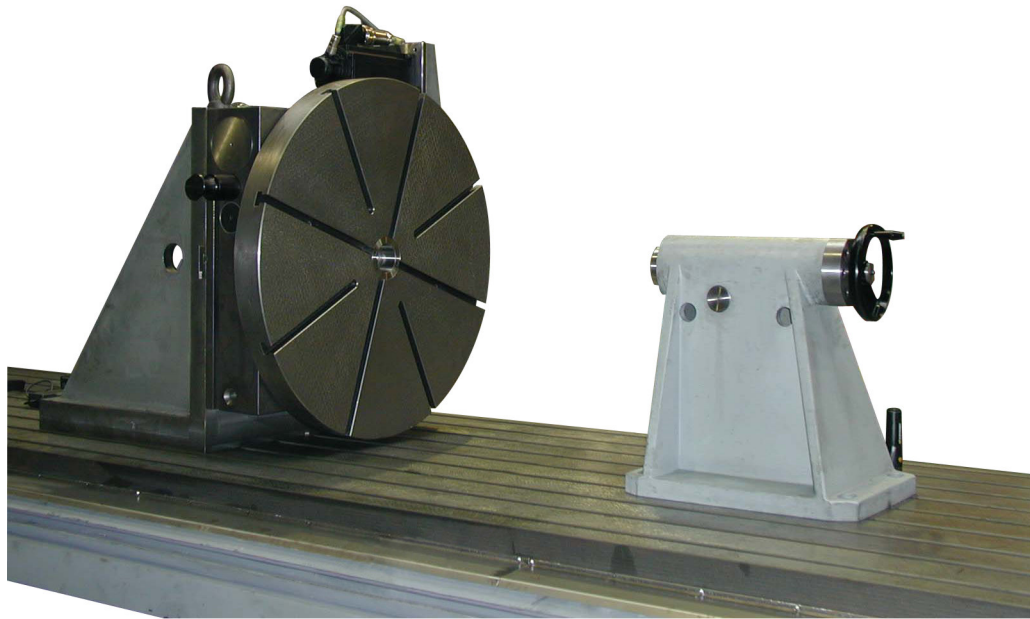


## Rotary table type ISN



### General information

Rotary table is designed to expand the possibilities of uses of the CNC milling machine thus increasing the ways of use and opening the door for potential business opportunities at the same time. It is an additional, fully controllable continuous axis allowing you to fasten the workpiece in any position. You can work the piece all the way around while keeping the precise milling. The rotary table can be attached to any area on the main table in horizontal or vertical position. Once the rotary table is fastened in vertical position, a supportive tailstock can be used for longer pieces.

### Square

The square is used to bring the rotary table to vertical position thus making the rotary axis horizontal. On one side of the square there are guiding inlets for the rotary table while on the opposite side there are “T” slots for fastening to the main machine table.

### Tailstock

The tailstock is designed specifically for longer workpiece while rotary table is fastened in vertical position as the rotary axis is in horizontal position. The tailstock is equipped with a shift out quill so that you don't have to move and fasten the tailstock every time you need to rotate the workpiece. Guiding inlets are used for fastening the tailstock to the main table.

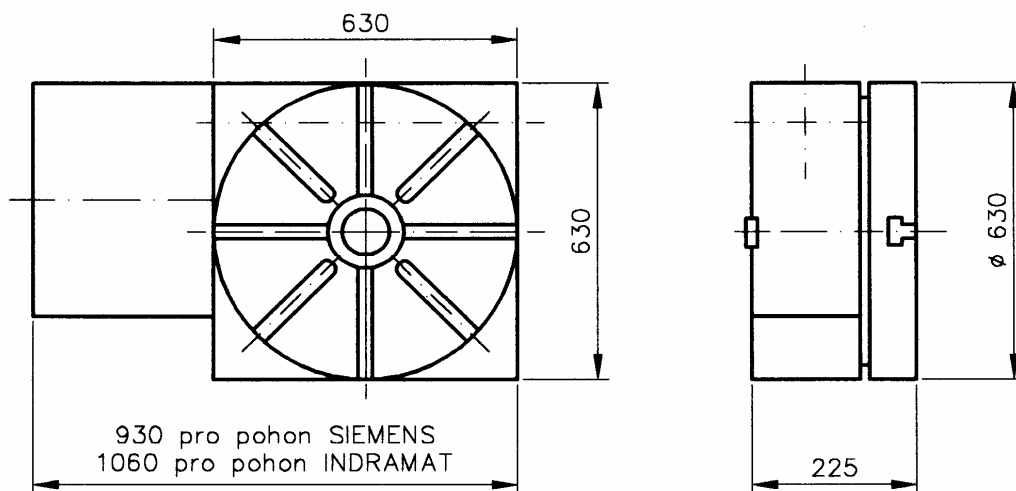
## Technical parameters

Table dimension			630	800	1 000
Table clamping area dimension [mm]			630	800	1 000
T-slots radial	position	number	4		
		width [mm]	18H7		22H7
	clamping	number	4		
		width [mm]	18H12		22H12
Centering hole [mm]			70H6	60H6	80H6
Guiding slots width [mm]			14J7		
Maximal workpiece weight	horizontal clamping area [kg]		1 700	3 500	
	vertical clamping area [kg]		400	1 500	
Maximal table load in the direction perpendicular to clamping area [N]			40 000	100 000	
Maximal table tilting moment in surface perpendicular to clamping area [Nm]			10 000	20 000	
Table rotation speed	working (continuous) [ $^{\circ}$ . min <sup>-1</sup> ]		1 - 3 600	1 - 1 080 <sup>1)</sup>	
	adjustable [ $^{\circ}$ . min <sup>-1</sup> ]		3 960	1 440 <sup>2)</sup>	
Maximal torque	during rotation [Nm]		600	1 600	
	during locking [Nm]		6 000	15 000	
Oil pressure level during locking [MPa]			5 – 6,3		
Measuring unit [ $^{\circ}$ ]			0,001		
Double-side position precision adjustement A (in acc. with ČSN ISO 230-2) ["]			15		
Single-side position repeatability adjustment R <sup>↑</sup> , R <sup>↓</sup> (in acc. with ČSN ISO 230-2) ["]			7,5		
Basic dimensions			see appendix A		
Table weight [kg]			500	800	1 000

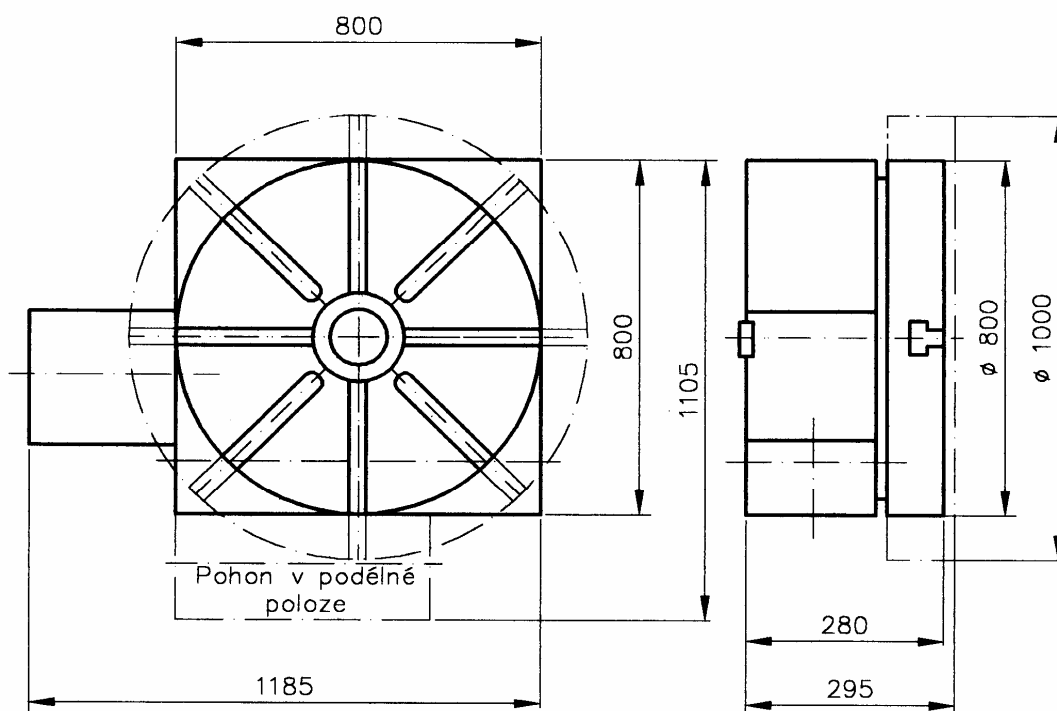
## Appendix A (informativ)

### Basic dimensions of rotary tables ISN 630, 800 and 1 000

#### A.1 Rotary table ISN 630



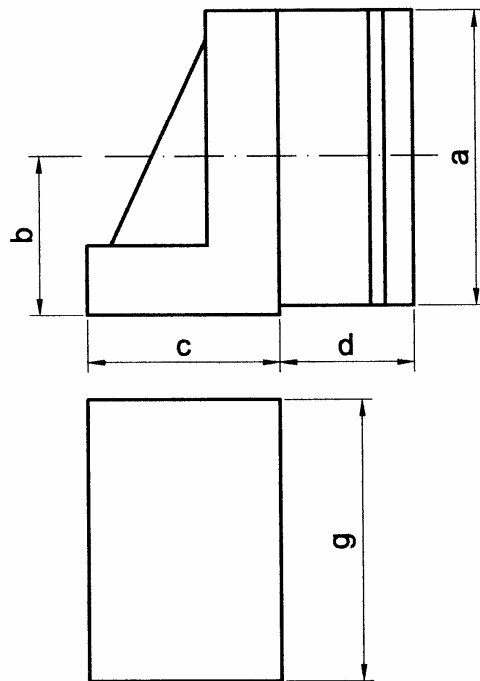
#### A.2 Rotary tables ISN 800, 1 000



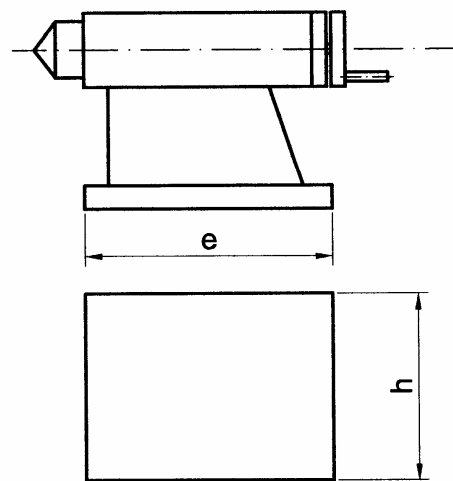
## Appendix B (informativ)

### Basic dimensions of square and tailstock

Square



Tailstock



Dimensions in mm

Rotary table ISN	Dimensions						
	<i>a</i>	<i>b</i>	<i>c</i>	<i>d</i>	<i>e</i>	<i>g</i>	<i>h</i>
630	630	340	400	225	520	630	360
800	800	420	700	280	545	800	400
1 000	1 000	520	700	295	572	800	430