

Exquisite Products of Taiwan. Extreme Ingenuity

TJR CNC Rotary Table

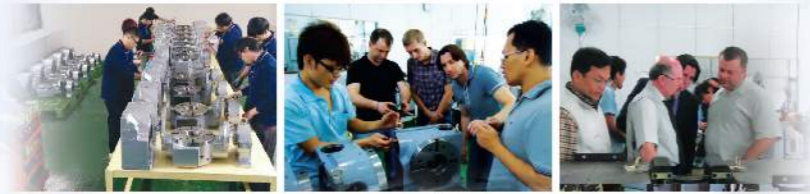


TJR Global Sales

Innovative Product

Integrity Business

Responsible Service



Taiwan, TJR Precision Technology Co., Ltd.
 TEL: +886-4-2562-1267 No. 805, Zhongshan Rd., Shengang Dist.,
 Taichung City 42943, Taiwan (ROC)

The 16th Edition

Jiangsu, Jin Tan Jia Precision Machinery Co., Ltd.
 TEL: +86-512-5781 8756



APP web www.tjr.com.tw



Shanghai Tan Jia Machinery Equipment Ltd.
 TEL: (86) 21-6806-0545-6 Room 904 No.1100, Kangqiao Rd.,
 Kangqiao Town Pudong New Area, Shanghai City.



Taiwan NO.1

TJR rotary table can surpass Japanese-made one

Worry no more for wear
 - longer lifetime -

Bearing determines rigidity
 Radial & Axial bearing



Alloy steel ion nitrided worm gear
 (1) Anti-wearing HRC85°
 (2) High torque
 (3) Auto self-locking

Alloy steel worm gear



FAD-300F-HS
 It can work as a horizontal lathe
 Super-High-Speed: 2000 rpm



**AD-170
 AD-260iB**
 Speed: 200 rpm



Driven by direct drive motor (D.D.M)
 D.D.M rotary table can be fully compatible with FANUC, Mitsubishi, Siemens, and other controller brands



FHD-650-ID650
 (2 DD Motors)
 Rotary: speed 210 rpm.
 Tilt: speed 120rpm.

TJR® Overwrite the image of LV TJR® rotary table speed



Driven by roller gear cam
Made by Japanese Roller Gear Cam Master



FHR-350F-2W-RC320-2A
 ① Dual A axis synchronization driven by roller gear cam
 ② Dual C axis driven by alloy steel worm & gear (Two C axes can rotate in the same or opposite direction)












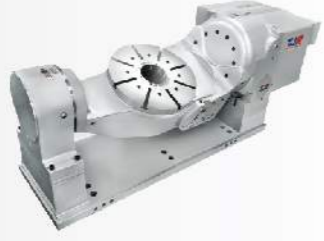
FAD-170F-RC210
 Tilt : Driven by Roller Gear Cam (Pneumatic brake) Speed 80 rpm.
 Rotary : Driven by D.D Motor (Pneumatic brake) Speed 300 rpm



HRC-400
 Swivel spindle head(B axis)
 HRC-400SP (driven by roller gear cam)
 HHRs-400SP (driven by alloy steel worm & gear)

The 16th Edition

There are **four common transmission mechanisms** of rotary table as bellow:
 You can find **all types of mechanism in TJR.**

<p>Transmission Mechanism</p> <p>A</p>  <p>Driven by alloy steel worm gear</p>	 <p>Strength:</p> <ul style="list-style-type: none"> ① Much more anti-wear than bronze worm gear ② High torque ③ Because the tilting axis needs to bear heavy load, alloy steel worm gear can significantly enhance wear resistance.
<p>B</p>  <p>Driven by roller gear cam (speed: 80 rpm)</p> <p>Made by Japanese roller gear cam master</p>	 <p>Strength:</p> <ul style="list-style-type: none"> ① Almost no backlash during the clockwise / anti-clockwise rotation ② Almost no abrasion for the transmission mechanism ③ High speed
<p>C-1</p>  <p>Driven by super high speed direct drive motor (super high speed: 2000 rpm)</p>	 <p>Strength: can work as a lathe concurrently</p> <ul style="list-style-type: none"> ① If the moving column vertical machining center or drilling & tapping center is equipped with our table, it can make the machine work as a horizontal or vertical lathe concurrently. ② The super high speed of rotary axis: 2000 rpm. ③ Truly zero backlash during the clockwise / anti-clockwise rotation. ④ Truly zero wear for the transmission mechanism. ⑤ Long-lasting high precision (The actual precision depends on the selected angle encoder)
<p>C-2</p>  <p>Driven by direct drive motor (speed: 200 rpm)</p>	 <p>Strength:</p> <ul style="list-style-type: none"> ① Truly zero backlash during the clockwise / anti-clockwise rotation. ② Truly zero wear for the transmission mechanism. (No abrasion at all) ③ High speed: 200 rpm ④ Long-lasting high precision (The actual precision depends on the selected angle encoder)
<p>D</p>  <p>Driven by Japan-made worm & worm gear (speed: 25 - 44 rpm)</p>	 <p>Strength:</p> <ul style="list-style-type: none"> ① The major and cost-effective solution. ② Easy to adjust backlash after some abrasions. <p>※ Alloy steel worm gear and roller gear cam are options to drive tilt axis of dual-axis rotary table.</p>

Bearing determines rigidity
 Radial & Axial bearing



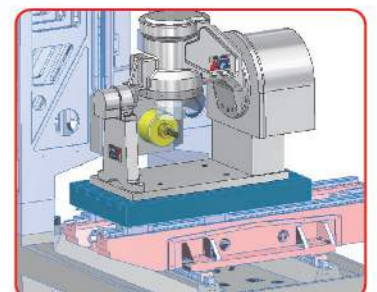
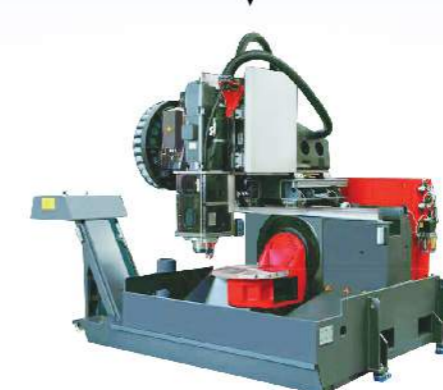
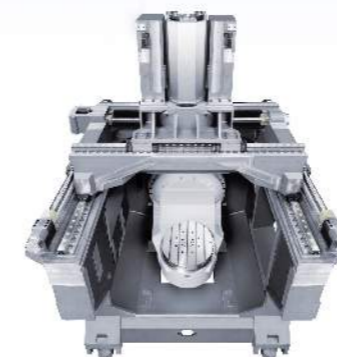
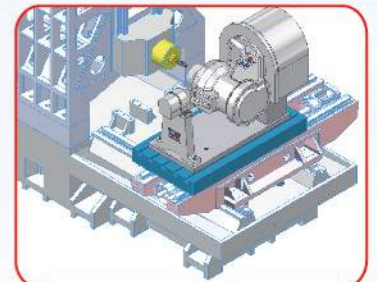
Alloy steel ion nitrided worm gear

- (1) Anti-wearing
- (2) High torque
- (3) Auto self-locking



Dual lead Alloy steel worm

Alloy steel worm gear



Competitive Advantage

You can have the following 20 kinds of models when you choose any size of TJR 4th & 5th axis rotary table.

- ※ **A** goes with ① or ② or ③ or ④ or ⑤
- ※ **B** goes with ① or ② or ③ or ④ or ⑤
- ※ **C** goes with ① or ② or ③ or ④ or ⑤
- ※ **D** goes with ① or ② or ③ or ④ or ⑤

20 kinds of models in total

Rotary axis:

- ① Driven by 200 rpm DD motor
- ② Driven by 2000 rpm DD motor
- ③ Driven by roller gear cam
- ④ Driven by bronze worm & worm gear
- ⑤ Driven by alloy steel worm gear

Tilt axis:

- A** Driven by 200 rpm DD motor
- B** Driven by roller gear cam
- C** Driven by bronze worm & worm gear
- D** Driven by alloy steel worm gear



Horizontal DD motor rotary table



HAD-170
(Driven by DD motor 200 rpm)
Mounted on the surface grinder, it can work for rotary surface grinding and side grinding. (the faceplate can be enlarged)



HAD-210F-HS
(2000 rpm)
Can work as a lathe concurrently

Make your dreams of "turning instead of grinding" and "mirror finish" come true

The first key of success: Use the right and high-precision dynamic balancing Instrument. Then, the secondary are cutting tools, cutting fluid, machine tool precision, and control system (incl. PLC)



▲ Dynamic balancing Instrument. (400 rpm – 20000 rpm)
Acceleration measurement range: 0.0001-20G

High-speed and high-precision dynamic balancing rotary table.

It takes only 5 minutes for adjustment to reach 1 μ m~5 μ m. It's possible to reach Dynamic balancing highest level G 0.4 ~G 1.0 when all necessary conditions are carried out.



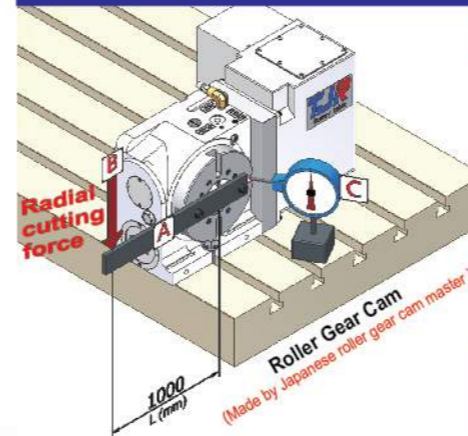
Why it's necessary to use dynamic-balance adjusting ring.

It's required to adjust dynamic balance every time whenever a different fixture or work-piece is mounted. However, by using the dynamic-balance adjusting ring, it's very easy to do even for a layman.

The adjustment method
Manually move the balancing piece. Require no drilling or screwing.

Taiwan patent number: M494043 M506667 counterfeiting not allowed
China patent number: ZL 2012 2 0525527.2 ZL 2015 2 0243029.2 counterfeiting not allowed

How can we know the real quality of roller gear cam rotary table?



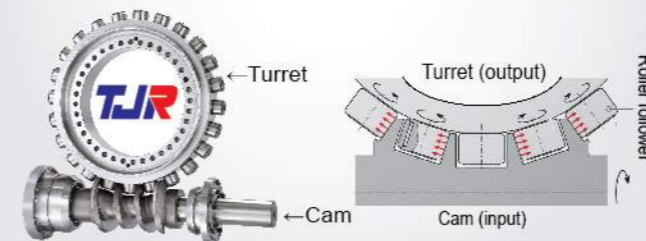
The simple rigidity testing on allowable cutting torque of roller gear cam:

Testing conditions: Keep rotary table unclamped and servo motor electrified.
1. The rigidity of roller gear cam can be indicated by the biggest allowable pressure kg-m exerted on point **B** to just keep the deformation within 0.01 mm measured by dial gauge **C**. If the rigidity of roller gear cam isn't good enough, it cannot well support the 4th axis simultaneous machining or eccentric machining on a fixture plate.
2. The lower the sound volume and the temperature are when the rotary speed is high, the better the quality of roller gear cam is.

If you want to know what is the maximal W KGs and L mm which TJR roller gear cam can sustain while keeping the deformation within 0.01 mm, please contact us to ask for the detailed technical report

Made by Japanese roller gear cam master

When a roller follower enters the spiral orbit of cam, the follower is preloaded to contact the orbit surface. Thus, there is no backlash between roller follower and cam. By using roller followers as transmission elements, follower's rolling with sliding contact makes almost no abrasion so as to substantially extend product life.



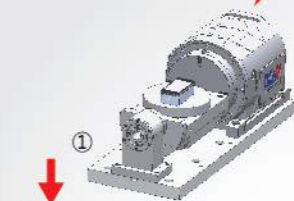
Two transmission mechanisms are available for swivel spindle head

- ① Driven by roller gear cam
 - ② Driven by direct drive motor
- The \varnothing 170 swivel spindle head (as below diagram shows) can be mounted on the engraving machine. \varnothing 250 - \varnothing 320 and \varnothing 400 available as other alternatives



Example: Five-face machining for cell phone case

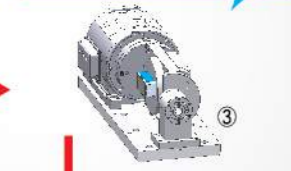
① Machine the front side at 0°.



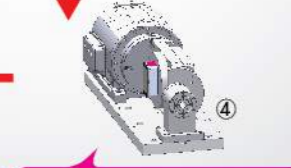
② Rotate the fixture plate 90° clockwise, and then machine the left side.



③ Rotate the fixture plate 90° counterclockwise, and then machine the right side.



⑤ Rotate the fixture plate 180° counterclockwise, and machine the down side.

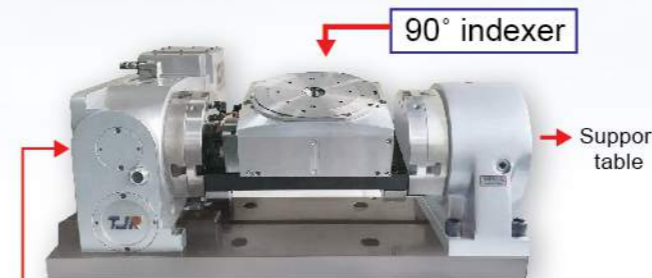


④ Rotate the pneumatic index table 90°, and then machine the up side.

A simplified 4th & 5th axis rotary table

Tilt axis: roller gear cam or DD motor rotary table
Rotary axis: 90° indexer

No abrasion even table rotates & tilts for 24-hours per day. It can do five face machining without employing a standard 4th & 5th axis rotary table.



Tilt axis

Tilt axis can be driven by the following transmission mechanisms (please see page 1 for more details)

- A-2: Driven by 200 rpm D.D. motor (No abrasion)
- B: Driven by roller gear cam
- C: Driven by worm & worm gear + angle encoder

So Elegant So Strong

Streamline model shows the elegance of power and beauty.



FHR-630S



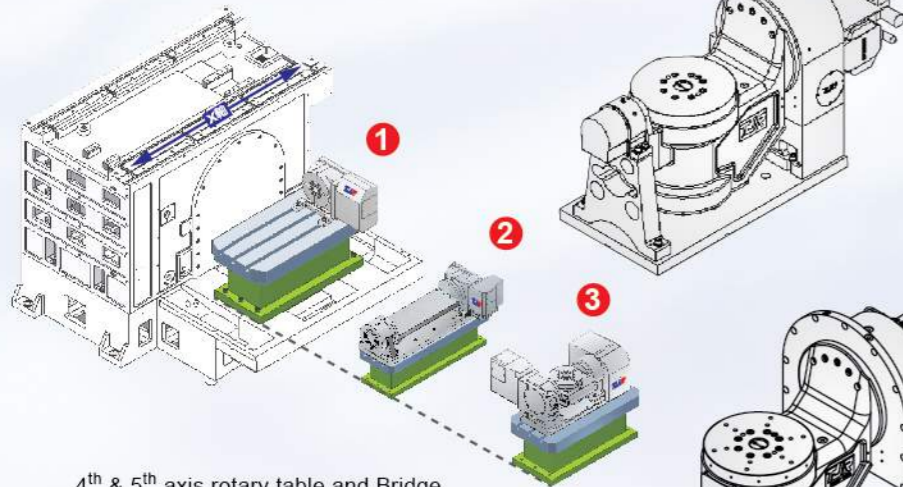
FHR-630SN
(Reduced type for Siemens control)

This is the only way to lead the trend.

D.D.M. (Direct Drive Motor) type dual-axis rotary table.

- ◀ FAD-300iwj-30D-HS can be equipped with a base plate and then directly placed on the alternative machines as follows:
- ① C type 3-axis-moving-column vertical machining center.
 - ② Large-working-table vertical machining center
 - ③ Bridge type machining center

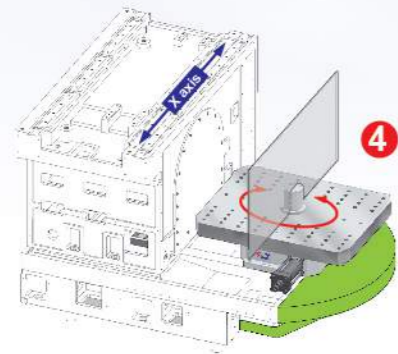
- ◀ FAD-300iwj-30D-HS can be directly placed on the bridge type machining center by fastening the tilt axis on the machine base. (An additional support table is optional)



4th & 5th axis rotary table and Bridge connection plate set are applicable.

Quintuple-purpose machine

One machine is able to be installed with **FIVE** different kinds of rotary tables.



For vertical machining center with auto pallet changer
Features: Two functional positions (180° to and fro)

- One position: machining
- Another position: loading & unloading

Only TJR large-diameter radial & axial bearing can deliver enough rigidity to well support tilt axis of single-arm type dual axis rotary table.



For 5-axis vertical machining center (3-axis moving) column type

- Features:
- Less interruption
 - Clear at a glance no matter how the table tilts



machine base

To enjoy the freedom of processing and molding

To experience the smoothness of heavy duty cutting.



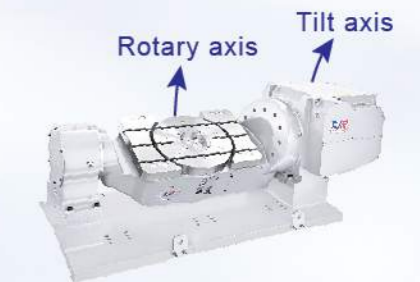
Do you pick the right rotary table?

Added value at no extra cost:

The tilt axis of the dual-axis rotary table which needs to bear a heavy load employs Japan-made worm and gear or alloy steel worm gear as a standard component.



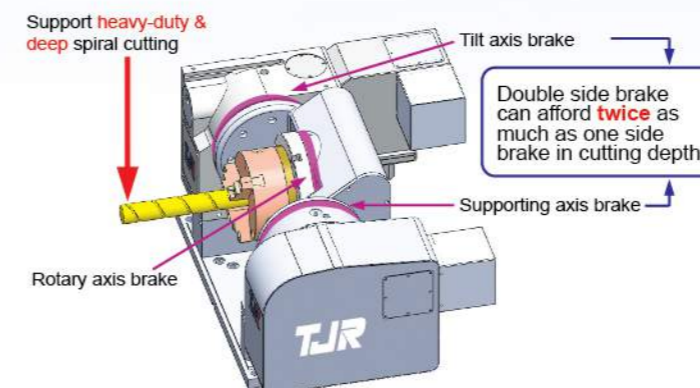
Alloy Steel Worm Gear ▲



▲ FHR-350 dual-arm type dual-axis rotary table

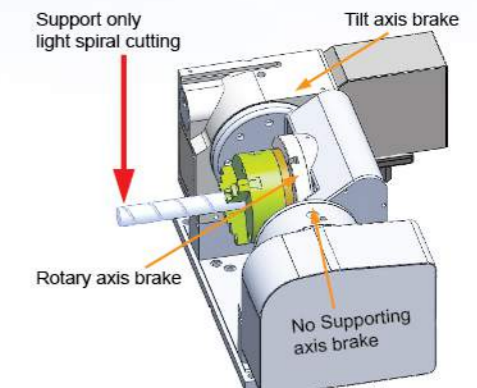
4 Features of TJR Tilting Rotary Table

- ① Max. tilt angle: $\pm 110^\circ$ (can be further customized or enlarged)
- ② TJR employs 3 independent encircling hydraulic braking systems for tilt, rotary, and supporting axis (3 brakes on 2 sides).
- ③ The tilt axis employs Japan-made worm and worm gear or alloy steel worm gear as the standard components.
- ④ Always use radial & axial preloading bearings for tilt and rotary axes.



Other Tilting Rotary Table

- ① Max. tilt Angle: $-30^\circ \sim +110^\circ$
- ② There is **no brake** for supporting axis. (2 brakes on 1 side)
- ③ A **home-made** worm & worm gear is installed in the tilt axis.
- ④ Use **normal bearings** for tilt and rotary axes.



Do you still buy products which use 20-year-old designs and technologies?



Old technology

If you prefer new car on market, why do you still buy rotary table of 20-year-old design.

CHECK!

How can we know if the product we purchase today is exactly the same as the one sold 20 years ago?

The answer:

If the exterior does not change for 20 years, the wooden mold might be the same. Hence, the interior structure has not been upgraded.



Trend



modern upgrade

20-year-old model

Other manufacturer : Smaller Through Hole → Smaller Bearing
Smaller Bearing → Lower Rigidity

Other rotary table manufacturers employ as follows



Small diameter

for hydraulic clamping for pneumatic clamping

Trend

The latest upgraded model

Redefine "RIGIDITY"

Larger Through Hole → Bigger Bearing
Bigger Bearing → Higher Rigidity

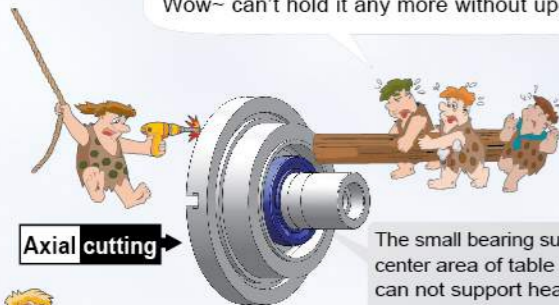
Large diameter



Devised by German

Specialized for Rotary Table, the Radial & Axial bearing can fully support heavy-duty cutting in both radial and axial directions.

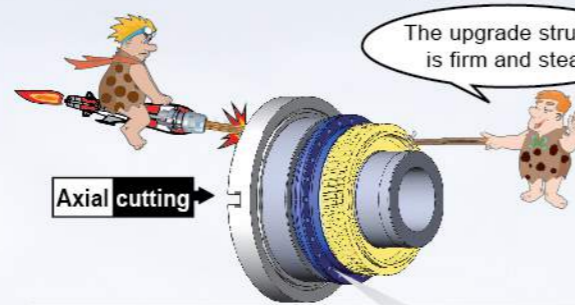
Wow~ can't hold it any more without upgrade.



Axial cutting

The small bearing sustains the center area of table so that it can not support heavy duty cutting. Therefore, small diameter indicates lower rigidity.

The upgrade structure is firm and steady.



Axial cutting

TJR employs large-diameter bearings which sustain outer circle periphery of table and accordingly better support heavy duty cutting. Therefore, bigger bearings significantly increase overall rigidity.

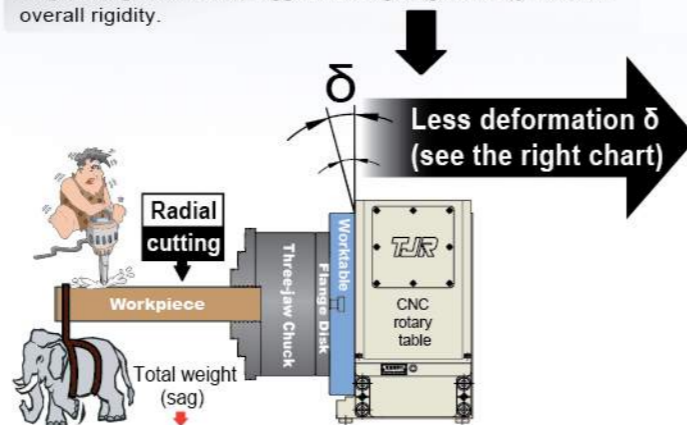
The most important characteristics for a rotary table to have are : 1. PRECISION 2. RIGIDITY



The **PRECISION** depends on worm wheel



The **RIGIDITY** depends on spindle bearing



Refine the rigidity.
Push boundaries of cutting.



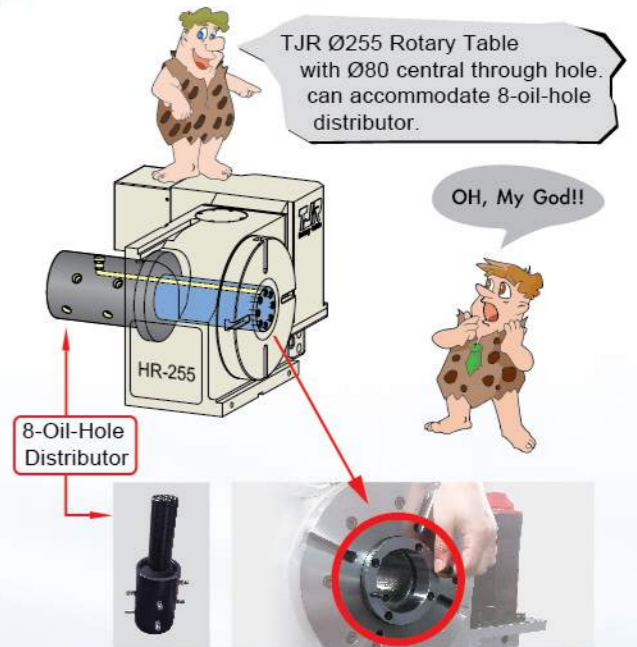
Stop searching!
Only in TJR, you can pay the price of small-through-hole rotary table for the large-through-hole rotary table.

Truly good value for money

TJR



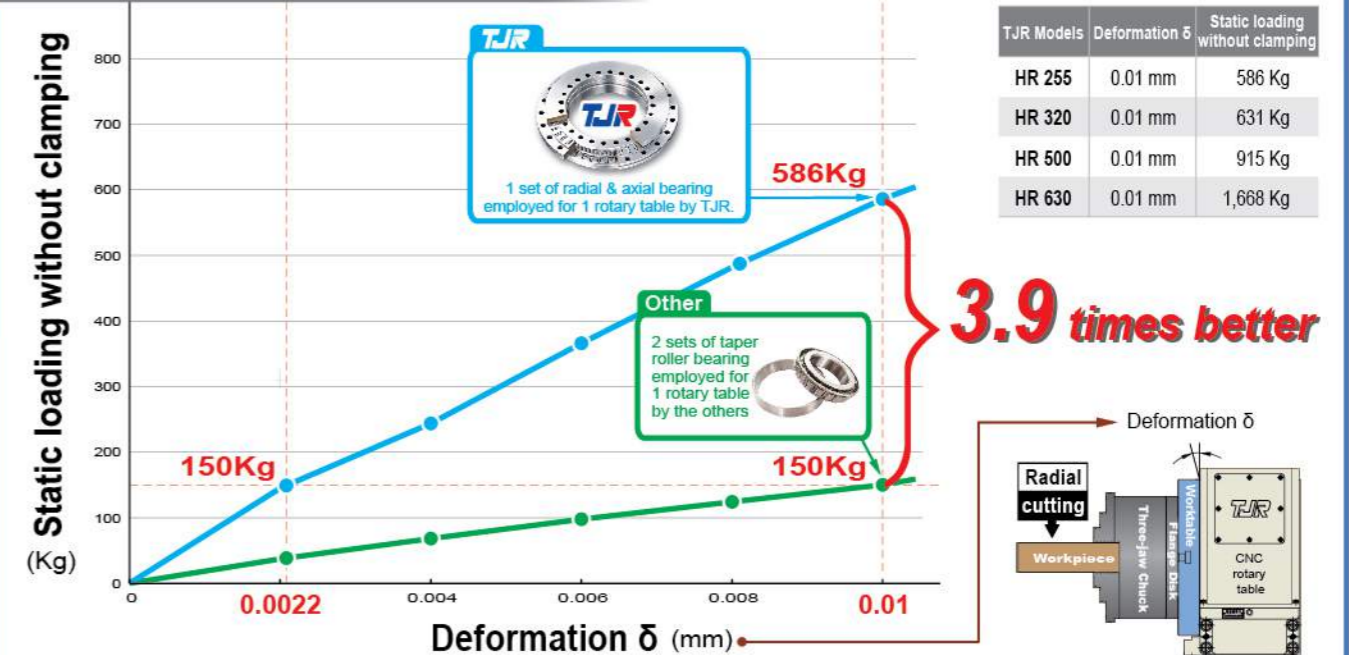
Value Added



The TJR through hole diameter can be easily adjusted by retrofitting the mandrel sleeve. But, it's no way to enlarge the small-through-hole design of others.

Rigidity comparison between radial & axial bearing and taper roller bearing

Take Ø255mm Rotary Table as an example



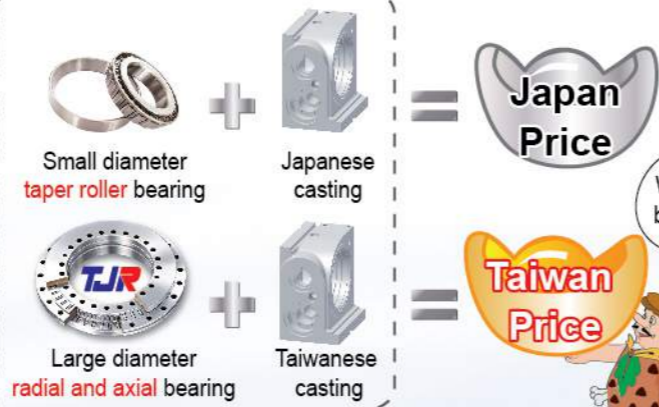
It is no longer required to buy Japanese brand in order to acquire Japanese quality. TJR can achieve Japanese quality with lower cost.

Ready to start saving money?
Here's how to do it right!

Japanese rotary table employs



Differences



What a bargain!

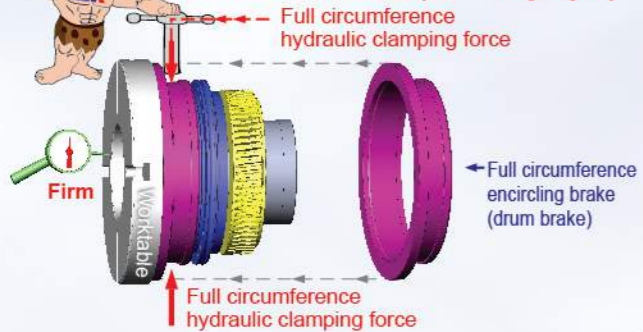
TJR rotary table employs



Comparison of braking system

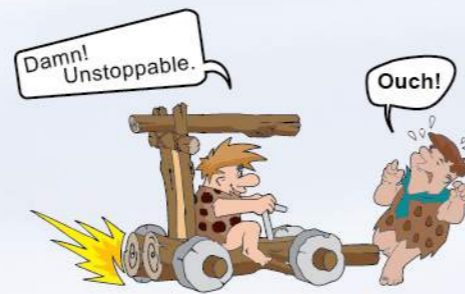
TJR Encircling braking system

- Bigger contact area ; higher clamping force
- Brake mechanism tightly encircles the work table and thus provides **high rigidity**



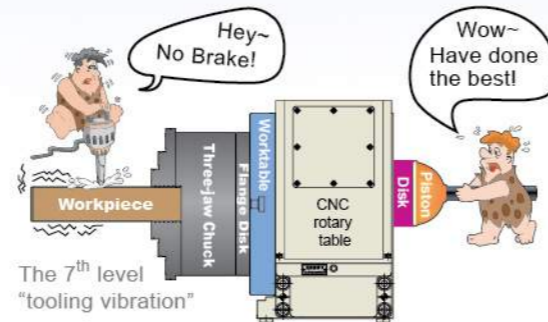
The brake system for rotary table is too important to be compromised!

Bad brakes cause car accident all the time.



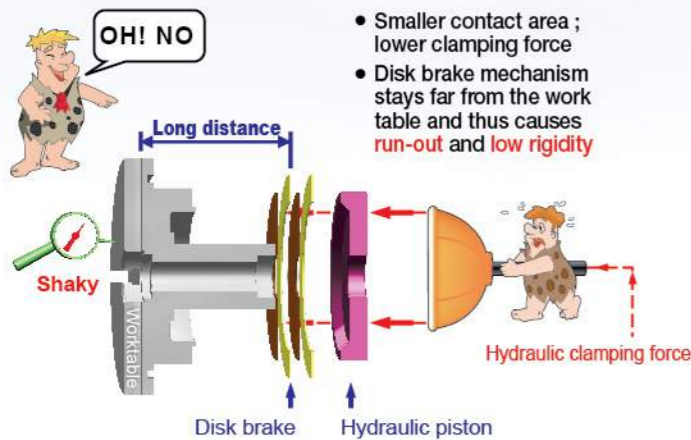
A rotary table without good brakes causes tooling vibration.

- ① Tooling vibration occurs while processing bar-shape work pieces
- ② Middle plate vibration occurs while machining with fixture plate and therefore damages worm gear, leading to bad precision.



Disk braking system

- Smaller contact area ; lower clamping force
- Disk brake mechanism stays far from the work table and thus causes **run-out and low rigidity**



Desired beauty of true machinery

Sophisticated, perfect, excellent in all details

Treasure for top talent scout



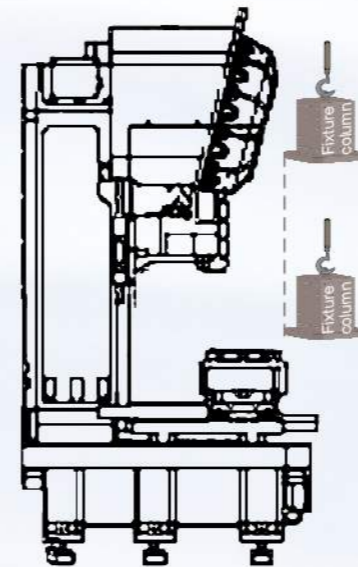
□255x255 / 320x320 / 400x400 – Horizontal application, Specially for small vertical machining center and small drilling & tapping center

New Thought → Future way out

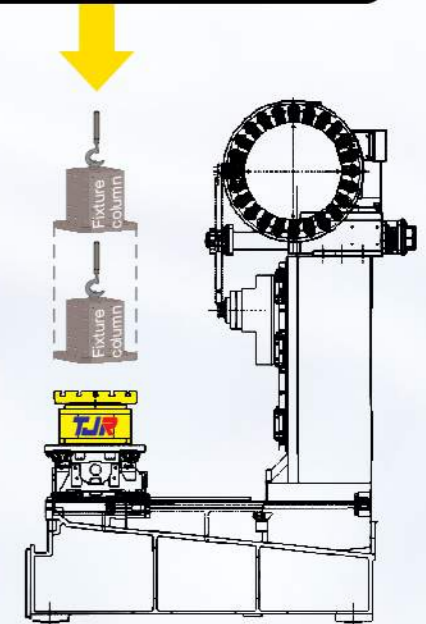
Don't worry about recession as long as you keep following up

The benefits of converting vertical machining center into horizontal one.

1. Less suppliers cause less competition
2. Cutting waste is not easy to fall into groove or slots of workpiece
3. More space for adjusting cutting tool and more convenient for setting up fixture column.
4. Because several work pieces can be mounted on the four faces of the fixture column, multi-operations can be performed by one operator so as to save human resource cost.
5. The same machine base can be applied to either vertical or horizontal machining center. The occupied floor space can be kept the same.
6. By only changing ATC and erective column, you can simply convert vertical machine into horizontal one.



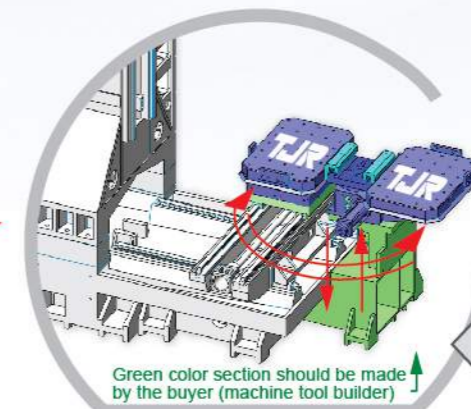
VERTICAL drilling & tapping center



small HORIZONTAL drilling & tapping center

Transform VERTICAL into HORIZONTAL

Transform VERTICAL into AUTO PALLET CHANGER



Green color section should be made by the buyer (machine tool builder)

▲ Application example: retrofitting CTU to drilling & tapping center or vertical machining center.



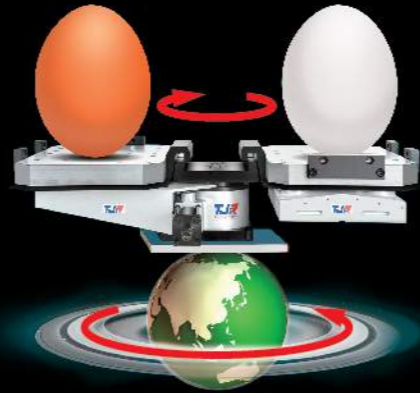
▲ CTU Hook type auto pallet changer

The location of CTU can vary, depending on the machine design and dimensions.

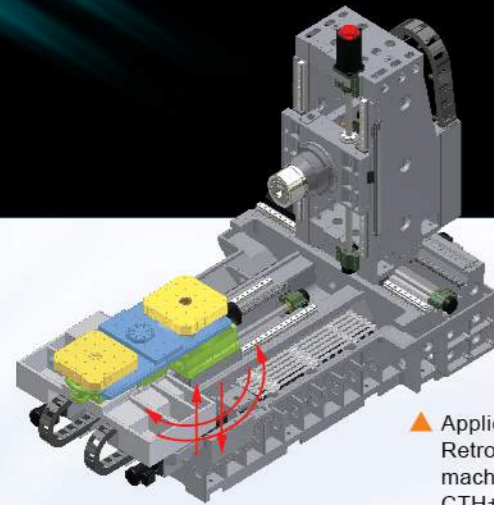
In the metal cutting industry, employing the 4th axis can easily solve the labor shortage crisis.

A living legend

Create a surprising exchange mechanism



Beyond the rotational inertia
Reach unimaginable stability



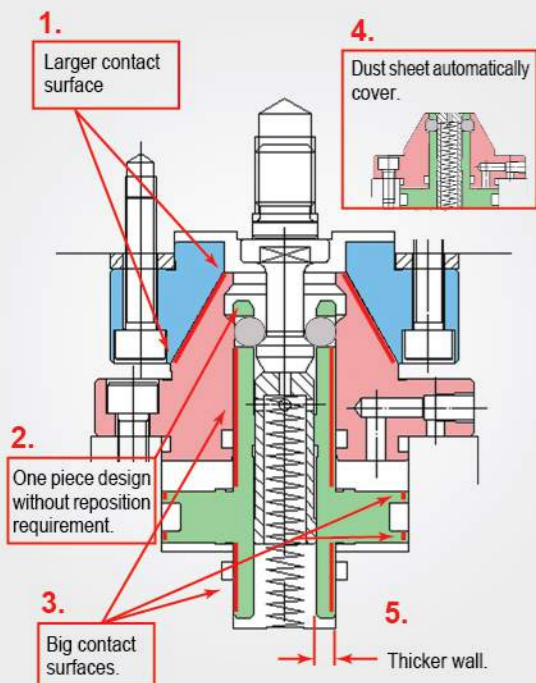
▲ Application diagram:
Retrofits horizontal
machining center with
CTH+CHI

▶ Positioning cones:
Powerful hydraulic
clamping



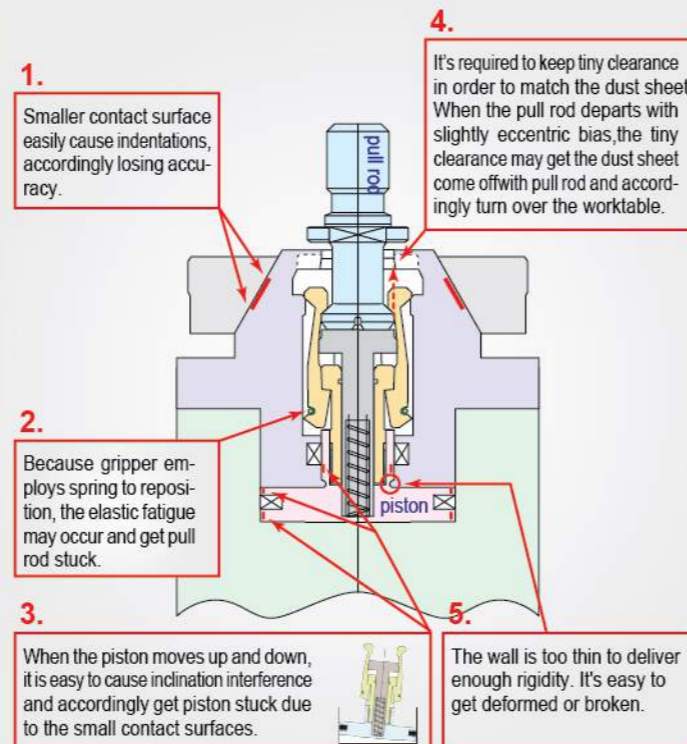
Comparison of positioning cones

Ball locking mode



90% Japanese horizontal machining center use the Ball locking mode.

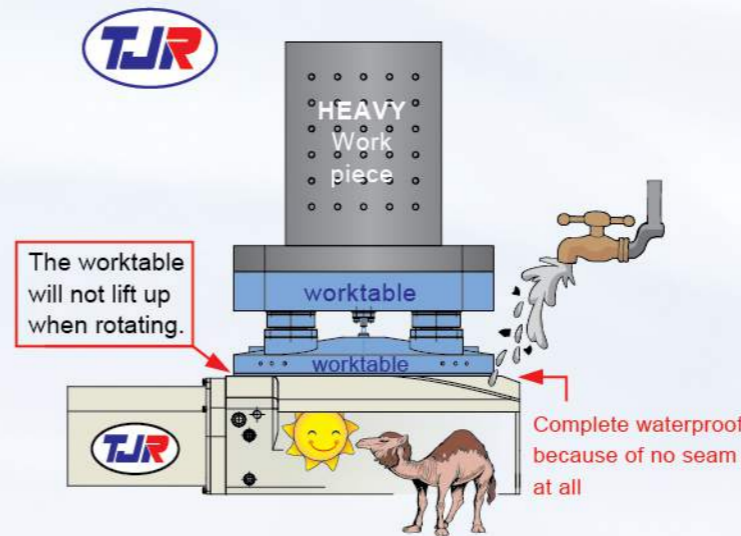
Grippers locking mode



You will sleep better than a Panda if you choose "TJR" rotary table for your Horizontal Machining Center.



The comparison of Clutch



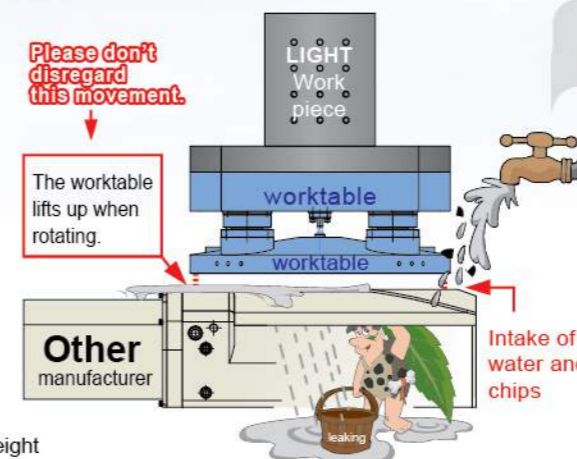
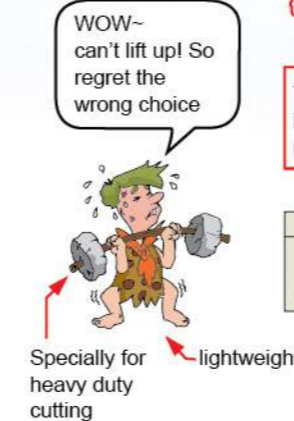
Positioning Accuracy: ± 5 sec
(TJR does not use 2-piece clutch.)

TJR use 3-piece clutch

Advantages :

1. The work plate does **not lift up** when rotating. So, there is no risk of intake of water and chips.
2. **Bigger** loading capacity.
3. **3-piece** clutch can employ labyrinth seal.

Other manufacturer



Other suppliers of Rotary Table use 2-piece clutch

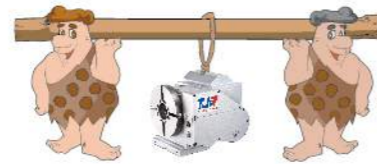
1. There is some risk of intake of water & chips when worktable **lifts up**.
2. The water-resistant seal of 2-piece clutch needs to sustain the constant friction while **rotating up & down**. Therefore, it gets worn easily and accordingly causes intake of water & chips.
3. **Smaller** loading capacity
4. **2-piece** clutch cannot employ labyrinth seal.

The comparison of price advantage



Driven by TJR's premium components and design, TJR price should be similar to the price of Japanese-made product. However, TJR price is actually similar to the price of Taiwanese-made one. It shows TJR is the most cost-effective choice.

The comparison of service attitude



The truly priceless value is the excellent customer service which TJR always persists in.



It is regretting that rotary tables become useless when you buy rotary tables without good after-sales services.

The comparison of inspection facilities

	3D measuring equipment - Geometry precision testing -	Laser measuring equipment - Indexing precision testing -
TJR	<p>YES</p> <p>Fully utilized to test all kind of precision and runout.</p>	<p>YES</p> <p>Every rotary table needs to pass laser angular test before shipment</p>
Others	<p>NO</p>	<p>Alternative methods</p> <ol style="list-style-type: none"> 1. Use the old-type measuring equipment 2. Use cheaper encoder or angle encoder 3. Use the fixture with height gauge to measure 4 squareness

Ignoring little details will make your motor immersed in water.

Is the rim of your sheet metal sealed by waterproof glue? The waterproof glue will be brittle and accordingly permeable as the result of prolonged exposure to metal removal fluid.



It is watertight by all rims sealed with O-ring.
(IP65 water-resistant enclosure)



The long-last, anti-erosion, and silver pearl lacquer makes your rotary table look fresh.

Customized model



▲ Pneumatic multi-spindle rotary table (4-wheel coupled) : AR-125-4W

Product Range

Longer service life due to TJR's dedication on quality

- **AR series** (Pneumatic brake)-back side motor AR-125B-250B
- **AR series** (Pneumatic brake) AR-125-250
- **HR series** (Hydraulic brake) HR-210-800
- **AD-260IB** (Direct drive motor)
- **FAD-170F / FAD-210F** (2DD motors, pneumatic brake)
- **FAD-170F-RC210** (Rotary : DD motor Tilt : Roller gear cam)
- **FAR series** (dual axis, pneumatic brake) FAR-170/210
- **FAR-170-2W-RC255** (dual axis, pneumatic brake)
- **FAD-300F-HS** (2DD motors, pneumatic brake)
- **FHR series** (dual axis, hydraulic, 3 brakes) FHR-255C (cradle type); FHR-255CL (Extended cradle type)
- **FHR series** (dual axis, hydraulic, 3 brakes) FHR-320C (cradle type)
- **HHi-500x500** (Hydraulic brake)
- **FHR-400BCF** (Back side motor type) (dual axis, hydraulic, 3 brakes)
- **FHR-400BCF** (Back side motor type) (dual axis, hydraulic, 3 brakes)
- **FHR-630SN**
- **FHR series** (dual axis, hydraulic, 3 brakes) FHR-500C (cradle type)
- **FHR-630C** (dual axis, hydraulic brakes)
- **FHD-650-ID650** (Hydraulic brake)
- **CTU-400x600 / 500x700** (180° to & fro) Hook type auto pallet changer for C type vertical machining center
- **CTH+CHI-500/630** (Hirth coupling hydraulic brake) Tray type auto pallet changer + dual pallets rotary table for horizontal machining center
- **CHC-700x1090** (180° to & fro) Flat type auto pallet changer for 3-axis moving column vertical machining center