA ELECTRIC	F

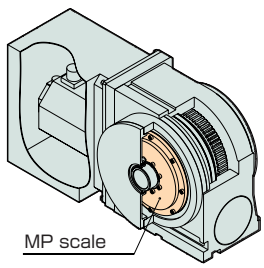
■ Model RS97 and corresponding Interface

RS97-1024EG ★

Interface	★
FANUC	A
MITSUBISHI ELECTRIC	D

■Specifications of MP scales (by Mitsubishi Heavy Industries)





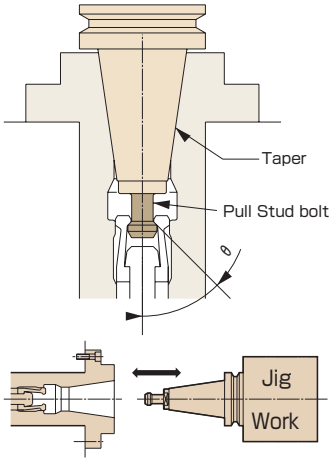
MP scale	MPI 536A	MPI 736B	MPI 1072B	MPI 1272B
Recommended resolution	0.0001°	0.0001°	0.00005°	0.00005°
A/D converter	ADB-20J10			

Note 1: AD converter (corresponding to the serial output interface) is necessary in the MPRZ series.
Note 2: Preamplifiers are necessary for MPR-series.
Note 3: When using preamplifiers for MPR-series other than those of MHI Machine Tool Engineering, consult us.

Pull Stud

A unit to position and fix a fixture and a workpiece on the rotary table, by using the taper shank with a pull stud. This unit can be combined with a robot or a work loader to create an unmanned machining system.


RBA-320R



Applicable models and specifications

Unit: mm

Order Code	Taper shank	Pull stud clamp force N [kgf]	Hydraulic pressure MPa [kgf/cm²]	Pneumatic pressure for air blow MPa [kgf/cm²]
RBA-250	BT-50	11,000 【1,122】	3.5 【35】	0.2~0.4 【2~4】
RBA-250K				
TN-201				
TN-320				
RBA-320	BT-50	15,000 【1,530】	3.5 【35】	0.2~0.4 【2~4】
RBA-320K				
RBA-400				
RBA-400K				
RBA-500				
RBA-500K				

Specify the pull stud type.

Taper	Pull stud type	
BT-50	θ	
	45°	I
	60°	II
	90°	Others

*With clamp/unclamp confirmation switch

Rotary Joint

A rotary joint unit to supply hydraulic or pneumatic pressure to workpieces or actuators mounted on rotary tables. Automatic loading and unloading of workpieces are possible.

Applicable models and specifications

Unit: mm

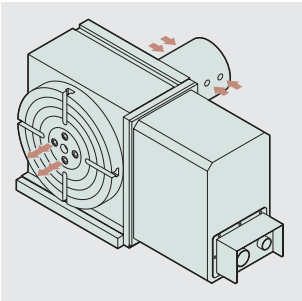
Order Code	Size	Max. number of ports	Rated supplied pressure MPa [kgf/cm²]
RG RNA RNE	161	6	3.5 【35】
	201	6	
	251	6	
	321	8	
RNCM	251	6	
	301	6	
	401	6	
	501	8	
RBA	250	8	
	320	8	
	400	8	
	500	8	
RNCK	631	12	

External mount type


RNCM-251R

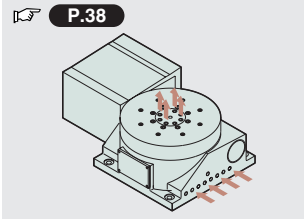
Internal mount type


RBA-320K

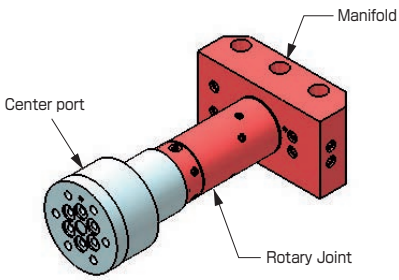


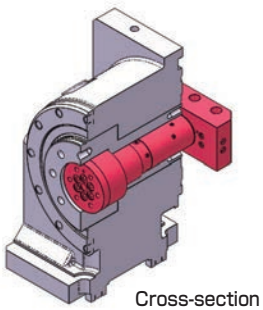
A rotary table of the **RC** series, equipped with 8 port rotary joints as standard features can be used as well.

☞ P.38



■Compact Rotary Joint




Cross-section

【仕様】

Max. number of ports : 6 port

Rated supplied pressure : 21.0MPa〔210kgf/cm²〕

【対象機種】

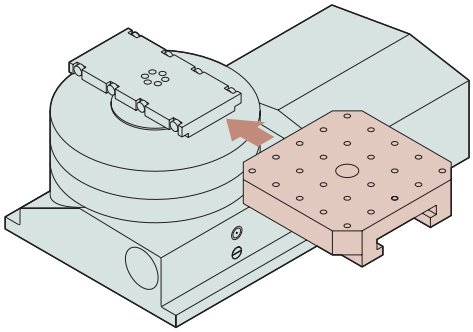
Correspond to the models which have more than ϕ40 center through hole.

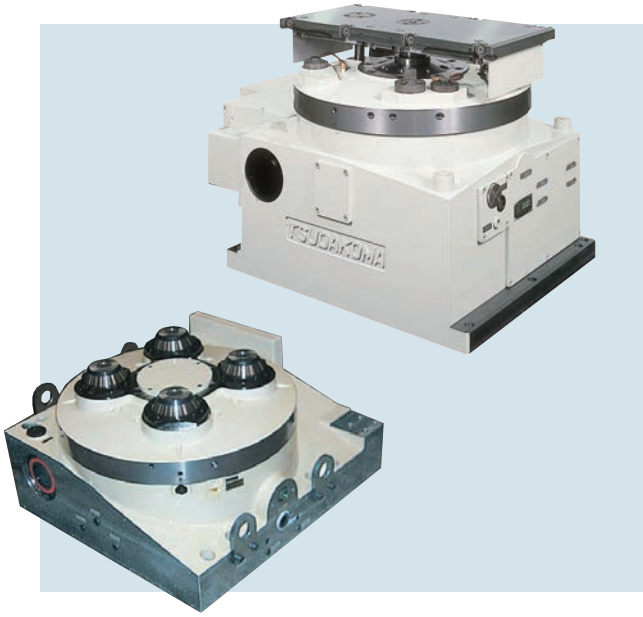
RG, RNA, RNE Series.

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

Pallet Clamp

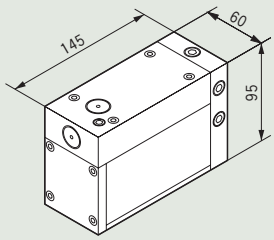
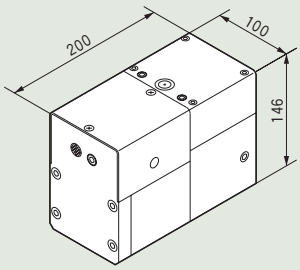
An NC rotary table with a built-in pallet clamp is available. This type of rotary table enables fast and highly accurate positioning of workpieces at any angle. Attachment of an auto-coupler makes it possible to apply hydraulic or pneumatic pressure to the top surface of pallets. By combining with a pallet-changer, setup, transfer and exchange can be carried out automatically.





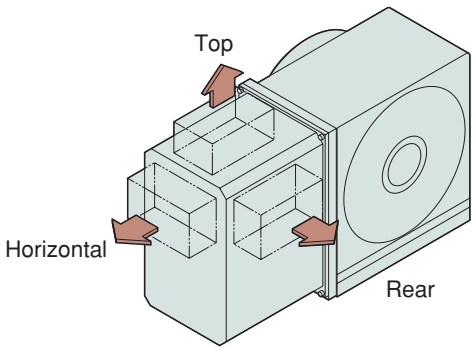
Air-hydraulic Booster

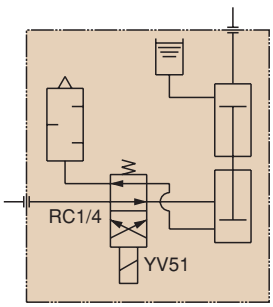
Tsudakoma's NC rotary tables are equipped with a high-power hydraulic clamp system (excluding RNA-series models, etc.). Air-hydraulic boosters are available for machines without a hydraulic source, which convert pneumatic pressure into hydraulic pressure for clamping.

Type	Applicable model	Dimensions
A (Small type)	RNCM-251	
B (Large type)	300 or more sizes	

Note: Different types of pneumatic-hydraulic boosters are used for the RBA series. ☞ P.5

■Mounting position





Please specify the following items:

1. Mounting position of the Air-hydraulic booster
2. Control voltage for the solenoid of the Air-hydraulic unit: AC100V or DC24V
   (This voltage depends on the machine to be attached)

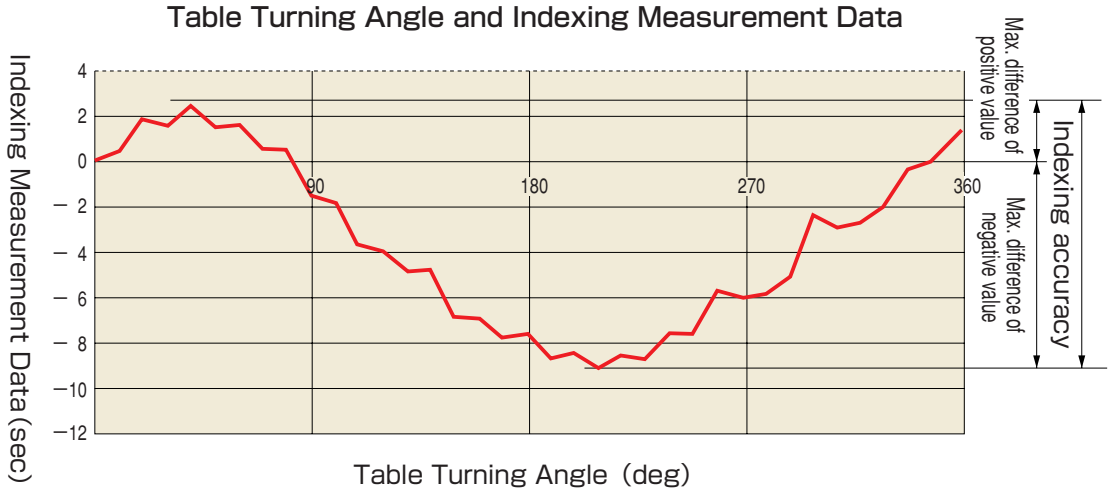
Explanation of Technical Terms

In order to help you understand Tsudakoma's products, here are some explanations about the main specifications.

Indexing Accuracy

After indexing one rotation of the table equally according to the tooth number of the worm gear, obtain the difference between the theoretical turning angle and the measured angle. The indexing accuracy is the sum of the maximum difference in positive values and that in negative values (absolute values).

Table Turning Angle and Indexing Measurement Data



Repeatability

Indexing at four specified angles (0, 90, 180 and 270 degrees) is carried out five times for clockwise rotation to measure the indexing angle. Then, the difference between the minimum and maximum values measured at each angular position is obtained. Carry out indexing for counterclockwise rotation in the same manner as the above, and obtain the difference between the minimum and maximum values measured at each angular position. The maximum value of the difference obtained through both measurements is the repeatability of the table.

Clamp Torque

Clamp torque is only the force of the clamping mechanism, which does not include force caused by self-locking of a worm gear. The clamp torque shown in the catalog is the figure obtained when the rated pressure (3.5 MPa for hydraulic pressure, and 0.49 MPa for pneumatic pressure) is supplied to the working fluid. When a larger clamp torque is required, increase the pressure gradually up to the maximum allowable pressure (4.9 MPa for hydraulic pressure, 0.69 MPa for pneumatic pressure) to increase the clamp torque.

Worm Gear Strength

Worm gear strength is the allowable wheel torque when table rpm is 1 min^{-1}. The allowable torque for the worm wheel is calculated according to the standards stipulated by the Japan Gear Manufactures Association.

Applicable Servo Motors

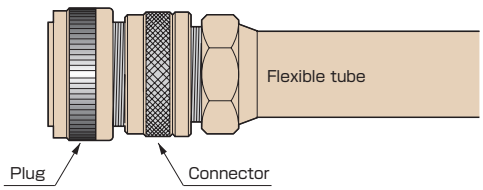
FANUC αi type servo motors are specified for each NC table model in the specifications table. The table below shows other servo motors, which have equivalent capacity to those of FANUC αi motors.

FANUC	αiF2／5000 (αiS2／5000)	αiF4／5000 (αiS4／5000)	αiF8／3000 (αiS8／4000)	αiF12／4000 (αiS12／4000)	αiF22／3000 (αiS22／4000)
MITSUBISHI	HF75T	HF54T	HF104T	HF204S	HF354S
YASKAWA	SGMPS-04	SGMGV-05	SGMGV-09	SGMGV-20	SGMGV-30
OKUMA	BL-ME24J	BL-ME40J	BL-ME80J	BL-ME150J	BL-ME200J
SIEMENS	1FK7042	1FK7060	1FK7063	1FK7083	1FK7101
HEIDENHAIN	QSY96A	QSY116C	QSY116E	QSY155B	QSY155D

Note 1: Some motors have speed reduction ratio (max rpm) or outline dimensions different from those of FANUC motors.
Note 2: The motors shown above are classified according to motor torque capacity. The motor which is suitable for your machines depends on the specifications of your machine NC controllers. Consult the machine manufacturer about motor selection.

Applicable Cable Connectors

All cable plugs and connectors for Tsudakoma's NC rotary tables should be waterproof. Refer to the table below.



Example of cable plug connectors

	Rotary table receptacle	Cable plug	Connector	Flexible tube
For signal cable	N／MS3102A20-29PW (Japan Aviation Electronics Industry, Ltd.)	JA06A20-29SW-J1-R (Japan Aviation Electronics Industry, Ltd.)	KMKD22-20 (SANKEI MANUFACTURING CO.,LTD) MSA22-20 (DAIWA DENGYO CO.,LTD)	KPF-22 (SANKEI MANUFACTURING CO.,LTD) FCV-22 (DAIWA DENGYO CO.,LTD)
	N／MS3102A22-14 (Japan Aviation Electronics Industry, Ltd.)	JA06A22-14S-J1-R (Japan Aviation Electronics Industry, Ltd.)	KMKD22-22 (SANKEI MANUFACTURING CO.,LTD) MSA22-22 (DAIWA DENGYO CO.,LTD)	
For power cable	N／MS3102A28-11P (Japan Aviation Electronics Industry, Ltd.)	JA06A28-11S-J1-R (Japan Aviation Electronics Industry, Ltd.)	KMKD28-28 (SANKEI MANUFACTURING CO.,LTD) MSA28-28 (DAIWA DENGYO CO.,LTD)	FCV-28 (DAIWA DENGYO CO.,LTD)

CE Example of cable plug connectors (with a FANUC αiF motor) P.80

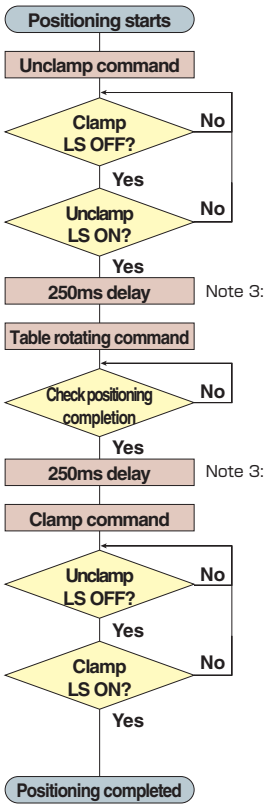
	Rotary table receptacle	Cable plug	Connector	Flexible tube
For signal cable	N／MS3102A20-29PW (Japan Aviation Electronics Industry, Ltd.)	JA06A20-29SW-J1-R (Japan Aviation Electronics Industry, Ltd.)	NBKD-20-20 (SANKEI MANUFACTURING CO.,LTD)	NSBS#20 (SANKEI MANUFACTURING CO.,LTD)
For power cable	JL04V-2A28-11PE-R (Japan Aviation Electronics Industry, Ltd.)	JL04V-6A28-11SE-R (Japan Aviation Electronics Industry, Ltd.)	NBKD-32-28 (SANKEI MANUFACTURING CO.,LTD)	NSBS#32 (SANKEI MANUFACTURING CO.,LTD)

Note: JA064□□ plug is waterproof when the plug is inserted.

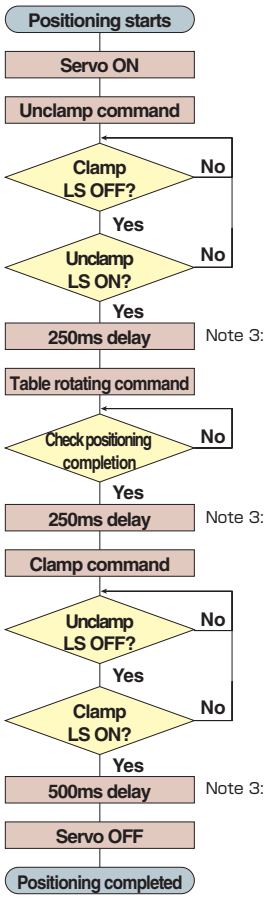
Flow Chart of Control System

It is recommended to control Tsudakoma's NC rotary table with the servo motor ON. The following are recommended flow charts.

a) Semi-closed loop control



b) Fully-closed loop control



Note 1: In a semi-closed loop control operation, do not turn the Servo motor OFF even when the rotary table is clamped.
Note 2: In a semi-closed operation, when the eccentric load increases in size, and a large current (70% or more of the rated current) is being applied, turn the Servo motor OFF and follow the steps for the full-closed loop control.
Note 3: Delay time is our recommended time. Parameters may differ depending on the specifications. Ask us for further information.

Indexing Cycle Time

The graphs below show the required indexing time which includes the time for the control command for the machine tools. This information helps you examine the cycle time of your process with the rotary table. Table rotation speed and acceleration and deceleration constants may differ depending on the model of the rotary table. If any data other than that shown below is required, please ask us.

A : Without clamp command
B : For hydraulic clamp (0.4Sec)
C : For pneumatic clamp (0.6Sec)
D : For air-hydraulic clamp (1.0Sec)

※( ) shows Clamp & Un-clamp reguired time

Table rpm 8000deg/min (22.2min^{-1})
Acceleration/deceleration constant:150ms

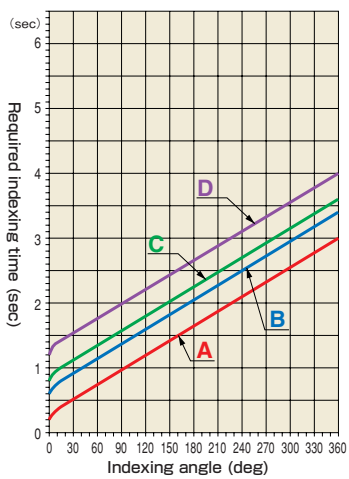
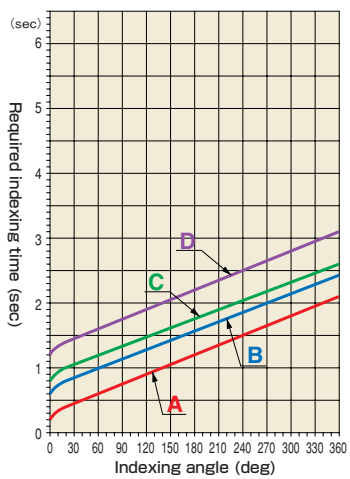
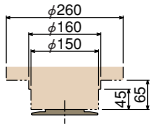
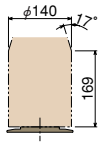
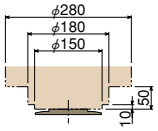
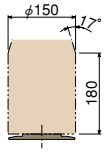
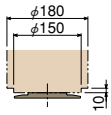
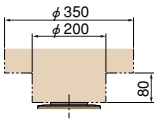
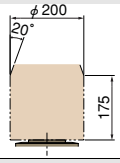
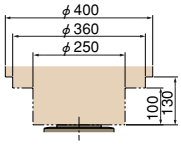
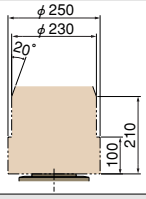
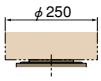
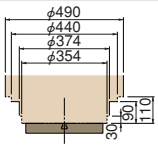
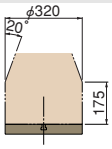
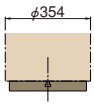
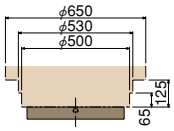
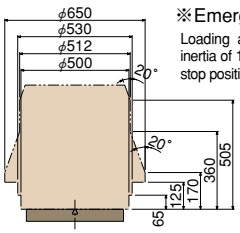


Table rpm 12000deg/min (33.3min^{-1})
Acceleration/deceleration constant:150ms



Note: For the above B and C cases, the indexing time includes the time to respond to the clamp and unclamp confirmation signals.

Workpiece mounting space for tilting rotary table

TN-101	0~+90° 	0~+107° 	−17°~0 
TN-131	0~+90° 	0~+107° 	−17°~0 
TN-161	0~+90° 	0~+110° 	−30°~0 
TN-201	0~+90° 	0~+110° 	−30°~0 
TN-320	0~+90° 	0~+110° 	−30°~0 
TN-450	−10°~+95° 	−15°~+100°  ※Emergency stop angle Loading area is set taking the inertia of 10° from the emergency stop position into consideration.	

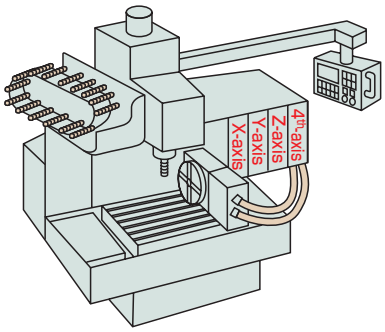
Note 1: If the tilting angle is over the above range or the table stops by emergency stop, check the unit.
Note 2: Be sure to remove the eye bolts used for lifting before using the rotary table.

To make the best use of TSUDAKOMA NC rotary table

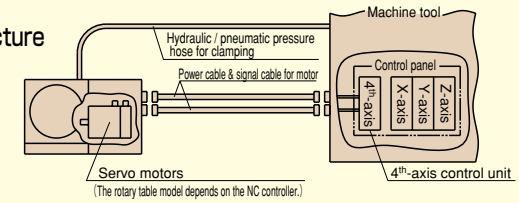
1 First of all, determine the NC controller system that best controls the NC rotary table.

NC control system 1

A control unit for the 4th axis (or 5th axis) should be installed in the NC controller of the machine tool.



Structure

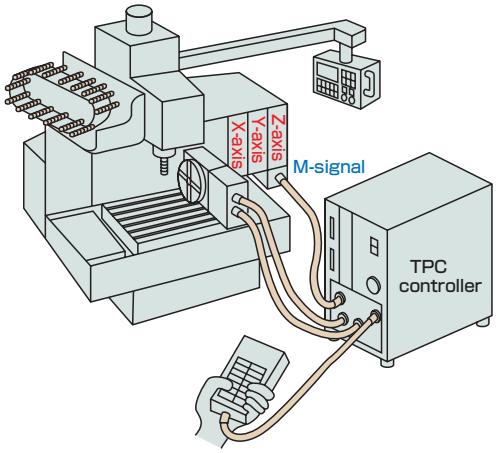


Features

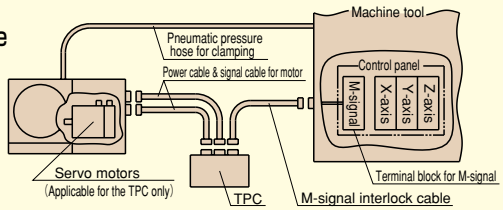
- **Simultaneous and continuous circular cutting on the X, Y, and Z-axes is possible depending on the specifications of the machine tool.**
- **The program of the rotary table should be input at the machine tool.**

NC control system 2

The TPC single axis NC controller of TSUDAKOMA is applied, receiving an M-signal from the machine tool.



Structure

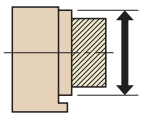


Features

- **Even if the 4th (or 5th) axis cannot be installed on a machine tool, the TPC controller can be used with an M-signal.**
- **Basically, this control system is only for indexing.**
- **Program for a rotary table should be input directly to the TPC. At the machine tool, an M-signal is input as a start command.**

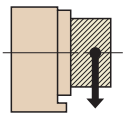
2 Please select the most suitable model of NC rotary table, depending on the workpiece and cutting conditions.

- Workpiece diameter



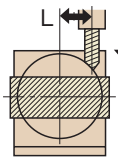
Within the rotary table diameter

- Workpiece weight



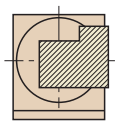
Should not be bigger than allowable as specified.

- Workpiece positioning



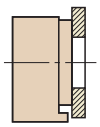
The value of (F×L) should be within the clamp force.

- When an eccentric load is applied:



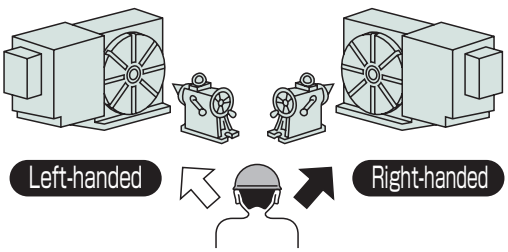
- The workpiece inertia should be within the allowable value.
- Pay attention to any interference with the machine tool.

- Workpiece of larger diameter, but lighter weight



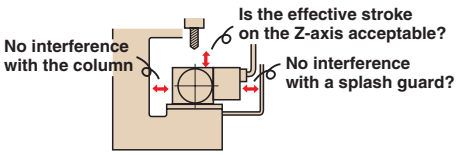
- The workpiece inertia should be within the allowable value.
- Pay attention to any interference with the machine tool.

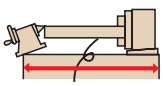
3 Please select the handedness of the NC rotary table.



Please take interference with the automatic tool changer (ATC) and easy operation into consideration when you make your selection.

4 Please take interference with a machining center into consideration when selecting a table.





In the case of long workpieces, check that the workpiece length is within the table length.

- No interference with the ATC? (Select L-type or R-type.)
- Are workpieces within the allowable load of the table?

If you need our help to select the best model for you:

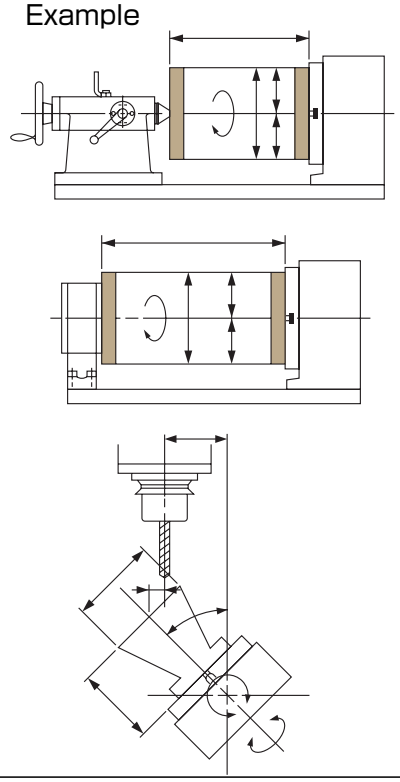
RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

Inform TSUDAKOMA of the information below, and TSUDAKOMA will suggest the best model for you.

Fill in this page and send it to a local distributor or TSUDAKOMA. Fax:+81-76-294-5157

1. Customer _____ Tel _____
2. Model considering _____ Unit _____
3. Machine Manufacturer _____
   Model _____ (New・Installed)
   NC controller _____
4. Coolant oil Not used Used (Oil・Water) (Normal・High Pressure)
5. Workpiece Kind _____ Material _____ Weight _____
   Dimensions Height (_____) × Length (_____) × Width (_____) mm
   Inner dia (_____) × Outer dia (_____) × Length (_____) mm
6. Layout of workpiece and fixture (Write the detailed dimensions from the top surface or the center of the face plate)

Example

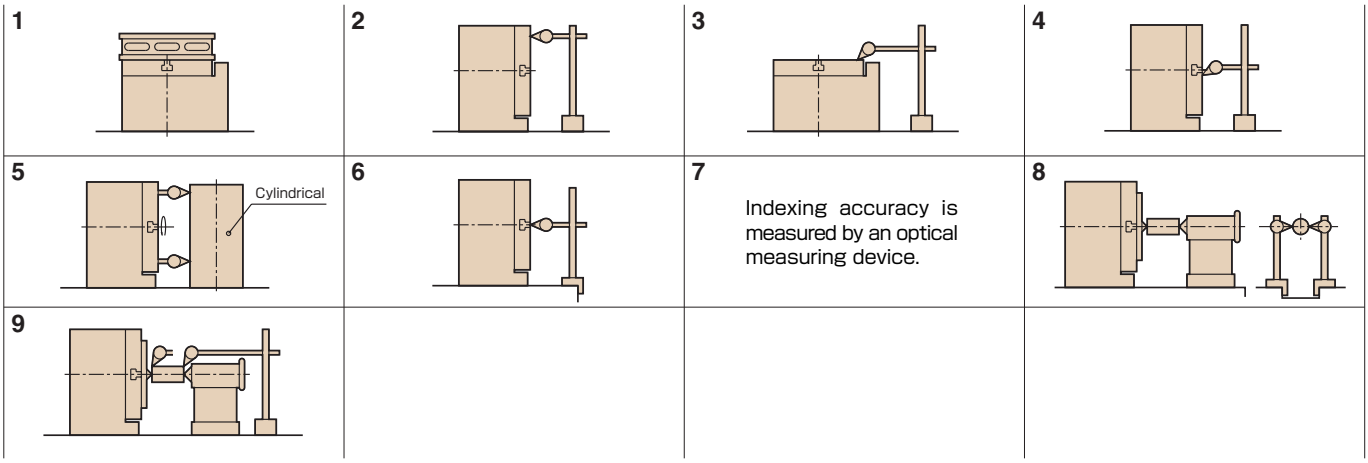


7. Cutting conditions

Cutting point	Cutter ／ teeth number	Cutting speed (V)	Cutting feed rate mm／min	Cutting depth mm／time	Cutting process (Indexing or continuous cutting)
a					
b					
c					
d					

Inspection Standard

NC Rotary Tables



RG

Unit: mm

No.	Inspection items			Tolerance RG-160 Standard	RG-160 With a scale	RG-250 Standard	RG-250 With a scale	RG-320 Standard	RG-320 With a scale
2	Spindle end runout	—	—	0.01		0.01		0.01	
3	Parallelism of spindle end to frame bottom	Per 200mm	Horizontal	0.02		0.02		0.02	
4	Center bore runout	Spindle nose	—	0.01		0.01		0.01	
5	Perpendicularity of spindle end to frame bottom	Per 200mm	Vertical	±0.02		±0.02		±0.02	
6	Perpendicularity of spindle end to frame bottom guide	Per overall length	Vertical	0.02		0.02		0.02	
7	Indexing accuracy (arc sec.)	Cumulative	—	15	15	15	10	15	10
8	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	Vertical	0.02		0.02		0.02	
9	Height difference of both center lines of rotary table and tailstock	—	Vertical	±0.03		±0.03		±0.03	

Note: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.

RNA

Unit: mm

No.	Inspection items			Tolerance RNA-161 Standard	RNA-161 With a scale	RNA-201 Standard	RNA-201 With a scale	RNA-251 Standard	RNA-251 With a scale	RNA-321 Standard	RNA-321 With a scale
2	Spindle end runout	—	—	0.01		0.01		0.01		0.01	
3	Parallelism of spindle end to frame bottom	Per 200mm	Horizontal	0.02		0.02		0.02		0.02	
4	Center bore runout	Spindle nose	—	0.01		0.01		0.01		0.01	
5	Perpendicularity of spindle end to frame bottom	Per 200mm	Vertical	±0.02		±0.02		±0.02		±0.02	
6	Perpendicularity of spindle end to frame bottom guide	Per overall length	Vertical	0.02		0.02		0.02		0.02	
7	Indexing accuracy (arc sec.)	Cumulative	—	25	15	20	15	20	10	20	10
8	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	Vertical	0.02		0.02		0.02		0.02	
9	Height difference of both center lines of rotary table and tailstock	—	Vertical	±0.03		±0.03		±0.03		±0.03	

Note: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.

RNE

Unit: mm

No.	Inspection items		Tolerance RNE-160 Standard	RNE-160 With a scale	RNE-200 Standard	RNE-200 With a scale	RNE-250 Standard	RNE-250 With a scale	RNE-320 Standard	RNE-320 With a scale
2	Spindle end runout	—	0.01		0.01		0.01		0.01	
3	Center bore runout	Spindle nose	0.01		0.01		0.01		0.01	
4	Perpendicularity of spindle end to frame bottom	Per overall length	±0.02		±0.02		±0.02		±0.02	
5	Perpendicularity of spindle end to frame bottom guide	Per overall length	0.02		0.02		0.02		0.02	
6	Indexing accuracy (arc sec.)	Cumulative	25		20		20		20	
7	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	0.02		0.02		0.02		0.02	
8	Height difference of both center lines of rotary table and tailstock	—	±0.03		±0.03		±0.03		±0.03	

Note: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.

Inspection Standard

NC Rotary Tables

RG
RNA RN
RNE
RNA-B RNCV-B
RNCM
RBA
RBA-K RNCK
RCH RNC
RCV RNCV
Multi-Spindle RN-N
RZ
TN
TTNC
THNC
Multi-Spindle TTNC-N
RC RH
RUA
TSUA
RTV RTT
NC Controllers
Accessories
Options
Technical Information

RN、RZ

Unit: mm

No.	Inspection items			Tolerance		
				RN-100	RZ-161	RZ-201
2	Spindle end runout	—	—	0.01	0.015	0.015
3	Parallelism of spindle end to frame bottom	Per overall length	Horizontal	0.015	0.02	0.02
4	Center bore runout	Spindle nose	—	0.01	0.015	0.02
5	Perpendicularity of spindle end to frame bottom	Per overall length	Vertical	±0.02	±0.02	±0.02
6	Perpendicularity of spindle end to frame bottom guide	Per overall length	Vertical	0.02	0.02	0.02
7	Indexing accuracy (arc sec.)	Cumulative	—	45	45	45
9	Height difference of both center lines of rotary table and tailstock	—	Vertical	±0.03	±0.03	±0.03

RCV、RNCV

Unit: mm

No.	Inspection items			Tolerance					
				RCV-800		RCV-1000		RNCV-1201	RNCV-1501
				Standard	With a scale	Standard	With a scale	Standard	Standard
1	Table top flatness (0.01 convex permissible)	Per overall length	—	0.03	0.02	0.04	0.02	0.04	0.04
2	Table top runout	—	—	0.02	0.01	0.03	0.02	0.03	0.03
3	Parallelism of table top to frame bottom	Per overall length	Horizontal	0.03	0.02	0.04	0.02	0.04	0.04
4	Center bore runout	Spindle nose	—	0.01	0.01	0.01	0.01	0.01	0.01
5	Perpendicularity of table top to frame bottom	Per overall length	Vertical	0.03	0.02	0.04	0.03	0.04	0.04
6	Perpendicularity of table top to frame bottom guide blocks	Per overall length	Vertical	0.03	0.03	0.04	0.03	0.04	0.04
7	Indexing accuracy (arc sec.)	Cumulative	—	15	8	15	8	15	15
8	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	Vertical	0.02	0.02	0.02	0.02	0.03	0.03
9	Height difference of both center lines of rotary table and tailstock (tailstock center line should be higher)	—	Vertical	0.02	0.02	0.02	0.02	0.04	0.04

Note: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.

RNCM

Unit: mm

No.	Inspection items			Tolerance					
				RNCM-251,301		RNCM-401,501		RNCM-631	
				Standard	With a scale	Standard	With a scale	Standard	With a scale
1	Table top flatness (0.01 convex permissible)	Per overall length	—	0.01	0.01	0.02	0.01	0.03	0.01
2	Table top runout	—	—	0.015	0.01	0.015	0.01	0.02	0.01
3	Parallelism of table top to frame bottom	Per overall length	Horizontal	0.02	0.01	0.02	0.01	0.03	0.02
4	Center bore runout	Spindle nose		0.01	0.005	0.01	0.005	0.01	0.01
5	Perpendicularity of table top to frame bottom	Per overall length	Vertical	0.02	0.01	0.02	0.01	0.03	0.02
6	Perpendicularity of table top to frame bottom guide blocks	Per overall length	Vertical	0.02	0.01	0.02	0.01	0.03	0.03
7	Indexing accuracy (arc sec.)	Cumulative	—	15	10	15	8	15	8
8	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	Vertical	0.02	0.01	0.02	0.01	0.02	0.02
9	Height difference of both center lines of rotary table and tailstock (tailstock center line should be higher)	—	Vertical	0.02	0.01	0.02	0.01	0.02	0.02

Note: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.

RNCK

Unit: mm

No.	Inspection items		Tolerance	
			RNCK-631	
			Standard	With a scale
1	Table top flatness (0.01 convex permissible)	Per overall length	0.03	0.02
2	Table top runout	—	0.02	0.01
4	Center bore runout	Spindle nose	0.01	0.005
5	Perpendicularity of table top to frame bottom	Per overall length	0.03	0.02
6	Perpendicularity of table top to frame bottom guide blocks	Per overall length	0.03	0.03
7	Indexing accuracy (arc sec.)	Cumulative	15	8
8	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	0.02	0.02
9	Height difference of both center lines of rotary table and tailstock (tailstock center line should be higher)	—	0.02	0.02

Note: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.

RBA、RBA-K

Unit: mm

No.	Inspection items			Tolerance			
				RBA-250,320 RBA-250K,320K		RBA-400,500 RBA-400K,500K	
				Standard	With a scale	Standard	With a scale
1	Table top flatness (0.01 convex permissible)	Per overall length	—	0.01	0.01	0.02	0.01
2	Table top runout	—	—	0.015	0.01	0.015	0.01
3	Parallelism of table top to frame bottom	Per overall length	Horizontal	0.02	0.01	0.02	0.01
4	Center bore runout	Spindle nose	—	0.01	0.005	0.01	0.005
5	Perpendicularity of table top to frame bottom	Per overall length	Vertical	0.02	0.01	0.02	0.01
6	Perpendicularity of table top to frame bottom guide blocks	Per overall length	Vertical	0.02	0.01	0.02	0.01
7	Indexing accuracy (arc sec.)	Cumulative	—	14	8 (10)	14	8
8	Parallelism of center line between rotary table and tailstock to frame bottom guide blocks	Per 300mm	Vertical	0.02	0.01	0.02	0.01
9	Height difference of both center lines of rotary table and tailstock (tailstock center line should be higher)	—	Vertical	0.02	0.01	0.02	0.01

Note 1: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.
Note 2: For RBA-K, No. 3 is not required.
Note 3: The figures in ( ) above show an indexing accuracy with scale for the RBA-250 and RBA-250K.

RCH、RNC

Unit: mm

No.	Inspection items		Tolerance					
			RCH-800		RCH-1000,1201,1501		RNC-2001	
			Standard	With a scale	Standard	With a scale	Standard	With a scale
1	Table top flatness (0.01 convex permissible)	Per overall length	0.03	0.02	0.04	0.02	0.04	0.03
2	Table top runout	—	0.02	0.01	0.03	0.02	0.03	0.02
3	Parallelism of table top to frame bottom	Per overall length	0.03	0.02	0.04	0.02	0.04	0.03
4	Center bore runout	Spindle nose	0.01	0.01	0.01	0.01	0.01	0.01
7	Indexing accuracy (arc sec.)	Cumulative	15	8	15	8	15	8

Note: The indexing accuracy above is for tables with MP scales.

RC

Unit: mm

No.	Inspection items		Tolerance
			RC-250,300,400,500
1	Table top flatness (High top at the center by 0.01mm is acceptable)	Per overall length	0.03
2	Table top runout	—	0.02
3	Parallelism of table top to frame bottom	Per overall length	0.03
4	Center bore runout	Spindle nose	0.02
7	Indexing accuracy (arc sec.)	Cumulative	25

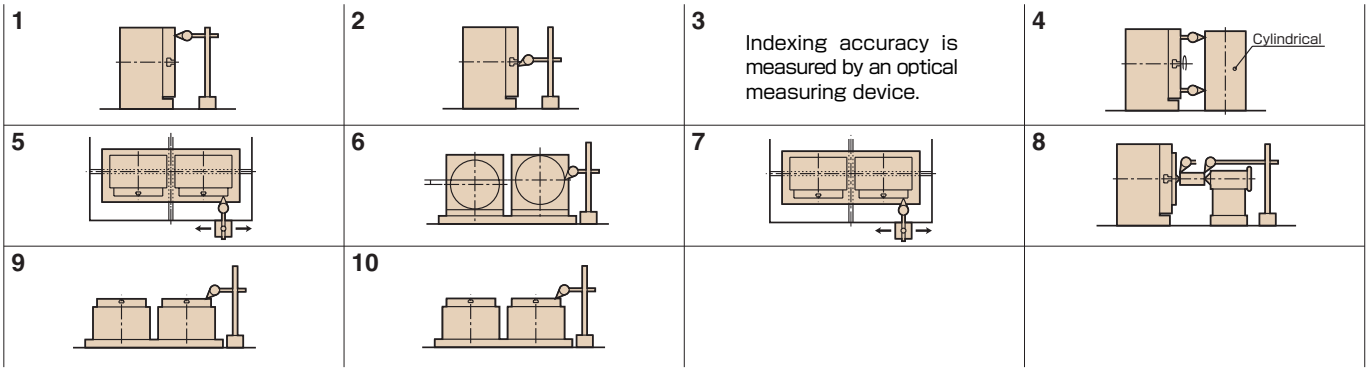
RUA

Unit: mm

No.	Inspection items		Tolerance			
			RUA-251	RUA-321	RUA-400	RUA-500
1	Table top flatness (High top at the center by 0.01mm is acceptable)	Per overall length	0.03	0.03	0.03	0.03
2	Table top runout	—	0.02	0.02	0.02	0.02
4	Center bore runout	Spindle nose	0.02	0.02	0.02	0.02
5	Perpendicularity of table top to frame bottom	Per overall length	0.03	0.03	0.03	0.03
7	Indexing accuracy (arc sec.)	Cumulative	30	30	25	25

Inspection Standard

NC Rotary Table / Multi-Spindle



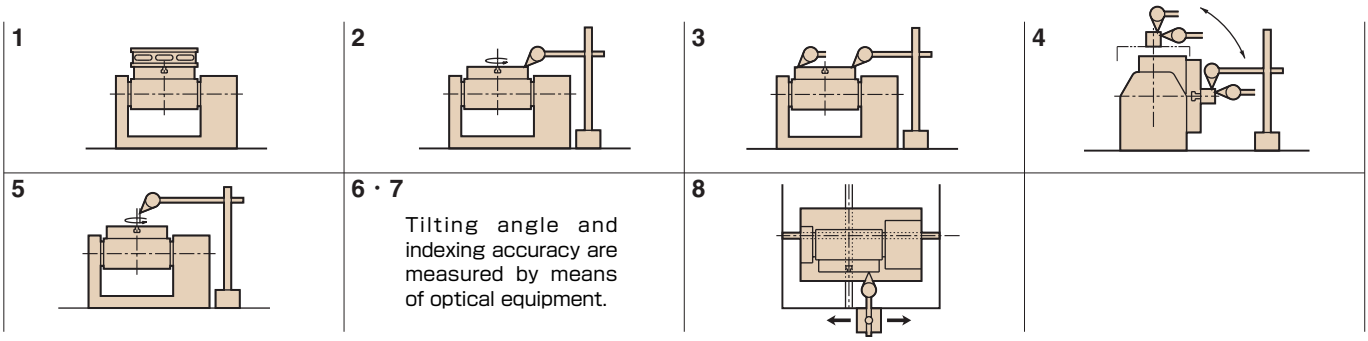
RN-N

Unit: mm

No.	Inspection items			Tolerance			
				RN-100-N	RN-150-N	RN-200-N	RN-250-N 300-N
1	Table top runout	—	—	0.015	0.015	0.015	0.02
2	Center bore runout	Spindle nose	—	0.01	0.015	0.02	0.02
3	Indexing accuracy (arc sec.)	Cumulative	—	60	30	30	30
4	Squareness between table top and base plate	Per overall length	Vertical	0.02	0.02	0.02	0.02
5	Parallelism and perpendicularity of the table top to base bottom guide blocks	Per overall length	Vertical	0.02	0.02	0.02	0.03
6	Difference between both center heights	—	Vertical	0.02	0.02	0.02	0.02
7	Difference of the distance between base bottom guide block and table top	—	Vertical	0.02	0.02	0.02	0.02
8	Height difference of both center lines of rotary table and tailstock	—	Vertical	0.03	0.02	0.02	0.02
9	Parallelism of the table top to base bottom	Per overall length	Horizontal	0.015	0.02	0.02	0.03
10	Difference among the average heights between base bottom and table top	—	Horizontal	0.02	0.02	0.02	0.02

Note 1: For the RN-100-N,RN-150-N and RN-200-N, all the descriptions of "table top" seen in the inspection items should be "spindle end surface".
Note 2: If the base has no guide block, "base bottom guide block" in the above instructions (Nos. 5 and 7) should be construed as "base bottom".

NC Tilting Rotary Tables



TN

Unit: mm

No.	Inspection items		Tolerance					
			TN-101	TN-131	TN-161	TN-201	TN-320	TN-450
			Standard	Standard	Standard	Standard	Standard	Standard
1	Table top flatness (0.01 convex permissible)	Per overall length	—	—	—	—	0.01	0.02
2	Table top runout	—	0.01	0.01	0.01	0.01	0.015	0.015
3	Parallelism of table top to frame bottom	Per overall length	0.015	0.015	0.015	0.015	0.02	0.02
4	Parallelism of tilt axis center to frame bottom	Per overall length	0.02	0.02	0.02	0.02	0.02	0.02
5	Center bore runout	Spindle nose	0.015	0.015	0.015	0.015	0.01	0.01
6	Tilting accuracy (arc sec.)	Cumulative (0°～+90°)	45	45 (15)	45	45	45	90
		Cumulative (−30°～+90°)	—	—	60	60	60	—
7	Indexing accuracy (arc sec.)	Cumulative	40	40 (15)	30	30	20	15
8	Perpendicularity of table top to frame bottom guide blocks (Parallelism)	Per overall length (90 degree)	0.015	0.015	0.015	0.015	0.02	0.02

Note 1: For item 8, values differ depending on the mounting direction of the guide block.
Note 2: The table tops of TN-101 and TN 131, are the ends of the spindles.
Note 3: Values in ( ) for TN-131 are accuracy for tables with rotary encoders and MP scales for high precision. P.65

NC Tilting Rotary Tables

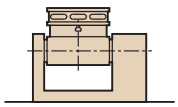
TTNC、THNC

Unit: mm

No.	Inspection items		Tolerance					
			TTNC-631		TTNC-1001		THNC-251,301	
			Standard	With a scale	Standard	With a scale	Standard	With a scale
1	Table top flatness (0.01 convex permissible)	Per overall length	0.03	0.03	0.04	0.04	0.01	0.01
2	Table top runout	—	0.02	0.02	0.03	0.03	0.015	0.015
3	Parallelism of table top to frame bottom	Per overall length	0.03	0.03	0.04	0.04	0.02	0.02
4	Parallelism of tilt axis center to frame bottom	Per overall length	0.03	0.03	0.04	0.04	0.02	0.02
5	Center bore runout	Spindle nose	0.01	0.01	0.01	0.01	0.01	0.01
6	Tilting accuracy (arc sec.)	0°～+90°	60	15	60	15	60	60
7	Indexing accuracy (arc sec.)	Cumulative	15	8	15	8	15	10
8	Perpendicularity of table top to frame bottom guide blocks (Parallelism)	Per overall length (90 degree)	0.02	0.02	0.02	0.02	0.02	0.02

Note 1: The indexing accuracy above is for tables with MP scales. See P.65 for indexing accuracy of HEIDENHAIN rotary encoders.
Note 2: For item 8, values differ depending on the mounting direction of the guide block.

NC Tilting Rotary Tables / Multi-Spindle

1


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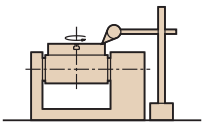

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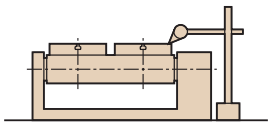

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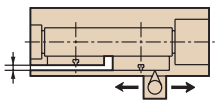

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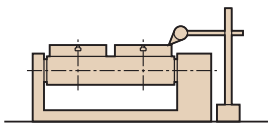

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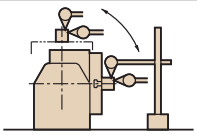

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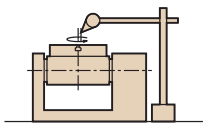
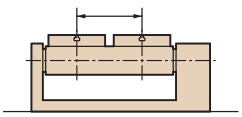


8
Tilt accuracy is measured using an optical scale.

9
Indexing accuracy is measured by an optical measuring device.

10


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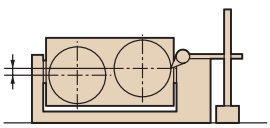

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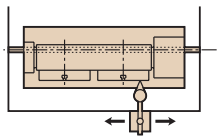


TTNC-N

Unit: mm

No.	Inspection items		Tolerance			
			TTNC-102-2	TTNC-101-4	TTNC-151-2	TTNC-201-2
1	Table top flatness (0.01 convex permissible)	Per overall length	—	—	0.02	0.01
2	Table top runout	—	0.015	0.015	0.015	0.015
3	Difference between average heights of both tables	0 degree	0.02	0.02	0.02	0.02
4	Difference between distances between frame standard face and both table tops	90 degree	0.02	0.02	0.02	0.02
5	Parallelism of table top to frame bottom	Per overall length	0.015	0.015	0.02	0.02
6	Parallelism of tilt axis center to frame bottom	Per overall length	0.02	0.02	0.02	0.02
7	Center bore runout	Spindle nose	0.015	0.01	0.01	0.01
8	Tilting accuracy (arc sec.)	0°～+90°	45	60	60	60
9	Indexing Accuracy (arc sec.)	Cumulative	40	60	30	20
10	Table center distance	—	±0.02	±0.02	±0.02	±0.02
11	Difference between both center heights	90 degree	0.02	0.02	0.02	0.02
12	Perpendicularity of table top to frame bottom guide blocks (Parallelism)	Per overall length (90 degree)	0.015	0.015	0.02	0.02

Note 1: For the TTNC-102 and TTNC-101-4, all the descriptions of "table top" seen in the inspection items above should be "spindle end surface".
Note 2: For item 12, values differ depending on the mounting direction of the guide block.

NOTES

OPERATION ENVIRONMENT AND MAINTENANCE RECOMMENDED TO KEEP PERFORMANCE AND FUNCTION

- **Do not use any coolant of chlorine or strong alkaline.**
- Do not use any corrosive gas, water, steam or chemicals damaging sealing parts.
- **Lubricant is indispensable** in order to operate a rotary table smoothly and to maintain its functions for a long time. **Supply a recommended lubricant (in the operation manual) to the rotary table before operation. Change all the lubricant periodically.**
- If a lot of cutting chips, (generated by machining,) accumulate on some sections of rotary table, install adequate covers for protection.
- Operate a rotary table within the specified range of temperature.
- Depending upon the operation environment, there is a possibility of dew condensation which may cause a malfunction or a rust problem of electrical components, so provide air-purging inside the motor cover. (Do not close the outlet of exhaust air.) See Fig. 1.
- When assembling a faceplate or a fixture with the main spindle, make the inner diameter section as the reference for fitting as shown in Fig. 2.
- Keep the clearance with 3mm or more between a Faceplate or a fixture and a Rotary table. Otherwise, cutting chips may impede the rotation of the main spindle or the waterproof capability of the seals. See Fig. 2.

Fig. 1

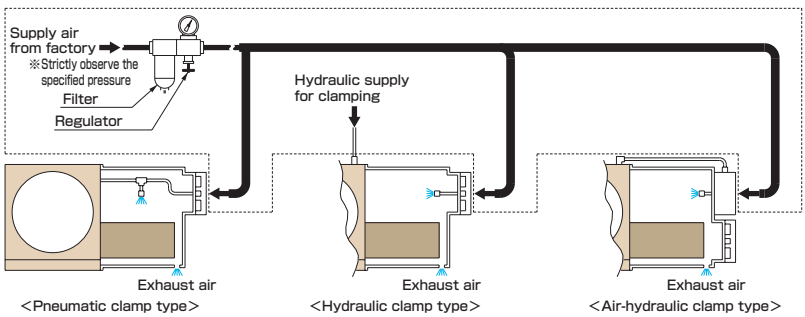
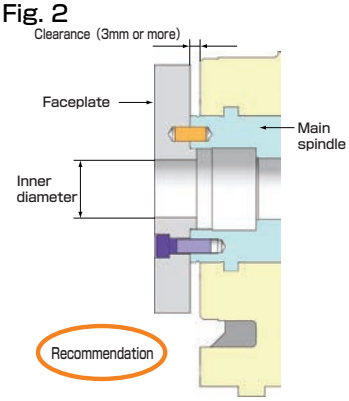


Fig. 2



SETTING ON MACHINE TOOL AND PREPARATION BEFORE USE

- When moving a rotary table by a hanging method, observe the specified method in the operation manual.
- To fix a rotary table on a machine tool, use the specified fixing parts and follow the specified method.
- Connect each interface cable in accordance with the instructions on the electrical drawing.
- Provide protective measures to avoid adding extraordinary force to any piping or any joint for each interface cable and each connector, to induce any damage, during the operation of a machine tool with a rotary table.
- Each piping is to be connected to the specified input port (connecting port) stated in the outlook drawing.
- Regarding each fluid to be supplied to a rotary table, make sure that **maximum pressure does not exceed the specified pressure** even if there is a pressure variation due to the pressure source or other factors.
- Refer to the recommendable flow chart on Page 71 for the NC control at the time of table clamping.

DAILY OPERATION, PERIODICAL CHECK AND OTHERS

- Make sure that the weight and size of the workpiece does not exceed the specified value of the workable force during machining.
- In case any abnormality is realized during operation, stop machining immediately.
- When any human work is carried out within the operational area of machine tool, be sure to turn off the power for the machine tool as well as the Tsudakoma controller.
- When restarting from a long stoppage, perform a warm-up operation of the rotary table.
- Do not make any conversion of a rotary table without Tsudakoma's consent.

Overseas Distributors

U.S.A. **KOMA PRECISION, INC.**
Address: 20 Thompson Road, East Windsor, CT 06088
Tel: +1 860 627 7059 Fax: +1 860 623 4132
E-mail: info@komaprecision.com
Website: www.komaprecision.com

BRASIL **TMTA BRASIL REPRESENTACOES COMERCIAIS LTDA.**
Address: Rua Olavo Bilac, 15 Sala 05
CEP 13465-470 Americana Sao Paulo Brasil
Tel: +55 19 3648-8088
E-mail: jortega@uol.com.br

GERMANY **THD GmbH**
Address: Spiesheimer Weg 19, 55286 Worrstadt
Tel: +49 6732 9379 0 Fax: +49 6732 9379 29
E-mail: info@thdgmbh.de
Website: www.thdgmbh.de

ITALY **TEOMA S.R.L.**
Address: Via M. Idiomi, 1/11 -20090 Assago Milano
Tel: +39 02 4571 3787 Fax: +39 02 4570 5320
E-mail: sales@teomasrl.it
Website: www.teomasrl.it

FRANCE **DOGA**
Address: ZA Pariwest - 8, avenue Gutenberg - BP53 - 78311
Maurepas cedex
Tel: +33 1 3066 4141 Fax: +33 1 3066 4199
E-mail: doga@doga.fr
Website: www.doga.fr

SPAIN **DTC TECNOLOGIA S.L.**
Address: Pol. Osinalde- Zelai Haundi, 1 20170- URSURBIL
(Guipuzcoa)
Tel: +34 943 37 6050 Fax: +34 943 37 0509
E-mail: dtc@dtctecnologia.com
Website: www.dtctecnologia.com

INDIA **TSUDAKOMA SERVICE INDIA PVT.LTD**
Address: 404, Meadows Building, Sahar Plaza Complex,
Andheri (EAST) Mumbai-400059, Maharashtra, INDIA
Tel: +91-22-2825-2826, +91-22-2825-2827
Fax: +91-22-2825-2828

KOREA **HANSA CORPORATION**
Address: #405,STX W-TOWER,90,Gyeongin-ro
53-gil,Guro-gu,SEOUL,KOREA
Tel: +82 2 771 1414 Fax: +82 2 771 0011
E-mail: tkshansa@kornet.net
Website: www.hansags.com

DAESUNG HI-TECH CO.,LTD.
Address: (153-712)#805 Hansin IT Tower 2-cha,
Gasan-dong,Geumcheon-gu,Seoul,KOREA
Tel: +82-2-2025-6200～2 Fax: +82-2-2025-6203

Address: (704-801)1010,Daecheon-dong,
Dalseo-gu,Daegu,KOREA
E-mail: sskim100468@gmail.com
Website: www.topdsht.com www.anylock.co.kr

TAIWAN **SHIN TONG LONG TRADING CO., LTD.**
Address: 7F No.3 Kuei Feng Street, Tai Shan Shiang,
Taipei Hsien, Taiwan
Tel: +886 2 2908 7139 Fax: +886 2 2907 1929
E-mail: stltpe@ms27.hinet.net

CHINA **TSUDAKOMA (SHANGHAI) CO., LTD.**
Machine tool department:
1st Floor,Building North C,No.787 Xiehe Road,
Changning District,Shanghai,200335 P.R.CHINA
Address: 17F No.6 Everbright Convention & Exhibition
Center, No.66 Caobao Road,
Shanghai 200050 P.R.CHINA
Tel: +86 21 5218 0630 Fax: +86 21 5218 0630
E-mail: info2@tsudakoma.co.jp
Website: www.tsudakoma.co.jp

THAILAND **SIN-TAI DEVELOPMENT (THAILAND) CO., LTD.**
Address: 18 Phaholyothin 107 Rd., Soi 1, Prachatipat,
Thanyaburi, Patumthanee 12130, Thailand,
Tel: +66 0 2533 7988 Fax: +66 0 2531 5064
E-mail: sintai@ksc.th.com

Bestcooper Co., Ltd.
Address: 84/160,1st floor, Soi 15, The Living Village, Moo 5,
Liapkhlong Rangsit Rd., Tambon Bangpoon,Amphoe
Mueang Pathumtani, Pathumtani 12000, Thailand.
Tel: (+66) 2958-8928 Fax:(+66) 2958-8927
E-mail: sales@bestair.co.th

INDONESIA **PT.GANSA TECHNO CENTER, Bandung Indonesia**
Address: Kopo Plaza G-5, Jl. Peta Lingkar Selatan, Bandung
40233, Indonesia
Tel: (+62) 22 607 1637-8 Fax: (+62) 22 607 1639
E-mail: info@gansa-techno.com

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TSUDAKOMA Corp.

Nonoichi Plant 5-100 Awada, Nonoichi, Ishikawa 921-8529 Japan
Phone:+81-76-294-5111 Fax:+81-76-294-5157
http://www.tsudakoma.co.jp E-mail:kexport@tsudakoma.co.jp

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