

TC

FIXED-STATION ROTARY INDEXING TABLES | TC ROTARY INDEXING TABLE



TC ROTARY INDEXING TABLE: RELIABILITY FOR A LIFETIME

EXTENDED WARRANTY

Using our rotary table control system minimises brake wear. This makes the rotary indexing table virtually maintenance-free throughout its entire service life. And using this control system also extends the warranty to four years.



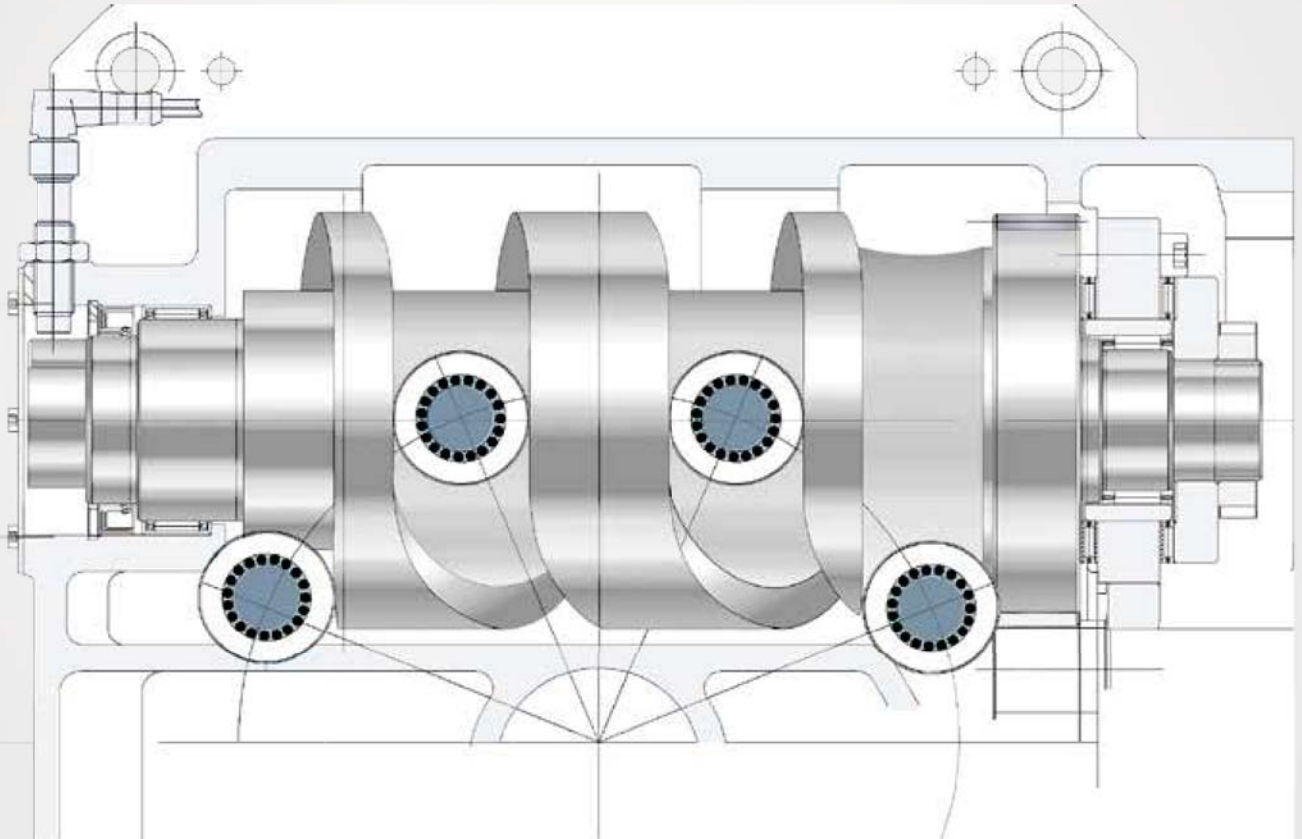


Custom machine for an automotive supplier. The assembly of sealing rings for injection pumps requires maximum precision. The TC 150 rotary indexing table with matched rotating plate delivers this.

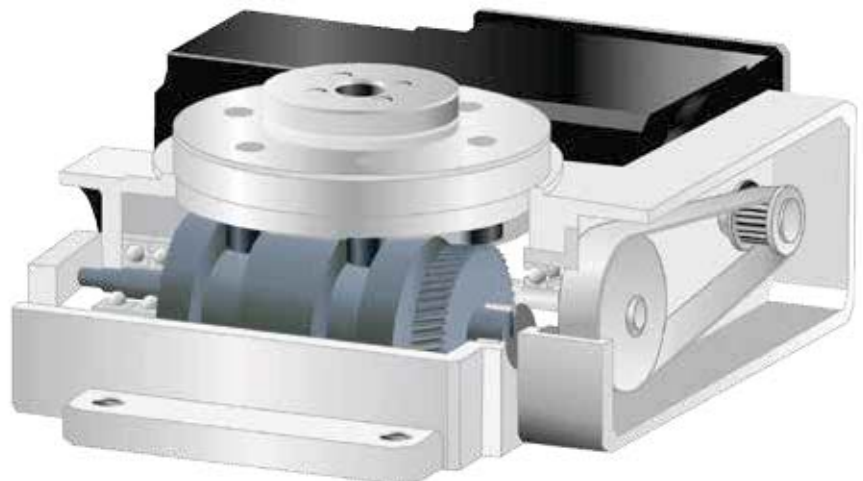
One of the most reliable and robust rotary indexing tables available worldwide. Your most popular partner in the field of automation technology. Extremely long service life combined with impressively fast switching. Now in its third generation. Robust rotary indexing table with smooth, jerk and impact-free running and extremely long service life. When using a WEISS rotary table control system, we extend the warranty from one to four years.

ADVANTAGES

- Powerful upright centre part
- Large central bore
- Plate gasket with soiling lip
- Precise, high-load plate bearing
- Cam rollers mounted on needle bearings
- Grey iron housing
- Hardened plates, soft mounting surface
- EWR electronic wear compensation
- Extremely high precision which always comes with an approval certificate.



The TC is one of the most reliable and robust rotary indexing tables available worldwide. Our roller cam drives are dimensioned as large as possible. And the full length of the cams is used here.



The fastest switching times and an extremely long service life – we achieve this with high-precision drive cams made by our in-house manufacturing department.

DELIVERS WHAT IT PROMISES – THAT’S A PROMISE.

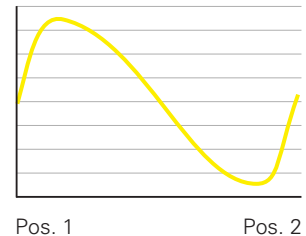
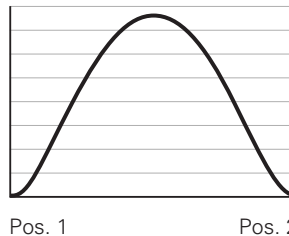
OPTIMISED BEARINGS

To achieve maximum quality and reliability, even when under load, all roller bearings run in an oil bath and the plate cam rollers are mounted on needle bearings.



GENTLE MOVEMENTS

Thanks to the cam profile with modified sine wave, we are able to achieve very gentle and smooth movements. This is the prerequisite for the fastest indexing times and a long service life.



— v velocity characteristics

— a acceleration characteristics

AS FLEXIBLE AS ITS DEPLOYMENT

The drive can be swung downward. You can do the conversion work yourself.



THE CLEANLINE: FOR CLEANROOM APPLICATIONS

Cleanroom-certified version also available: The TC 150T CL is certified to air cleanliness class 5 as per ISO 14644-1.





TC 120G

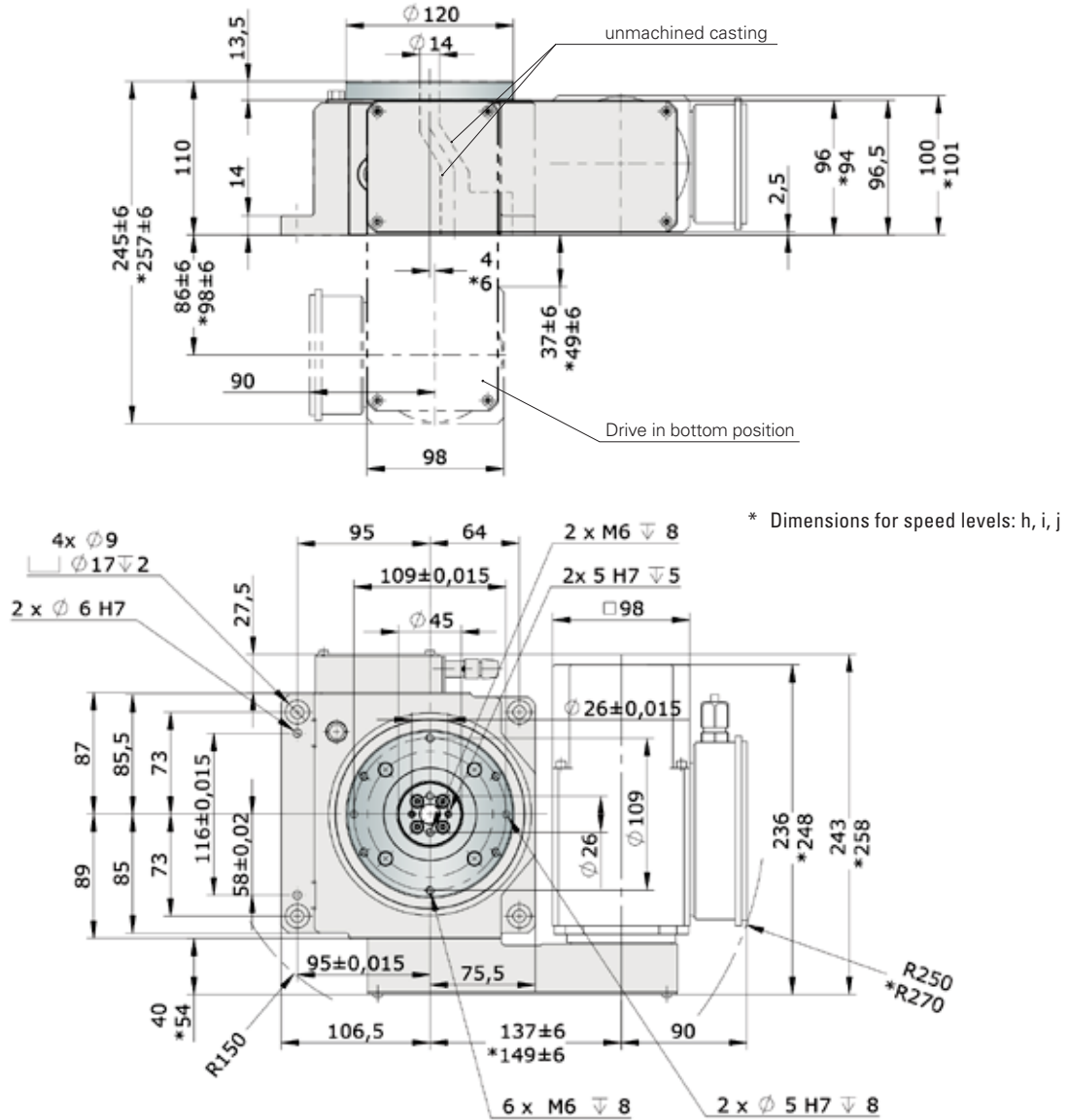
TECHNICAL DATA

Tool plate diameter:	Recommended up to 600 mm	Mounting position:	See page 47 – on request, also suitable for screw-on mounting from above (please request drawing)*
Dial diameter:	120 mm	Indexing precision (arcsec):	Indexing 2-10: $\pm 45''$ Indexing 12-20: $\pm 55''$ Higher indexing precision upon request
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Indexing precision in radian measurement:	(at \varnothing 120 mm) indexing 2-10: ± 0.013 mm indexing 12-20: ± 0.016 mm
Indexings:	2, 4, 5, 6, 8, 10, 12, 16, 20, special increments upon request	Max. axial run-out of the plate:	(at \varnothing 120 mm) 0.02 mm
Cycle frequency:	Up to 220 cpm, depending on mass moment of inertia and angle of rotation	Max. concentricity:	0.02 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Max. parallelism of rotating plate surface to bottom housing surface:	(at \varnothing 120 mm) 0.04 mm
Drive motor:	0.045 - 0.12 kW; size 56		
Weight:	22 kg		

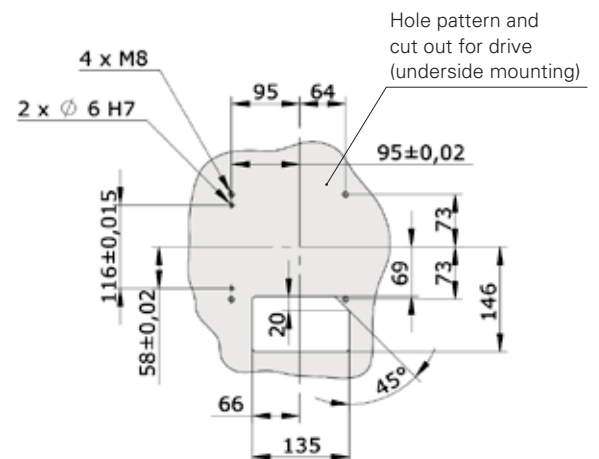
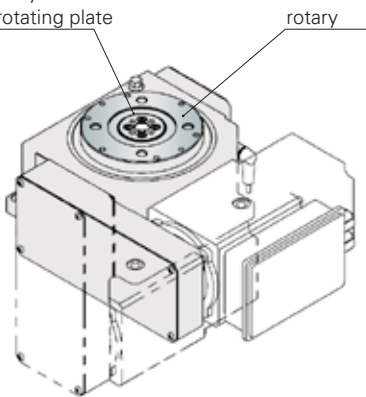
* Please consult WEISS for overhead mounting positions.

DIMENSIONS

If you require subsequent drilling work on the indexing table, please request information on permissible drilling depths. The illustrated rotating plate position corresponds to the basic position of the rotary indexing table (Position when delivered).



Jockey pulley, stationary
0.5 mm lower than rotating plate



Max. centre line deviation between stationary centre section and dial: ± 180"
Max. centre line deviation between dial and indexer housing: ± 120"

Note: Please ensure motor and brake are accessible for servicing!

TC 120G

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

Indexing		Speed level										
		s	a	b	c	d	e	f	g	h	i	j
2	J_{max}	-	-	-	0.06	0.1	0.174	0.285	0.505	1.15	2.03	4.94
	t _s	-	-	-	0.41	0.51	0.63	0.78	0.99	1.42	1.81	2.66
4	J_{max}	-	0.1 *	0.19	0.29	0.47	0.67	1.25	1.95	5.11	8.95	19.5
	t _s	-	0.24 *	0.31	0.37	0.46	0.57	0.70	0.89	1.28	1.63	2.39
5	J_{max}	-	0.16 *	0.33	0.5	0.808	1.05	1.95	3	8.7	14.1	30.5
	t _s	-	0.24 *	0.31	0.37	0.46	0.57	0.70	0.89	1.28	1.63	2.39
6	J_{max}	0.136 *	0.23 *	0.408	0.62	1	1.5	2.70	4.4	10.7	18.8	44
	t _s	0.21 *	0.24 *	0.31	0.37	0.46	0.57	0.70	0.89	1.28	1.63	2.39
8	J_{max}	0.248 *	0.41 *	0.85	1.28	2.07	2.7	5	7.8	21.4	34.9	75.5
	t _s	0.21 *	0.24 *	0.31	0.37	0.46	0.57	0.70	0.89	1.28	1.63	2.39
10	J_{max}	0.35 *	0.57 *	1	1.51	2.44	4.08	6.55	10.7	21.8	35.5	76.8
	t _s	0.21 *	0.24 *	0.31	0.37	0.46	0.57	0.70	0.89	1.28	1.63	2.39
12	J_{max}	-	-	-	-	0.47 *	0.67	1.25	1.95	5.08	8.9	19.6
	t _s	-	-	-	-	0.22 *	0.27	0.34	0.43	0.61	0.78	1.15
16	J_v	-	-	-	-	0.55 *	0.92	1.49	2.6	5.9	10.3	25.2
	t _s	-	-	-	-	0.22 *	0.27	0.34	0.43	0.61	0.78	1.15
20	J_{max}	-	-	-	-	0.86 *	1.44	2.32	4.06	9.2	16.1	35.5
	t _s	-	-	-	-	0.22 *	0.27	0.34	0.43	0.61	0.78	1.15

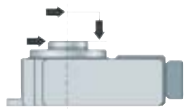
J = max admissible mass inertia loading (kgm²) **t_s** = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

***EF2** - control system for brake wear reduction recommended (see page 58).

Note on indexing times

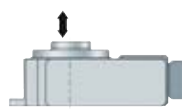
The actual measured rotation time (from the start signal to the electrical in-position signal) comprises the calculated rotation motion time given in the tables and type-related delays. An important factor are electrical signal processing times, input filters, mechanical motor idle times and also the setting and optimization of the ideal starting position.

LOAD DATA (for the stationary centre section)



Perm. tilting moment acting on the centre section

150 Nm



Perm. radial force acting on the centre section

2000 N



Perm. force acting vertically on the centre section

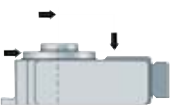
3000 N



Perm. tangential moment acting on the centre section

120 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

200 Nm



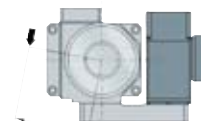
Perm. radial force acting on the locked dial plate

2000 N



Perm. operating force (acting vertically on the locked dial plate within the normal Ø)

3300 N

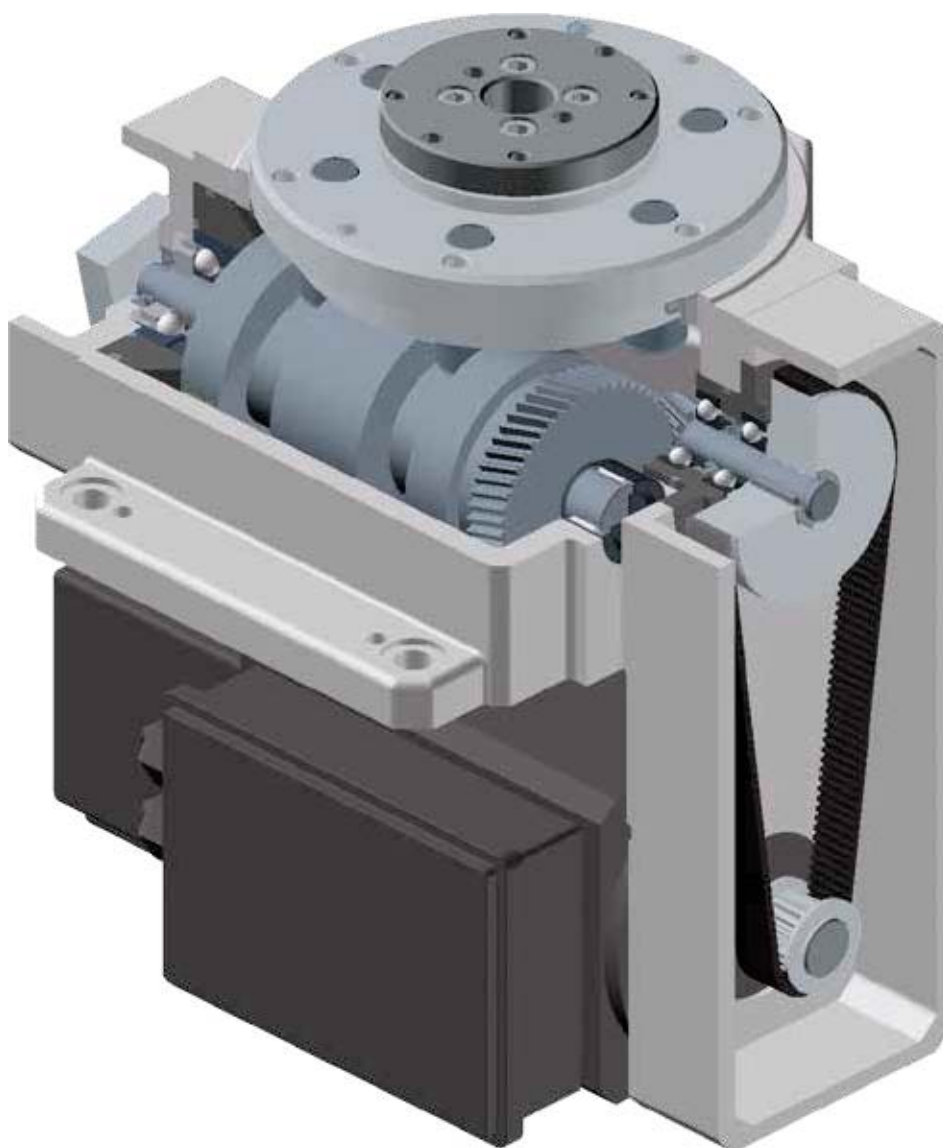


Perm. tangential moment acting on the locked dial plate

120 Nm

Combined loads only after inspection by WEISS.

TC 120G (The picture shows TC 150T)





TC 150T

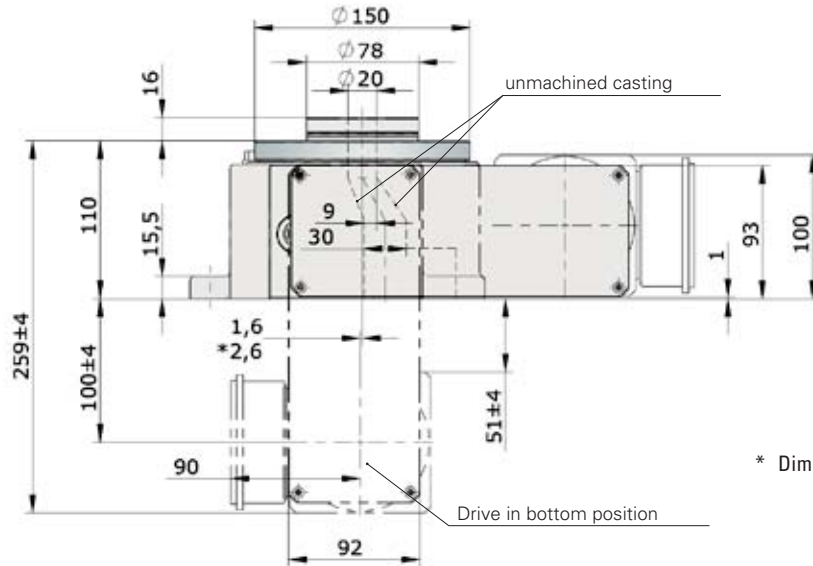
TECHNICAL DATA

Tool plate diameter:	Recommended up to 800 mm	Mounting position:	See page 47*
Dial diameter:	150 mm	Indexing precision (arcsec):	Indexing 2-12: $\pm 30''$ indexing 16-24: $\pm 45''$ Higher indexing precision upon request
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Indexing precision in radian measurement:	(at $\varnothing 150$ mm) indexing 2-12: ± 0.011 mm indexing 16-24: ± 0.016 mm
Indexings:	2, 3, 4, 6, 8, 10, 12, 16, 20, 24, special increments upon request	Max. axial run-out of the plate:	(at $\varnothing 150$ mm) 0.01 mm
Cycle frequency:	Up to 230 cpm, depending on mass moment of inertia and angle of rotation	Max. concentricity:	0.01 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Max. parallelism of rotating plate surface to bottom housing surface:	(at $\varnothing 150$ mm) 0.03 mm
Drive motor:	0.045 - 0.12 kW, size 56	Min. inner diameter of tool plate:	80 mm
Weight:	23 kg		

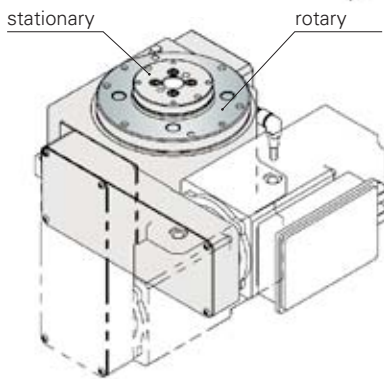
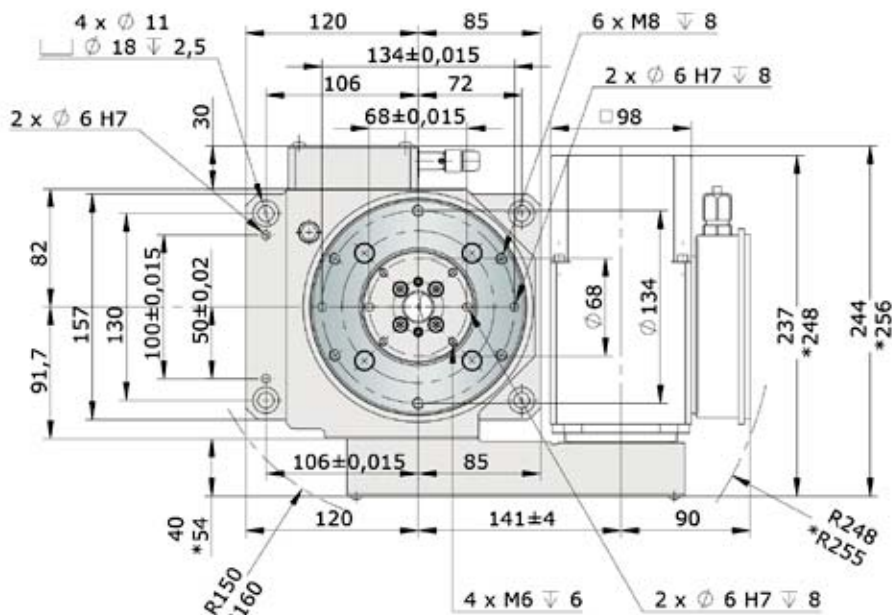
* Please consult WEISS for overhead mounting positions.

DIMENSIONS

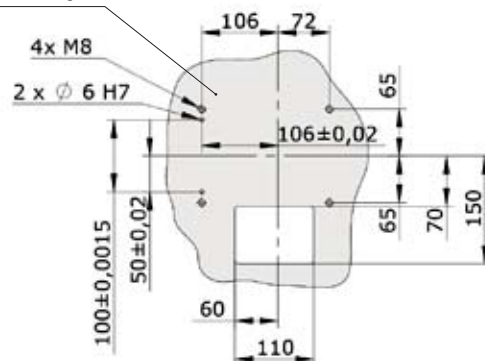
If you require subsequent drilling work on the indexing table, please request information on permissible drilling depths. The illustrated rotating plate position corresponds to the basic position of the rotary indexing table (Position when delivered).



* Dimensions for speed levels: h, i, j



hole pattern and cut out for drive (underside mounting)



Max. centre line deviation between stationary centre section and dial: ± 180"

Max. centre line deviation between dial and indexer housing: ± 120"

Note: Please ensure motor and brake are accessible for servicing!

TC 150T

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

Indexing		Speed Step										
		s	a	b	c	d	e	f	g	h	i	j
2	J_{max}	-	-	-	0.09	0.149	0.255	0.415	0.73	1.67	2.93	7.12
	t_s	-	-	-	0.43	0.53	0.66	0.81	1.03	1.47	1.88	2.76
3	J_{max}	-	-	-	0.14	0.23	0.39	0.63	1.1	2.53	4.43	10.7
	t_s	-	-	-	0.43	0.53	0.66	0.81	1.03	1.47	1.88	2.76
4	J_{max}	-	0.11 *	0.23	0.37	0.59	0.75	1.4	2.17	6.4	11.3	26.4
	t_s	-	0.25 *	0.32	0.39	0.47	0.59	0.73	0.93	1.33	1.69	2.49
6	J_{max}	0.155 *	0.26 *	0.53	0.8	1.29	1.69	3.15	4.9	13.9	24.3	59
	t_s	0.21 *	0.25 *	0.32	0.39	0.47	0.59	0.73	0.93	1.33	1.69	2.49
8	J_{max}	0.28 *	0.46 *	0.96	1.62	2.61	3.02	5.61	8.71	25.3	48.8	105
	t_s	0.21 *	0.25 *	0.32	0.39	0.47	0.59	0.73	0.93	1.33	1.69	2.49
10	J_{max}	0.44 *	0.72 *	1.42	2.14	3.45	4.72	8.80	13.5	36.8	61	132
	t_s	0.21 *	0.25 *	0.32	0.39	0.47	0.59	0.73	0.93	1.33	1.69	2.49
12	J_{max}	0.64 *	1.04 *	1.82	2.75	4.42	6.8	11.9	19.8	45.2	73.4	158
	t_s	0.21 *	0.25 *	0.32	0.39	0.47	0.59	0.73	0.93	1.33	1.69	2.49
16	J_v	-	-	-	0.55	0.88	1.34	2.4	3.9	9.5	16.7	40.6
	t_s	-	-	-	0.19	0.23	0.29	0.35	0.45	0.64	0.81	1.20
20	J_v	-	-	-	0.69	1.11	1.86	3.01	5.26	11.95	20.9	50.7
	t_s	-	-	-	0.19	0.23	0.29	0.35	0.45	0.64	0.81	1.20
24	J_{max}	-	-	-	0.83 *	1.33 *	2.24	3.61	6.3	14.35	25.1	60.90
	t_s	-	-	-	0.19 *	0.23 *	0.29	0.35	0.45	0.64	0.81	1.20

J = max admissible mass inertia loading (kgm²) t_s = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

*EF2 - control system for brake wear reduction recommended (see page 58).

Note on indexing times

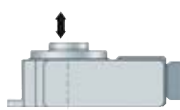
The actual measured rotation time (from the start signal to the electrical in-position signal) comprises the calculated rotation motion time given in the tables and type-related delays. An important factor are electrical signal processing times, input filters, mechanical motor idle times and also the setting and optimization of the ideal starting position.

LOAD DATA (for the stationary centre section)



Perm. tilting moment acting on the centre section

200 Nm



Perm. radial force acting on the centre section

2500 N



Perm. force acting vertically on the centre section

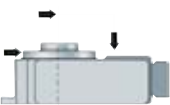
3500 N



Perm. tangential moment acting on the centre section

150 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

500 Nm



Perm. radial force acting on the locked dial plate

6000 N



Perm. operating force (acting vertically on the locked dial plate within the normal \emptyset)

5500 N

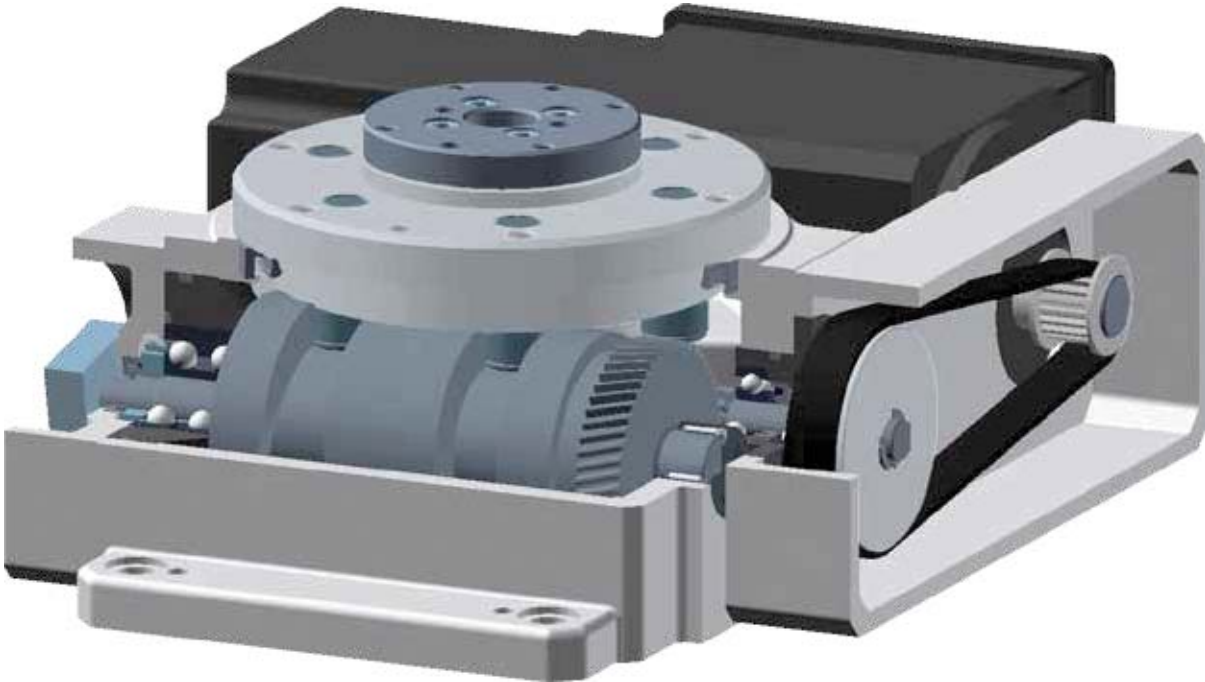


Perm. tangential moment acting on the locked dial plate

150 Nm

Combined loads only after inspection by WEISS.

TC 150T





TC 220T

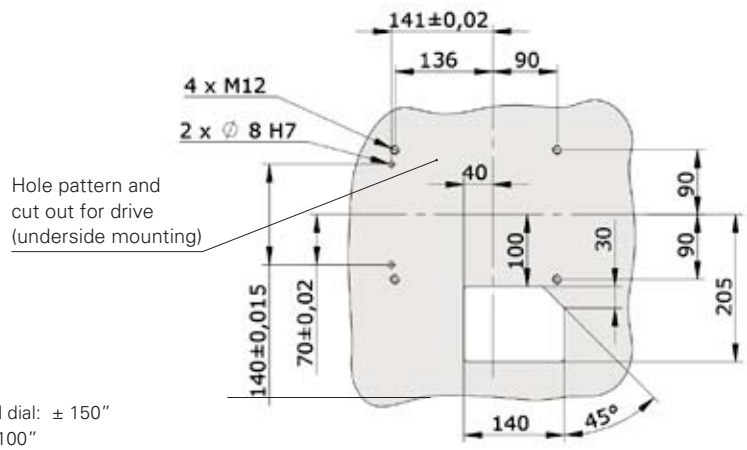
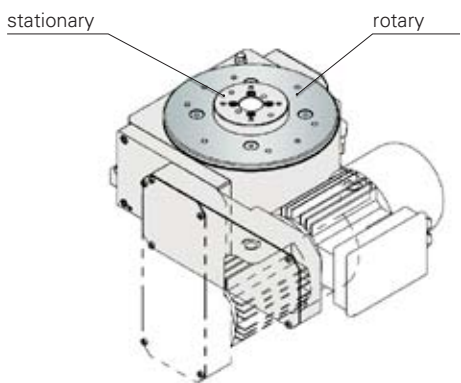
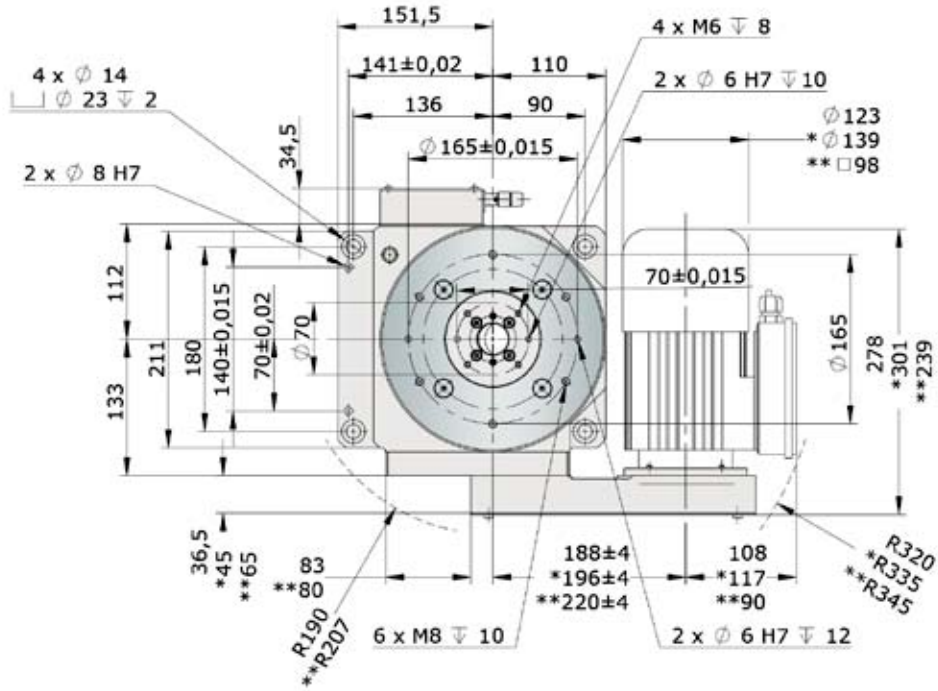
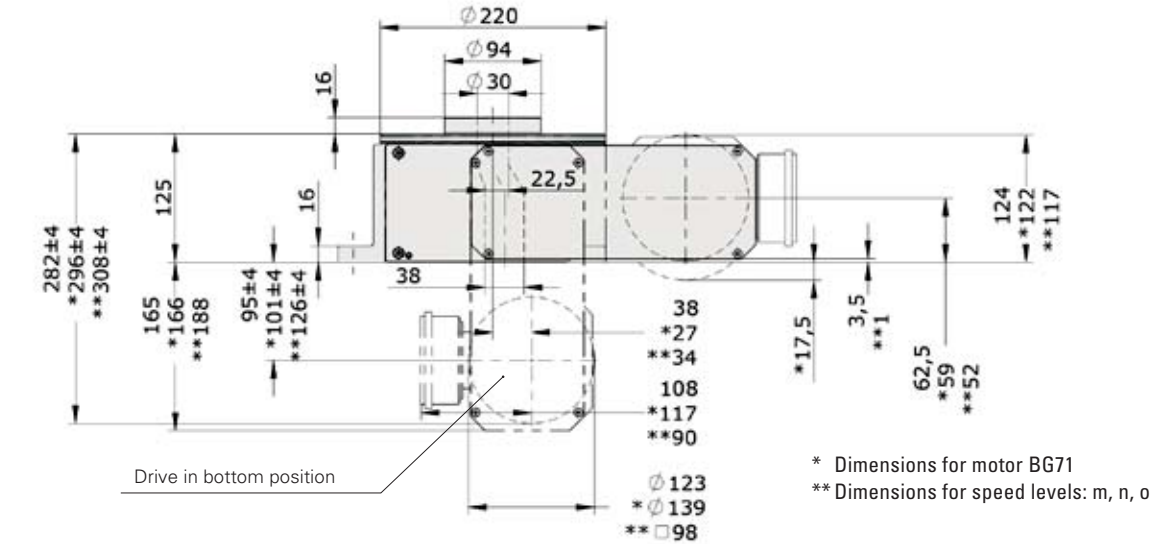
TECHNICAL DATA

Tool plate diameter:	Recommended up to 1100 mm	Indexing precision (arcsec):	Indexing 2-12: $\pm 20''$ Indexing 16-24: $\pm 30''$ Indexing 30-36: $\pm 40''$ Higher indexing precision upon request
Dial diameter:	220 mm	Indexing precision in radian measurement:	(at $\varnothing 220$ mm) Indexing 2-12: ± 0.011 mm Indexing 16-24: ± 0.016 mm Indexing 30-36: ± 0.021 mm
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Max. axial run-out of the plate:	(at $\varnothing 220$ mm) 0.01 mm
Indexings:	2, 3, 4, 6, 8, 10, 12, 16, 20, 24, 30, 36, special increments upon request	Max. concentricity:	0.01 mm
Cycle frequency:	Up to 220 cpm, depending on mass moment of inertia and angle of rotation	Max. parallelism of rotating plate surface to bottom housing surface:	(at $\varnothing 220$ mm) 0.03 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Min. inner diameter of tool plate:	96 mm
Drive motor:	0.045 - 0.37 kW, size 56/63/71		
Weight:	44 kg		
Mounting position:*	See page 47		

* Please consult WEISS for overhead mounting positions.

DIMENSIONS

If you require subsequent drilling work on the indexing table, please request information on permissible drilling depths. The illustrated rotating plate position corresponds to the basic position of the rotary indexing table (Position when delivered).



Max. centre line deviation between stationary centre section and dial: ± 150"
 Max. centre line deviation between dial and indexer housing: ± 100"

Note: Please ensure motor and brake are accessible for servicing!

TC 220T

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

Indexing		Speed level													
		b	c	d	e	f	g	h	i	j	k	l	m	n	o
2	J _{max}	-	-	0.15	0.36	0.58	0.76	1.3	2.02	3.55	9.6	13.30	35.6	96	167
	t _s	-	-	0.35	0.50	0.60	0.67	0.84	1.02	1.30	1.99	2.30	3.53	5.42	6.91
3	J _{max}	-	0.18 *	0.3	0.69	1.09	1.43	2.41	3.73	6.54	17.65	24.55	65.5	176	308
	t _s	-	0.29 *	0.35	0.50	0.60	0.67	0.84	1.02	1.30	1.99	2.30	3.53	5.42	6.91
4	J _{max}	0.12 *	0.24 *	0.46	1.34	2.38	3.36	6.6	11.6	17.3	31.5	48.5	144	340	552
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	0.61	0.76	0.92	1.17	1.80	2.07	3.17	4.88	6.22
6	J _{max}	0.31 *	0.58 *	1.06	3.05	5.4	7.6	14.9	24.9	26	70.9	109	324	765	1240
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	0.61	0.76	0.92	1.17	1.80	2.07	3.17	4.88	6.22
8	J _{max}	0.58 *	1.06 *	1.92	5.44	9.63	13.55	19.05	33.5	46.2	126	195	495	1170	1900
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	0.61	0.76	0.92	1.17	1.80	2.07	3.17	4.88	6.22
10	J _{max}	0.92 *	1.67 *	3.01	8.48	14.55	18.88	29.8	48.7	72	192	257	600	1420	2300
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	0.61	0.76	0.92	1.17	1.80	2.07	3.17	4.88	6.22
12	J _{max}	1.34 *	2.41 *	4.35	10.7	16	20.1	31.5	45.9	74.6	176.4	235.2	551	1300	2110
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	0.61	0.76	0.92	1.17	1.80	2.07	3.17	4.88	6.22
16	J _v	-	-	-	2 *	3.1 *	4.03	6.74	9.95	18.2	49.1	68.30	182	490	855
	t _s	-	-	-	0.22 *	0.26 *	0.29	0.37	0.44	0.56	0.86	1.00	1.53	2.35	2.99
20	J _v	-	-	-	3.05 *	4.72 *	6.14	10.2	15.6	27.7	68.1	90.9	213	500	815
	t _s	-	-	-	0.22 *	0.26 *	0.29	0.37	0.44	0.56	0.86	1.00	1.53	2.35	2.99
24	J _v	-	-	-	3.67 *	5.68 *	7.38 *	12.35	19	33.3	81.7	109	255	600	980
	t _s	-	-	-	0.22 *	0.26 *	0.29 *	0.37	0.44	0.56	0.86	1.00	1.53	2.35	2.99
30	J _v	-	-	-	-	-	3.59 *	6.01 *	9.29 *	16.2	43.7	60.9	162	420	680
	t _s	-	-	-	-	-	0.19 *	0.24 *	0.29 *	0.37	0.57	0.65	1.00	1.54	1.96
36	J _{max}	-	-	-	-	-	4.32 *	7.23 *	11.15*	19.5	52	69.5	163	385	625
	t _s	-	-	-	-	-	0.19 *	0.24 *	0.29 *	0.37	0.57	0.65	1.00	1.54	1.96

Loads when using motor BG71

Indexing		Speed level													
		b	c	d	e	f	g	h	i	j	k	l	m	n	o
4	J _{max}	0.19 *	0.37 *	0.69	1.97	3.5	4.61	-	-	-	-	-	-	-	-
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	0.61	-	-	-	-	-	-	-	-
6	J _{max}	0.48 *	0.87 *	1.59	4.53	7.45	-	-	-	-	-	-	-	-	-
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	-	-	-	-	-	-	-	-	-
8	J _{max}	0.87 *	1.58 *	2.85	6.92	10.7	-	-	-	-	-	-	-	-	-
	t _s	0.22 *	0.26 *	0.32	0.45	0.54	-	-	-	-	-	-	-	-	-
10	J _{max}	1.37 *	2.48 *	4.24	9.4	-	-	-	-	-	-	-	-	-	-
	t _s	0.22 *	0.26 *	0.32	0.45	-	-	-	-	-	-	-	-	-	-
12	J _{max}	1.96 *	3.08 *	-	-	-	-	-	-	-	-	-	-	-	-
	t _s	0.22 *	0.26 *	-	-	-	-	-	-	-	-	-	-	-	-

J = max admissible mass inertia loading (kgm²) t_s = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

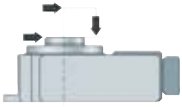
*EF2 - control system for brake wear reduction recommended (see page 58).

The values in the second table apply for the maximum permitted mass moment of inertia when using the size 71 motor.

Note on indexing times

The actual measured rotation time (from the start signal to the electrical in-position signal) comprises the calculated rotation motion time given in the tables and type-related delays. An important factor are electrical signal processing times, input filters, mechanical motor idle times and also the setting and optimization of the ideal starting position.

LOAD DATA (for the stationary centre section)



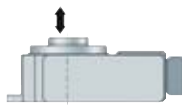
Perm. tilting moment acting on the centre section

300 Nm



Perm. radial force acting on the centre section

4000 N



Perm. force acting vertically on the centre section

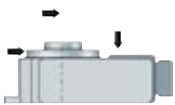
5000 N



Perm. tangential moment acting on the centre section

200 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

700 Nm



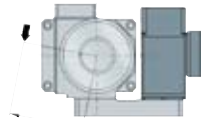
Perm. radial force acting on the locked dial plate

8000 N



Perm. operating force (acting vertically on the locked dial plate within the normal \emptyset)

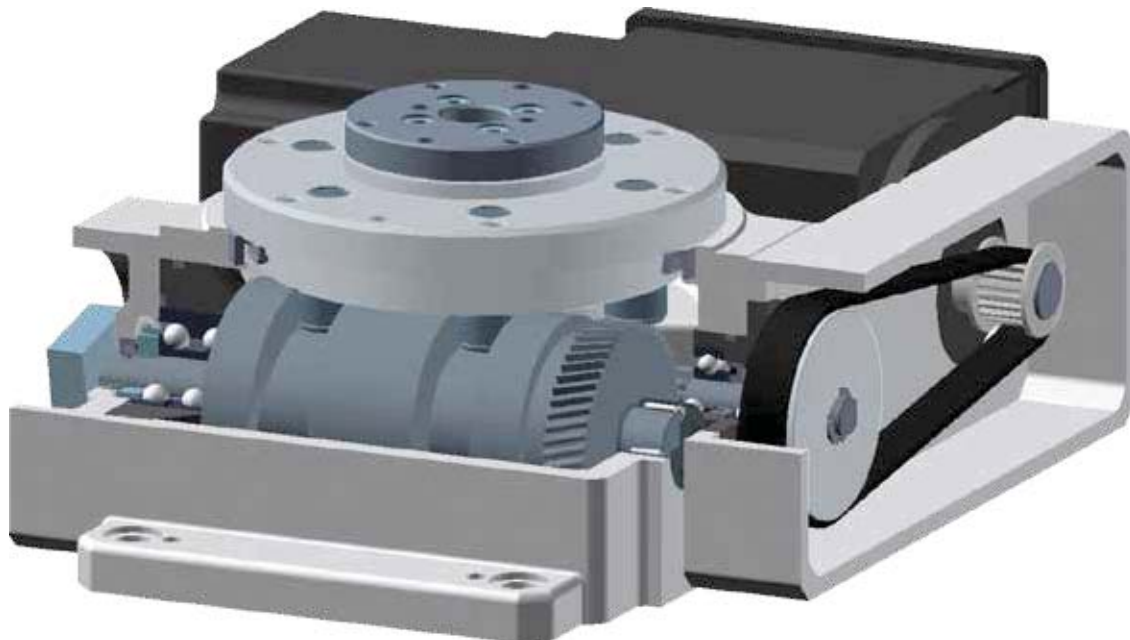
7500 N



Perm. tangential moment acting on the locked dial plate

200 Nm

Combined loads only after inspection by WEISS.





TC 320T

TECHNICAL DATA

Tool plate diameter:	Recommended up to 1400 mm	Indexing precision (arcsec):	Indexing 2-12: $\pm 20''$ Indexing 16-24: $\pm 30''$ Indexing 30-36: $\pm 35''$ Higher indexing precision upon request
Dial diameter:	320 mm	Indexing precision in radian measurement:	(at $\varnothing 320$ mm) Indexing 2-12: ± 0.016 mm Indexing 16-24: ± 0.023 mm Indexing 30-36: ± 0.027 mm
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Max. axial run-out of the plate:	(at $\varnothing 320$ mm) 0.01 mm
Indexings:	2, 3, 4, 6, 8, 10, 12, 16, 20, 24, 30, 36, special increments upon request	Max. concentricity:	0.01 mm
Cycle frequency:	Up to 200 cpm, depending on mass moment of inertia and angle of rotation	Max. parallelism of rotating plate surface to bottom housing surface:	(at $\varnothing 320$ mm) 0.03 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Min. inner diameter of tool plate:	150 mm
Drive motor:	0.18 kW - 1.1, size 71/80		
Weight:	112 kg		
Mounting position:*	See page 47		

* Please consult WEISS for overhead mounting positions.

TC 320T

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

Indexing		Speed Step																		
		s	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o	p	q	
2	J _{max}	-	-	-	-	-	2.67	3.51	4.3	6.27	9.79	18	27.3	36.6	72	95.5	106	143	214	
	t _s	-	-	-	-	-	0.61	0.69	0.75	0.89	1.06	1.37	1.64	2.07	2.64	3.04	3.3	3.72	4.55	
3	J _{max}	-	-	-	-	3.15	4.26	5.58	6.81	10.3	15.3	28.1	42.6	72.8	127	175	212	280	446	
	t _s	-	-	-	-	0.54	0.61	0.69	0.75	0.89	1.06	1.37	1.64	2.07	2.64	3.04	3.3	3.72	4.55	
4	J _{max}	1.62 *	2.95 *	4.59	5.6	7.33	9.83	11.8	15.2	23.4	31.8	58.1	83.4	109	215	285	318	427	640	
	t _s	0.3 *	0.36 *	0.42	0.45	0.51	0.57	0.64	0.7	0.83	0.99	1.28	1.53	1.93	2.46	2.83	3.08	3.47	4.25	
6	J _{max}	3.9 *	6.89 *	9.57	11.6	15.1	20.2	26.2	31.9	48	71.1	129	187	246	485	641	716	961	1440	
	t _s	0.3 *	0.36 *	0.42	0.45	0.51	0.57	0.64	0.7	0.83	0.99	1.28	1.53	1.93	2.46	2.83	3.08	3.47	4.25	
8	J _{max}	7.1 *	12.4 *	18.97	24.2	31.4	42	54.4	66.1	98.4	128	233	334	439	862	1140	1270	1700	2560	
	t _s	0.3 *	0.36 *	0.42	0.45	0.51	0.57	0.64	0.7	0.83	0.99	1.28	1.53	1.93	2.46	2.83	3.08	3.47	4.25	
10	J _{max}	10 *	17.19 *	23.7	28.8	37.5	50	64.8	78.7	118	174	318	456	615	1170	1550	1780	2330	3500	
	t _s	0.29 *	0.35 *	0.4	0.44	0.49	0.55	0.62	0.67	0.8	0.95	1.24	1.48	1.87	2.38	2.73	2.97	3.35	4.1	
12	J _{max}	13.5 *	20.7 *	28.6	34.7	45.1	60.1	77.9	94.7	142	210	382	547	871	1410	1860	2200	2800	4200	
	t _s	0.29 *	0.35 *	0.4	0.44	0.49	0.55	0.62	0.67	0.8	0.95	1.24	1.48	1.87	2.38	2.73	2.97	3.35	4.1	
16	J _v	-	-	-	-	8.15 *	10.9 *	14.2	17.2	26	38.5	70.4	105	138	271	359	400	538	806	
	t _s	-	-	-	-	0.22 *	0.25 *	0.28	0.3	0.36	0.42	0.55	0.66	0.83	1.06	1.21	1.32	1.49	1.82	
20	J _v	-	-	-	-	12.29 *	16.4 *	21.3	25.9	37.7	57.7	105	159	215	424	561	626	841	1260	
	t _s	-	-	-	-	0.22 *	0.25 *	0.28	0.3	0.36	0.42	0.55	0.66	0.83	1.06	1.21	1.32	1.49	1.82	
24	J _v	-	-	-	-	17.24 *	22.3	27.2	40.9	60.5	110	167	285	498	686	872	1100	1650		
	t _s	-	-	-	-	0.25 *	0.28	0.3	0.36	0.42	0.55	0.66	0.83	1.06	1.21	1.32	1.49	1.82		
30	J _v	-	-	-	-	-	-	14.16 *	21.3 *	31.6	57.7	87.5	143	260	359	418	560	840		
	t _s	-	-	-	-	-	-	0.2 *	0.24 *	0.28	0.37	0.44	0.55	0.7	0.81	0.88	0.99	1.21		
36	J _{max}	-	-	-	-	-	-	17.03 *	25.6 *	37.9	69.3	103	179	308	431	581	738	1100		
	t _s	-	-	-	-	-	-	0.2 *	0.24 *	0.28	0.37	0.44	0.55	0.7	0.81	0.88	0.99	1.21		

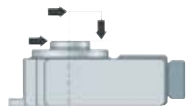
J = max admissible mass inertia loading (kgm²) t_s = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

*EF2 - control system for brake wear reduction recommended (see page 58).

Note on indexing times

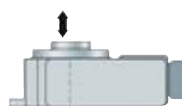
The actual measured rotation time (from the start signal to the electrical in-position signal) comprises the calculated rotation motion time given in the tables and type-related delays. An important factor are electrical signal processing times, input filters, mechanical motor idle times and also the setting and optimization of the ideal starting position.

LOAD DATA (for the stationary centre section)



Perm. tilting moment acting on the centre section

1800 Nm



Perm. radial force acting on the centre section

10000 N

Perm. force acting vertically on the centre section

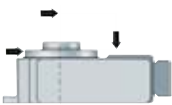
18000 N



Perm. tangential moment acting on the centre section

800 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

2250 Nm

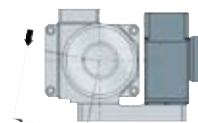


Perm. radial force acting on the locked dial plate

15000 N

Perm. operating force (acting vertically on the locked dial plate within the normal Ø)

15000 N

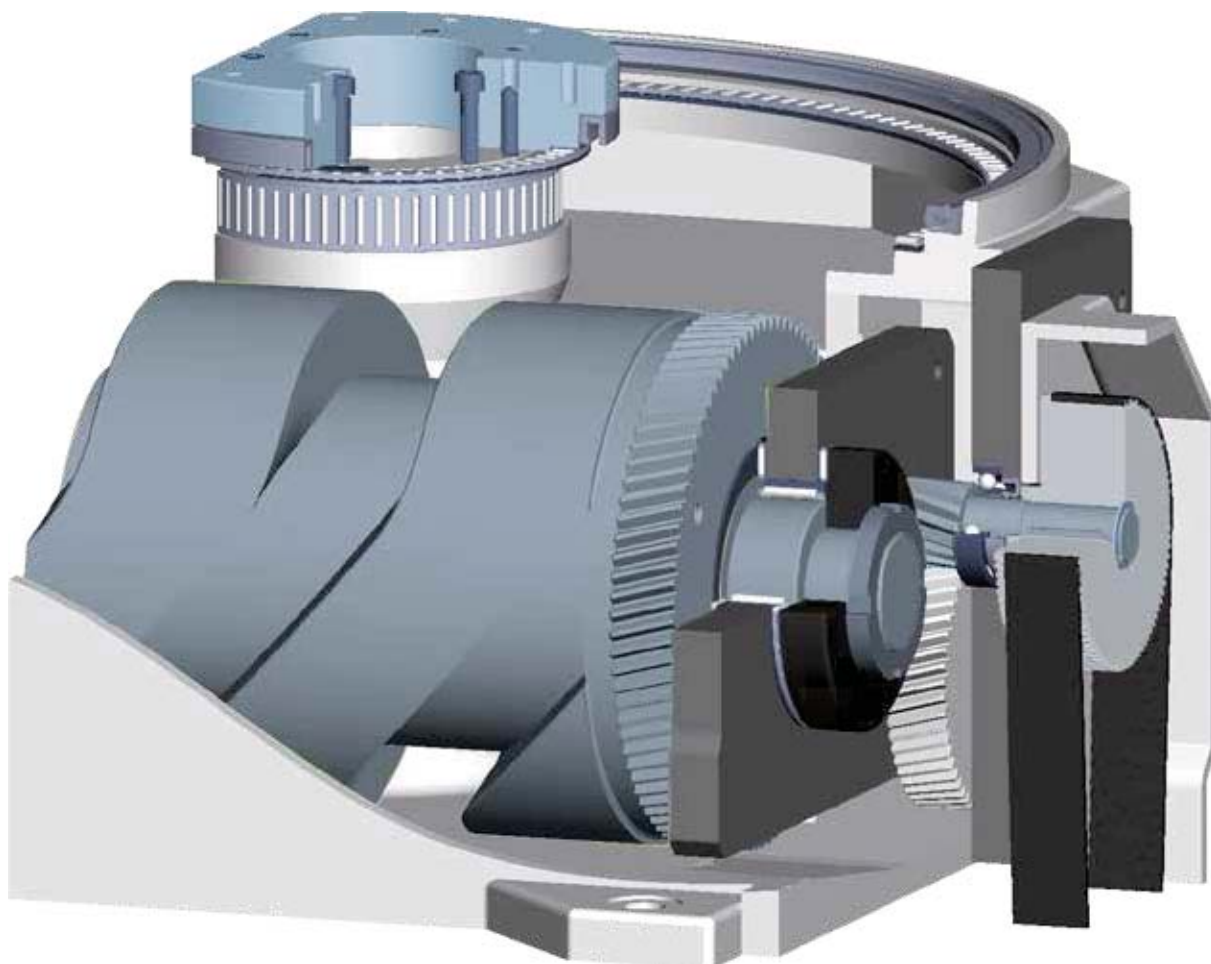


Perm. tangential moment acting on the locked dial plate

600 Nm

Combined loads only after inspection by WEISS.

TC 320T





TC 500T

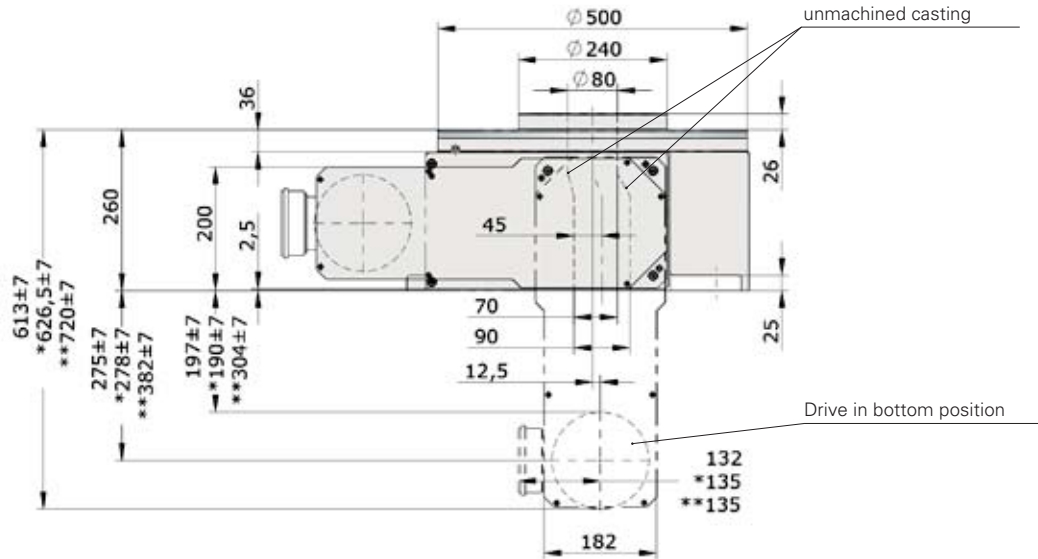
TECHNICAL DATA

Tool plate diameter:	Recommended up to 2000 mm	Mounting position:	See page 47*
Dial diameter:	500 mm	Indexing precision (arcsec):	Indexing 2-12: $\pm 15''$ Indexing 16-48: $\pm 20''$ Higher indexing precision upon request
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Indexing precision in radian measurement:	(at \varnothing 500 mm) Indexing 2-12: ± 0.018 mm Indexing 16-48: ± 0.024 mm
Indexings:	2, 3, 4, 6, 8, 10, 12, 16, 20, 24, 30, 36, 48, special increments upon request	Max. axial run-out of the plate:	(at \varnothing 500 mm) 0.015 mm
Cycle frequency:	Up to 180 cpm, depending on mass moment of inertia and angle of rotation	Max. concentricity:	0.015 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Max. parallelism of rotating plate surface to bottom housing surface:	(at \varnothing 500 mm) 0.03 mm
Drive motor:	0.18 - 2.2 kW, size 71/80/90	Min. inner diameter of tool plate:	242 mm
Weight:	305 kg		

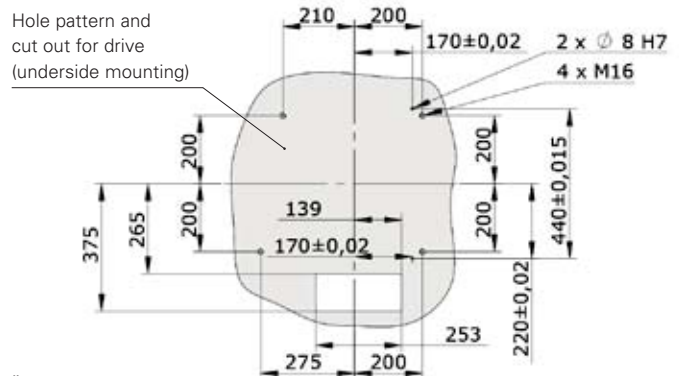
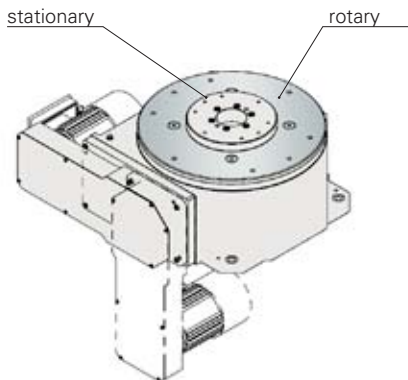
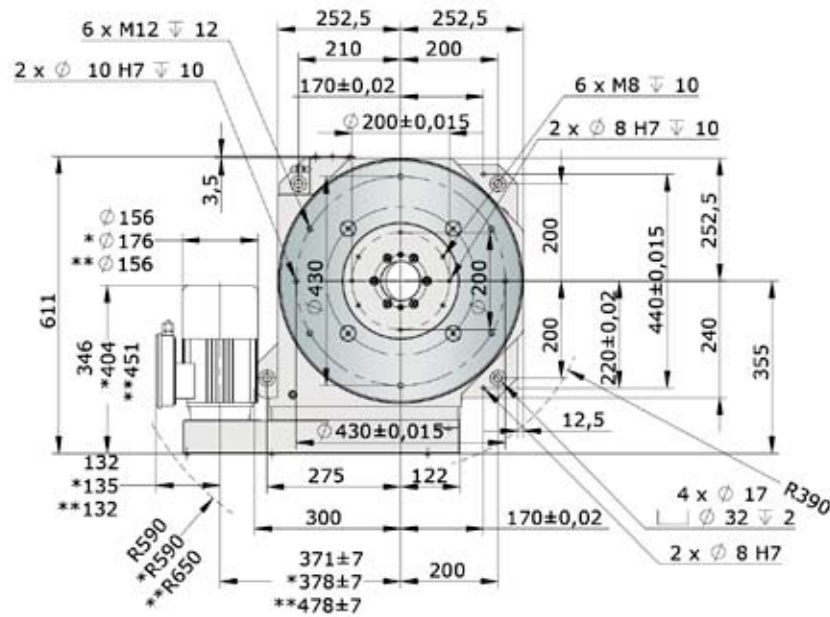
* Please consult WEISS for overhead mounting positions.

DIMENSIONS

If you require subsequent drilling work on the indexing table, please request information on permissible drilling depths. The illustrated rotating plate position corresponds to the basic position of the rotary indexing table (Position when delivered).



* Dimensions for motor BG90
 ** Dimensions for speed levels: o, p, q



Max. centre line deviation between stationary centre section and dial: ± 75"

Max. centre line deviation between dial and indexer housing: ± 55"

Note: Please ensure motor and brake are accessible for servicing!

TC 500T

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

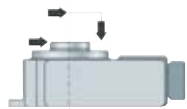
Indexing		Speed Step																	
		s	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o	p	q
2	J _{max}	-	-	-	6.2	9.3	12	18	24.3	36.4	55.6	100	172	233	274	474	805	1010	1650
	t _s	-	-	-	0.68	0.79	0.87	1.02	1.16	1.36	1.66	2.10	2.67	3.02	3.26	4.28	5.80	6.26	8.23
3	J _{max}	-	-	-	7.8	11.5	14.9	22.1	29.7	44.2	70.7	121	213	282	337	634	1270	1520	2850
	t _s	-	-	-	0.68	0.79	0.87	1.02	1.16	1.36	1.66	2.10	2.67	3.02	3.26	4.28	5.80	6.26	8.23
4	J _{max}	-	7.1 *	10.6	18	25.9	32.9	48.1	64	94.6	150	257	450	595	710	1260	2150	2710	4430
	t _s	-	0.43 *	0.50	0.61	0.71	0.79	0.92	1.04	1.23	1.50	1.89	2.41	2.72	2.93	3.85	5.22	5.64	7.40
6	J _{max}	10.2 *	14.7 *	22.20	35.9	51.1	64.4	93.5	124	182	289	493	862	1140	1360	2550	4840	6100	9980
	t _s	0.37 *	0.43 *	0.50	0.61	0.71	0.79	0.92	1.04	1.23	1.50	1.89	2.41	2.72	2.93	3.85	5.22	5.64	7.40
8	J _{max}	23.8 *	34.2 *	49	79.5	112	140	204	270	397	628	1070	1850	2350	2740	4740	8620	10100	17500
	t _s	0.37 *	0.43 *	0.50	0.61	0.71	0.79	0.92	1.04	1.23	1.50	1.89	2.41	2.72	2.93	3.85	5.22	5.64	7.40
10	J _{max}	30.2 *	43.1 *	61.5	99.7	140	177	255	338	497	785	1330	2330	2980	3480	6010	11000	12800	22000
	t _s	0.37 *	0.43 *	0.50	0.61	0.71	0.79	0.92	1.04	1.23	1.50	1.89	2.41	2.72	2.93	3.85	5.22	5.64	7.40
12	J _{max}	36.5 *	52 *	73.3	120	169	212	307	406	595	941	1600	2800	3580	4180	7210	13200	15400	26600
	t _s	0.37 *	0.43 *	0.50	0.61	0.71	0.79	0.92	1.04	1.23	1.50	1.89	2.41	2.72	2.93	3.85	5.22	5.64	7.40
16	J _v	-	-	11.7 *	19.8 *	28.4	36	52.6	70	103	164	280	490	629	775	1450	2920	3480	6230
	t _s	-	-	0.22 *	0.27 *	0.32	0.35	0.41	0.46	0.55	0.67	0.84	1.07	1.21	1.30	1.71	2.32	2.50	3.29
20	J _v	-	-	-	31.8 *	45.3	57.2	83.1	110	162	257	439	768	1010	1210	2270	4340	5060	8750
	t _s	-	-	-	0.27 *	0.32	0.35	0.41	0.46	0.55	0.67	0.84	1.07	1.21	1.30	1.71	2.32	2.50	3.29
24	J _v	-	-	-	38.5 *	54.7	68.2	100	132	193	309	528	923	1220	1450	2700	5200	6080	10500
	t _s	-	-	-	0.27 *	0.32	0.35	0.41	0.46	0.55	0.67	0.84	1.07	1.21	1.30	1.71	2.32	2.50	3.29
30	J _v	-	-	-	-	-	34.9 *	50.9 *	67.8	100	158	271	455	629	751	1400	2820	3370	5830
	t _s	-	-	-	-	-	0.23 *	0.27 *	0.31	0.36	0.44	0.56	0.71	0.80	0.87	1.14	1.55	1.67	2.19
36	J _{max}	-	-	-	-	-	34.2 *	49.8 *	66.4	98.1	155	266	466	616	736	1350	2470	2880	4950
	t _s	-	-	-	-	-	0.23 *	0.27 *	0.31	0.36	0.44	0.56	0.71	0.80	0.87	1.14	1.55	1.67	2.19
48	J _{max}	-	-	-	-	-	46.2 *	67.1 *	89.3	131	208	356	623	824	984	1800	3300	3850	6650
	t _s	-	-	-	-	-	0.23 *	0.27 *	0.31	0.36	0.44	0.56	0.71	0.80	0.87	1.14	1.55	1.67	2.19

J = max admissible mass inertia loading (kgm²) t_s = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

*EF2 - control system for brake wear reduction recommended (see page 58).

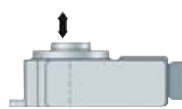
Note on indexing times: The actual measured rotation time (from the start signal to the electrical in-position signal) comprises the calculated rotation motion time given in the tables and type-related delays. An important factor are electrical signal processing times, input filters, mechanical motor idle times and also the setting and optimization of the ideal starting position.

LOAD DATA (for the stationary centre section)



Perm. tilting moment acting on the centre section

2500 Nm



Perm. radial force acting on the centre section

15000 N

Perm. force acting vertically on the centre section

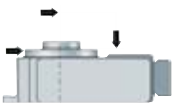
25000 N



Perm. tangential moment acting on the centre section

1100 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

6000 Nm

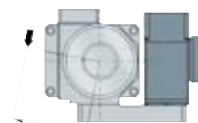


Perm. radial force acting on the locked dial plate

25000 N

Perm. operating force (acting vertically on the locked dial plate within the normal Ø)

25000 N

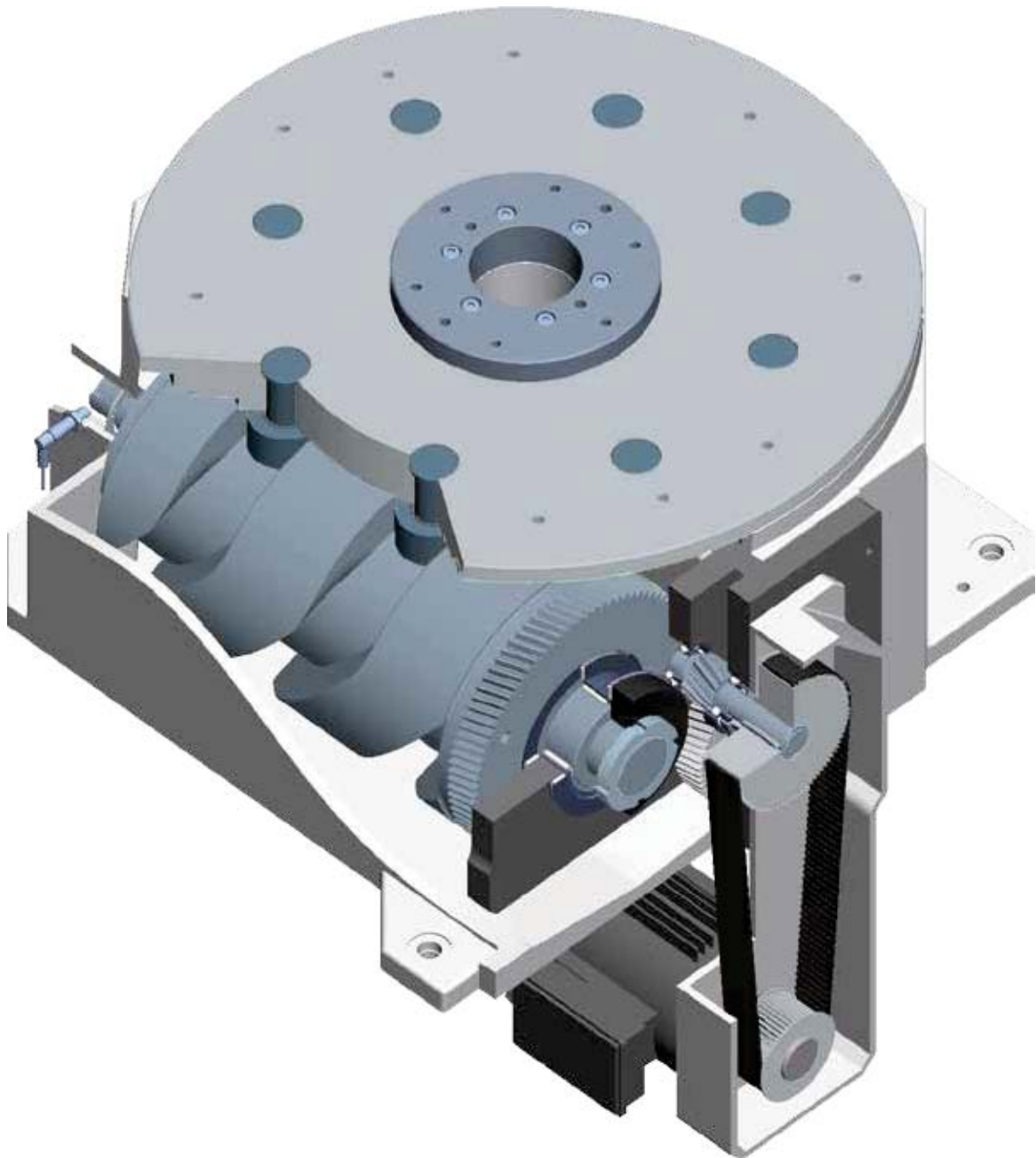


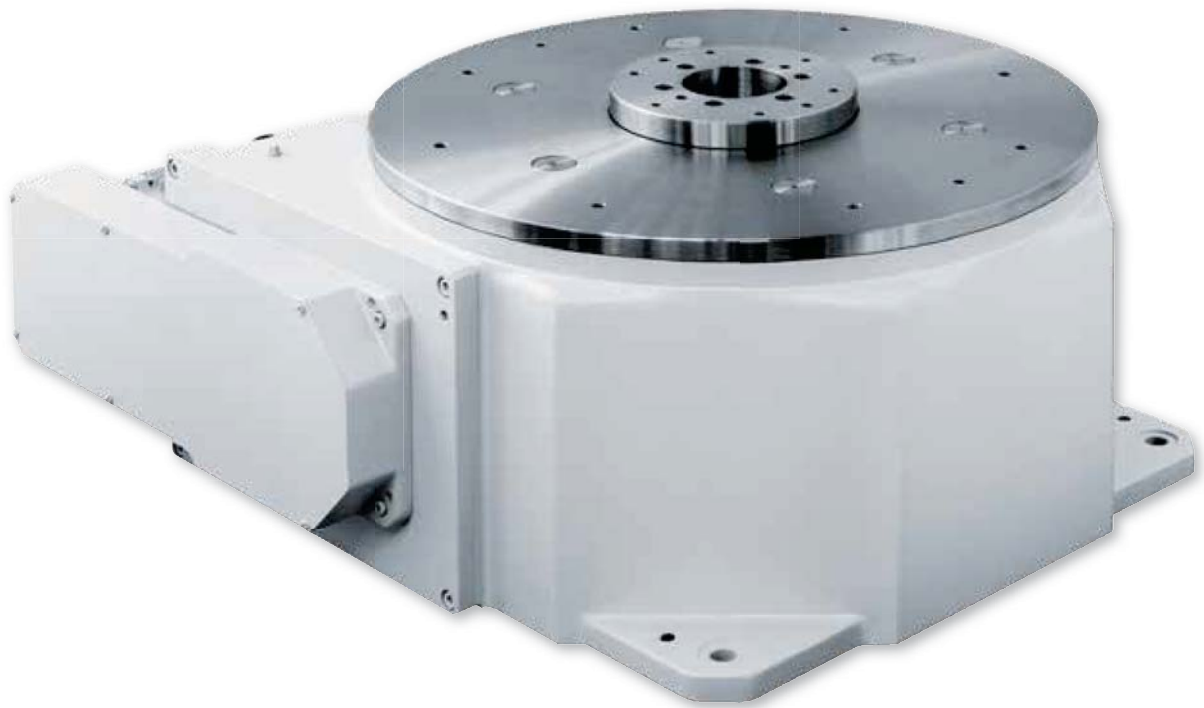
Perm. tangential moment acting on the locked dial plate

1000 Nm

Combined loads only after inspection by WEISS.

TC 500T





TC 700T

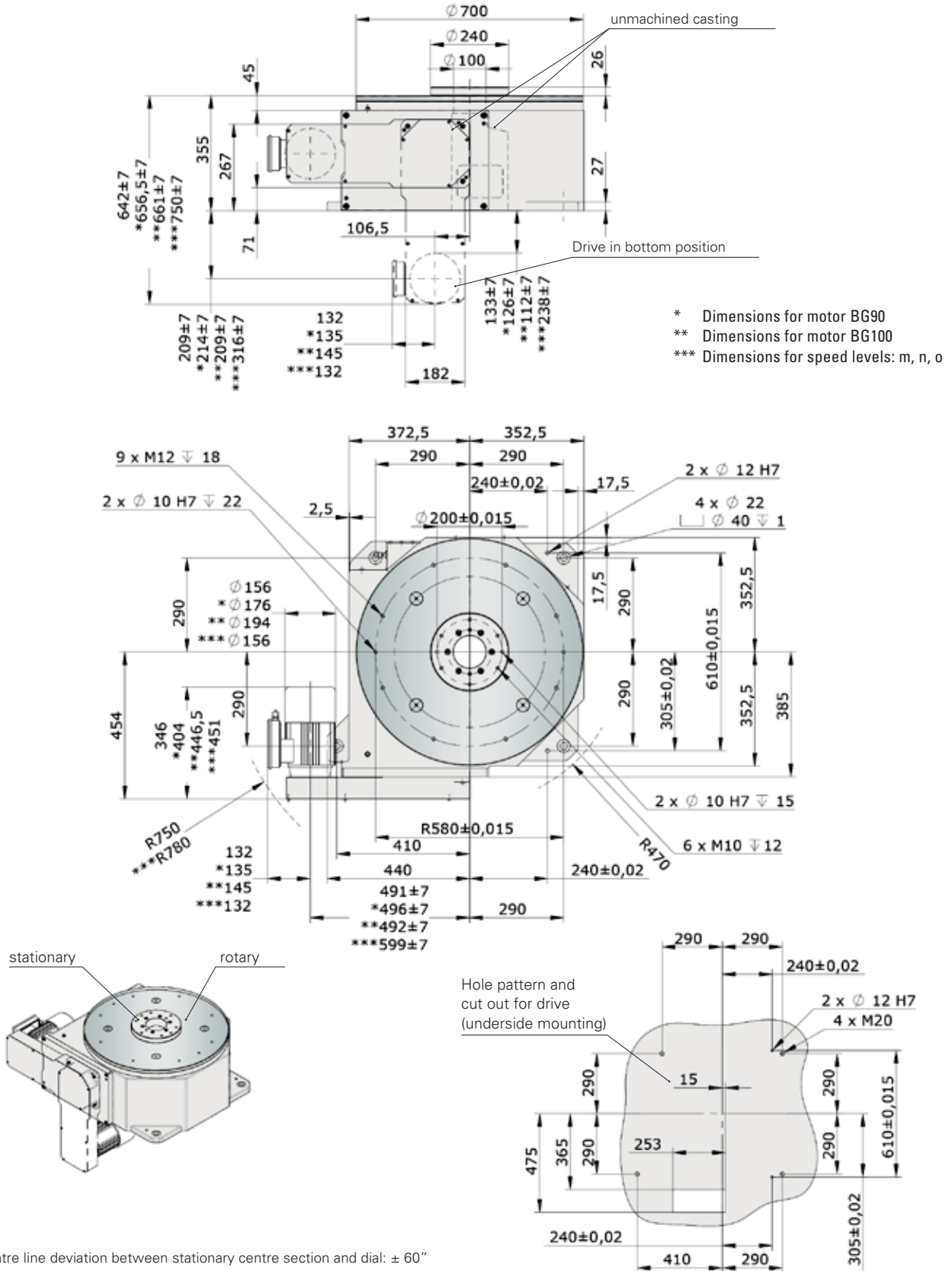
TECHNICAL DATA

Tool plate diameter:	Recommended up to 3000 mm	Mounting position:	See page 47*
Dial diameter:	700 mm	Indexing precision (arcsec):	Indexing 2-12: $\pm 12''$ Indexing 16-60: $\pm 16''$ Higher indexing precision upon request
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Indexing precision in radian measurement:	(at $\varnothing 700$ mm) Indexing 2-12: ± 0.021 mm Indexing 16-60: ± 0.027 mm
Indexings:	2, 3, 4, 6, 8, 10, 12, 16, 20, 24, 30, 36, 48, 60, special increments upon request	Max. axial run-out of the plate:	(at $\varnothing 700$ mm) 0.015 mm
Cycle frequency:	Up to 100 cpm, depending on mass moment of inertia and angle of rotation	Max. concentricity:	0.015 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Max. parallelism of rotating plate surface to bottom housing surface:	(at $\varnothing 700$ mm) 0.03 mm
Drive motor:	0.25 - 3 kW, size 71/80/90/100	Min. inner diameter of tool plate:	242 mm
Weight:	660 kg		

* Please consult WEISS for overhead mounting positions.

DIMENSIONS

If you require subsequent drilling work on the indexing table, please request information on permissible drilling depths. The illustrated rotating plate position corresponds to the basic position of the rotary indexing table (Position when delivered).



Max. centre line deviation between stationary centre section and dial: ± 60"

Max. centre line deviation between dial and indexer housing: ± 40"

Note: Please ensure motor and brake are accessible for servicing!

TC 700T

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

Indexing		Speed Step														
		s	a	b	c	d	e	f	g	h	i	j	k	l	m	n
2	J_{max}	-	9	19	37	56.7	104	149	213	335	587	1010	1650	2920	4650	6700
	t _s	-	0.69	0.81	0.98	1.14	1.46	1.69	1.96	2.40	3.01	3.84	4.70	6.18	7.37	9.04
3	J_{max}	-	24	37.6	62.4	93.4	165	239	340	547	927	1620	2590	4850	7320	11700
	t _s	-	0.69	0.81	0.98	1.14	1.46	1.69	1.96	2.40	3.01	3.84	4.70	6.18	7.37	9.04
4	J_{max}	20	36	62	115	169	294	424	601	909	1630	2730	4550	7800	12500	17900
	t _s	0.53	0.62	0.73	0.88	1.03	1.31	1.52	1.76	2.16	2.71	3.45	4.23	5.56	6.64	8.13
6	J_{max}	53	90	149	233	342	604	845	1190	1910	3230	5640	9020	16900	25300	40300
	t _s	0.53	0.62	0.73	0.88	1.03	1.31	1.52	1.76	2.16	2.71	3.45	4.23	5.56	6.64	8.13
8	J_{max}	101	166	270	484	702	1200	1720	2430	3650	6560	10900	18300	31200	48800	71500
	t _s	0.53	0.62	0.73	0.88	1.03	1.31	1.52	1.76	2.16	2.71	3.45	4.23	5.56	6.64	8.13
10	J_{max}	161	263	412	641	900	1630	2280	3220	5150	8670	15100	24200	41800	59500	89500
	t _s	0.53	0.62	0.73	0.88	1.03	1.31	1.52	1.76	2.16	2.71	3.45	4.23	5.56	6.64	8.13
12	J_{max}	236	360	518	803	1170	2050	2850	4040	6460	10900	19000	29100	50200	71500	107000
	t _s	0.53	0.62	0.73	0.88	1.03	1.31	1.52	1.76	2.16	2.71	3.45	4.23	5.56	6.64	8.13
16	J_v	-	-	-	-	195	346	486	688	1100	1850	3250	5210	9760	14600	23400
	t _s	-	-	-	-	0.46	0.58	0.67	0.78	0.96	1.20	1.53	1.88	2.47	2.95	3.62
20	J_v	-	-	-	-	302	533	747	1050	1690	2850	4980	7960	14900	22400	35400
	t _s	-	-	-	-	0.46	0.58	0.67	0.78	0.96	1.20	1.53	1.88	2.47	2.95	3.62
24	J_v	-	-	-	-	364	642	898	1270	2030	3430	5990	9570	17900	26800	42400
	t _s	-	-	-	-	0.46	0.58	0.67	0.78	0.96	1.20	1.53	1.88	2.47	2.95	3.62
30	J_v	-	-	-	-	-	179	252	356	577	978	1710	2740	5130	7710	12300
	t _s	-	-	-	-	-	0.39	0.45	0.52	0.64	0.80	1.02	1.25	1.65	1.97	2.41
36	J_{max}	-	-	-	-	-	216	304	432	694	1170	2040	3280	6160	9250	14700
	t _s	-	-	-	-	-	0.39	0.45	0.52	0.64	0.80	1.02	1.25	1.65	1.97	2.41
48	J_{max}	-	-	-	-	-	291	408	579	930	1570	2740	4390	8240	12300	19700
	t _s	-	-	-	-	-	0.39	0.45	0.52	0.64	0.80	1.02	1.25	1.65	1.97	2.41
60	J_{max}	-	-	-	-	-	250	351	498	800	1350	2360	3780	7100	10600	17000
	t _s	-	-	-	-	-	0.39	0.45	0.52	0.64	0.80	1.02	1.25	1.65	1.97	2.41

J = max admissible mass inertia loading (kgm²) **t_s** = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

EF2 - control system for brake wear reduction recommended (see page 58).

LOAD DATA (for the stationary centre section)



Perm. tilting moment acting on the centre section

3000 Nm



Perm. radial force acting on the centre section

17000 N

Perm. force acting vertically on the centre section

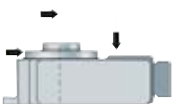
30000 N



Perm. tangential moment acting on the centre section

1400 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

10000 Nm

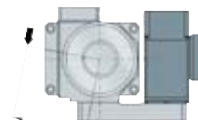


Perm. radial force acting on the locked dial plate

30000 N

Perm. operating force (acting vertically on the locked dial plate within the normal Ø)

40000 N

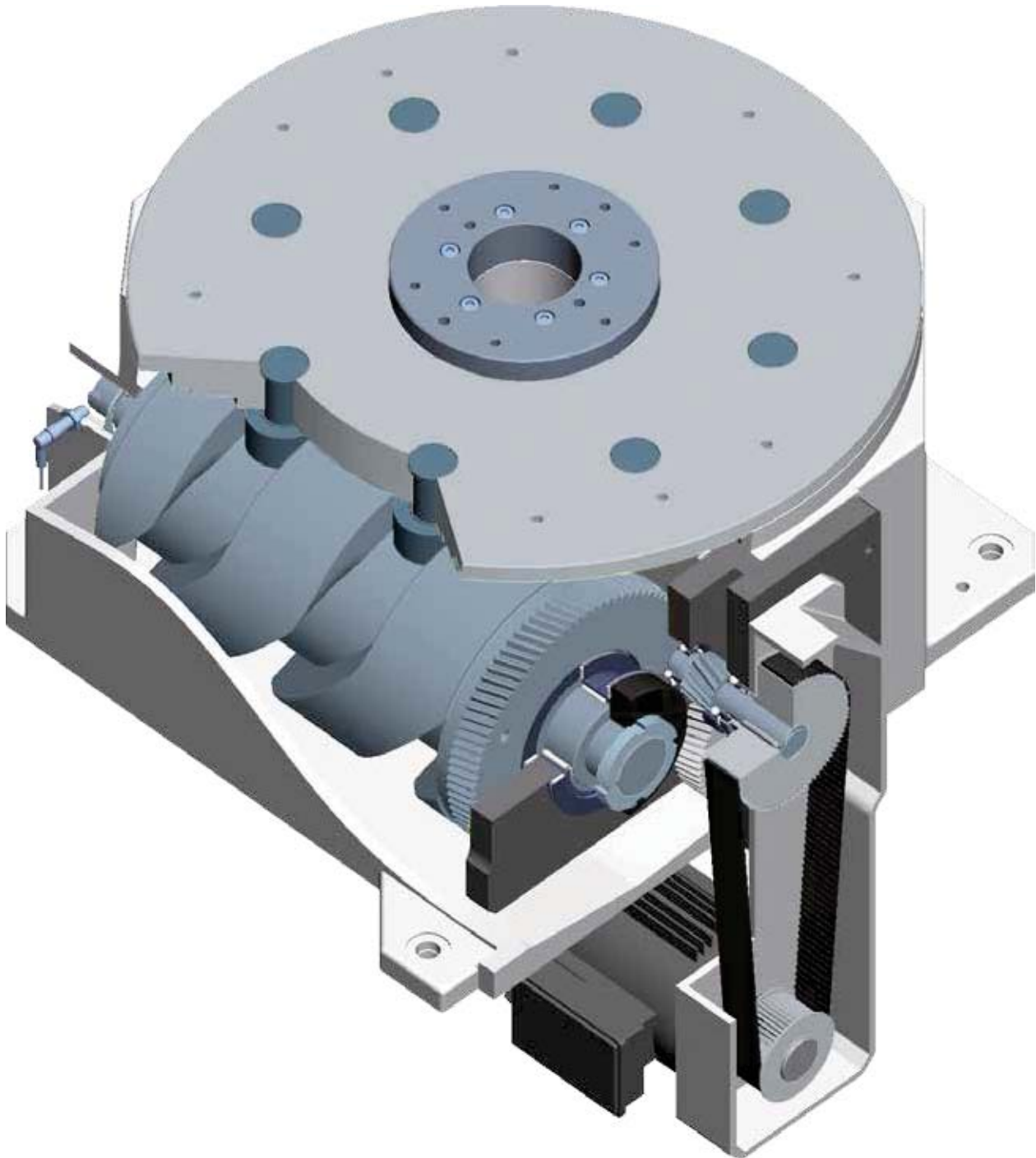


Perm. tangential moment acting on the locked dial plate

1700 Nm

Combined loads only after inspection by WEISS.

TC 700T





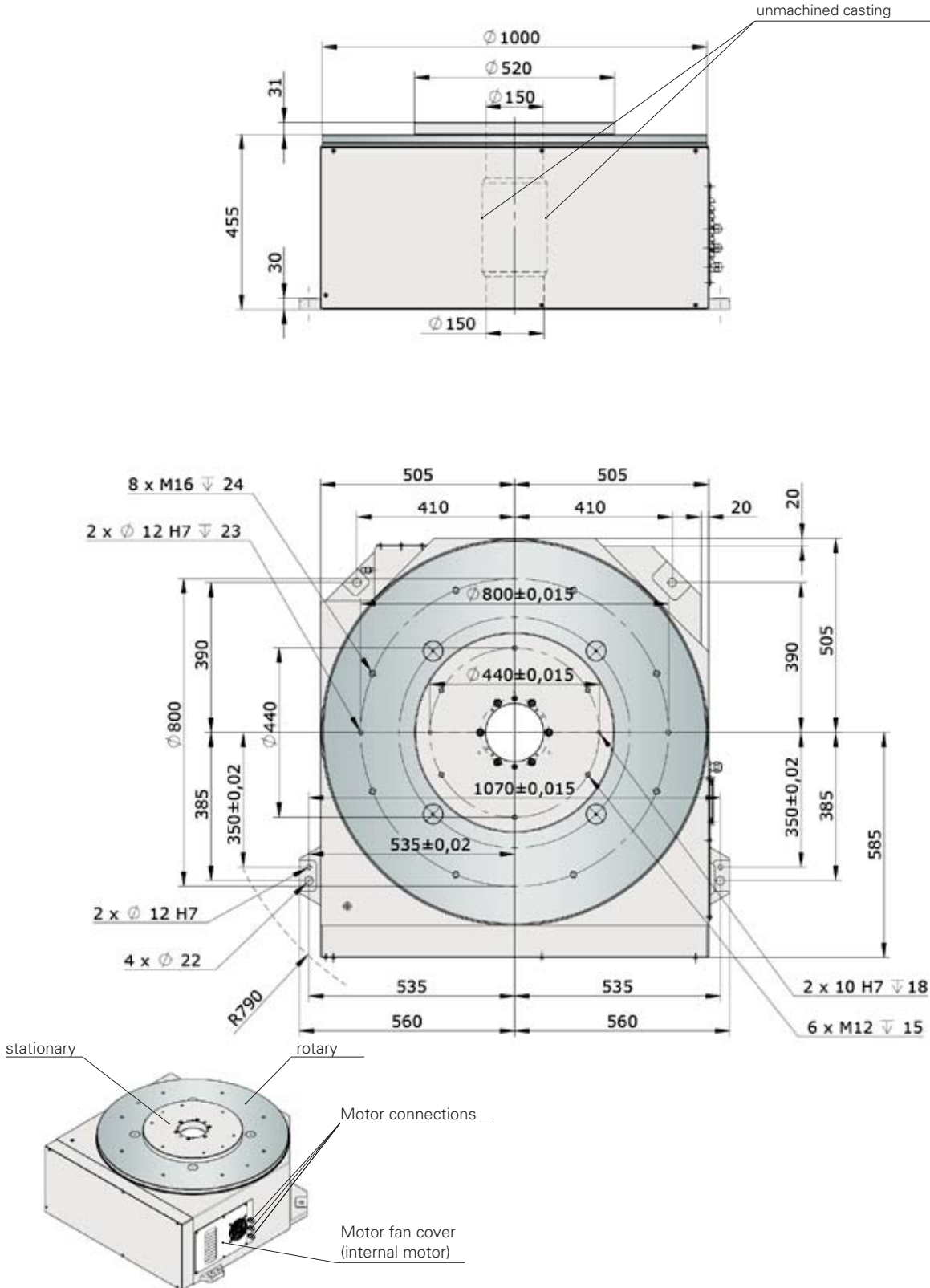
TC 1000T

TECHNICAL DATA

Tool plate diameter:	Recommended up to 5000 mm	Mounting position:	See page 47
Dial diameter:	1000 mm	Indexing precision (arcsec):	Indexing 2-20: $\pm 12''$ Indexing 24-36: $\pm 16''$
Direction of rotation:	Clockwise - counter clockwise or reciprocating	Indexing precision in radian measurement:	(at \varnothing 1000 mm) Indexing 2-20: ± 0.029 mm Indexing 24-36: ± 0.039 mm
Indexings:	2, 3, 4, 6, 8, 10, 12, 16, 20, 24, 36 special increments upon request	Max. axial run-out of the plate:	(at \varnothing 1000 mm) 0.03 mm
Cycle frequency:	Up to 80 cpm, depending on mass moment of inertia and angle of rotation	Max. concentricity:	0.03 mm
Voltage:	230 / 400 V 50 Hz, special voltages upon request	Max. parallelism of rotating plate surface to bottom housing surface:	(at \varnothing 1000 mm) 0.05 mm
Drive motor:	0.55 - 3.0 kW, size 90/100	Min. inner diameter of rotating tool:	522 mm
Weight:	1530 kg		

DIMENSIONS

If you require subsequent drilling work on the indexing table, please request information on permissible drilling depths. The illustrated rotating plate position corresponds to the basic position of the rotary indexing table (Position when delivered).



Max. centre line deviation between stationary centre section and dial: $\pm 45''$

Max. centre line deviation between dial and indexer housing: $\pm 35''$

Note: Please ensure motor and brake are accessible for servicing!

TC 1000T

LOAD TABLE (Only valid for 50 Hz. In the case of higher loads or longer cycle times, please ask us for advice.)

Indexing		Speed Step									
		a	b	c	d	e	f	g	h	i	j
2	J_{max}	108	173	333	695	1130	1930	2820	4910	14900	19700
	t_s	1.28	1.50	1.92	2.57	3.15	3.96	5.04	6.18	10.74	12.33
3	J_{max}	182	280	521	1060	1720	2920	4670	8230	29400	40500
	t_s	1.28	1.50	1.92	2.57	3.15	3.96	5.04	6.18	10.74	12.33
4	J_{max}	406	604	1080	1990	3410	5370	7600	13200	39900	52700
	t_s	1.15	1.35	1.73	2.32	2.84	3.56	4.54	5.56	9.67	11.10
6	J_{max}	807	1180	2100	4170	6680	11200	17100	29700	89900	118000
	t_s	1.15	1.35	1.73	2.32	2.84	3.56	4.54	5.56	9.67	11.10
8	J_{max}	1710	2480	4380	8080	13700	21600	30500	52900	160000	210000
	t_s	1.15	1.35	1.73	2.32	2.84	3.56	4.54	5.56	9.67	11.10
10	J_{max}	2147	3110	5480	10800	17300	28100	35000	64400	207000	273000
	t_s	1.15	1.35	1.73	2.32	2.84	3.56	4.54	5.56	9.67	11.10
12	J_{max}	2585	3750	6590	13000	20800	33700	54800	82400	249000	328000
	t_s	1.15	1.35	1.73	2.32	2.84	3.56	4.54	5.56	9.67	11.10
16	J_v	3459	5010	8800	17300	27700	45000	73000	109000	332000	437000
	t_s	1.15	1.35	1.73	2.32	2.84	3.56	4.54	5.56	9.67	11.10
24	J_v	730	1070	1900	3780	6070	10200	17600	28600	98400	129000
	t_s	0.51	0.60	0.77	1.03	1.26	1.58	2.02	2.47	4.30	4.93
36	J_{max}	-	-	1109	2220	3570	6040	10500	16900	60400	83000
	t_s	-	-	0.51	0.69	0.84	1.06	1.34	1.65	2.86	3.29

J = max admissible mass inertia loading (kgm^2) t_s = cycle time (sec.) Depending on motor size, electronics and time optimisation settings, the cycle time measured from the start signal to the electric position indication is approx. 80 - 130 ms longer than the value specified in the table.

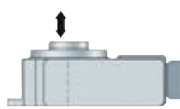
EF2 - control system for brake wear reduction recommended (see page 58).

LOAD DATA (for the stationary centre section)



Perm. tilting moment acting on the centre section

5000 Nm



Perm. radial force acting on the centre section

17000 N

Perm. force acting vertically on the centre section

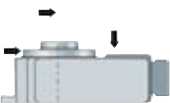
40000 N



Perm. tangential moment acting on the centre section

1800 Nm

LOAD DATA (for the rotary indexing dial plate)



Perm. tilting moment acting on the locked dial plate

13000 Nm

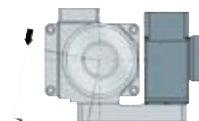


Perm. radial force acting on the locked dial plate

45000 N

Perm. operating force (acting vertically on the locked dial plate within the normal \emptyset)

80000 N

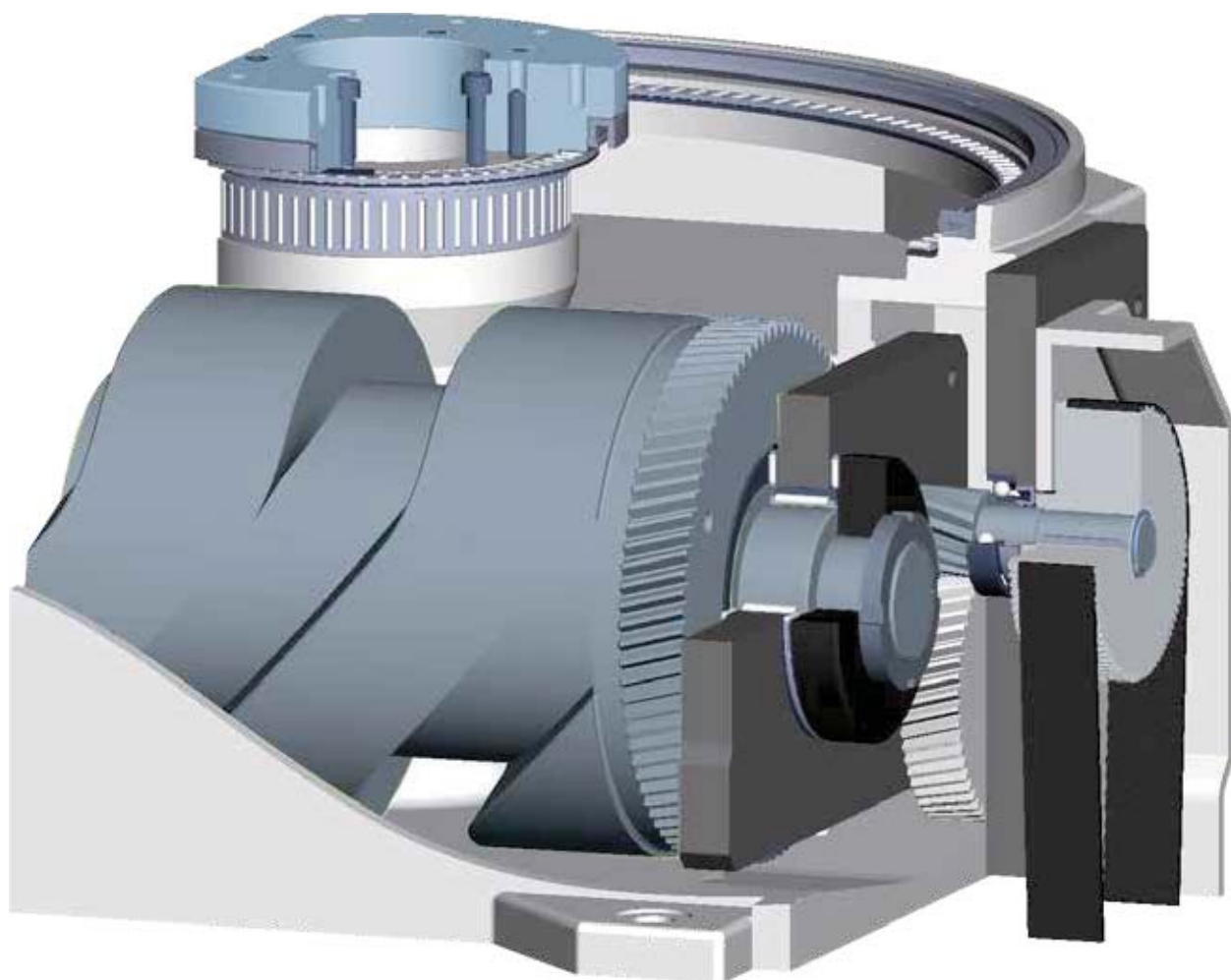


Perm. tangential moment acting on the locked dial plate

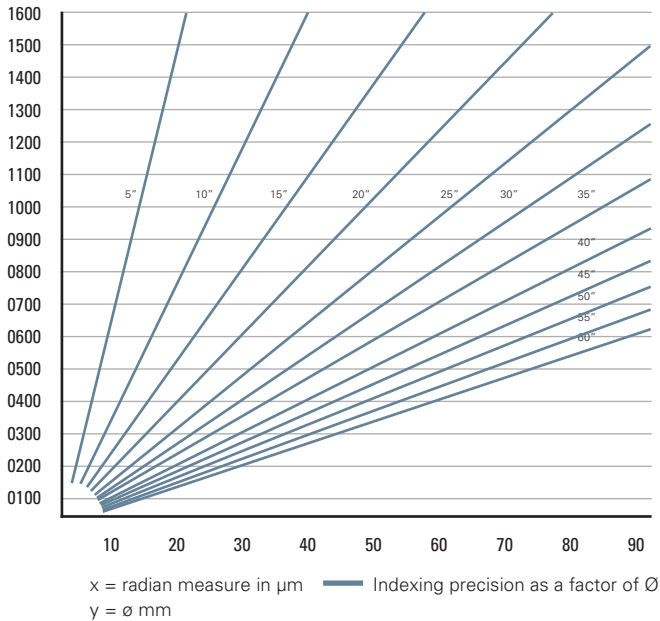
2200 Nm

Combined loads only after inspection by WEISS.

TC 1000T



CALCULATION



Nominal indexing precision = $\pm \frac{\pi \times D \times T_g}{360 \times 3600}$
 D = Pitch circle diameter
 T_g = Brochure precision

Accuracy of circular run-out for additional plates

Diameter (mm)	Thickness (mm)	Flatness Quality A (mm)	Flatness Quality B (mm)
≤ 600	≥ 20	0.04	0.10
	< 20	0.06	0.15
≤ 800	≥ 20	0.06	0.15
	< 20	0.07	0.18
≤ 1100	≥ 20	0.07	0.18
	< 20	0.08	0.20
≤ 1400	≥ 25	0.08	0.20
	< 25	0.10	0.25
≤ 1800	≥ 25	0.10	0.25
	< 25	0.20	0.50
≤ 2500	≥ 30	0.15	0.40
	< 30	0.25	0.55

If we machine your additional indexing plate, $\pm 3''$ needs to be added to the indexing precision of the rotary indexing table specified in the diagram.

ADDITIONAL INDEXING PLATES

We manufacture additional steel or aluminium indexing plates according to your specification. Especially with aluminium plates (material AlMg4,5Mn F28) we ensure that the material is tempered. If requested, aluminium plates can be anodized (natur or in color) and steel plates chemically nickel-plated.

For detailed information on additional plates, please refer to the section on indexing machine bases.



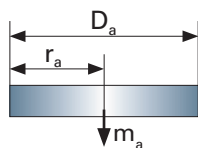
CALCULATION OF THE MOMENT OF MASS INERTIA

Solid body:

$$J = 0.5 \times r_a^2 \times m_a$$

or

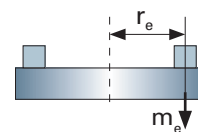
$$J = 0.125 \times m_a \times D_a^2$$



r_a = radius in m
 m_a = mass (weight) in kg
 D_a = diameter in m

Individual weights (approximation formula):

$$J = 1.1 \times r_e^2 \times m_e \times n$$



r_e = radius in m
 m_e = mass (weight) in kg
 n = number of individual masses

MACHINE DESIGN TC

Fax to: +49 (0) 6281 5208-99 or just fill in the form online: www.weiss-international.com

Enquiry Attachment to order

Dear Customer,

Thank you for your interest in our TC rotary indexing tables. To enable us to supply you with the correct unit for your application, we kindly ask you to answer the following questions:

Model

- TC 120G TC 320T
 - TC 150T TC 500T
 - TC 220T TC 700T
 - TC 220T with motor size 71 TC 1000T
- Indexing _____
- Higher indexing precision

Standard colours

- RAL 7035 (light grey)
- Special colour RAL _____ (extra charge)

Calculation of the total mass moment of inertia

The following specifications of the tooling plate are extremely important to establish the shortest possible indexing time of your TC table. The calculation is based on the formula on page 46. Alternatively, you can simply let us do the calculation for you.

Additional indexing plate

Diameter: _____ mm Thickness: _____ mm

Material Al St Other

Included in offer and delivery Do not supply

Based on the calculated mass moment of inertia, do you want:

- The shortest possible indexing time
- A longer indexing time of approx. _____ sec

Electrical data

Drive

Index frequency: _____ cycles/min
(at an indexing frequency of more than 25 cycles/min we recommend the use of the EF rotary table control system)

Drive Motor

Connection voltage 3 x 400 V / 50 Hz (Standard)
 Other: _____ V / _____ Hz

Brake

Brake voltage 24 V = (recommended)
 Other: _____ V

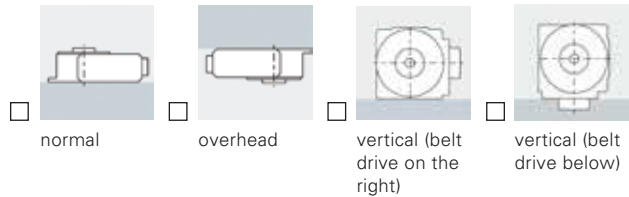
We strongly recommend using solid-state relays for controlling the motors!

- Electronic contactor
(not necessary with frequency converter control system EF1/EF2)
- Electronic reversing contactor
(not necessary with frequency converter control system EF1/EF2)

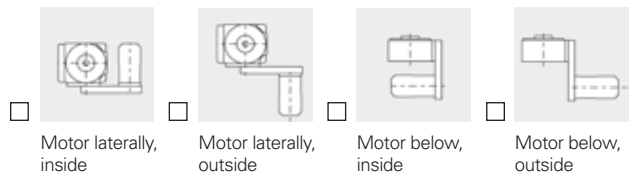
For technical enquiries

Company: _____
Name: _____
Country: _____

Permissible mounting positions



Position of the drive motor



Workpiece and fixture:

No. of stations: _____
Weight per station: _____ kg
Centre of gravity diameter: _____ mm

Control systems EF1 / EF2 / TS 004 E

(an EF2 is supplied with the TC 700T / TC 1000T)

- Frequency converter control system EF1 (Lenze)
- Frequency converter control system EF2 (Siemens) interface Profibus + ProfiNet onboard
 - TM 15 module for interface Digitale I/O
 - SIL3 (STO) - motor contactor + safety relay
- WEISS control card TS 004 E
- Terminal PCB for 19" rack
- PCB card holder
- Protective housing for:
 - Rear wall mounting
 - Front panel mounting
 - Rail mounting
 - Front door, lockable and transparent

Front panel language for WEISS control card TS004E

German Italian English
 French Dutch Czech

Desired delivery date: _____
Phone: _____ Fax: _____
E-Mail: _____