

# OPERATION AND SERVICE MANUAL



For Rotary Table



OPERATION AND SERVICE MANUAL

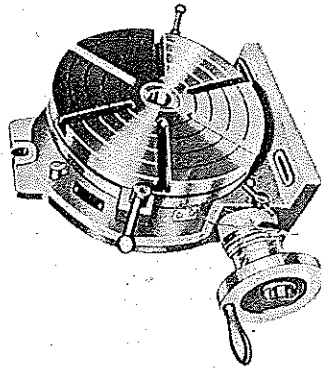
**HV, RT**

**H.V. & RT. TYPE Rotary Tables**

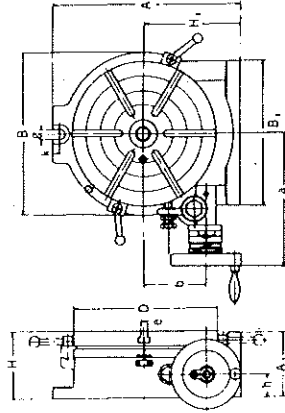
Two types of Rotary tables are summarized here collectively. The mechanisms common to these tables are shown on some page of their description.  
**Horizontal & Vertical Rotary Table (HV)**  
 This H.V. Type Rotary Table is so designed as to permit machining operations at a higher dimension than that of RT. Type Rotary tables. The base can be used in a vertical position to enabling to carry out center work.

**Order No. & Dimensions**

Order No.	Table		Base dimension			Width of T-slot		Bolt slots	Center sleeve	Weight kg/lb.	Worm Gear ratio
	Outer diameter	Height	A	B	H	Type					
						a	b				
HV-6	78	80	100	160	10	1/2	15	MT-2	12	90:1	
	3.07	3.11	3.94	7.87	0.39						0.59
HV-8	100	105	135	265	12	1/2	17	MT-3	30.0	90:1	
	3.94	4.13	5.31	10.43	0.47						0.67
HV-10	110	115	165	325	14	3/4	17	MT-3	48.0	90:1	
	4.33	4.53	6.50	12.80	0.47						0.67
HV-12	130	135	195	388	14	3/4	18	MT-4	77.0	90:1	
	5.12	5.32	7.68	15.27	0.55						0.71
HV-14	130	140	230	450	14	3/4	18	MT-4	95.0	90:1	
	5.12	5.51	9.06	17.72	0.55						0.71



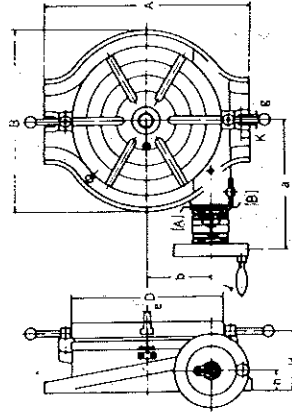
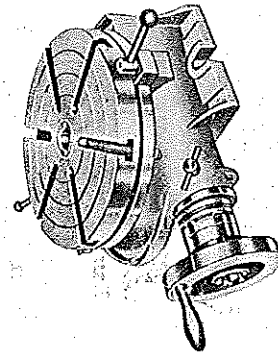
Horizontal Rotary Table (RT)



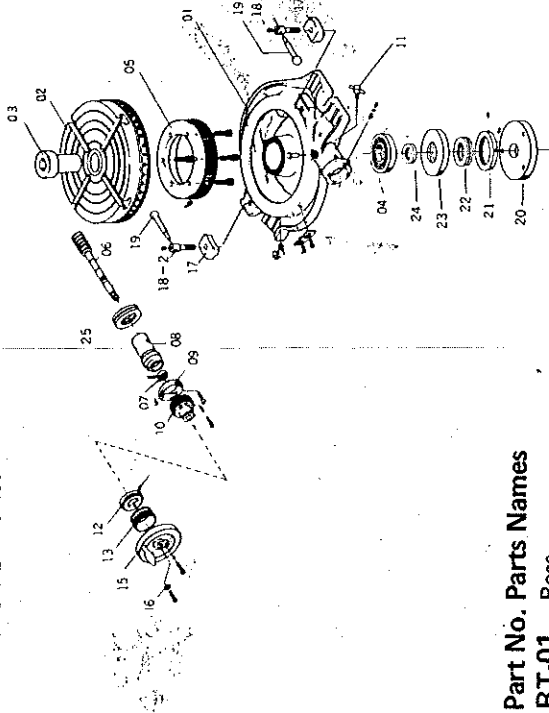
This Rotary table is widely used for circular cutting work, angle setting, boring, spot-facing and similar work in conjunction with a milling machine. (Refer to Page 2)

**Order No. & Dimensions**

Order No.	Table		Base dimension			Width of T-slot		Bolt slots	Center sleeve	Weight kg/lb.	Worm Gear ratio
	Outer diameter	Height	A	B	H	Type					
						a	b				
RT-6	150	78	184	10	10	1/2	10	MT-2	10.0	90:1	
	5.91	3.07	8.27	7.24	0.39						0.39
RT-8	200	105	280	12	14	1/2	14	MT-3	25.0	90:1	
	7.87	4.13	11.02	9.84	0.47						0.55
RT-10	250	115	340	12	16	3/4	16	MT-3	37.0	90:1	
	9.84	4.53	13.39	11.81	0.47						0.63
RT-12	300	135	400	14	18	3/4	18	MT-4	60.0	90:1	
	11.81	5.32	15.75	14.33	0.55						0.71
RT-14	350	140	460	14	18	3/4	18	MT-4	85.0	90:1	
	13.78	5.51	18.11	16.54	0.55						0.71



## RT Horizontal Rotary Table EXPLODED VIEW



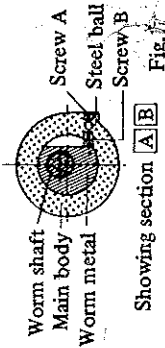
### Part No. Parts Names

RT-01	Base
RT-02	Table
RT-08	Worm metal
RT-11	Metal setting screw
RT-17	Clamp Piece
RT-18	Clamp bolt
RT-19	Clamp handle

### Operating Instruction and Function of Each Unit

1. Turn the handle clockwise at all times. When this handle has been turned until it passes the desired position, turn back it once counterclockwise to a great extent and then softly rotate it clockwise so as not to cause the backlash of the gear.
2. When turning the right and left table stoppers 19 inwards concurrently, they are pushed down because the projected part of the stopper Piece 17 is fitted into the slot section on the center of the side of the table, thus clamping the table. The bolt 18-2 is a left-handed screw and the bolt 18 is a right-handed one.

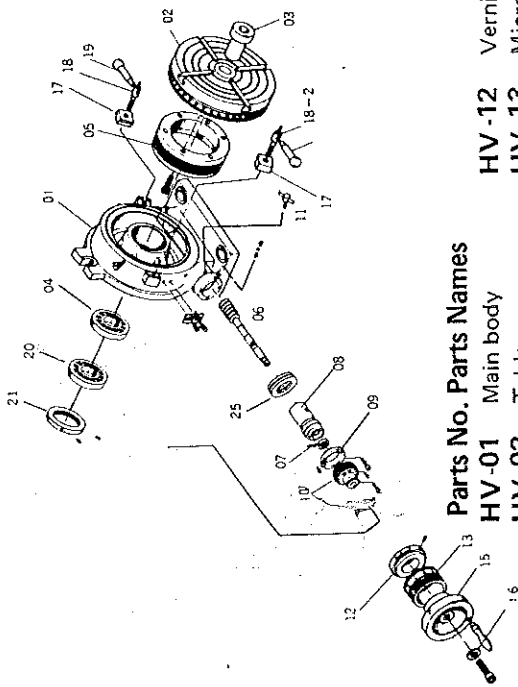
3. The center hole has a Morse tapered sleeve, so that jigs and measuring apparatus can be fitted with precision.
4. The worm gear ratio is 1:90. As a result, 90 turns of the handle lead to one turn of the table, and the table moves 4 ( $360^\circ \div 90 = 4^\circ$ ) for one turn of the handle.
5. Dividing of 2 to 100 can be carried out quickly and accurately by attaching a Dividing Mechanism (See Page 5).
6. Loosen the metal clamp handle 11 and rotate the switch metal 10 until it touches the stopper. The worm gear and wheel have now been disengaged, thus enabling to turn the table manually.



1. **Adjusting Mesh of Worm Gear:** Loosen the metal clamp handle and turn the switch metal clockwise until it touches the stopper. The worm gear has now been disengaged. Turn it counterclockwise until it touches the stopper, the worm and gear wheel will engage. Tighten the metal clamp handle after engagement. An additional adjustment can be obtained by removing the screw A and steel ball and turning the inner screw B counterclockwise, so bringing the worm in closer engagement with the gear wheel. Turning clockwise brings the worm away from the wheel. After adjustment insert the steel ball and tighten the screw A.

2. **Axial Adjustment of Worm Shaft:** When axial slack occurs gear adjustment is carried out by tightening the inside worm shaft nut after the handle, vernier ring and switch metal have been removed. After adjustment, lock the nut on the shaft by means of the set screw. (The RT-150 has an adjusting nut, which can be used after removal of the handle.)

**(HV)** Horizontal and Vertical Rotary Table  
EXPLODED VIEW



**Parts No. Parts Names**

<b>HV -01</b>	Main body	<b>HV -12</b>	Vernier ring
<b>HV -02</b>	Table	<b>HV -13</b>	Micro-collar
<b>HV -05</b>	Worm wheel	<b>HV -17</b>	Clamp piece
<b>HV -08</b>	Worm metal	<b>HV -18</b>	Clamp bolt
<b>HV -11</b>	Metal setting screw	<b>HV -19</b>	Clamp handle

**Operating Instruction and Function of Each Unit**

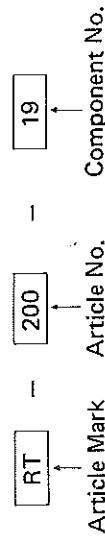
1. The worm gear ratio is 1:90.
- One turn of the handle moves the table by 4°.
- Micro-collar is graduated in steps of 1 min.
- Vernier scale makes settings down to 10 seconds possible.  
(20 seconds for HV-150)

2. Dividing of 2 to 100 can be carried out quickly and accurately by attaching a Dividing Mechanism.
3. Center work can also be carried out by using the base in the vertical position in conjunction with a tailstock. (See Page 4.)
4. The worm gear engagement is adjusted by the switch metal in the same manner as that of (RT). (See Page 2.)

**\* Suggestions for Order**

The parts names expressed in the operation and service manual are abbreviated for description.

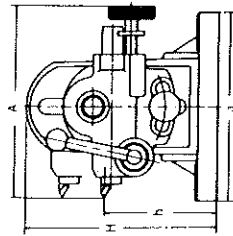
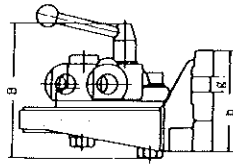
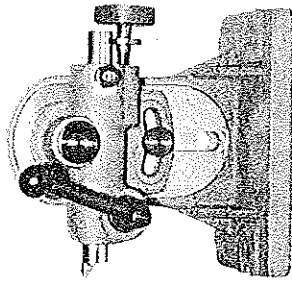
Therefore, when ordering parts for replacement, be sure to specify article marks, article Nos. and component Nos., which are shown in the table of Order No. & Dimensions.



**Special Accessories**

**Tailstock**

The height can be varied when working with different index centers, while the angle of inclination can be changed for various machining applications. In addition, the tip of the center is finely rotatable. Clamping is made by means of the lever handle.

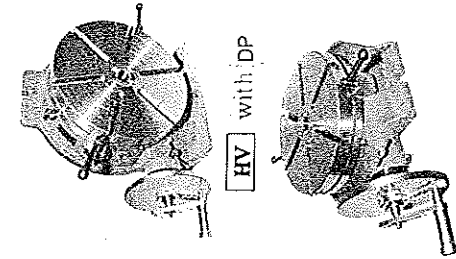


**Dividing Mechanism**

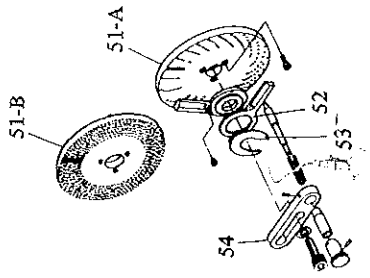


**DP SETS**

- Dividing Plates (A plate and B plate) each 1
- Sector 1
- Crank handle 1
- Sector spring 1



**HV** with DP



**Order No. & Dimensions for Tail Stock** Unit: mm/in.

Order No.	Center Height		Suitable for
	Max.	Min.	
TS-1	131 5.15	97 3.81	HV-150
TS-2	166 6.53	103 4.05	HV-300 HV-250
TS-3	210 8.26	160 6.29	HV-300
TS-4	300 11.81	210 8.27	HV-350 HV-400 HV-500

**RT** with DP

**Order No. & Dimensions**

Order No.	Dividing plate set screw	Major dimension of DM			Weight kg/lb	Shipping measurement ft	Applicable table
		Inner diameter of sector arm	Outer diameter of spring clip	Groove width in handle plate			
DP-1	PCD <sub>32</sub> 126 <sup>ø</sup>	21 0.83	18 0.71	9 0.03	2.5 5.51	0.12	HV-6 RT-6
DP-2	(3holes) PCD <sub>46</sub> 181	28.7 1.12	44 1.73	10 0.39	4 8.82	0.12	HV-8 RT-8
DP-3-4	(3holes) PCD <sub>46</sub> 181	28.7 1.12	44 1.73	10 0.39	4 8.82	0.12	HV-10,12 RT-14 CS-5,8

Unit mm/in

### In case of An Optional DM Device Attached

Indexing of 2 to 100 can be made accurately and quickly.

#### Equation of Indexing

Since the worm ratio is 1 : 90, when the handle is made to rotate a 360° revolution, the table therefore will rotate a 1/90 revolution. The relationships between handle revolution 'N' and dividial number 'T' to be sought are shown in the following equation:

$$N = \frac{90}{T}$$

Remarks: The index table on Page 6 is made on the basis of this equation.

#### (Example)

In case where the operator wants to index the position divided into 29 equal parts. Hints on operation As for 29 dividial numbers, the number of crank handle revolutions (N) is  $3 \frac{3}{7}$  as shown in the table on Page 6, so that the handle should be rotated a full 360° revolution three times plus an interval of nine holes (in this time, it means hole intervals not hole numbers). After setting this point as a start point, rotate the handle a full 360° revolution three times plus an interval of nine holes. When the procedure is repeated in turn as many as 29 times, the indexing of dividing into 29 equal parts is thus achieved.

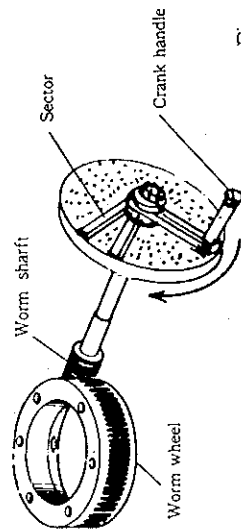


Fig. 4

### Operations of Crank-Handle and Sector

In case of the Example 'Division into 29 Equal Parts' aforesaid, it is natural that indexing operation should proceed with the intervals of nine holes after setting the index plate (B plate) on which a row of 87 holes are provided. But in this method, the operator has to count nine holes' intervals one by one. He must feel inefficient. In this viewpoint, it is necessary to use a device called 'sector' to avoid such troublesome procedures. The following will describe some necessary procedures for operation of the sector.

a. Loosen the crank handle lock nut, adjust its length so as to cause the index pin to fall in the train of 87 holes, and retighten it.

b. Loosen the set-screws of the sector, open two arms in accordance with the interval of nine holes (total numbers of holes are ten), and retighten with set-screws.

c. First, bring the left arm of the sector near to the index pin's left side.

d. Next, rotate the crank handle clockwise to apply it to the right arm of the sector so that the index pin will fall in the hole located at this right arm's left side surface.

e. Rotate the sector clockwise this time, and put the right side surface of the left arm to the left side of the index pin. In this time, the relationships between the index pin and the sector's left arm in their positions are the same as in Par. c). The index plate hole that actually accommodates the index pin is located at the point where goes across ten holes to the right away from the hole as in Par. c).

f. Repeat the same procedures as necessary.

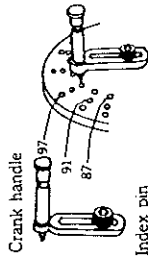


Fig. 5

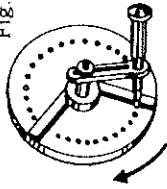


Fig. 6

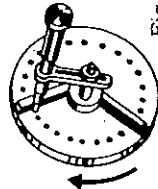


Fig. 7

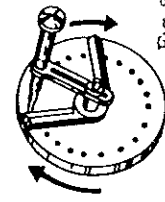


Fig. 8

**Index Table (For worm ratio 1:90)**  
**DP-1 For HV-6**

T	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N
1	A	20	22	B	33	1	3/33	43	C	43	64	C	39	1	15/39	83	A	20	100	A	20	18/20				
2	A	20	23	B	33	2	2/33	44	C	43	65	C	39	1	15/39	83	A	20	100	A	20	18/20				
3	A	20	24	B	33	3	15/20	45	C	43	66	B	33	1	12/33	84	A	20	100	A	20	18/20				
4	A	20	25	A	20	3	12/20	46	B	23	67	C	47	1	22/23	85	A	20	100	A	20	18/20				
5	A	20	26	C	39	3	16/39	47	C	47	68	C	47	1	2/43	86	C	43	100	A	20	18/20				
6	A	20	27	A	18	3	6/18	48	A	18	69	B	23	1	7/23	87	B	20	100	A	20	18/20				
7	B	21	28	C	49	3	3/29	49	C	49	70	B	21	1	6/21	88	B	20	100	A	20	18/20				
8	A	20	29	B	29	3	5/29	50	C	49	71	A	20	1	5/20	89	A	20	100	A	20	18/20				
9	A	20	30	D	31	2	2/31	51	D	31	72	A	20	1	5/20	90	A	20	100	A	20	18/20				
10	B	33	31	A	16	2	13/16	52	A	16	73	C	37	1	8/37	91	A	20	100	A	20	18/20				
11	A	20	32	B	33	2	24/33	53	A	18	74	C	37	1	4/20	92	B	31	100	A	20	18/20				
12	A	20	33	B	33	2	24/33	54	A	18	75	A	20	1	4/20	93	B	31	100	A	20	18/20				
13	C	39	34	A	17	2	11/17	55	B	33	76	A	20	1	4/20	94	C	47	100	A	20	18/20				
14	C	39	35	B	21	2	12/21	56	B	21	77	A	20	1	6/39	95	A	16	100	A	20	18/20				
15	A	16	36	A	20	2	10/20	57	A	10	78	C	39	1	6/39	96	A	16	100	A	20	18/20				
16	A	16	37	C	37	2	16/37	58	B	20	79	C	39	1	2/16	97	C	49	100	A	20	18/20				
17	A	17	38	A	18	2	7/18	59	A	16	80	A	16	1	2/16	98	C	49	100	A	20	18/20				
18	A	18	39	C	39	2	12/39	60	A	20	81	A	18	1	2/18	99	C	33	100	A	20	18/20				
19	A	20	40	A	20	2	15/20	61	A	20	82	A	18	1	2/18	100	A	30	100	A	20	18/20				
20	A	20	41	C	41	2	8/41	62	B	31	83	B	21	1	14/31	101	A	30	100	A	20	18/20				
21	B	21	42	B	21	2	3/21	63	B	21	84	B	21	1	9/21	102	B	31	100	A	20	18/20				

**DP-2 For HV-8 DP-3 For HV-10,12,14 DP-4 For CS-6.8**

T	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N	Y	H	H	N
1	A	28	45	B	34	5	10/34	32	A	32	48	A	32	1	28/32	66	B	34	100	A	32	100	100	A	32	100
2	A	28	46	B	34	5	10/34	33	B	30	49	A	32	2	22/30	67	A	41	100	A	32	100	100	A	32	100
3	A	28	47	A	36	4	28/36	34	A	30	50	A	30	2	22/30	68	A	41	100	A	32	100	100	A	32	100
4	A	28	48	A	36	4	13/28	35	B	30	51	A	34	1	26/34	69	B	30	100	A	32	100	100	A	32	100
5	A	28	49	A	36	4	14/28	36	B	30	52	A	34	1	26/34	70	B	30	100	A	32	100	100	A	32	100
6	A	28	50	A	36	4	14/28	37	A	28	53	A	34	1	19/26	71	A	34	100	A	32	100	100	A	32	100
7	B	27	51	B	27	4	22/27	38	A	28	54	A	30	1	37/30	72	A	48	100	A	32	100	100	A	32	100
8	A	28	52	A	44	4	14/44	39	A	32	55	B	30	1	42/30	73	A	48	100	A	32	100	100	A	32	100
9	A	44	10	A	46	3	42/46	40	A	32	56	A	30	1	20/30	74	A	48	100	A	32	100	100	A	32	100
10	A	44	11	B	69	3	63/69	41	A	30	57	B	30	1	49/77	75	B	71	100	A	32	100	100	A	32	100
11	A	44	12	A	44	3	31/44	42	A	20	58	A	28	1	17/28	76	A	44	100	A	32	100	100	A	32	100
12	A	44	13	A	44	3	31/44	43	A	20	59	A	28	1	17/28	77	A	44	100	A	32	100	100	A	32	100
13	A	28	14	B	28	3	18/28	44	A	41	60	B	27	1	48/27	78	B	27	100	A	32	100	100	A	32	100
14	A	28	15	A	28	3	12/28	45	A	28	61	A	34	1	17/34	79	A	30	100	A	32	100	100	A	32	100
15	A	28	16	A	28	3	12/28	46	A	43	62	A	34	1	17/34	80	A	30	100	A	32	100	100	A	32	100
16	A	28	17	B	28	3	21/28	47	A	43	63	B	27	1	20/27	81	B	27	100	A	32	100	100	A	32	100
17	A	28	18	B	28	3	6/28	48	A	43	64	A	43	2	2/43	82	B	27	100	A	32	100	100	A	32	100
18	A	28	19	B	28	3	6/28	49	A	40	65	A	40	1	44/40	83	B	27	100	A	32	100	100	A	32	100
19	A	28	20	B	28	3	6/28	50	A	40	66	A	40	1	44/40	84	B	27	100	A	32	100	100	A	32	100
20	A	28	21	B	28	3	6/28	51	A	40	67	A	40	1	44/40	85	B	27	100	A	32	100	100	A	32	100
21	A	28	22	B	28	3	6/28	52	A	40	68	A	40	1	44/40	86	B	27	100	A	32	100	100	A	32	100
22	A	28	23	B	28	3	6/28	53	A	40	69	A	40	1	44/40	87	B	27	100	A	32	100	100	A	32	100
23	A	28	24	B	28	3	6/28	54	A	40	70	A	40	1	44/40	88	B	27	100	A	32	100	100	A	32	100
24	A	28	25	B	28	3	6/28	55	A	40	71	A	40	1	44/40	89	B	27	100	A	32	100	100	A	32	100
25	A	28	26	B	28	3	6/28	56	A	40	72	A	40	1	44/40	90	B	27	100	A	32	100	100	A	32	100
26	A	28	27	B	28	3	6/28	57	A	40	73	A	40	1	44/40	91	B	27	100	A	32	100	100	A	32	100
27	A	28	28	B	28	3	6/28	58	A	40	74	A	40	1	44/40	92	B	27	100	A	32	100	100	A	32	100
28	A	28	29	B	28	3	6/28	59	A	40	75	A	40	1	44/40	93	B	27	100	A	32	100	100	A	32	100
29	A	28	30	B	28	3	6/28	60	A	40	76	A	40	1	44/40	94	B	27	100	A	32	100	100	A	32	100
30	A	28	31	B	28	3	6/28	61	A	40	77	A	40	1	44/40	95	B	27	100	A	32	100	100	A	32	100
31	A	28	32	B	28	3	6/28	62	A	40	78	A	40	1	44/40	96	B	27	100	A	32	100	100	A	32	100
32	A	28	33	B	28	3	6/28	63	A	40	79	A	40	1	44/40	97	B	27	100	A	32	100	100	A	32	100
33	A	28	34	B	28	3	6/28	64	A	40	80	A	40	1	44/40	98	B	27	100	A	32	100	100	A	32	100
34	A	28	35	B	28	3	6/28	65	A	40	81	A	40	1	44/40	99	B	27	100	A	32	100	100	A	32	100
35	A	28	36	B	28	3	6/28	66	A	40	82	A	40	1	44/40	100	B	27	100	A	32	100	100	A	32	100

**Description of In the index table.**

This table is the one being calculated for the index plate with hole numbers shown below.

**Description of codes used in the index table**

T : Desired dividual number

N : Number of revolution of the crank handle

H : Hole number of the index plate

: Option

A : Using A plate

B : Using B plate

**Number of holes**

**DP-1**

A Plate.....15, 16, 17, 18, 19, 20

B Plate.... 21, 23, 27, 29, 31, 33

C Plate.....37, 39, 41, 43, 47, 49

**DP-2-3-4**

A Plate.....26, 28, 30, 32, 34, 37, 38, 39, 41, 43, 44, 46,

47, 49, 51, 53, 57, 59

B Plate.... 61, 63, 67, 69, 71, 73, 77, 79, 81, 83, 87, 89,

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