A work of art... and function.
Our rotary tables are customizable to perfectly match your specifications. Outstanding performance combined with immediate customer service response guarantees minimal to zero outages. Our rotary tables will help you meet your production goals.
troyke° Rotary Tables …

Troyke Manufacturing Company has been manufacturing Rotary Tables since 1939. During that period we have evolved from a manufacturer of Manual Rotary Tables to a manufacturer of 4TH and 5TH axis Rotary Positioning Systems that will increase productivity on any Vertical Machining Center.

Troyke Rotary Table accuracy is achieved through quality manufactured parts and custom manufactured Dual Lead Worm Gearsets designed specifically for each individual Troyke model. We chose Dual Lead for their wormgear efficiency, low backlash, rigidity, and excellent wear characteristics.

We offer a wide range of Rotary and Rotary/Tilt Tables. Our product line has expanded to 12 Rotary Table models ranging from 6.5” to 84” diameter and 5 Rotary/Tilt Table models ranging from 6.5” to 30” diameter. Our products are versatile and lend themselves to a variety of custom applications.

Through continuous improvement, Troyke Rotary Tables have evolved into the most rigid, versatile, and cost effective high quality products in the industry.

ACCESSORIES:

Talstocks ............................................. 13
Workholding ..................................... 14
Controls .......................................... 15
Accuracy .......................................... 16
How to Order Rotary Tables ................. 17
Vertical Mount only (best choice for Vertical Spindle Machines)

**Standard Features:**
- 8 sizes (6.5", 25" table diameters)
- Dual lead wormset simplifies backlash adjustment
- C907 bronze wormgear and hardened and ground worm running in a bath of oil
- High precision spindle bearings
- Turcite bearing surface
- Internal pneumatic brake
- Vertical Mount only (16.5", 20", 25" dual track & pinion)
- Precision ground surfaces

**Optional Features:**
- Chucks - (Manual or Pneumatic)
- Collet fixtures - (Manual or Pneumatic)
- Talistsocks - (Manual or Pneumatic)
- Single Axis programmable control
- Clamping outfit supports (Pneumatic or Hydraulic)
- Ball Lock™ sub plate and fixture plate
- Cables - for interfacing to machine tool
- Compatible with all standard servo motors
- Oversize thru hole (Hedehedan scale for accuracy up to +/-.2 arc seconds)

**Standard Features:**
- Precision ground surfaces
- Turcite bearing surface running in a bath of oil
- Dual track & pinion pneumatic brake

**Optional Features:**
- Compatible with all standard servo motors
- Direct mount bezel (Hedehedan scale for accuracy up to +/-.2 arc seconds)

**VERTICAL LOAD CAPACITY**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
</tr>
</thead>
<tbody>
<tr>
<td>DL-16.5-B</td>
<td>0.511</td>
<td>1.400</td>
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<td>3.25</td>
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<td>DL-18.5-B</td>
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<tr>
<td>DL-20-B</td>
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<tr>
<td>DL-25-B</td>
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<td>2.55</td>
<td>3.45</td>
<td>4.35</td>
<td>5.25</td>
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</table>

**DUAL MOUNTABLE**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>ensburg</th>
<th>20-25</th>
</tr>
</thead>
<tbody>
<tr>
<td>DL-6.5-B</td>
<td>0.471</td>
<td>1.400</td>
</tr>
<tr>
<td>DL-8-B</td>
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<td>1.650</td>
</tr>
<tr>
<td>DL-10-B</td>
<td>0.575</td>
<td>1.650</td>
</tr>
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</table>

**STANDARD FEATURES**

- Precision ground surfaces
- Turcite bearing surface running in a bath of oil
- Dual track & pinion pneumatic brake

**Optional Features:**
- Compatible with all standard servo motors
- Oversize thru hole (Hedehedan scale for accuracy up to +/-.2 arc seconds)

**Standards:**
- Precision ground surfaces
- Turcite bearing surface running in a bath of oil
- Dual-trac & pinion pneumatic brake

**Optional Features:**
- Compatible with all standard servo motors
- Direct mount bezel (Hedehedan scale for accuracy up to +/-.2 arc seconds)
TROYKE® NC Series - B Model

Vertical Mount – (42” - 84” are Horizontal Mount only) - see HBM Series

Standard Features:
• 2 sizes (30” - 36” table diameters)
• C907 bronze wormgear and hardened and ground worm running in a bath of oil
• High precision spindle bearings
• Turcite bearing surface
• Dual rack & pinion pneumatic brake
• Precision ground surfaces

Optional Features:
• Chucks - (Manual or Pneumatic)
• Tailstocks - (Manual or Pneumatic)
• Single Axis programmable control
• Clamping outboard supports (Pneumatic or Hydraulic)
• Ball Lock™ sub plate
• Cables - for interfacing to machine tool
• Compatible with all standard servo motors
• Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)

HORIZONTAL LOAD CAPACITY

MODEL NC-30-C NC-42-C NC-60-C

[MM] 4,000 [157.5] 7,000 [276.0] 15,000 [590.6]

VERTICAL LOAD CAPACITY

MODEL NC-30-C NC-42-C NC-60-C

[KG] 1,000 [220.4] 2,000 [440.9] 4,000 [881.8]

MAXIMUM THRU HOLE DIA

MODEL NC-30-C NC-42-C NC-60-C

[MM] 1.500 [38.1] 3.000 [76.2] 3.000 [76.2]

STANDARD THRU HOLE DIA

MODEL NC-30-C NC-42-C NC-60-C

[MM] 1.500 [38.1] 3.000 [76.2] 3.000 [76.2]

TURNTABLE DIAMETER

MODEL NC-30-C NC-42-C NC-60-C

[MM] 30.0 [762.0] 42.0 [1066.0] 60.0 [1524.0]

STANDARD TOTAL GEAR RATIO

MODEL NC-30-C NC-42-C NC-60-C

360.0 [14.0] 720.0 [14.0] 720.0 [14.0]

ALTERNATE TOTAL GEAR RATIO

MODEL NC-30-C NC-42-C NC-60-C

360.0 [14.0] 720.0 [14.0] 720.0 [14.0]

PROGRAMMABLE RESOLUTION

MODEL NC-30-C NC-42-C NC-60-C

.0005 [0.0127] .001 [0.0254] .001 [0.0254]

STD. TOTAL ANGULAR ACCURACY

MODEL NC-30-C NC-42-C NC-60-C

.005 [0.127] .010 [0.254] .010 [0.254]

STD. REPEATABILITY

MODEL NC-30-C NC-42-C NC-60-C

.005 [0.127] .010 [0.254] .010 [0.254]

OPT. (HO-R) ANG. ACCURACY

MODEL NC-30-C NC-42-C NC-60-C

+.5 [0.013] +.5 [0.013] +.5 [0.013]

OPT. (HO-R) REPEATABILITY

MODEL NC-30-C NC-42-C NC-60-C

+.2 [0.005] +.2 [0.005] +.2 [0.005]

UNIT WEIGHT

MODEL NC-30-C NC-42-C NC-60-C

LBS (KG) 1.500 (67.7) 1.410 (63.2) 1.450 (66.0)

SH-WEIGHT

MODEL NC-30-C NC-42-C NC-60-C

LBS (KG) 1.600 (67.7) 1.460 (66.0)

Optional Features:
• Cables - for interfacing to machine tool
• Compatible with all standard servo motors
• Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)

TROYKE® NC Series - C Model

Horizontal Mount – Vertical Mount (42” - 84” requires Angle Bracket Option)

Standard Features:
• 3 sizes (30” - 60” table diameters)
• C907 bronze wormgear and hardened and ground worm running in a bath of oil
• High precision spindle bearings
• Turcite bearing surface
• Dual rack & pinion pneumatic brake
• Precision ground surfaces

Optional Features:
• Chucks - (Manual or Pneumatic)
• Tailstocks - (Manual or Pneumatic)
• Single Axis programmable control
• Clamping outboard supports (Pneumatic or Hydraulic)
• Ball Lock™ sub plate
• Cables - for interfacing to machine tool
• Compatible with all standard servo motors
• Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)

Large Bore + Chuck Option
**HBM Series**

**Optional Features:**
- Custom table T-slot pattern
- Ball Lock™ sub plates and fixture plates
- Cables – for interfacing to machine tool
- Compatible with all standard servo motors
- Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)

**Standard Features:**
- 5 sizes (20", 30", 42", 48", 60", 75" square table)
- Load capacity (20"-30") 4,000 lbs.; (42"-48") 7,000 lbs.; (60"-75") 15,000 lbs.
- C007 bronze wormgear and hardened and ground worm running in a bath of oil
- 20 arc-seconds accuracy
- High precision spindle bearings
- Turcite bearing surface
- Dual rack & pinion pneumatic brake
- Precision ground surfaces

**Square Tables primarily used on horizontal boring mill applications**

---

**HDL Series**

**Optional Features:**
- Chucks - (Manual or Pneumatic)
- Tailstocks - (Manual or Pneumatic)
- Single axis programmable control
- Clamping outboard supports (Pneumatic or Hydraulic)
- Cables – for interfacing to machine tool
- Compatible with all standard servo motors
- Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)

**Standard Features:**
- 5 sizes (16.5", 20", and 25" table diameters)
- C007 bronze wormgear and hardened and ground worm running in a bath of oil
- High precision spindle bearings
- Turcite bearing surface
- Dual rack & pinion pneumatic brake
- Precision ground surfaces

---

**Square Tables primarily used on horizontal boring mill applications**

**Vertical Mount only – for use on horizontal spindle machining centers**

---

**Specifications**

- **HBM-20**
  - Turntable Diameter (mm): 20,000
  - Standard Thrust Hole Dia (mm): 20.00
  - Vertical Load Capacity (kg): 2,000
  - Faceplate T-Slot Width (mm): 6.80
  - Max Speed Range (Std Ratio): 0-5
  - Std Cont Torque (lbs ft): 750
  - Brake Method: Pneumatic
  - Brake Torque (lbs ft): 850
  - Programmable Resolution: 0.01
  - Std Total Angular Accuracy: 10 SEC.
  - Std Repeatability: 3 SEC.
  - Opt. + OR - Anglr. Accuracy: +/-3.6
  - Opt. + OR - Repeatability: +/-2
  - Unit Weight (lbs): 1,500
  - Ship Weight (lbs): 1,500

- **HBM-30**
  - Turntable Diameter (mm): 30,000
  - Standard Thrust Hole Dia (mm): 20.00
  - Vertical Load Capacity (kg): 2,000
  - Faceplate T-Slot Width (mm): 6.80
  - Max Speed Range (Std Ratio): 0-5
  - Std Cont Torque (lbs ft): 750
  - Brake Method: Pneumatic
  - Brake Torque (lbs ft): 850
  - Programmable Resolution: 0.01
  - Std Total Angular Accuracy: 10 SEC.
  - Std Repeatability: 3 SEC.
  - Opt. + OR - Anglr. Accuracy: +/-3.6
  - Opt. + OR - Repeatability: +/-2
  - Unit Weight (lbs): 1,500
  - Ship Weight (lbs): 1,500

---

**HDL Series - 500MM Table on 500MM Pallet**

**Optional Features:**
- Chucks - (Manual or Pneumatic)
- Tailstocks - (Manual or Pneumatic)
- Single axis programmable control
- Clamping outboard supports (Pneumatic or Hydraulic)
- Cables – for interfacing to machine tool
- Compatible with all standard servo motors
- Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)

**Standard Features:**
- 5 sizes (16.5", 20", and 25" table diameters)
- C007 bronze wormgear and hardened and ground worm running in a bath of oil
- High precision spindle bearings
- Turcite bearing surface
- Dual rack & pinion pneumatic brake
- Precision ground surfaces

---

**Square Tables primarily used on horizontal boring mill applications**

**Vertical Mount only – for use on horizontal spindle machining centers**

---

**Specifications**

- **HDL-16.5**
  - Turntable Diameter (mm): 16.50
  - Standard Thrust Hole Dia (mm): 2.00
  - Vertical Load Capacity (kg): 0.60
  - Faceplate T-Slot Width (mm): 0.68
  - Standard Total Gear Ratio: 180:1
  - Max Speed Range (Std Ratio): 0-5
  - Std Cont Torque (lbs ft): 375
  - Brake Method: Pneumatic
  - Brake Torque (lbs ft): 480
  - Programmable Resolution: 0.01
  - Std Total Angular Accuracy: 30 SEC.
  - Std Repeatability: 10 SEC.
  - Opt. + OR - Anglr. Accuracy: +/-5
  - Opt. + OR - Repeatability: +/-2
  - Unit Weight (lbs): 1,350
  - Ship Weight (lbs): 1,500

- **HDL-20**
  - Turntable Diameter (mm): 20.00
  - Standard Thrust Hole Dia (mm): 2.00
  - Vertical Load Capacity (kg): 1.00
  - Faceplate T-Slot Width (mm): 0.68
  - Standard Total Gear Ratio: 180:1
  - Max Speed Range (Std Ratio): 0-5
  - Std Cont Torque (lbs ft): 750
  - Brake Method: Pneumatic
  - Brake Torque (lbs ft): 800
  - Programmable Resolution: 0.01
  - Std Total Angular Accuracy: 20 SEC.
  - Std Repeatability: 5 SEC.
  - Opt. + OR - Anglr. Accuracy: +/-3.6
  - Opt. + OR - Repeatability: +/-1
  - Unit Weight (lbs): 1,450
  - Ship Weight (lbs): 1,600

- **HDL-25**
  - Turntable Diameter (mm): 25.00
  - Standard Thrust Hole Dia (mm): 2.00
  - Vertical Load Capacity (kg): 1.50
  - Faceplate T-Slot Width (mm): 0.68
  - Standard Total Gear Ratio: 180:1
  - Max Speed Range (Std Ratio): 0-5
  - Std Cont Torque (lbs ft): 950
  - Brake Method: Pneumatic
  - Brake Torque (lbs ft): 1,000
  - Programmable Resolution: 0.01
  - Std Total Angular Accuracy: 10 SEC.
  - Std Repeatability: 3 SEC.
  - Opt. + OR - Anglr. Accuracy: +/-5
  - Opt. + OR - Repeatability: +/-1
  - Unit Weight (lbs): 1,950
  - Ship Weight (lbs): 2,150
### SPECIFICATIONS - ROTARY AXIS

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CTL-6.5-A</th>
<th>CTL-6.5-B</th>
<th>CTL-6.5-C</th>
<th>CTL-10-A</th>
<th>CTL-10-B</th>
<th>CTL-10-C</th>
</tr>
</thead>
<tbody>
<tr>
<td>VARIABLE DIAMETER (in.)</td>
<td>6.50</td>
<td>6.50</td>
<td>6.50</td>
<td>10.00</td>
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<td>STANDARD THRU HOLE DIAM (in.)</td>
<td>1.08</td>
<td>1.08</td>
<td>1.08</td>
<td>1.08</td>
<td>1.08</td>
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<td>OVERSIZE THRU HOLE DIAM (in.)</td>
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<td>N/A</td>
<td>N/A</td>
<td>3.00</td>
<td>3.00</td>
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<tr>
<td>MAXIMUM LOAD CAPACITY (lb)</td>
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<td>47.3</td>
<td>47.3</td>
<td>133.0</td>
<td>133.0</td>
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<tr>
<td>FACEPLATE TILTED LENGTH (in.)</td>
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<td>47.3</td>
<td>47.3</td>
<td>47.3</td>
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<tr>
<td>STANDARD TOTAL GEAR RATIO</td>
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<td>90.1</td>
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<td>90.1</td>
<td>90.1</td>
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<td>STANDARD TOTAL ANGULAR ACCURACY (arc sec)</td>
<td>+/-10</td>
<td>+/-10</td>
<td>+/-10</td>
<td>+/-10</td>
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<td>BRAKE TORQUE (lbs ft)</td>
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<td>300</td>
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<td>300</td>
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<td>BRAKE METHOD</td>
<td>PNEUMATIC</td>
<td>PNEUMATIC</td>
<td>PNEUMATIC</td>
<td>PNEUMATIC</td>
<td>PNEUMATIC</td>
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<tr>
<td>MAXIMUM TILT AXLE TRAVEL (in.)</td>
<td>5 / +100</td>
<td>5 / +100</td>
<td>5 / +100</td>
<td>5 / +100</td>
<td>5 / +100</td>
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</tr>
<tr>
<td>CENTER HEIGHT &amp; 70 DEG POSITION (in.)</td>
<td>4.75 (121)</td>
<td>4.75 (121)</td>
<td>4.75 (121)</td>
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<tr>
<td>TILT+HOLE &amp; 80 DEG POSITION (in.)</td>
<td>8.00 (203)</td>
<td>8.00 (203)</td>
<td>8.00 (203)</td>
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<td>10.60 (269)</td>
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<tr>
<td>STANDARD TOTAL GEAR RATIO</td>
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<td>90:1</td>
<td>90:1</td>
<td>180:1</td>
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<tr>
<td>MAXIMUM LOAD CAPACITY (lb)</td>
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<td>75</td>
<td>150</td>
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<tr>
<td>BRAKE TORQUE @ 100 PSI (lbs ft)</td>
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<td>125</td>
<td>200</td>
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<tr>
<td>OVERSIZE THRU HOLE DIA (mm)</td>
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<td>N/A</td>
<td>N/A</td>
<td>3.000</td>
<td>3.000</td>
<td>3.000</td>
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### SPECIFICATIONS - TILT AXIS

<table>
<thead>
<tr>
<th>MODEL</th>
<th>CTL-6.5-A</th>
<th>CTL-6.5-B</th>
<th>CTL-6.5-C</th>
<th>CTL-10-A</th>
<th>CTL-10-B</th>
<th>CTL-10-C</th>
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<tbody>
<tr>
<td>TOTAL GEAR RATIO</td>
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<td>180:1</td>
<td>180:1</td>
<td>180:1</td>
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<tr>
<td>MAXIMUM SPEED RANGE (STD GEAR)</td>
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<td>0.20</td>
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<tr>
<td>CONTINUOUS TORQUE (lbs ft)</td>
<td>N/A</td>
<td>75</td>
<td>75</td>
<td>N/A</td>
<td>300</td>
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<td>PNEUMATIC</td>
<td>MANUAL</td>
<td>MANUAL</td>
<td>MANUAL</td>
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<tr>
<td>UNIT WEIGHT (lb)</td>
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<td>250</td>
<td>250</td>
<td>300</td>
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<td>300</td>
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<tr>
<td>SHIP WEIGHT (lb)</td>
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<td>275</td>
<td>375</td>
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</tbody>
</table>

### Optional Features:
- Oversize thru hole
- Chucks (Manual or Pneumatic)
- Collet fixtures (Manual or Pneumatic)
- Tailstocks (Manual or Pneumatic)
- Alternate handwheel location (Tilt Axis)
- Single Axis programmable control
- Manual, pneumatic, or hydraulic brake
- Air-over-hydraulic unit (AHU)
- Ball Lock™ sub plate and fixture plate
- Cables - for interfacing to machine tool
- Compatible with standard servos motors
- Direct mount feedback (Heidenhain scale for accuracy up to +/- 2 arc seconds)
**Rotary Axis Centered on Tilt Axis (Heavy Duty)**

**Standard Features:**
- 5 sizes of “X”, “Y”, “15”, “20”, and “25” table diameters
- Rotary and Tilt axis
- Dual lead wormset simplifies backlash adjustment
- C907 bronze wormgears and a hardened and ground worm running in a bath of oil
- High precision spindle bearings
- Turcite bearing surfaces
- Internal pneumatic brake (Rotary & Tilt)
- Precision ground surfaces
- Zero return / home switches (Both Axis)
- +/- overtravel limit switches (Tilt Axis)

**Optional Features:**
- Chucks – (Manual or Pneumatic)
- Cable - (Manual or Pneumatic)
- Single axis programmable control
- Cables - for interfacing to machine tool
- Manual Rotary axis and / or manual tilt axis
- Air over hydraulic unit (AHU)
- Clamping outboard support (Pneumatic or Hydraulic)
- Ball Lock™ sub plate
- Compatible with all standard servo motors

**Rotary Axis Centered on Tilt Axis**

**Standard Features:**
- 2 sizes: “6.5” and “10” (rotary table diameters)
- Rotary and Tilt axis
- Dual lead wormset simplifies backlash adjustment
- C907 bronze wormgears and a hardened and ground worm running in a bath of oil
- High precision spindle bearings
- Turcite bearing surfaces
- Internal pneumatic brake (Rotary & Tilt)
- Precision ground surfaces
- Zero return / home switches (Both Axis)
- +/- overtravel limit switches (Tilt Axis)

**Optional Features:**
- Chucks – (Manual or Pneumatic)
- Cable - (Manual or Pneumatic)
- Single Axis programmable control
- Compatible with all standard servo motors
- Cables - for interfacing to machine tool
- Manual Rotary Axis and / or Manual Tilt Axis
- Ball Lock™ sub plate

---

**TROYKE**

**TROYKE - CINCINNATI, OH**

**PHONE** - 513.769.4242

**FAX** - 513.769.6362

**WWW.TROYKE.COM**
TROYKE® TT Series

Dual Tilting Table (Primarily used for machining and porting cylinder heads)

Standard Features:
• 360 degrees “A” axis travel & 25 degrees “B” axis travel
• Dual lead wormset allows for simple backlash adjustment
• C907 bronze worm wheel and a hardened and ground worm shaft running in a bath of oil
• High precision spindle bearings
• Turcite bearing surfaces
• Internal pneumatic brakes
• Precision ground surfaces
• Zero return / home switches (both axis)
• +/- Overtravel limit switches (tilt axis)
• MS cable receptacles

Optional Features:
• Collet fixtures – (manual or pneumatic)
• Single axis programmable control
• Cables – for interfacing to machine tool
• Manual rotary axis and/or manual tilt axis
• Ball lock sub plate
• Compatible with all standard servo motors

TS & PTS Series — Tailstock

Standard Features:
• Removable dead center
• #3 morse taper on models TS-5c, 6.5, 9, 10, 12 and 15
• #5 morse taper on models TS-16.5, 20 and 25
• Left hand or right hand locking handle position
• 4 way - 2 position pneumatic valve (pts model only)
• Spindle Oilers on all models
• Matched center height to mating table

Optional Outboard Supports:
• HOS-Series (hydraulic braking outboard support)
• POS-Series (pneumatic braking outboard support)
• CS-Series (cable outboard support)
• FR-Series (free rotating rotary table)
• AHU (air over hydraulic unit for hos-series)

* for additional information consult factory.
TROYKE - CINCINNATI, OH  PHONE - 513.769.4242  FAX - 513.769.6362  WWW.TROYKE.COM

TROYKE - CINCINNATI, OH  PHONE - 513.769.4242  FAX - 513.769.6362  WWW.TROYKE.COM

**Standard Features:**
- Available in single or dual axis configurations
- AC brushless servo motors (21 in/lbs to 230 in/lbs)
- Operator station with LCD display and keypad
- Multiple interface options to a host CNC system
- Absolute and incremental program modes
- Rapid traverse and feed rate modes
- MDI mode capability (manual data input)
- Emergency stop and cycle start pushbuttons
- RS-232 communications port (upload, download & DNC)
- M-function interface capability (cable included) see print
- Backlash compensation (parameter setting)
- Battery backed memory (298 lines of program space)
- Control box enclosure size: length 4.38” (111) x width 11.81” (300) x height 13” (330) sc-60
- For other available controls consult factory

**MODEL 408 - 21 in/lb CONTINUOUS TORQUE CONTROL**
**MODEL 506 - 48 in/lb CONTINUOUS TORQUE CONTROL**
**MODEL 904 - 230 in/lb CONTINUOUS TORQUE CONTROL**

**Standard Features:**
- Available in single or dual axis configurations
- AC brushless servo motors (21 in/lbs to 230 in/lbs)
- Operator station with LCD display and keypad
- Multiple interface options to a host CNC system
- Absolute and incremental program modes
- Rapid traverse and feed rate modes
- MDI mode capability (manual data input)
- Emergency stop and cycle start pushbuttons
- AC brushless motor with resolver feedback
- Optional position feedback via scale
- RS-232 interface to host CNC (upload, download & DNC)
- Digital I/O for “m-code” interface to CNC
- Backlash compensation (parameter setting)
- Optional remote handwheel for table jogging
- Control box enclosure size: length 12” [304] x width 14” [356] x height 21” [533]
Angular accuracy of each rotary table is checked with an auto-collimator.

20 SECONDS = .00029 \([307]\) ON A 6.00 \([152]\) DIAMETER
30 SECONDS = .00044 \([511]\) ON A 6.00 \([152]\) DIAMETER
45 SECONDS = .00066 \([816]\) ON A 6.00 \([152]\) DIAMETER
60 SECONDS = .00087 \([1022]\) ON A 6.00 \([152]\) DIAMETER

### Geometric Accuracy:

<table>
<thead>
<tr>
<th>No.</th>
<th>INSPECTION ITEM</th>
<th>TOLERANCE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>TABLE FACE FLATNESS (CONCAVE)</td>
<td>.0005 ([.013])</td>
</tr>
<tr>
<td>2</td>
<td>TABLE FACE PARALLELISM</td>
<td>.0005 ([.013])</td>
</tr>
<tr>
<td>3</td>
<td>TABLE FACE RUNOUT (THRU 360 DEGREES OF ROTATION)</td>
<td>.0010 ([.025])</td>
</tr>
<tr>
<td>4</td>
<td>TABLE FACE PERPENDICULARITY TO FOOT OF BASE PER 12.0 ([304])</td>
<td>.0010 ([.025])</td>
</tr>
<tr>
<td>5</td>
<td>CENTER HOLE RUNOUT</td>
<td>+/- .0005 ([.013])</td>
</tr>
<tr>
<td>6</td>
<td>CENTER-HEIGHT DIFFERENCE OF TURNTABLE AND TAILSTOCK</td>
<td>.0010 ([.025])</td>
</tr>
</tbody>
</table>

NOTE: ALL DIMENSIONS IN \([\ldots\ldots]\) ARE METRIC UNITS

### Accuracy:

Accuracy is measured in an unloaded condition. The following examples may affect the stated accuracy of the table. (User's fixtures, size and weight of part, off-center parts, outboard supports, tailstock pressures, off-center drilling or milling fixture mounting surfaces, out of alignment (tir) tailstocks or supports, etc.)

### Critical Alignments:

Alignments of tailstocks and outboard supports to the rotary table are critical. Alignments must be within a maximum 0.002" tir. If the runout of the part is greater, or if the tailstock or outboard support is not centered to the rotary table axis, you are in effect bending the part. This requires substantial torque and causes accuracy problems and accelerates wear on the rotary table.

### Angular Accuracy:

20 SECONDS = .00029 \([307]\) ON A 6.00 \([152]\) DIAMETER
30 SECONDS = .00044 \([511]\) ON A 6.00 \([152]\) DIAMETER
45 SECONDS = .00066 \([816]\) ON A 6.00 \([152]\) DIAMETER
60 SECONDS = .00087 \([1022]\) ON A 6.00 \([152]\) DIAMETER

### How to Order — Rotary Tables

- DL
- NC
- HBM
- HLD
- L
- CTL
- CT
- TT

### Motor Mount

- A
- B
- C

### Position Feedback

- RH
- LH

### Center Hole

- 5-STANDARD DIA.
- O-OVERSIZE DIA.
- P-MAXIMUM

### Total Gear Reduction

- 60:1
- 90:1
- 120:1
- 180:1
- 240:1
- 270:1
- 360:1
- 540:1
- 720:1
- 1440:1

- 60:1
- 90:1
- 120:1
- 180:1
- 240:1
- 270:1
- 360:1
- 540:1
- 720:1
- 1440:1

### Controls

- 55

### Air Over Hydraulics

- AHU

### Cables

- CA-10
- CA-15
- CAT-10
- CAT-15
- SP-8
- SP-10
- SP-12
- FP-8
- FP-10
- FP-12

### Subplates

- FP-8.5
- FP-10.5
- FP-12.5

### Fixtures

- FP-8.5
- FP-10.5
- FP-12.5

### Angle Bracket

- AB-42
- AB-48
- AB-60

### Thank you

Thank you for choosing Troyke for your machine tool accessory needs!

Call to discuss custom specific applications.
Single and Dual Axis Rotary Collet Indexers Available

Ask for Catalog 88-04

Direct Drive Rotary Tables Available

Ask for the Direct Drive Rotary Tables Catalog