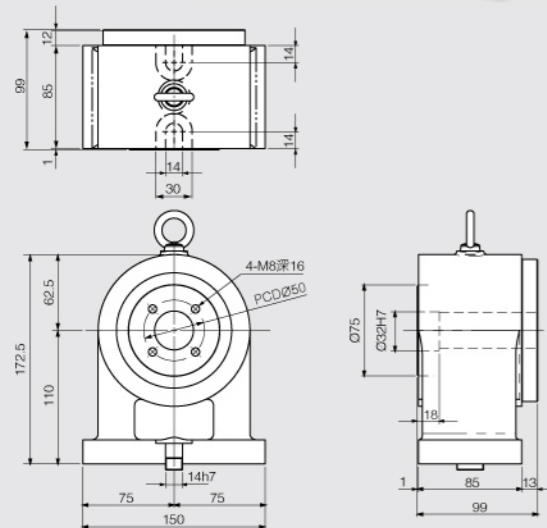


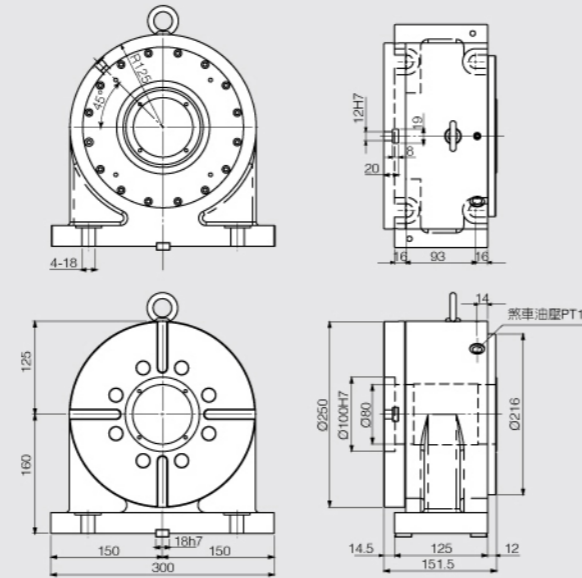
**ASS 系列 簡易型圓盤尾座**  
**ASS-Series Faceplate Tailstock**

ASS125  
無制車尾座  
without brake



**ATT-250H 高剛性圓盤尾座**  
**ATT-250H Faceplate Tailstock**

機型 Model	ATT250H	機型 Model	ATT250H
工作盤直徑 Table diameter	mm 2250	基準定位寬 Guide block width	mm 18h7
中心高 Center height	mm 160	鉗緊動力源 Clamp system	油壓 H
基準孔 Guide hole	mm 100H7	鉗緊壓力 Hydraulic pressure	kg/cm <sup>2</sup> 20
貫穿孔 Spindle hole	mm Ø60	鉗緊出力 Output torque at brake	kg·m 60
T 型溝 T slot width	mm 12H7	製成品重量 Weight	kg 55

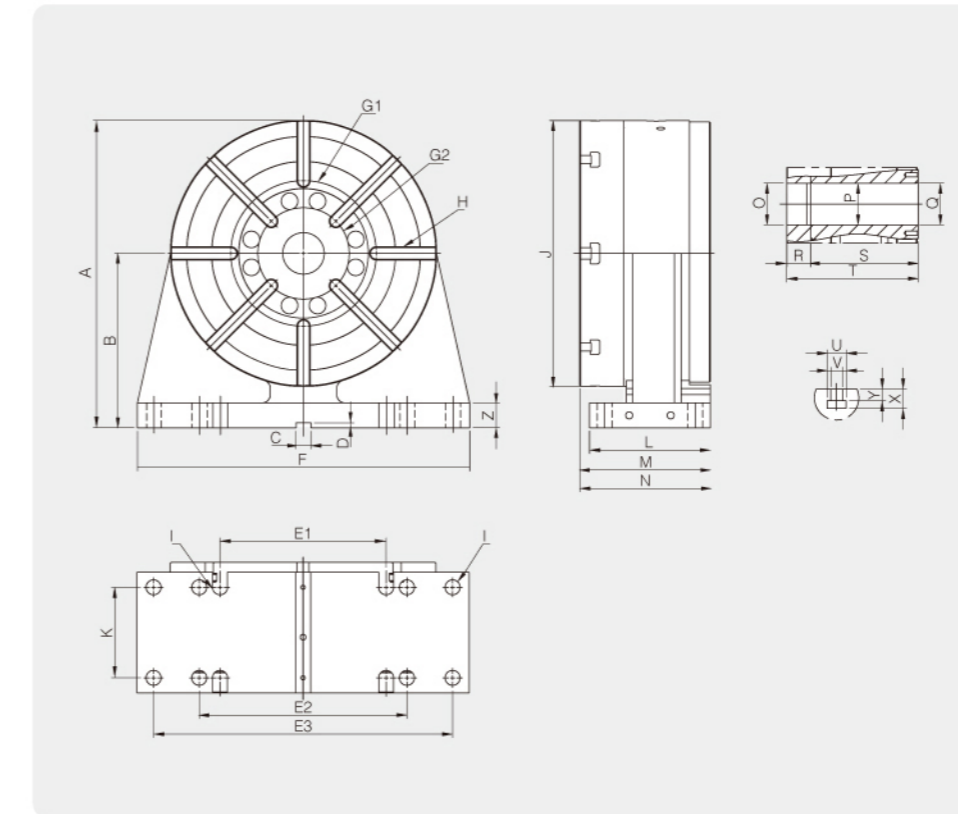


**AST 系列 圓盤尾座 AST-Series Faceplate Tailstock**

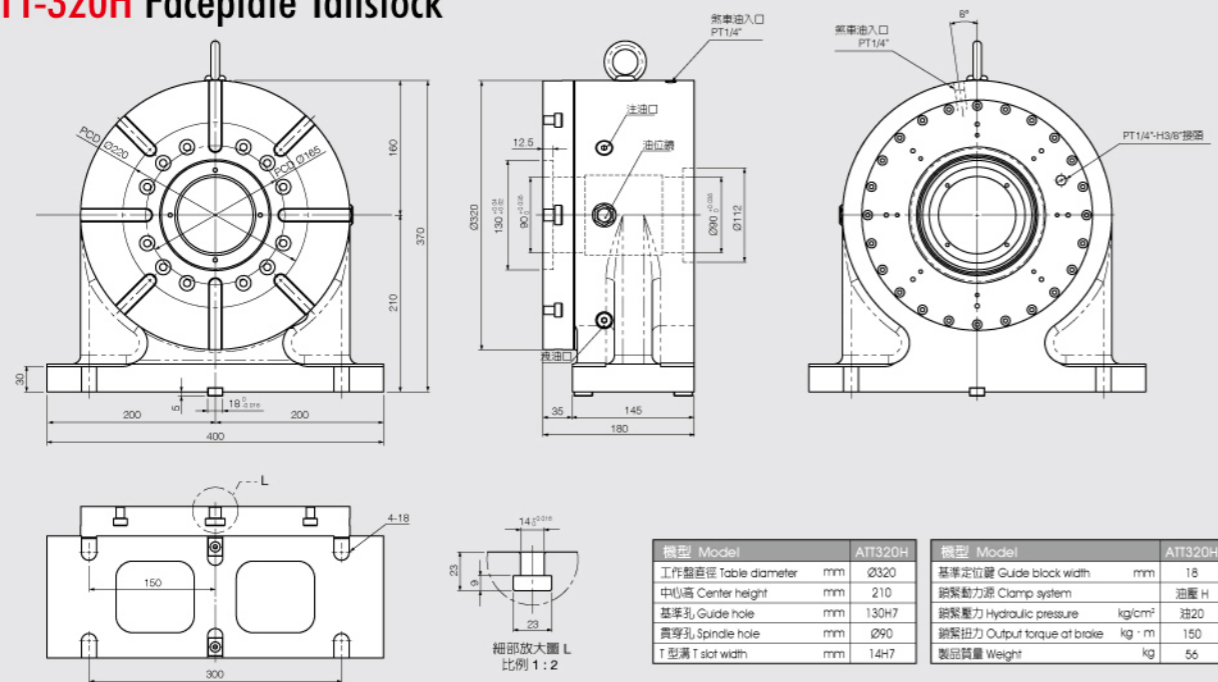
The AST faceplate tailstock can operate as attach to CNC rotary table of AT series, and its plate application assembly can reach to the effectiveness of making many moulds one time. It adopts overall pneumatic brake disc locking system or hydraulic clamping surrounding oil pressure embrace locking system. The integrate design ensures to save the working-hour and cost efficiently.

AST圓盤尾座可與AT系列CNC Rotary Table搭配使用，加上治具中板的應用組合，可達到一次作動多模數加工效果，採用氣壓鎖緊全面碟式制車鎖緊方式，完整的搭配設計，有效確實節省加工工時及成本。

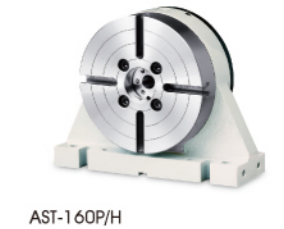
**機械寸法圖 Outline dimensions**



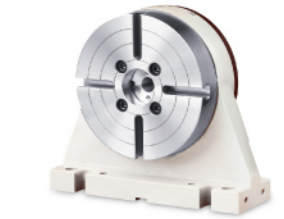
**ATT-320H 高剛性圓盤尾座**  
**ATT-320H Faceplate Tailstock**



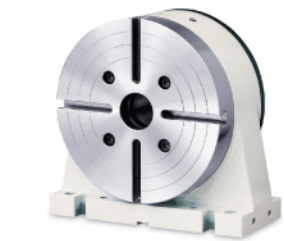
機型 Model	ATT320H	機型 Model	ATT320H
工作盤直徑 Table diameter	mm Ø320	基準定位寬 Guide block width	mm 18
中心高 Center height	mm 210	鉗緊動力源 Clamp system	油壓 H
基準孔 Guide hole	mm 130H7	鉗緊壓力 Hydraulic pressure	kg/cm <sup>2</sup> 20
貫穿孔 Spindle hole	mm Ø90	鉗緊出力 Output torque at brake	kg·m 150
T 型溝 T slot width	mm 14H7	製成品重量 Weight	kg 56



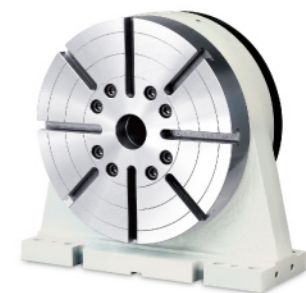
AST-160P/H



AST-200P/H



AST-250P/H



AST-320H

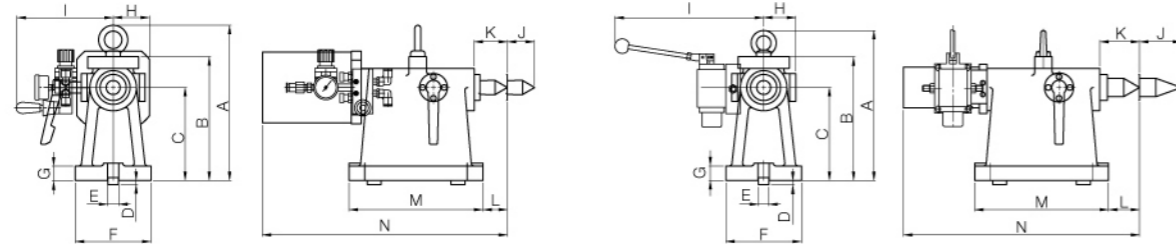
機型 Model/尺寸 Size	mm														
	A	B	C	D	E1	E2	E3	F	G	H	I	J	K	L	M
AST-160P/H	235	135	14	6	200	250	-	300	Ø87	4	8-14	Ø200	64	96	101.3
AST-200P/H	260	160	18	6	200	250	-	300	Ø87	4	8-18	Ø200	64	96	101.3
AST-250P/H	285	160	18	6	200	250	-	300	Ø87	4	8-18	Ø250	93	125	139
AST-320H	370	210	18	6	200	250	360	400	Ø175	8	12-18	Ø320	109	145	157

機型 Model/尺寸 Size	mm													重量 kg	
	N	O	P	Q	R	S	T	U	V	X	Y	Z	空壓 P / 油壓 H		
AST-160P/H	102	Ø50	Ø20	Ø20	24	78	102	19	12	20	9	30	29 / 33		
AST-200P/H	102	Ø50	Ø20	Ø20	24	78	102	19	12	20	9	30	31 / 35		
AST-250P/H	142	Ø50	Ø52	Ø51.5	24	115	142	19	12	20	9	30	47.5 / 51.5		
AST-320H	158	Ø50	Ø50.2	Ø50.2	29	129	158	23	14	23	14	30	106 / 110		

**TAT 系列 氣壓/油壓頂針尾座 - 手動閥**  
**Pneumatic / Hydraulic Manual Tailstock - Manual Valve**

TAT 頂針尾座，與AT系列CNC Rotary Table搭配使用，固定工件中心旋轉加工應用。

TAT Center tailstock can attach to CNC rotary table of AT series. The alternative choices are spindle with center type changeable center type for pivoting the work piece for swivel processing application.



手動閥氣壓

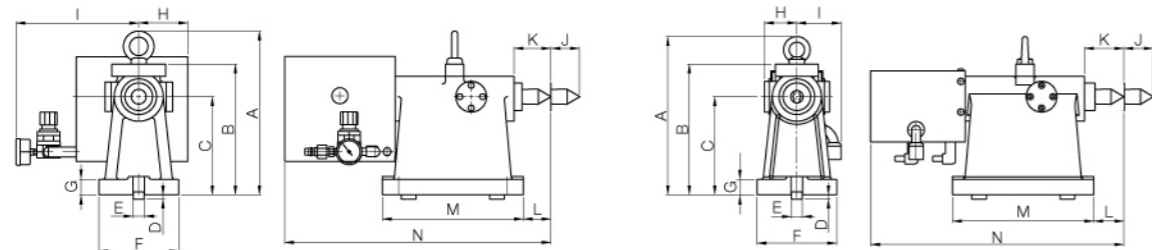
手動閥油壓

機型/規格尺寸 Specification / Model	A	B	C	D	E	F	G	H	I	J	K	L	M	N	莫氏椎度 Morse Taper	重量 Weight
TAT-110PC	187	144	110	7	14	100	20	48	142	50	57	37	135	230	2#	15 kg
TAT-135PC	214	171	135	7	14	100	20	48	142	50	67	47	135	230	2#	15 kg
TAT-160PC	267	224	160	7	18	130	30	53	145	100	64	49	230	379	3#	25 kg
TAT-135HC	211	168	135	7	14	100	20	48	247	30	67	47	135	210	2#	15 kg
TAT-160HC	267	224	160	7	18	130	30	53	191	100	64	49	230	366	3#	25 kg
TAT-210HC	317	274	210	7	18	146	30	53	256	100	64	49	230	366	3#	36 kg
TAT-255HC	381	338	255	7	18	200	35	65	238	100	84	94	285	455	4#	66 kg

**TAT-A 系列 氣壓/油壓頂針尾座 - 電磁閥+檢出**  
**Pneumatic/Hydraulic Tailstock - Solenoid Valve + Sensor**

TAT 頂針尾座，與AT系列CNC Rotary Table搭配使用，固定工件中心旋轉加工應用。

TAT Center tailstock can attach to CNC rotary table of AT series. The alternative choices are spindle with center type changeable center type for pivoting the work piece for swivel processing application.



電磁閥+檢出氣壓

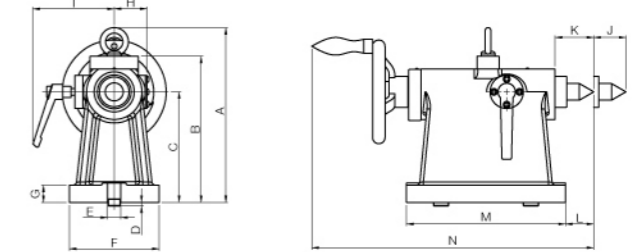
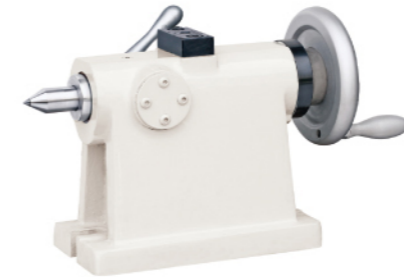
電磁閥+檢出油壓

機型/規格尺寸 Specification / Model	電磁閥 Solenoid Valve	檢出 Sensor	A	B	C	D	E	F	G	H	I	J	K	L	M	N	莫氏椎度 Morse Taper	重量 Weight
TAT-135PC-A	√	√	211	168	135	7	14	100	23	80	158	50	40	20	135	306	2#	15 kg
TAT-160PC-A	√	√	267	224	160	7	18	130	30	103	170	100	64	49	230	438	3#	26 kg
TAT-135HC-A	-	√	211	168	135	7	14	100	23	48	72	50	40	20	135	310.5	2#	15 kg
TAT-160HC-A	-	√	256	213	160	7	18	130	30	53	72	100	64	49	230	412.5	3#	25 kg
TAT-210HC-A	-	√	317	274	210	7	18	146	30	55	72	100	64	49	230	412.5	3#	36 kg

**AMT 系列 手動頂針尾座 Manual Tailstock**

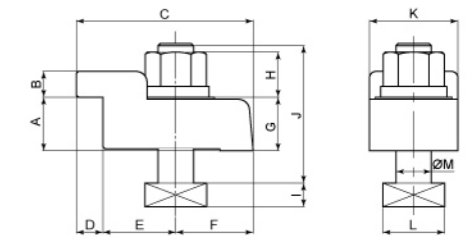
AMT手動頂針尾座，與AT系列CNC Rotary Table搭配使用，固定工件中心旋轉加工應用。

AMT Center tailstock can attach to CNC rotary table of AT series. The alternative choices are spindle with center type changeable center type for pivoting the work piece for swivel processing application.



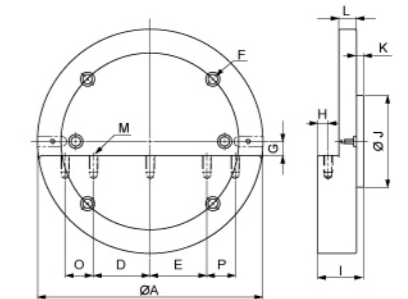
機型/規格尺寸 Specification / Model	A	B	C	D	E	F	G	H	I	J	K	L	M	N	莫氏椎度 Morse Taper	重量 Weight
AMT-110C	160	144	110	5	14	100	20	48	110.5	30	45	25	135	288	2#	15 kg
AMT-135C	185	170	135	5	14	100	20	48	110.5	30	45	25	135	288	2#	15 kg
AMT-160C	253	193	160	5	18	130	25	48	135.5	50	56	41	230	386	3#	25 kg
AMT-210C	283	240	210	5	18	146	25	48	135.5	50	56	41	230	386	3#	15 kg
AMT-255C	335	292	255	5	18	200	32	60	150.5	50	106	116	285	551	4#	25 kg

**定位壓板  
Position Blocks**



適用機種 Code No.	數量/台	適合溝尺寸	尺寸 Size													
			A	B	C	D	E	F	G	H	I	J	K	L	M	
AT125	2	14	-	-	-	-	-	-	-	-	17	8	55	-	23	12
AT160	2	14	-	-	-	-	-	-	-	-	17	8	60	-	23	12
AT200	2	18	-	-	-	-	-	-	-	-	21	11	60	-	28	16
AT250	4	18	25	12	80	12	33	35	22	21	11	65	40	28	16	
AT320	4	18	30	15	90	16	31	43	25	21	11	70	46	28	16	

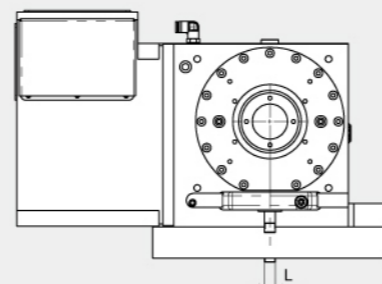
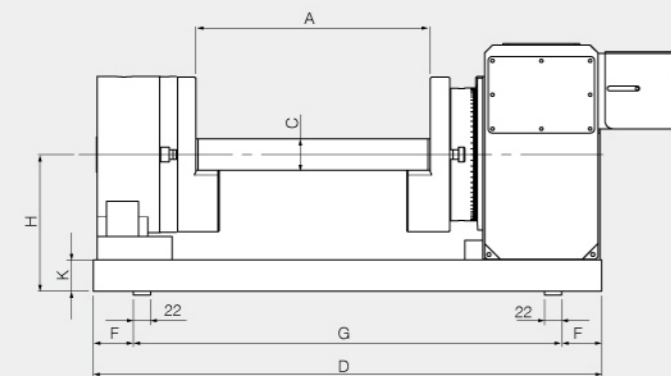
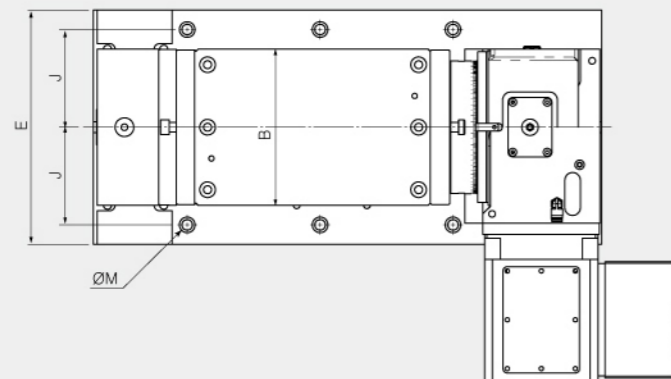
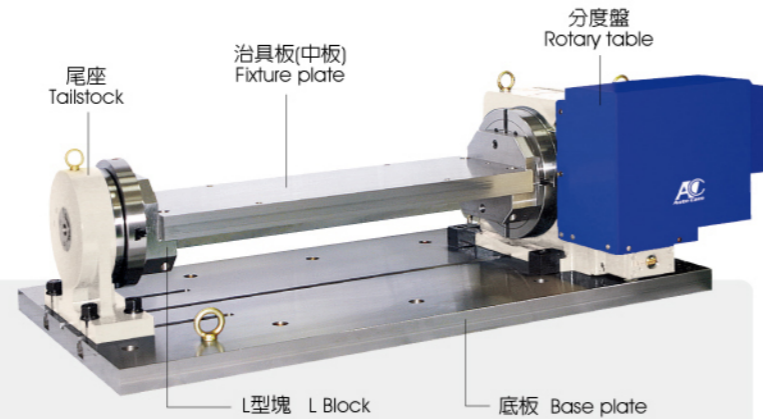
**一體式L型塊  
Block**



機型 Model	A	D	E	F	G	H	I	J		K	L	M	O	P	Weight
								第四軸端	尾座端						
TL-125	∅128	40	40	M10-PCD∅105	20	15	60	∅30	∅40	10	20	2-M12	-	-	3 kg
TL-160	∅198	80	80	M10-PCD∅138	20	15	65	∅60	∅50	10	25	3-M12	-	-	9 kg
TL-200	∅198	80	80	M10-PCD∅138	20	15	65	∅60	∅50	10	25	3-M12	-	-	9 kg
TL-250	∅248	80	80	M10-PCD∅150	20	15	65	∅90	∅50	10	25	3-M12	-	-	14 kg
TL-320	∅318	80	80	M12-PCD∅250	20	15	65	∅130	∅50	10	25	5-M12	40	40	23 kg

### 滾輪凸輪分度盤中底板選配件 Accessories for CNC Rotary Table

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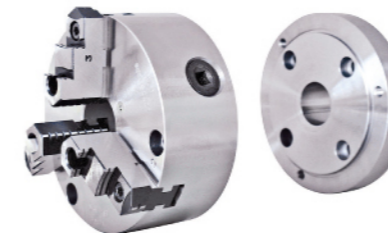


### 機械式樣表 Specification

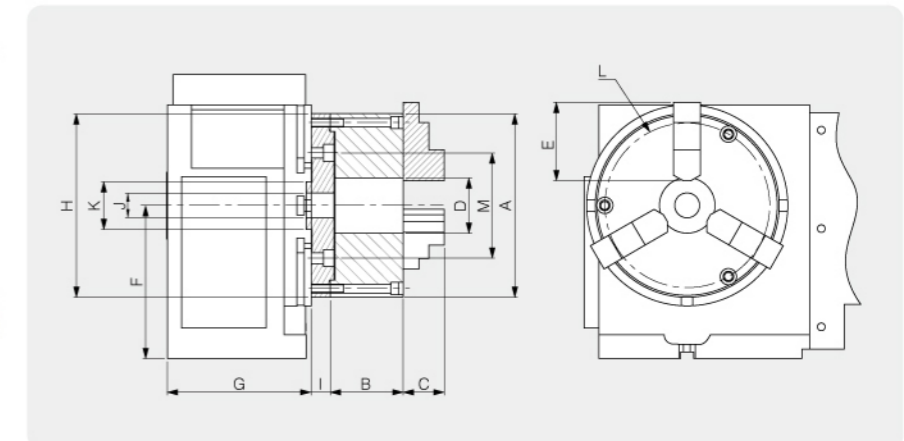
機型 Code No.	AT125R	AT160R	AT200R	AT250R	AT320R
A	300	400	600	700	800
B	125	160	200	250	320
C	40	40	40	40	40
D	582	744	944	1082	1218
E	260	300	300	300	400
F	91	122	172	191	209
G	400	500	600	700	800
H	150	175	200	200	250
J	100	100	100	100	100
K	40	40	40	40	40
L	14	14	18	18	18

### 三爪連接板 3-Jaw Back Plate

※搭配強力型前鎖式三爪、油壓三爪來夾持圓型工件。  
※Equipped with front mount scroll chuck or hydraulic 3-Jaw chuck for holding round material.



### 機械寸法圖 Outline dimensions

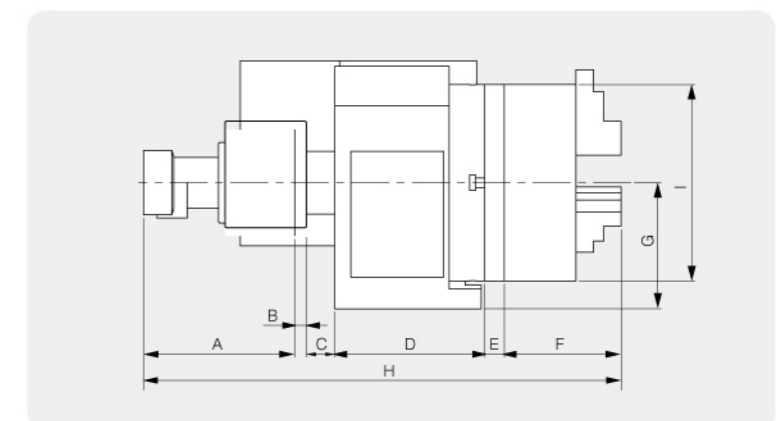
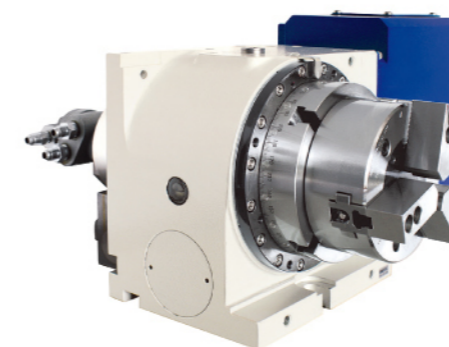


機型 Model	三爪尺寸 3 Jaw Size	A	B	C	D	E	F	G	H	I	J	K	L	M
TC-160	6"	167	66	39	45	68	135	193	167	25	30	60	147	100
TC-200	7"	193	76	43	58	82	160	193	193	25	30	60	172	130
TC-250	8"	203	76	43	58	82	160	190	203	25	30	90	176	165
TC-320	9"	233	84	50	70	93	210	210	233	30	30	130	210	220
TC-400	10"	273	86	50	89	93	255	250	-	-	-	150	250	-
TC-500	12"	310	96	56	105	118	320	300	-	-	-	200	285	-

### 三爪油壓夾頭搭配迴轉缸 3 Jaw Hydraulic Chuck with Cylinder

搭配油壓自動夾頭及腳踏開關或手動切換器，可縮短換料時間，增加產能，提昇加工效率。  
Equipped with hydraulic chuck and foot switch or manual switch shorten loading and unloading time, increasing productivity and efficiency.

### 機械寸法圖 Outline dimensions



機型 Model	三爪尺寸 3 Jaw Size	A	B	C	D	E	F	G	H	I
TC-160	6"	192	15	36	193	25	118	135	536	169
TC-200	8"	192	15	36	193	25	129	160	547	210
TC-250	8"	192	15	36	190	25	129	160	593	210
TC-320	10"	202	15	40	210	30	143	210	650	254

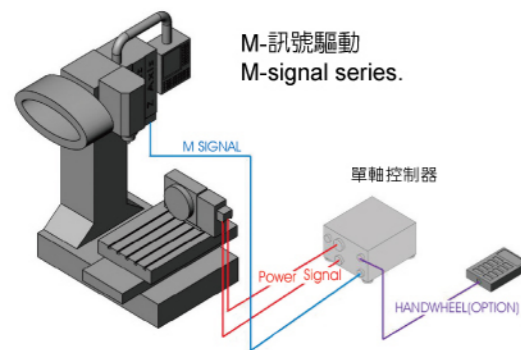
## 單軸控制器 Single Axis Controller

### Features:

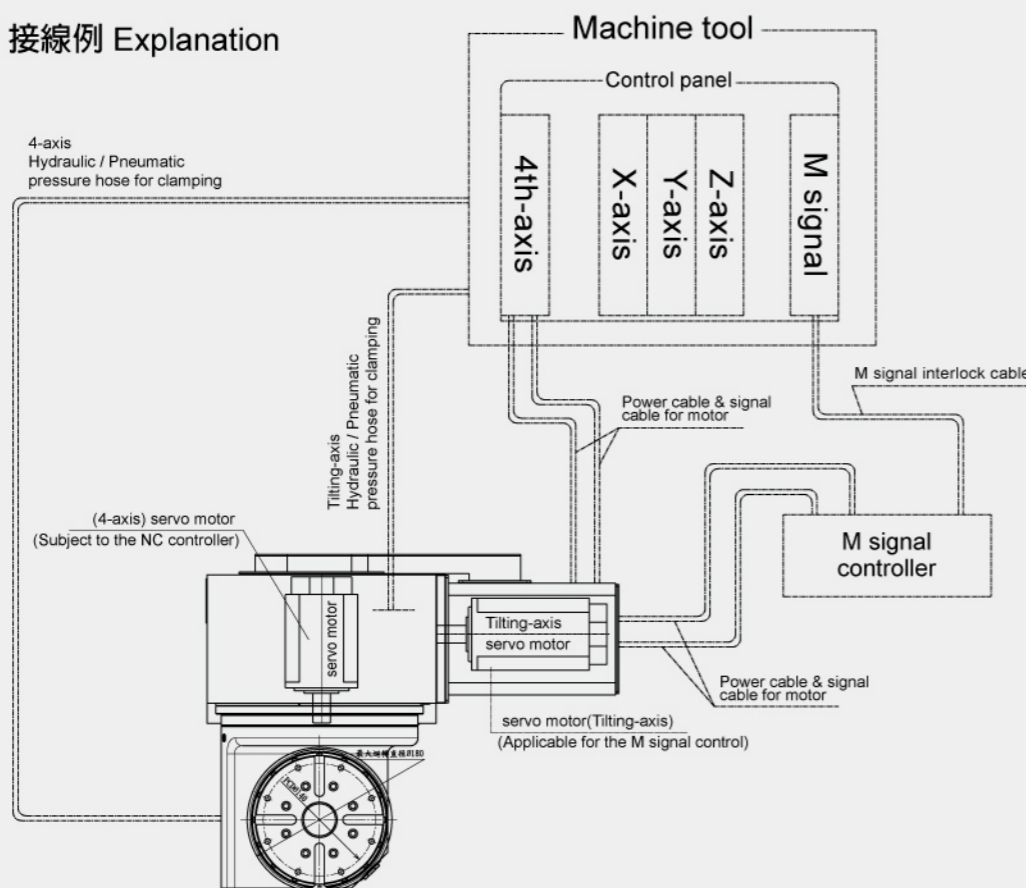
1. Single axis controller can be used with M-signal to resolve a machine cannot be installed 4th or 5th axis case.
2. Program for a rotary table should be inputted directly to the single axis controller. At the machine tool, M-signal is input as a start command.
3. M-signal control system is only for indexing.

### 特性:

1. 無法加裝第四、五軸之機床，可使用單軸控制器的M信號來連接。
2. 分度盤的程式可以直接輸入到單軸控制器，然後加工中心機以M指令作為分割控制的開始訊號。
3. M信號的控制系統僅適用於分割加工。



### 接線例 Explanation

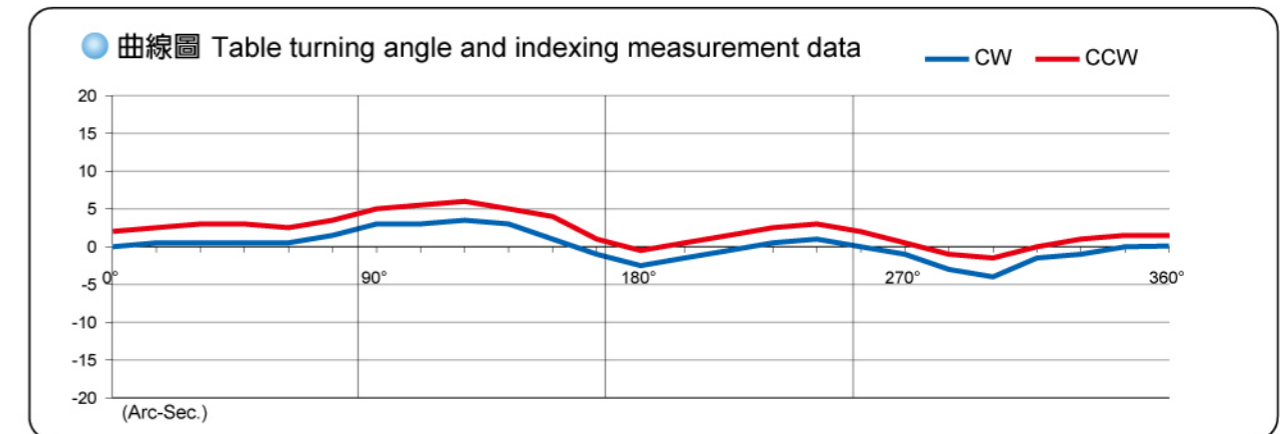


## ▶ 技術資料 Technical Information

### 分割精度 Indexing Accuracy

分度盤轉一圈並以出力軸上之滾子數等分測定角度，且以理論計算之迴轉角度與所測量之迴轉角度間之差異值。因此分割精度為測量後之正值與負值之差的最大值總和(絕對值)。

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



### 重覆精度 Repeatability

分度盤定位在(0, 90, 180, 270度)，各進行5次正轉的分割角度量測。再依每個定位角度所際量測的最小和最大值之間的差異。再作反轉量測，與正轉相同的方式進行分割角度量測，而最小值和最大值之間的差異就是量測值。所謂重覆精度即是這兩種量測值的最大誤差值。

Indexing at four specified (0, 90, 180, 270) degrees are 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.

### 鎖緊扭力 Clamp Torque

鎖緊扭力為夾緊機構所產生之鎖緊力構成。在型錄中所示的夾緊扭力為依據額定壓力(2.0 MPa的液壓和氣動壓力為0.5 MPa)時所產生之力矩能力。當需要一個更大的夾緊扭力時，可增加最大容許壓力至(3.5 MPa的液壓，氣動壓力為0.7 MPa)逐漸增加夾緊扭力。

Clamp torque is only the force of the clamping mechanism. The clamp torque shown in the catalog is the figure obtained when the rated pressure (2.0 MPa for hydraulic pressure and 0.5 MPa for pneumatic pressure) is supplied to the working fluid. When larger clamp torque is required, increase the pressure gradually up to the maximum allowable pressure (3.5 MPa for hydraulic pressure, 0.7 MPa for pneumatic pressure) to increase the clamp torque.