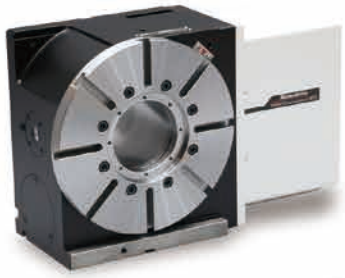
SANKYO SEISAKUSHO CO.

CNC ROTARY TABLE

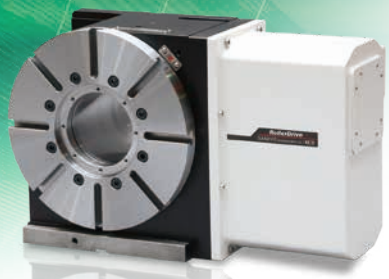
RollerDrive CNC™

RCD, RT series

For Machining Center from Makino Milling Machine



The Ultimate CNC Rotary Table



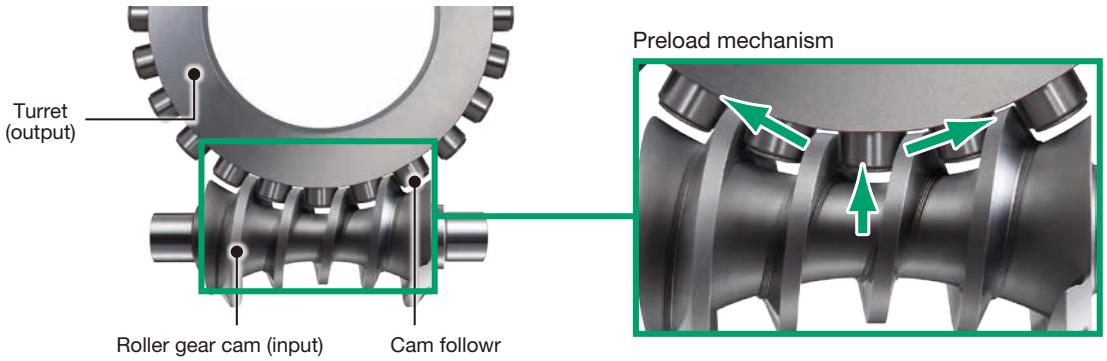
Zero-backlash Technology Delivers Unsurpassed Motion

The RollerDrive CNC is a rotary table designed to meet the requirements of machine tool manufacturers for greater speed and accuracy. The RollerDrive—Sankyo's zero-backlash reducer—delivers accurate output motion that stands up to external disturbances, unlike gearmotors or torque motors. It offers excellent rotary positioning accuracy of 10 seconds or less, and can hold up to heavy cutting forces on hard steel.
The heavy-duty RollerDrive CNC has no internal part wear and no loss of accuracy over long-term use, thus eliminating the need for regular calibration or adjustments.

Theory of Operation of the RollerDrive

The RollerDrive uses the roller gear mechanism, one of the finest motion control mechanisms available. The unit is constructed from an input shaft (the roller gear cam) and a turret (output shaft) fitted with roller followers. The roller followers are preloaded against a screw-like input shaft to completely eliminate backlash. Our proprietary adjustment mechanism provides optimum preload.
The roller followers planted in the turret use internal roller bearings to transfer torque while rotating. This ensures zero backlash, outstanding precision, and excellent efficiency without causing wear, while providing long-term consistent accuracy.

Exclusive zero-backlash construction



Features

Rolling contact

Preload

- ☑ No backlash (play).
- ☑ High accuracy and good efficiency.
- ☑ Preloadable for high rigidity.
- ☑ Clampless machining reduces positioning time.
- ☑ No deterioration of accuracy over time, initial accuracy is maintained for an extended period.

No Maintenance and Excellent Price Performance

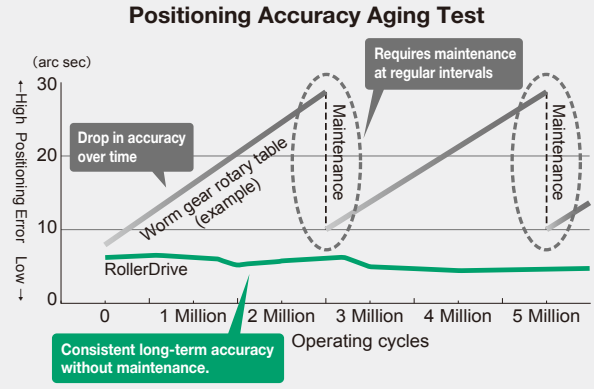
Consistent long-term accuracy without maintenance.

Worm gear models

Accuracy declines over time. Requires maintenance to achieve initial accuracy.

RollerDrive

Accuracy is consistent with no maintenance even after 5 million operation cycles.



The RollerDrive graph is based on internal testing. (Center distance of test unit: 170)

Cost Comparison with a Worm Gear Rotary Table

Offers Long-term Use without Maintenance

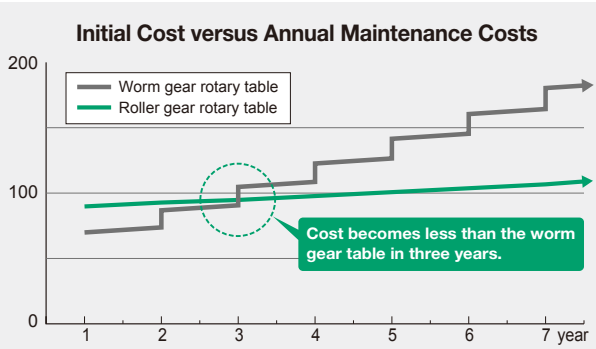
Worm gear models

Maintenance costs occur once or twice a year to adjust the backlash.

RollerDrive

Long-term use is possible without any mechanical maintenance.
Beats the cost of a worm gear even after adding annual running costs to the initial investment cost. Price performance continues thereafter.

(Based on internal calculations.)



①Worm gear rotary tables require maintenance twice a year.
②Assumes an annual running cost of 3% (oil changes, etc.) for both types.

Cost simulations are based on a table diameter of about 200 mm.

Shorter positioning time

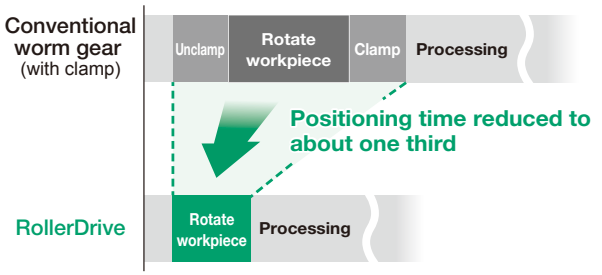
Time comparison for 90° positioning

Conventional worm gear

Clamping using hydraulic pressure or air pressure is required to suppress backlash.

RollerDrive

Zero backlash and high rigidity eliminate the need for clamping.
Compared to the worm gear type, positioning time is reduced to about one third.



(Based on in-house calculations)

Extended Accuracy

Compared against a worm gear for over 5 million indexes.

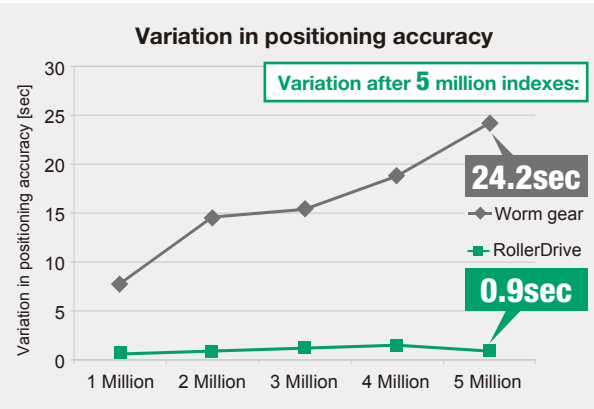
Test conditions

- Table size: Output table diameter: 170 mm
- Load inertia: 0.5 kgm^2
- Index angle: 36° (unidirectional)
- Indexing time: 0.35sec

Results after 5 million indexes:

Item	Worm gear	RollerDrive
Variation in positioning accuracy	24.2sec	0.9sec
Backlash (measured at R60)	18 µm (15 µm → 33 µm)	-

(Based on internal testing data.)



Sizing and Product Code

CNC Rotary Table Selection Chart

CNC Rotary Table		V33i	V56i
1-axis	RCD170	○	
	RCD200	○	
	RCD250		○
	RCD300		○
2-axis	RT100	○	○

Product Code [1-axis Series]

Rotary table

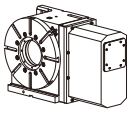
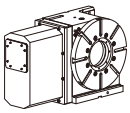
1 RCD170	-	2 A1	3 R	4 B	5 F	6 1

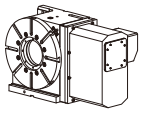
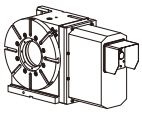
1	2		3		4		5		6	
Model	Servo motor Without brake		Motor mounting side		Connector position		Connector type		Table shape	
RCD170	A1	FANUC	R	Right	B	Rear	R	Receptacle	1	Tapped holes
RCD200			L	Left	S	Side			2	T slot
RCD250										
RCD300										

-	7 E	8 C	9 J	-	10 X

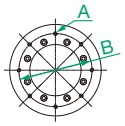
7		8		9		10	
Options						Standard / Custom	
High-accuracy model*1, *2		Air / Hydraulic clamping		Rotary joint*1, *2			
E	With MP scale	C	With clamp	J	Internal type	Blank	Standard
Blank	None	Blank	None	H	External type	X	Custom
				Blank	None		

*1 There is no hollow bore in the table when the MP scale (high-accuracy model) or rotary joint is installed.
*2 Simultaneous installation of MP scale (high-accuracy model) and rotary joint is not supported.

Motor mounting side	
R	
L	

Connector position	
B	
S	

Connector type / shape	
R	

Table shape	
1	

	A	B
RCD170	(8)M8×1.25, 14DP	140
RCD200	(8)M8×1.25, 14DP	170
RCD250	(8)M10×1.5, 18DP	210
RCD300	(8)M10×1.5, 18DP	250

2	P6: Table with RCD dimensions

Support table

1 ST170A	-	2 C	3 J	-	4 X

1		2		3		4	
Model		Options				Standard / Custom	
		Air / Hydraulic clamping		Rotary joint			
ST170A	For RCD170 and RCD200	C	With clamp	J	Internal type	Blank	Standard
ST250A	For RCD250 and RCD300	Blank	None	H	External type	X	Custom
				Blank	None		

Tail stock

1 TSS135	-	2 M	3 R	-	4 X

1		2		3		4	
Model		Type		Handle side		Standard / Custom	
TSS135	For RCD170 and RCD200	M	Manual	R	Right	Blank	Standard
TSS185	For RCD250 and RCD300			L	Left	X	Custom

Product Code [2-axis Series]

Rotary table

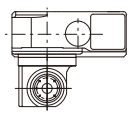
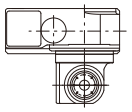
1 RT100	-	2 A	3 R	4 S

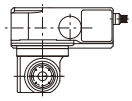
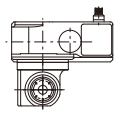
1	2		3		4	
Model	Servo motor		Motor mounting side		Connector position	
RT100	A	FANUC	R	Right	S	Side
			L	Left	B	Rear

-	5 E	6 J

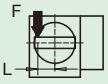
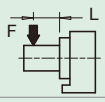
5		6	
Options			
High-accuracy model*1		Rotary joint (Internal type)*2	
E	With MP scale	J	Internal type
Blank	None	Blank	None

*1 There is no hollow bore in the table when the MP scale (high-accuracy model) or rotary joint is installed.
*2 Use the rotary joint for the air supply. It is not suitable for supplying hydraulic oil.

Motor mounting side	
R	
L	

Connector position	
S	
B	

Specifications [1-axis Series]

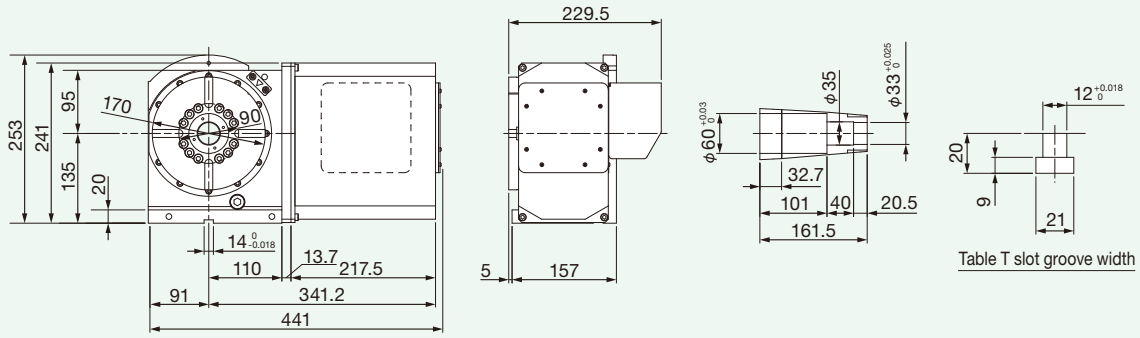
Specifications			RCD170	RCD200	RCD250	RCD300
Table diameter		mm	Φ170	Φ200	Φ250	Φ300
Table pilot bore diameter		mm	$\Phi 60^{+0.03}_{0}$	$\Phi 60^{+0.03}_{0}$	$\Phi 110^{+0.035}_{0}$	$\Phi 110^{+0.035}_{0}$
Center height		mm	135	135	185	185
Table T slot width		mm	$12^{+0.018}_{0}$	$12^{+0.018}_{0}$	$12^{+0.018}_{0}$	$12^{+0.018}_{0}$
Keyway width		mm	$18^{0}_{-0.011}$	$18^{0}_{-0.011}$	$18^{0}_{-0.011}$	$18^{0}_{-0.011}$
Clamp type (air 0.5 MPa, hydraulic 3.5 MPa)			Air / Hydraulic	Air / Hydraulic	Hydraulic	Hydraulic
Clamp torque[*1]		N·m	310	310	1100	1100
Motor shaft equivalent inertia[*2,*3]		$\times 10^{-4}$ kg·m^2	2.96	3.15	5.70	5.70
Motor model (FANUC)			αiS4/5000-B (A06B-2215-B100)	αiS8/4000-B (A06B-2235-B100)	αiS8/4000-B (A06B-2235-B100)	αiS8/4000-B (A06B-2235-B100)
Minimum setting unit		deg	0.0001	0.0001	0.0001	0.0001
Maximum table speed		min^{-1}	70	70	60	60
Gear ratio			1/50	1/50	1/60	1/60
Indexing accuracy		arc.sec	±15	±15	±10	±10
Repeatability		arc.sec	8	8	4	4
Net weight		kg	51	59	110	115
Allowable payload	Upright position[*4] 	kg	70 (140)	70 (140)	255 (510)	255 (510)
	Horizontal position 	kg	140	140	510	510
Allowable load	F 	N	21000	21000	52000	52000
	F×L with clamping 	N·m	310	310	1100	1100
	Continuous holding torque[*2,*5]	N·m	236	416	512	512
	Maximum output torque[*2,*5,*6]	N·m	362	544	987	987
	F×L 	N·m	1300	1300	5500	5500
Allowable workpiece inertia		kg·m^2	1.1	1.1	8.3	8.3
Extenal rotary joint (number of ports)[*7]			6+1	6+1	10+1	10+1
Internal rotary joint (number of ports)[*7]			6	6	8	8
MP scale (high-accuracy model)[*7]			MPRZ-536A (MHI)			
			MPI-536A (MHI)			

*1 Values for RCD170 and RCD200 are clamping torques when using an air hydro booster with a air pressure of 0.5 MPa as the supply source.
*2 Values for motor shaft equivalent inertia, and continuous / maximum holding torque are given for Fanuc motors. Please contact Sankyo if a different motor is to be used.
*3 Motor shaft equivalent inertia does not include the inertia of the motor shaft.
*4 The allowable payload value for upright mounting shown in brackets applies when a tail stock or support table is used.
*5 The continuous / maximum holding torque is the allowable load torque when a clamp is not used.
*6 Maximum holding torque should not exceed 10 seconds with 20% duty.
*7 Simultaneous use of the MP scale (high-accuracy model) and the rotary joint is not supported.

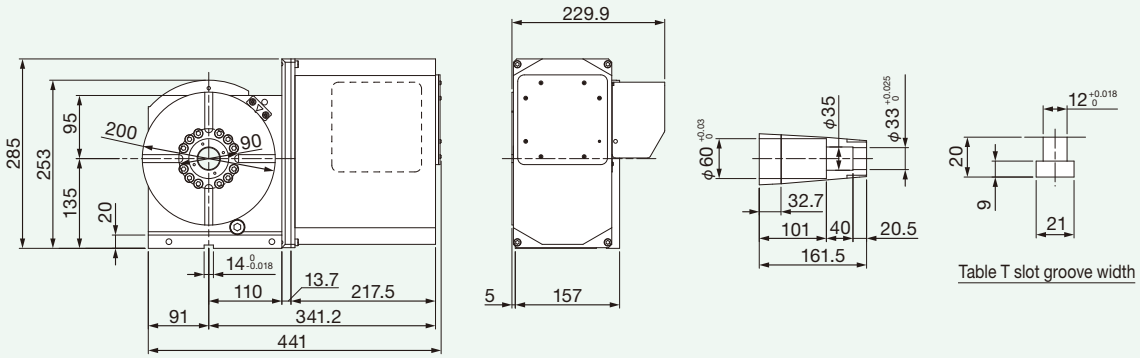
Dimensions [1-axis Series]

The drawings apply to the following specifications: R side motor mounting, rear connector.

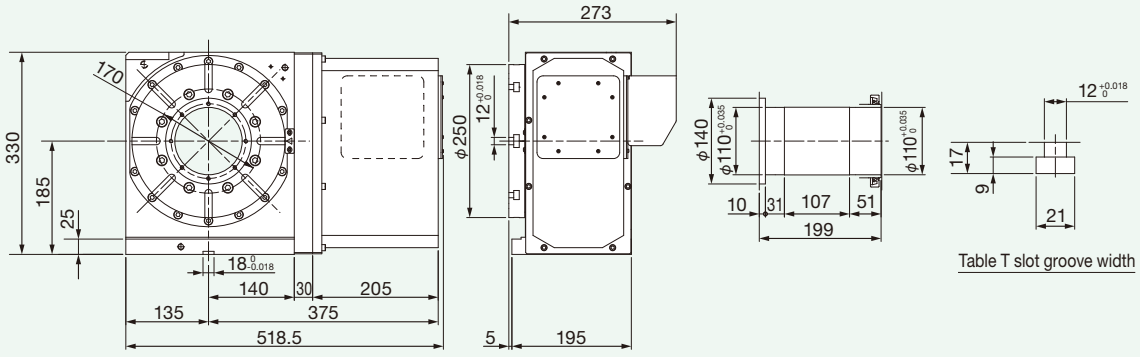
RCD170



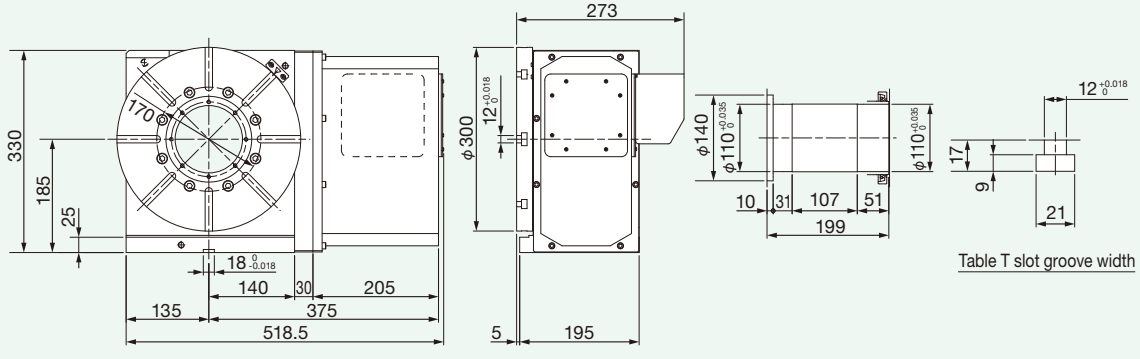
RCD200



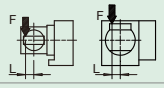
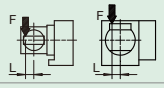
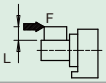
RCD250



RCD300



Specifications [2-axis Series]

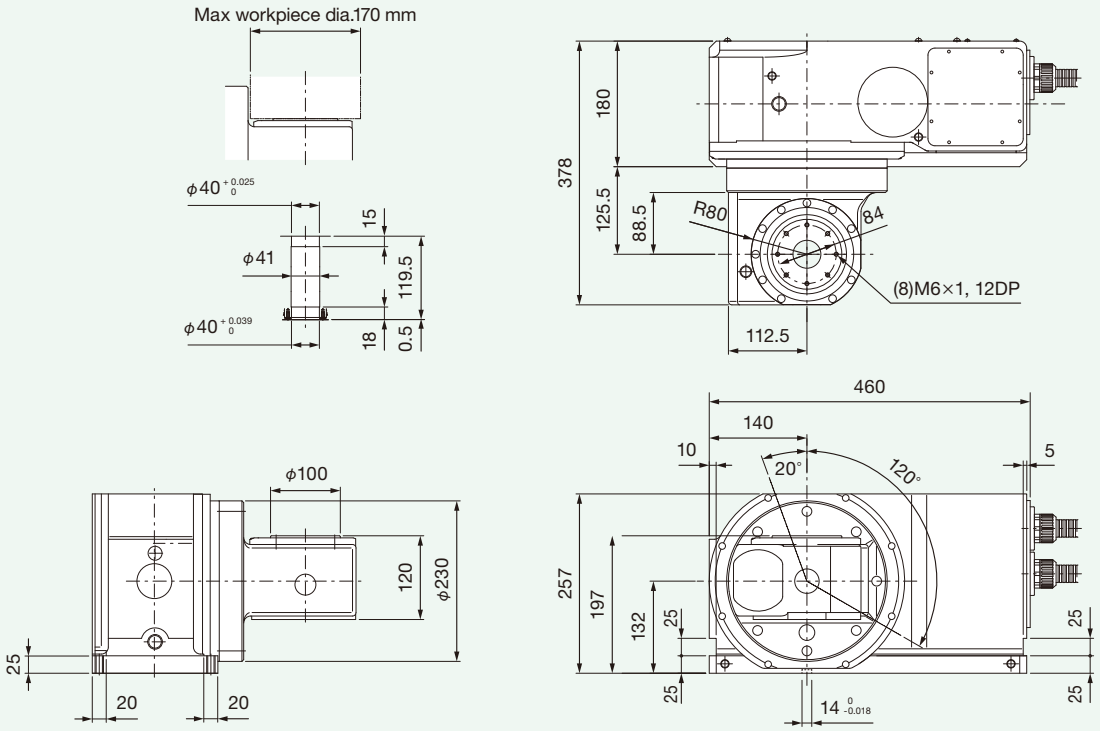
Specifications			RT100	
			Rotary axis	Tilt axis
Tilting angle		deg	-20 ~ +120	
Table diameter		mm	Φ100	
Table pilot bore diameter		mm	$\Phi 40^{+0.025}_{0}$	
Center height (90 degrees)		mm	132	
Table surface height (0 degree)		mm	197	
Keyway width		mm	$18^{0}_{-0.011}$	
Motor shaft equivalent inertia*1		$\times 10^{-4}$ kg·m^2	0.92	1.98
Motor model (FANUC)			αiS2/5000-B (A06B-2212-B000)	αiS4/5000-B (A06B-2215-B000)
Minimum setting unit		deg	0.0001	0.0001
Maximum table speed		min^{-1}	100	55
Gear ratio			1/48	1/90
Indexing accuracy		arc.sec	±15	±10
Repeatability		arc.sec	8	4
Net weight		kg	91	
Allowable payload	0 degree 	kg	30	
	90 degrees 	kg	30	
Allowable load	F 	N	6016	
	F×L Continuous holding torque 	N·m	118	384
	F×L Maximum output torque*2 	N·m	213	611
	F×L 	N·m	290	
Allowable workpiece inertia		kg·m^2	0.1	
Internal rotary joint (number of ports)*3			2	-
MP scale (high-accuracy model)			MPRZ-536A (MHI)	MPRZ-736A (MHI)
			MPI-536A (MHI)	MPI-736A (MHI)

*1 Motor shaft equivalent inertia does not include the inertia of the motor shaft.
*2 Maximum holding torque should not exceed 10 seconds with 20% duty.
*3 Use the rotary joint for the air supply. It is not suitable for supplying hydraulic oil.

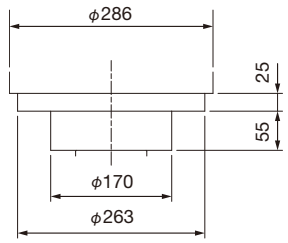
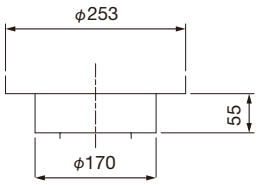
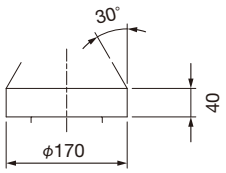
Dimensions [2-axis Series]

The drawings apply to the following specifications: R side motor mounting, side connector.

RT100



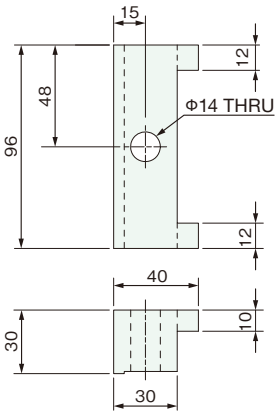
Workpiece interference region for tilting

	Tilting angle		
	-20° ~ 45°	-20° ~ 90°	-20° ~ 120°
RT100			

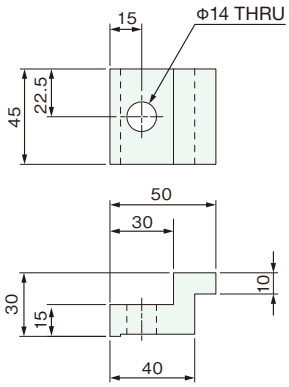
Mount clamps (Accessories)

Model	Size	Mount clamps type / Qty. used
RCD	170	g, h (1 pc. each)
	200	g, h (1 pc. each)
	250	i (4 pcs.)
	300	i (4 pcs.)
RT	100	b (4 pcs.)

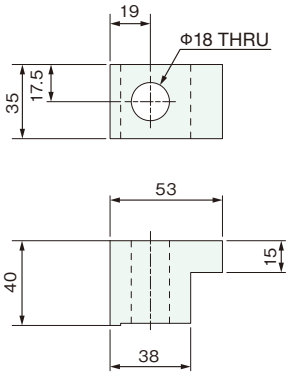
g



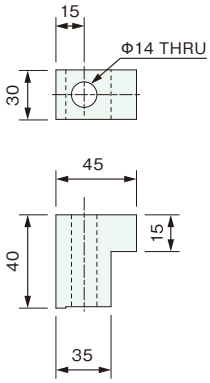
h



i



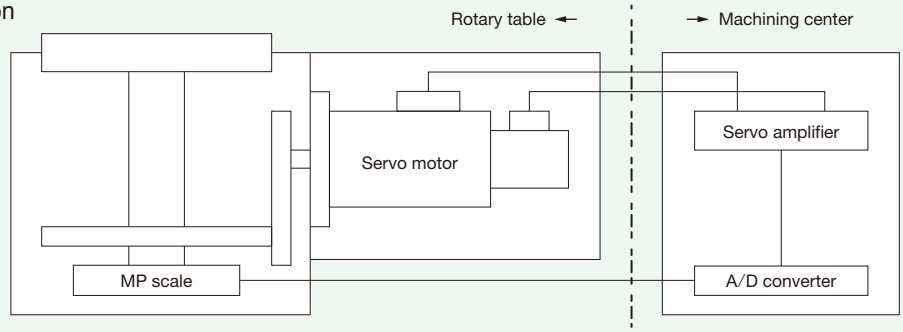
b



Main unit options — High-accuracy model

By mounting a commercially available MP scale (MHI) to the rotary table, fully closed loop control can be realized.
Direct detection of the table's rotation angle enables indexing with high accuracy.

MP scale configuration



Notes
1. With the incremental specification, absolute detection is possible by combination with an absolute type servo motor.
2. Refer to the documentation of the respective manufacturer for operation instructions and information on the connection between the A/D converter and higher-level equipment.

Main unit options — Rotary joint

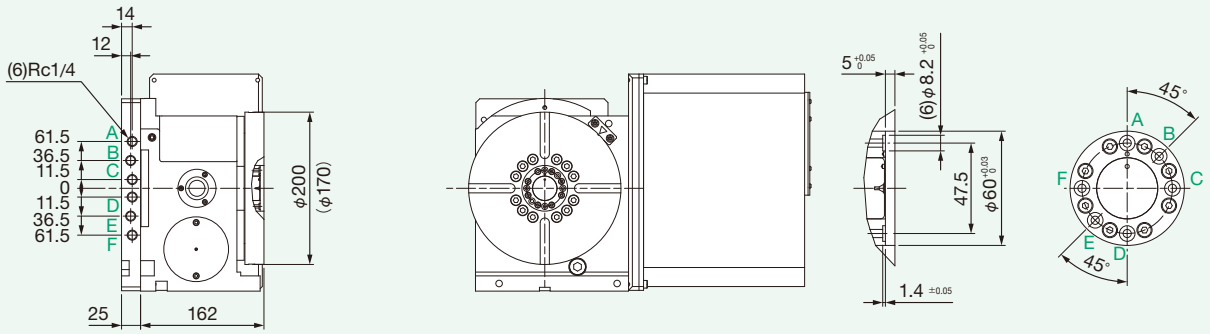
Specifications

Product type	Size	Max. number of ports		Maximum actuation pressure
		Internal type	External type	
RCD	170	6	6+1*1	Fluid: Air 0.7 MPa / Hydraulic 6 MPa
	200	6	6+1*1	
	250	8	10+1*1	
	300	8	10+1*1	
RT	100	2	-	Fluid: Air 0.7 MPa*4

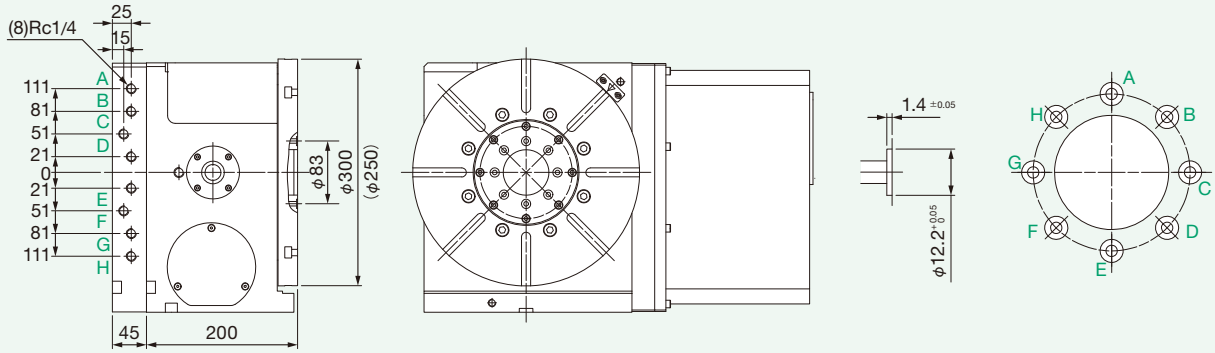
*1 The +1 indicates the port in the center bore.
*2 Make sure to furnish a line filter in the air supply line.
*3 Under prolonged use a small amount of actuation oil may leak from the oil port toward the adjacent air port. If possible, the adjacent ports should be left open for use as drain ports.
*4 Use the rotary joint for the air supply. It is not suitable for supplying hydraulic oil.

Internal type

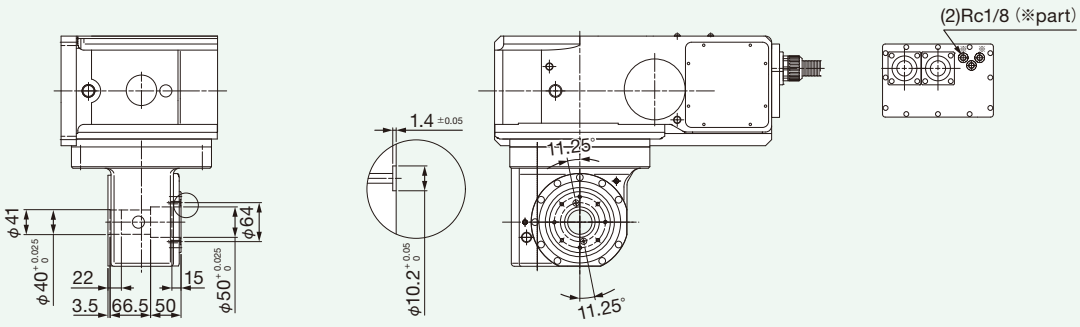
RCD170,200



RCD250,300

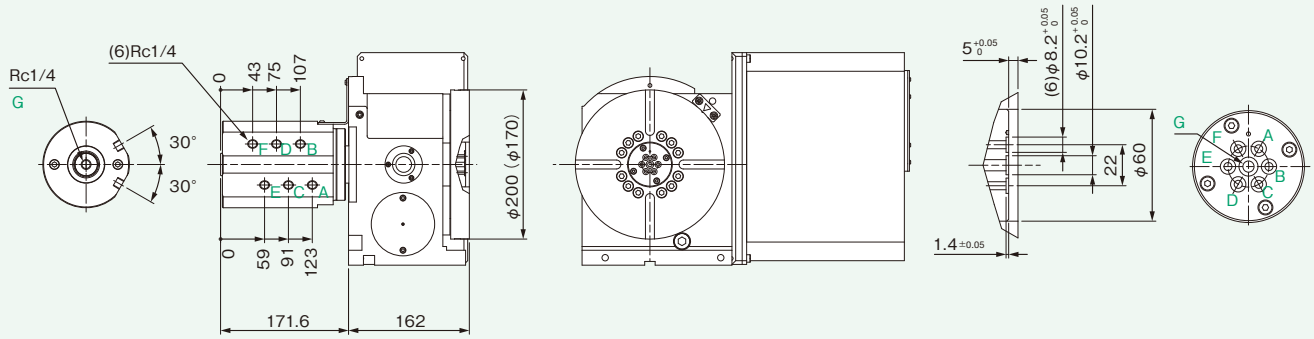


RT100

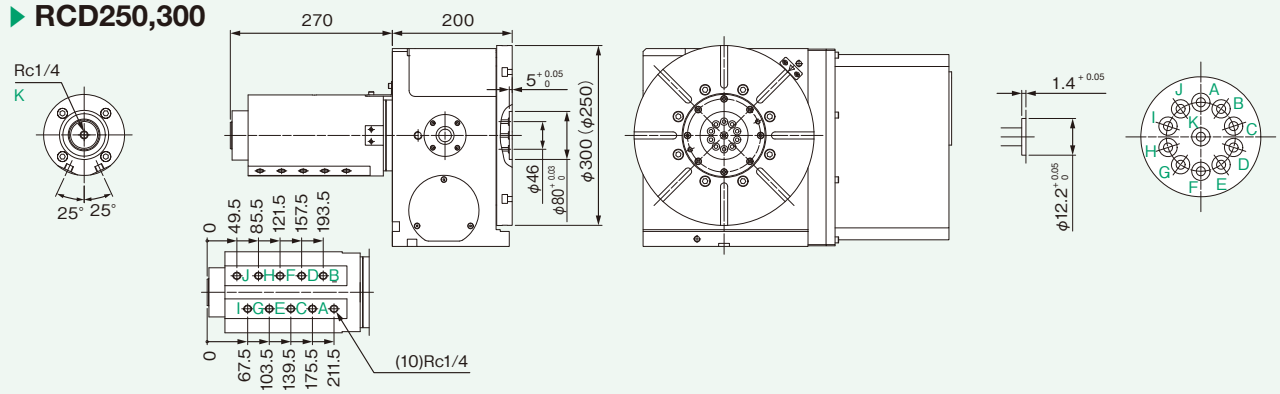


External type

RCD170,200

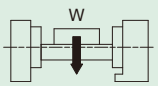
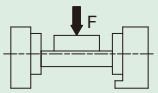
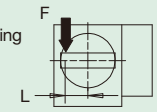


RCD250,300



Auxiliary equipment — Support table

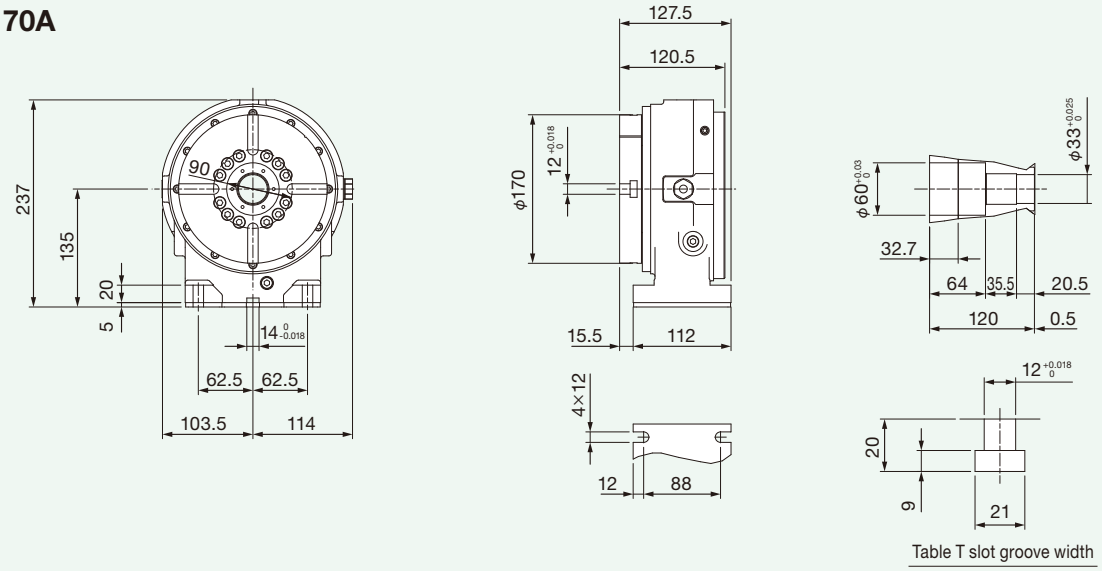
Specifications

Specifications			ST170A		ST250A	
Rotary table model			RCD170	RCD200	RCD250	RCD300
Table diameter		mm	Φ170		Φ250	
Table pilot bore diameter		mm	$\Phi 60^{+0.03}_{0}$		$\Phi 110^{+0.035}_{0}$	
Center height		mm	135		185	
Table T slot width		mm	$12^{+0.018}_{0}$		$12^{+0.018}_{0}$	
Keyway width		mm	$18^{0}_{-0.011}$		$18^{0}_{-0.011}$	
Clamp type (air 0.5 MPa, hydraulic 3.5 MPa)			Air / Hydraulic		Hydraulic	
Clamp torque*1		N·m	310		1200	
Inertia of rotating output part		$\times 10^{-2}$kg·m^2	2.10		20.00	
Maximum table speed		min^{-1}	70		60	
Net weight		kg	24		54	
Allowable payload*2		kg	140		510	
Allowable load*2	F 	N	18900		46300	
	F×L with clamping 	N·m	620		2400	
	Continuous holding torque*3	N·m	236	416	512	
	Maximum holding torque*3,*4	N·m	362	544	987	
External rotary joint (number of ports)			6+1		10+1	
Internal rotary joint (number of ports)			4		6	

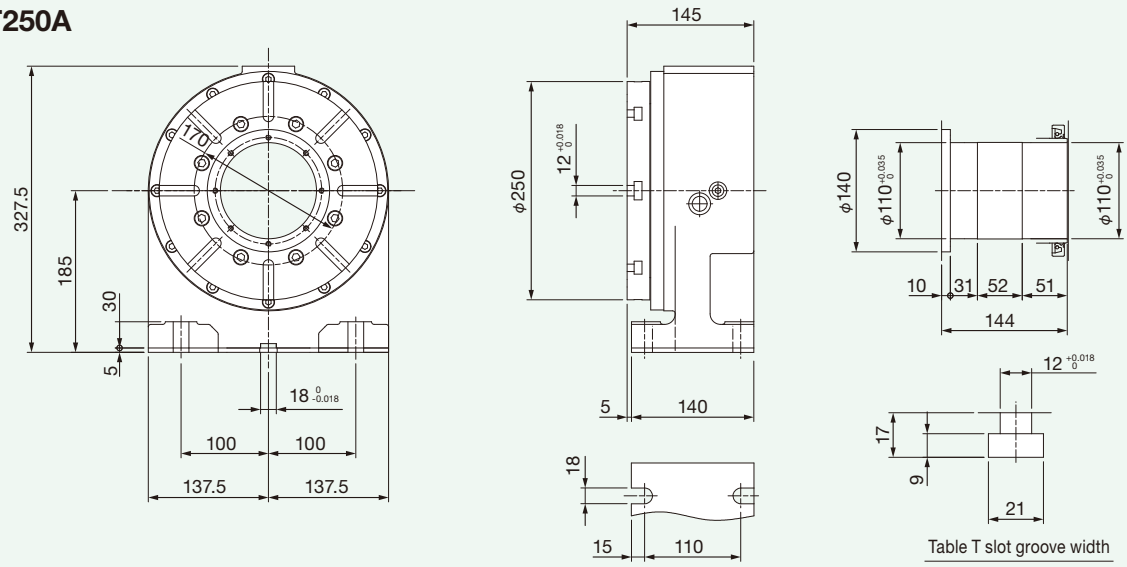
*1 Values for ST170A is clamping torques when using an air hydro booster with a air pressure of 0.5 MPa as the supply source.
*2 The allowable payload and allowable load values apply to the entire set including the rotary table.
*3 The continuous / maximum holding torque is the allowable load torque when a clamp is not used.
*4 Maximum holding torque should not exceed 10 seconds with 20% duty.

Auxiliary equipment — Support table dimensions

ST170A



ST250A



Support table options — Rotary joint

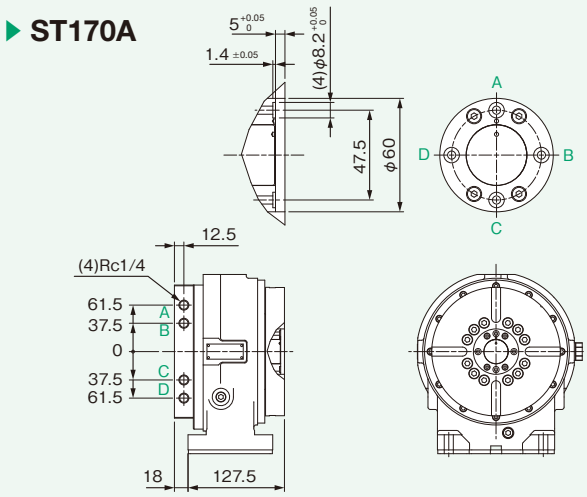
Specifications

Product type	Size	Max. number of ports		Maximum actuation pressure
		Internal type	External type	
ST	170A	4	6+1*1	Fluid: Air 0.7 MPa / Hydraulic 6 MPa
	250A	6	10+1*1	

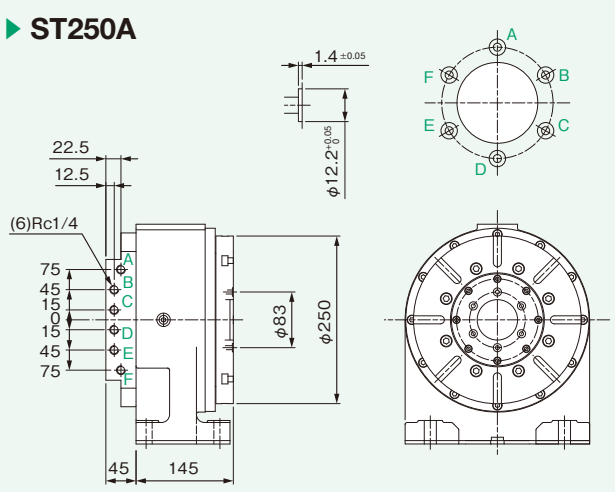
*1 The "+1" indicates a port using the center bore.
*2 Be sure to use a line filter in the air supply.
*3 During prolonged use, a small amount of actuation oil may leak from an oil port to an adjacent air port.
If possible, the adjacent port should be left open as a drain port.

Internal type

ST170A

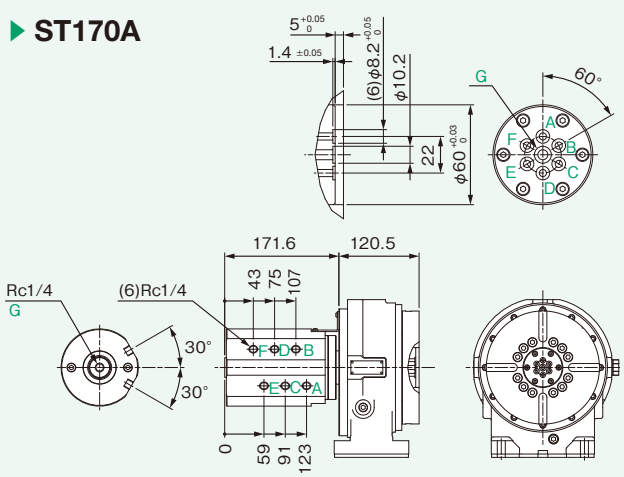


ST250A

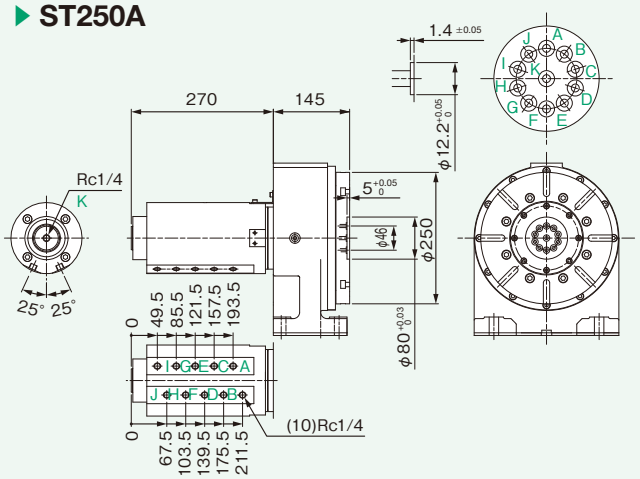


External type

ST170A

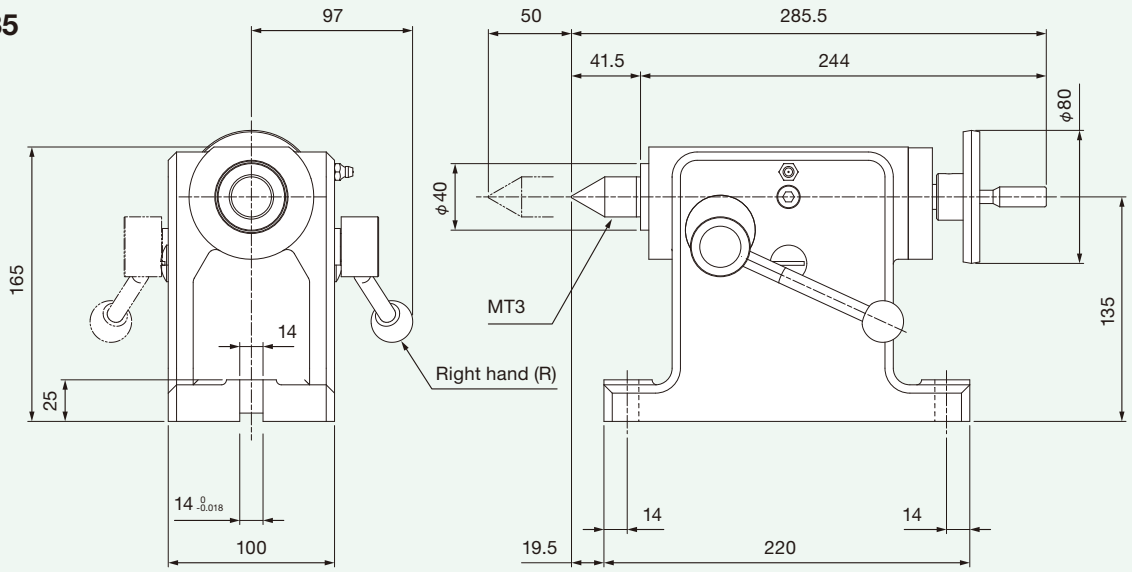


ST250A

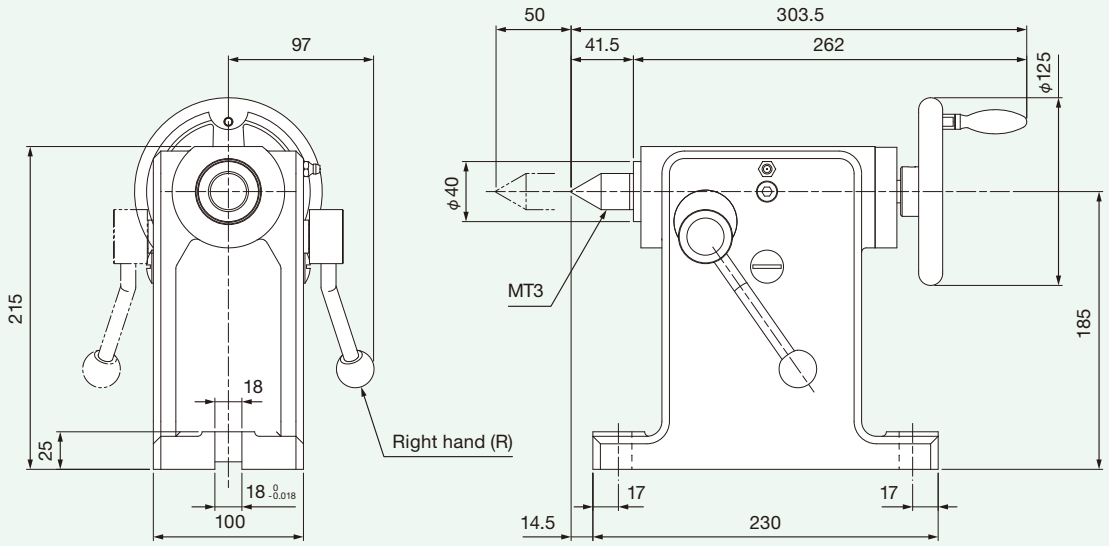


Auxiliary equipment — Tail stock dimensions

TSS135



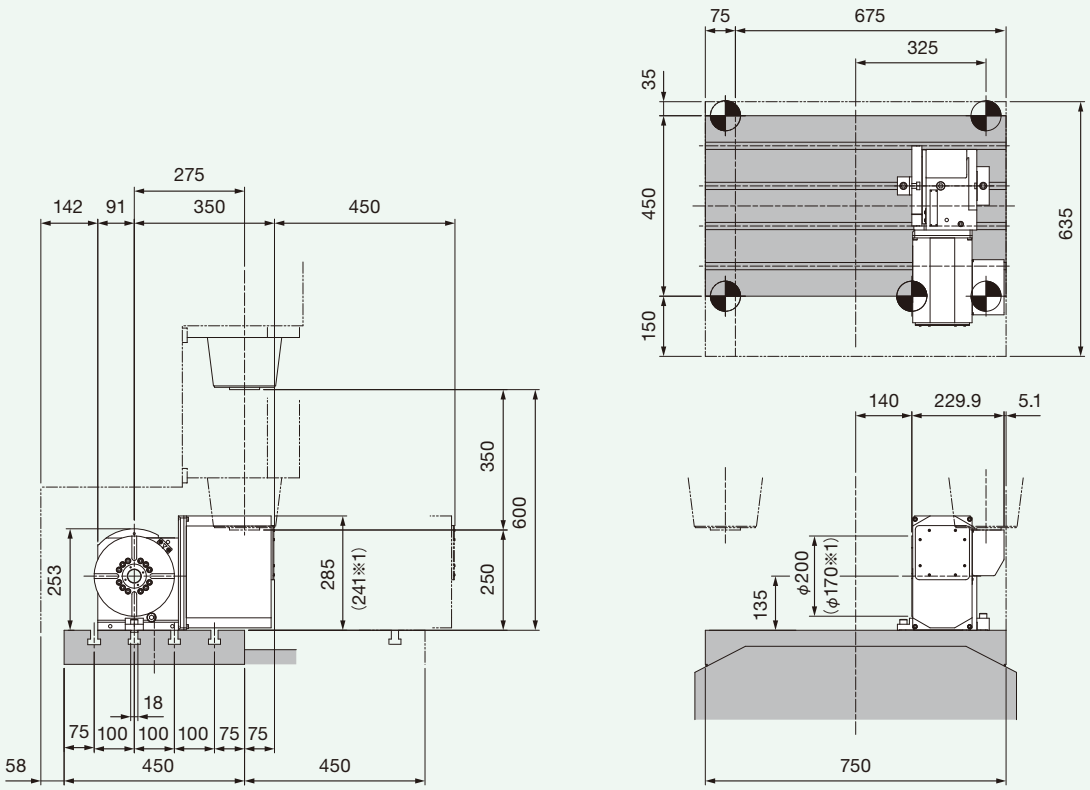
TSS185



Layout dimensions on machine

V33i【RCD200R（RCD170R)】

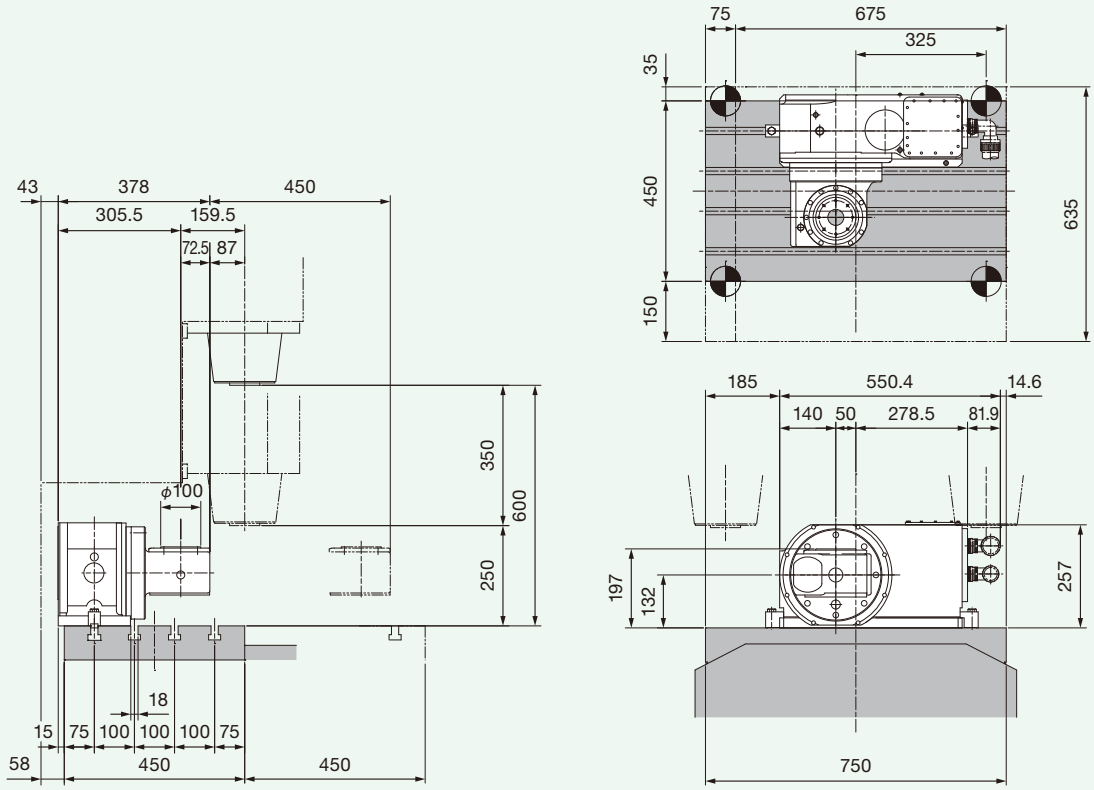
The drawings apply to the following specifications:
R side motor mounting, rear connector.



(※ 1) RCD170R dimensions.

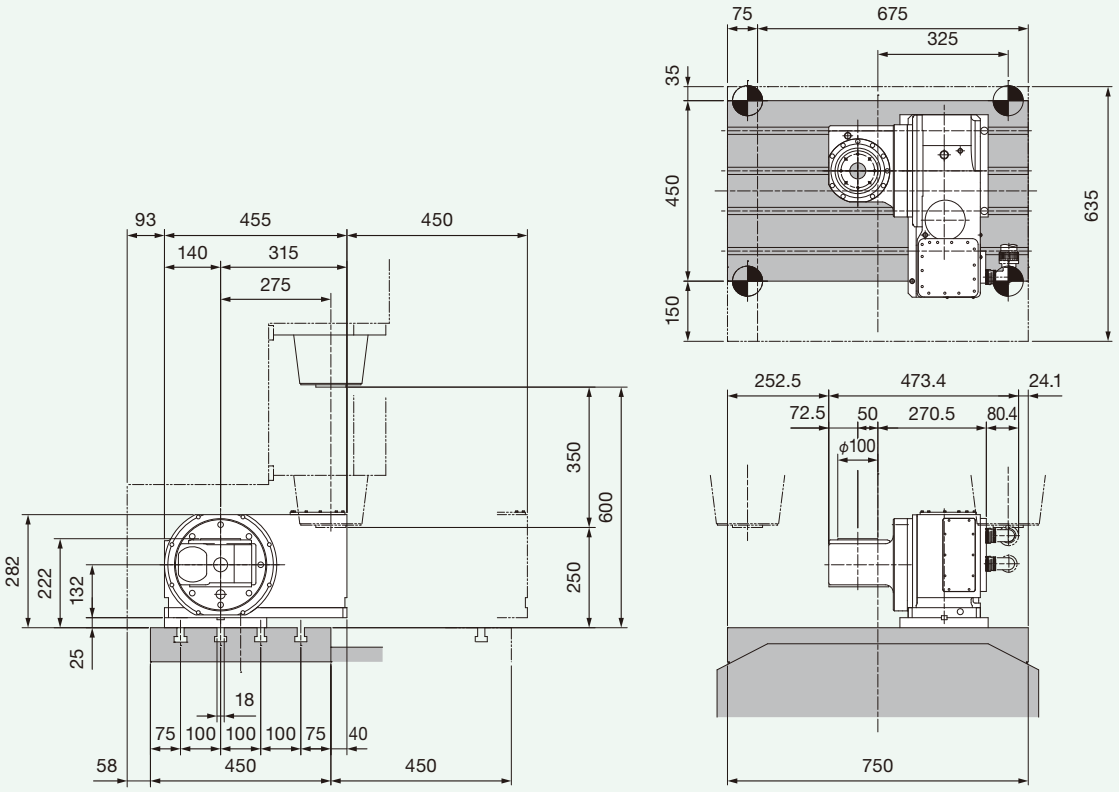
V33i【RT100R（BC axis)】

The drawings apply to the following specifications:
R side motor mounting, side connector.



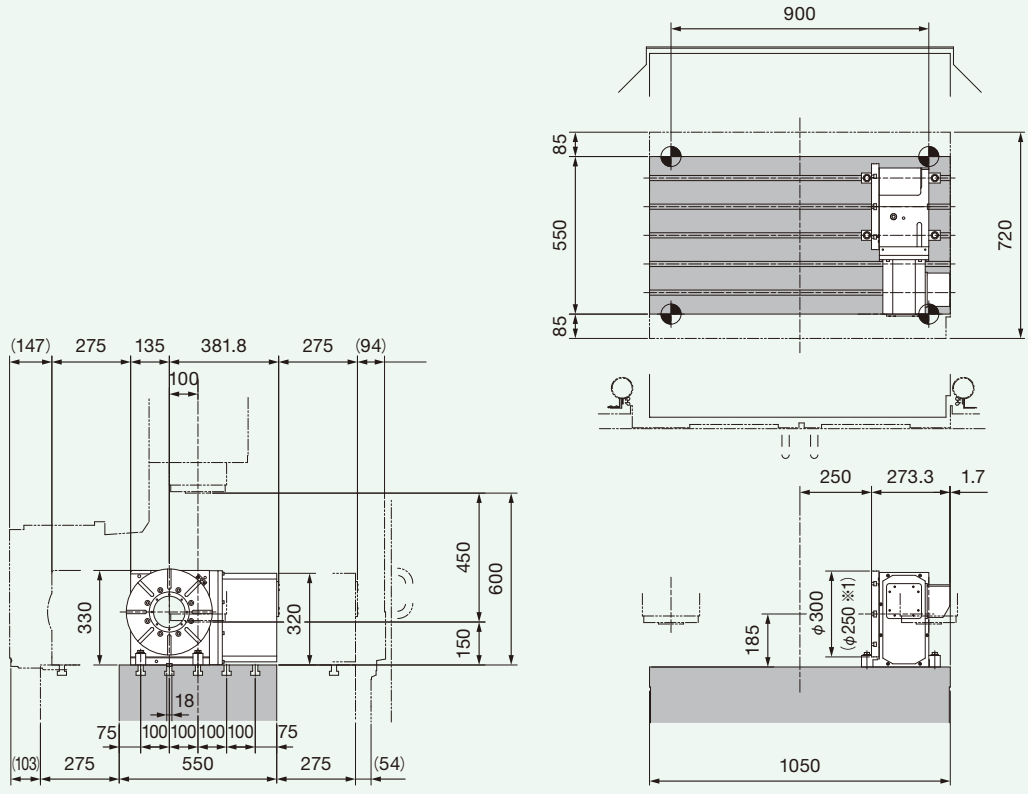
V33i【RT100R（AC axis)】

The drawings apply to the following specifications:
R side motor mounting, rear connector.



V56i【RCD300R（RCD250R)】

The drawings apply to the following specifications:
R side motor mounting, rear connector.

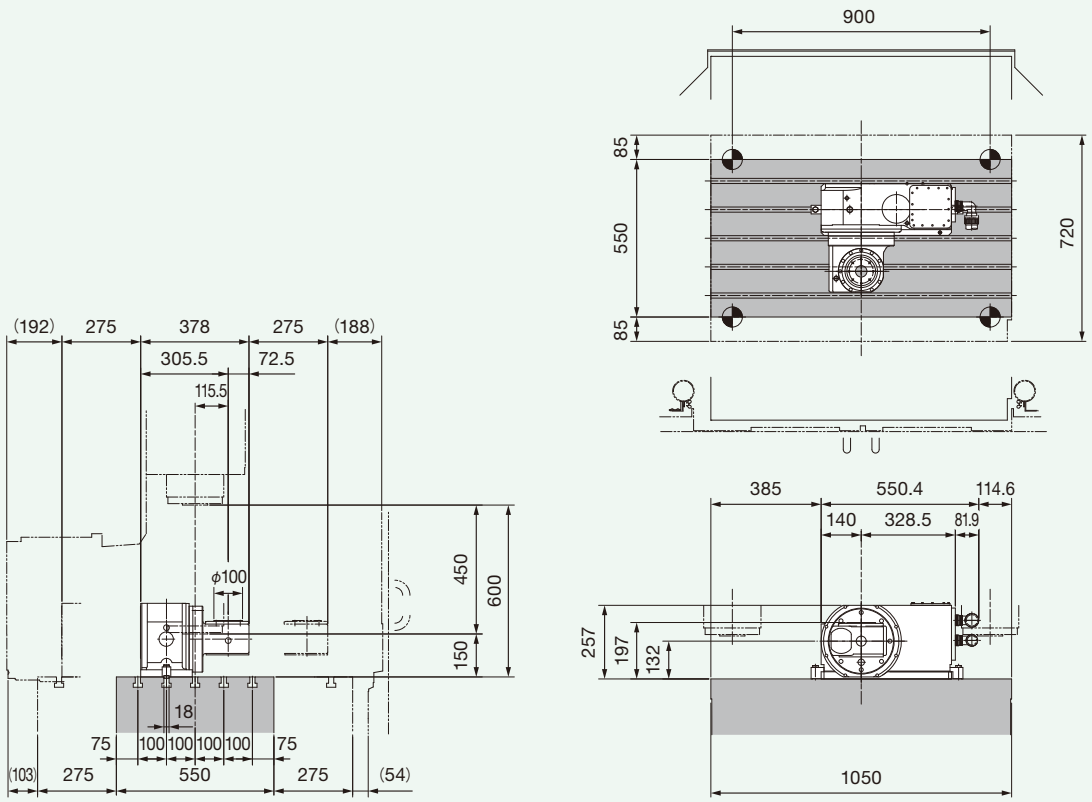


(※ 1) RCD250R dimensions.

Layout dimensions on machine

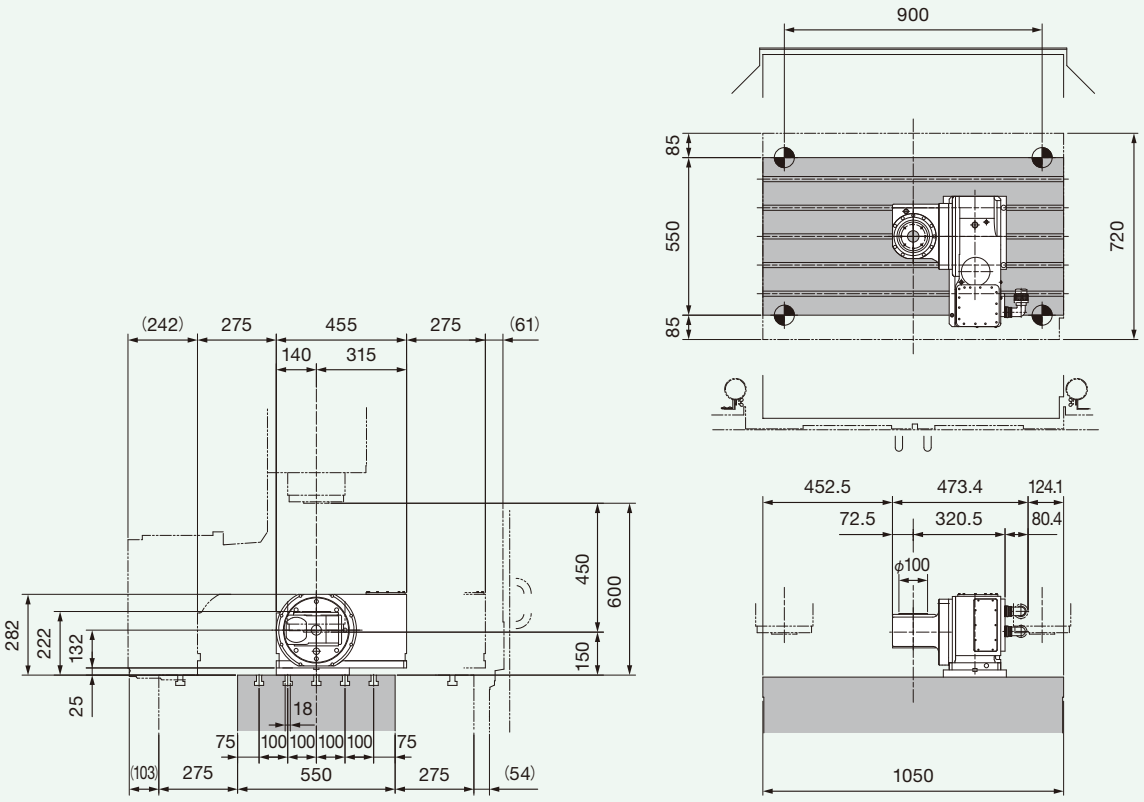
V56i【RT100R（BC axis)】

The drawings apply to the following specifications:
R side motor mounting, side connector.



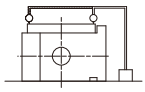
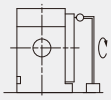
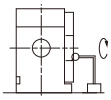
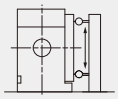
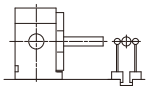
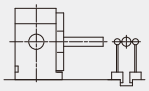
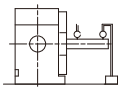
V56i【RT100R (AC axis)】

The drawings apply to the following specifications:
R side motor mounting, rear connector.

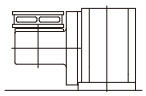
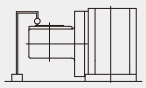
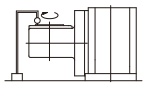
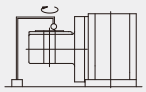
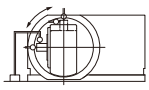
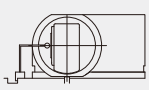


Precision Ratings

1-axis Series

NO.	Measurement	Method	RCD170	RCD200	RCD250	RCD300
1	Parallelism between table top and reference surface for upright mounting		0.015mm	0.015mm	0.02mm	0.02mm
2	Runout of table top		0.01mm	0.01mm	0.01mm	0.01mm
3	Runout of table reference bore		0.01mm	0.01mm	0.01mm	0.01mm
4	Perpendicularity between table top and reference surface for upright mounting		0.02mm (must not lean forward)	0.02mm (must not lean forward)	0.02mm (must not lean forward)	0.02mm (must not lean forward)
5	Parallelism between rotary axis and guide blocks for reference surface for upright mounting		0.02mm/150mm	0.02mm/150mm	0.02mm/150mm	0.02mm/150mm
6	Deviation between rotary axis and guide blocks for reference surface for upright mounting		0.02mm	0.02mm	0.02mm	0.02mm
7	Parallelism between rotating center and reference surface for upright mounting		0.02mm/150mm	0.02mm/150mm	0.02mm/150mm	0.02mm/150mm
8	Indexing accuracy		±15arc.sec	±15arc.sec	±10arc.sec	±10arc.sec
9	Repeatability		8arc.sec	8arc.sec	4arc.sec	4arc.sec

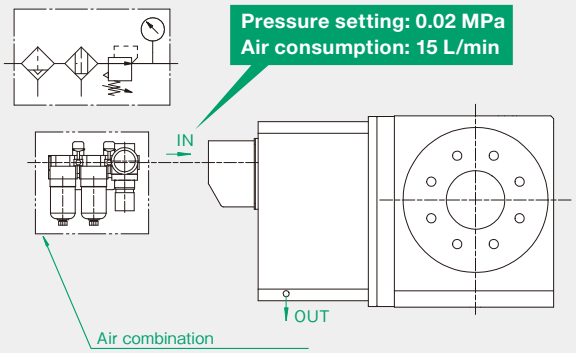
2-axis Series

NO.	Measurement		Method	RT100
1	Straightness of table top			0.01mm over full length
2	Parallelism between table top and bottom surface of base			0.01mm
3	Runout of table top			0.01mm
4	Runout of table reference bore			0.01mm
5	Parallelism between tilt axis center line and bottom surface of base			0.02mm over full length
6	Parallelism between table top and guide block			0.02mm
7	Indexing accuracy	Rotary axis		±15arc.sec
		Tilt axis		±10arc.sec
8	Repeatability	Rotary axis		8arc.sec
		Tilt axis		4arc.sec

Precautions

Air supply

Sankyo's CNC rotary tables come standard equipped with an air purge outlet. (Use it to blow out condensation and coolant to prolong the life of electrical parts and prevent rust in the motor housing.) Supply clean air for the air purge by referring to the drawing shown.
(Do NOT block the exhaust outlet.)



Lubrication

Sankyo's CNC rotary tables use high-performance lubrication oil. Although the lubricant is chemically and thermally stable, it should be changed every 3,000 hours of operation in order to ensure longer product life. Even if operated less than 3,000 hours, the oil should be changed once per year. The condition of the oil can be checked with the oil level gauge while the unit is in the stop condition. Check the oil level and color. If the level is low or the color has changed, change the oil regardless of the number of operation hours. Some air bubbles may form in the oil during operation. This is normal and does not affect quality.

* Be sure to use only the lubricant specified below. Otherwise service life may be reduced and parts may deteriorate.

Specified lubricant: Mobil SHC629 (VG150)

Use in grinding machines

When used in grinding machines, the seal device on the outer periphery of the table may become damaged. The warranty does not cover such damage.

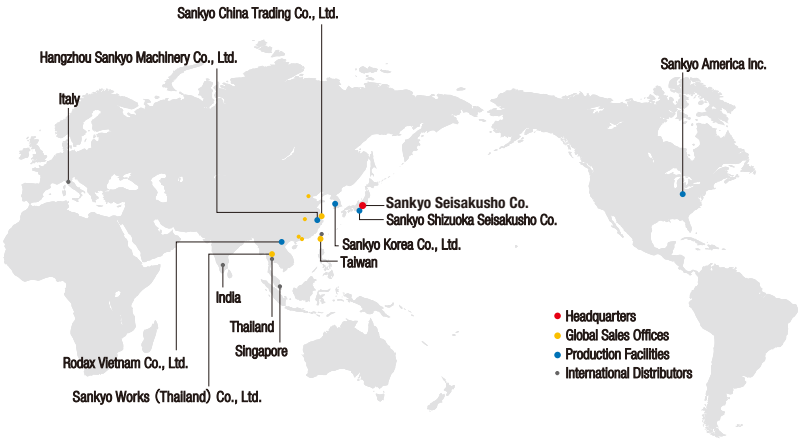
Maximum rotation speed

The maximum rotation speed for the table given in the specifications refers to the indexing speed. Consult with Sankyo if the table is to be rotated continuously. Otherwise, the table will heat up and lose accuracy, causing overload alarms with the servo motor.

General Precautions

- Under the Japanese trade regulation, RollerDrive CNC can be restricted to supply or export to a country which may produce weapons or related products.
- Dimensions and specifications are subjected to be modified without notice.
- Contents of this catalogue is published in March 2021.
- Whole or part of the contents, mechanisms, logos, drawings belongs to Sankyo-Seisakusho, Japan. No part of the catalogue is allowed to copy or redistributed to the third party without the permission of Sankyo Seisakusho.

Global network



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