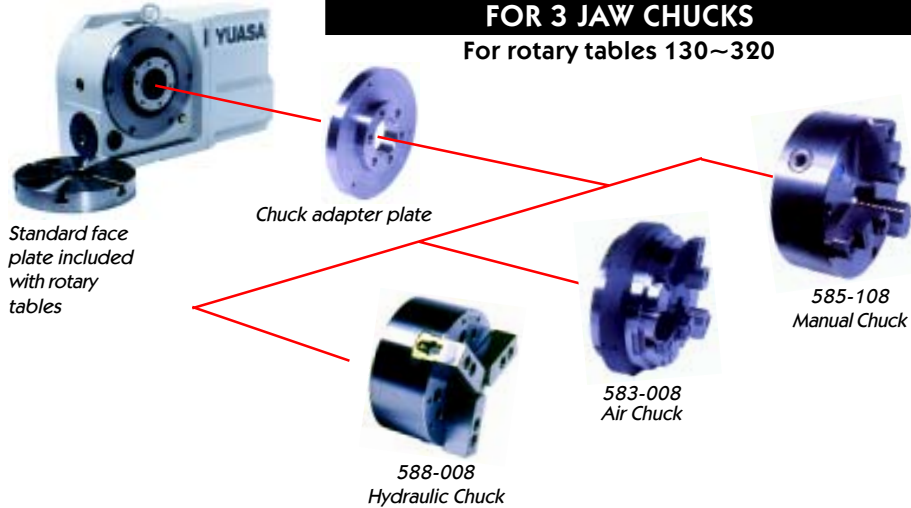




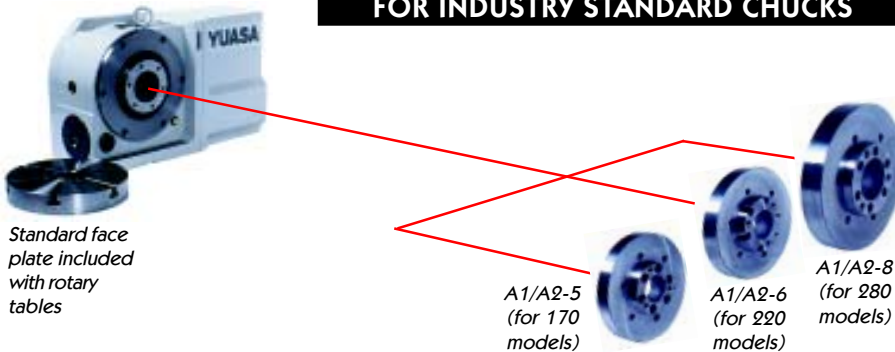
ROTARY TABLE CHUCK OPTIONS

FOR 3 JAW CHUCKS

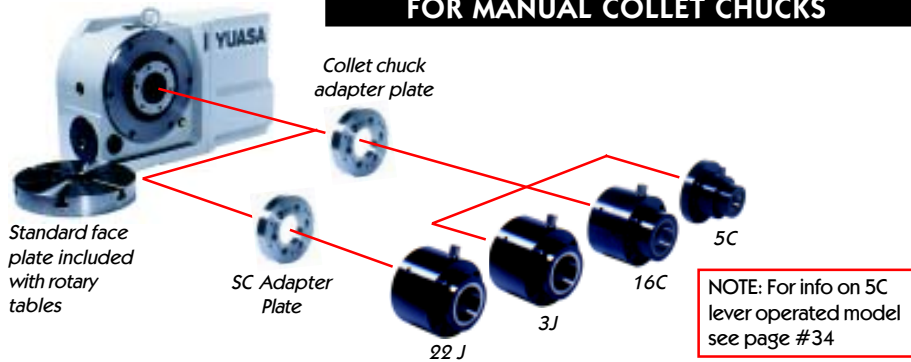
For rotary tables 130~320



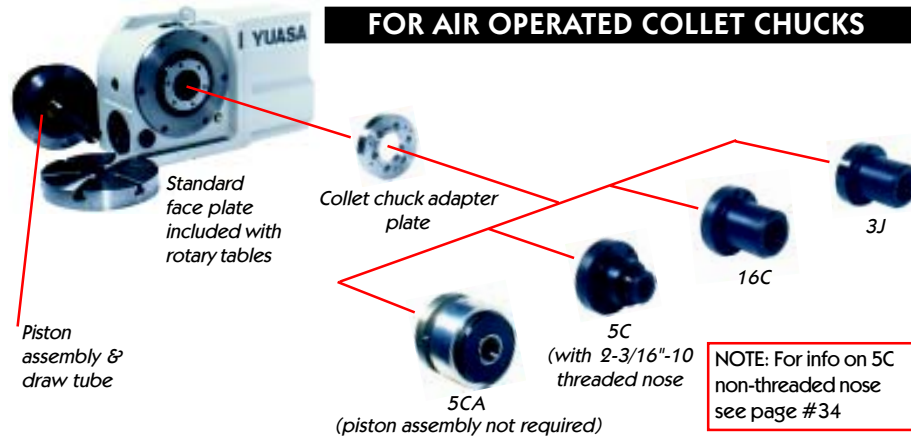
FOR INDUSTRY STANDARD CHUCKS



FOR MANUAL COLLET CHUCKS



FOR AIR OPERATED COLLET CHUCKS



CNC ROTARY PRODUCTS

DMNC & DRFT SERIES ACCESSORY CHART ROTARY TABLES (Including multi-spindle)



MODEL DMNC/DRFT	130 (2,3)	170 (2,3)	220 (2,3)	280 (2)	320	400
TAILSTOCK (MANUAL)	DTS-130	DTS-170	DTS-220	DTS-2800	DTS-3202	DTS-400
TAILSTOCK (AIR)	660-130	660-170	660-220	660-280	N/A	
BASE PLATE FOR MULTI-SPINDLE MODELS (FOR 660 SERIES TAILSTOCKS)	661-132 (2SP) 661-133 (3SP)	661-172 (2SP) 661-173 (3SP)	661-222 (2SP) 661-23 (3SP)	661-128 (2SP)	N/A	
HYDRAULIC BRAKE PARTS (REQUIRES BOOSTER PHB-100)	PHB-130	PHB-170	PHB-220	PHB-280	PHB-320	PHB-400
5C MULTI-COLLET BLOCK (4 CHUCKS) W/ SPINDLE MOUNTING PLATE	N/A	640-404 (A) OR (B); ("A" INSERTS TAILSTOCK; "B" END CAPS, END SUPPORT) REQUIRES COLLET CHUCK ADAPTER PLATE		N/A		
END SUPPORT FOR 5C MULTI-COLLET BLOCK	N/A	640-417	640-422	N/A		
3-JAW ACCU-CHUCK (MANUAL)	585-004	585-106	585-108	585-110	585-112	N/A
3-JAW AIR OPERATED CHUCK	583-004	583-106	583-008	583-010	583-012	N/A
3-JAW HYDRAULIC CHUCK	N/A		588-008	583-010	588-012	N/A
CYLINDER FOR HYDRAULIC CHUCK (REQUIRED)	N/A		588-222	583-228	588-320	N/A
ADAPTER PLATE (ALL THREE JAW CHUCKS, REQ'D)	553-513	553-517	553-522	553-528	553-532	N/A
A1/A2 SPINDLE ADAPTER PLATES	N/A	553-717	553-722	553-728	N/A	
5C MANUAL COLLET CHUCK (FRONT MOUNTED)	ACSU-5C (REQUIRES COLLET CHUCK ADAPTER PLATE)					N/A
16C MANUAL COLLET CHUCK (FRONT MOUNTED)	ACSU-16C (REQUIRES COLLET CHUCK ADAPTER PLATE)					N/A
3J MANUAL COLLET CHUCK (FRONT MOUNTED)	ACSU-3J (REQUIRES COLLET CHUCK ADAPTER PLATE)					N/A
22J MANUAL COLLET CHUCK (FRONT MOUNTED)	N/A	ACSU-22J (REQUIRES SC STYLE ADAPTER PLATE)				
5C AIR COLLET CHUCK (FRONT MOUNTED)	ACSU-5CA (REQUIRES COLLET CHUCK ADAPTER PLATE)					
COLLET CHUCK ADAPTER PLATE (FOR FRONT MOUNTED COLLET CHUCKS)	553-613	553-617	553-622	553-628	553-632	N/A
SC ADAPTER PLATES (22J)CHUCK	N/A	553-817	553-822	553-828	553-832	N/A
5C LEVER CLOSER (MANUAL)W/ DRAW TUBE & THREADED NOSE PIECE (2 3/16"-10)	N/A	640-527	640-523	N/A		
5C AIR OPERATED COLLET CLOSER (2 3/16"-10) THREADED NOSE (FOR ROTARY TABLE MODELS)	N/A	640-637	640-624	N/A		
16C AIR OPERATED COLLET CLOSERS (FOR ROTARY TABLE MODELS)	N/A	640-747	640-723	N/A		
3J AIR OPERATED COLLER CLOSERS (FOR ROTARY TABLE MODELS)	N/A	640-857	640-826	N/A		
5C AIR COLLET CHUCK(REAR) DRAW TUBE AND PARTS (REQUIRES BOTH PARTS)	P-ACPU-45U P-ACPU-104U	P-ACPU-68U P-ACPU-106U	P-APCU-68U P-ACPU-108U	N/A		

***SPECIAL NOTE: 5C, 16C & 3J air operated collet closers must be ordered with the following:**

170 Models: 553-617, P-ACPU-68U & P-ACP-106U

220 Models: 553-622, P-ACPU-68U & P-ACP 108U

DMNC ACCESSORY CHART FOR 5C STYLE MODELS (incl. multi-spindle units)

MODEL / DMNC	5C	5CA-2	5CA-3	5CA-4	
TAIL STOCK (MANUAL)	DTS-5C	N/A			
TAIL STOCK (AIR)	660-100				
BASE PLATE FOR MULTI-SPINDLE AIR TAILSTOCKS	N/A	661-122	661-123	661-124	
3-JAW ACCU-CHUCK (MANUAL)	N/A				
3-JAW AIR OPERATED CHUCK	N/A				
5C AIR COLLET CHUCK (REAR); DRAW TUBE & PARTS (BOTH REQ'D)	DM-105A	INCLUDED AS STANDARD			

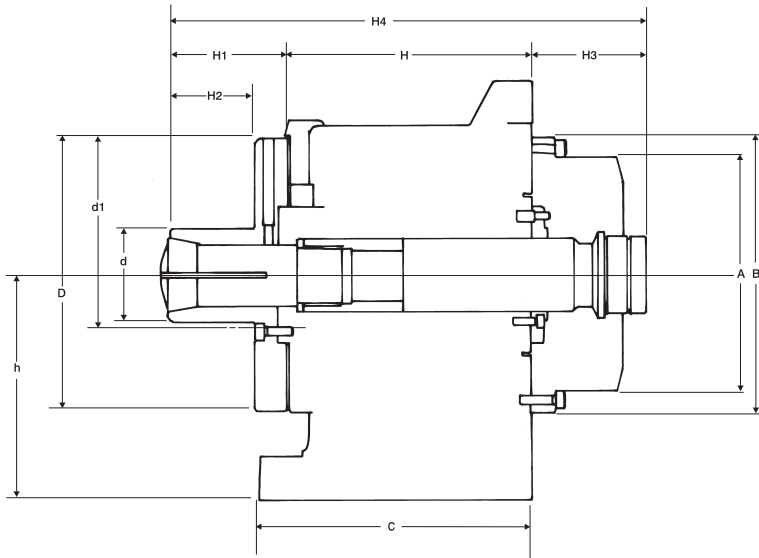


DMNC/DRFT ACCESSORIES (con't.)

P-ACP REAR MOUNTED AIR PISTON 5C AIR OPERATED COLLET CLOSERS WITH NOSE PIECE



SHOWN ON MODEL 220



inch/(mm)

MODEL	A	B	C	D	d	d1	H	H1	H2	H3	H4	h
P-ACPU-45U & P-ACP-104U (130 Models)	4.68 (119)	5.51 (140)	5.31 (135)	4.88 (124)	1.85 (47)	2.36 (60)	4.92 (125)	1.96 (50)	1.49 (38)	2.36 (60)	9.25 (235)	4.13 (105)
P-ACPU-68U & P-ACP-106U (170 Models)	6.37 (162)	7.20 (183)	5.90 (150)	6.69 (170)	1.85 (47)	2.44 (62)	5.31 (135)	2.55 (65)	1.88 (48)	3.14 (80)	11.02 (280)	5.12 (130)
P-ACPU-68 & P-ACP-108U (220 Models)	6.37 (162)	8.42 (214)	6.88 (175)	8.66 (220)	2.36 (60)	3.54 (90)	6.18 (157)	2.87 (73)	2.16 (55)	3.14 (80)	12.20 (310)	6.29 (160)

CNC ROTARY PRODUCTS

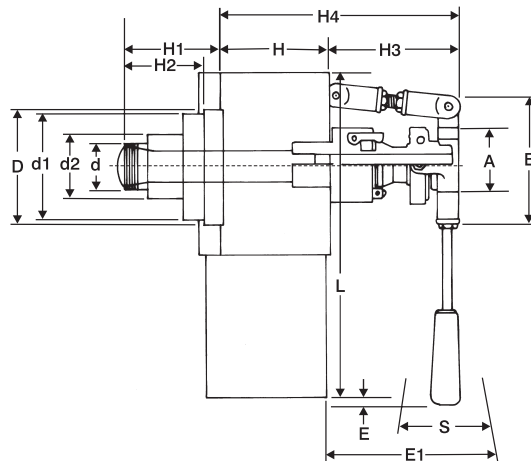
5C LEVER CLOSER (MANUAL) W/DRAW TUBE & 2 3/16"-10 THREADED NOSE



MODEL 170 (Front)



MODEL 170 (Rear)



Inch/(mm)

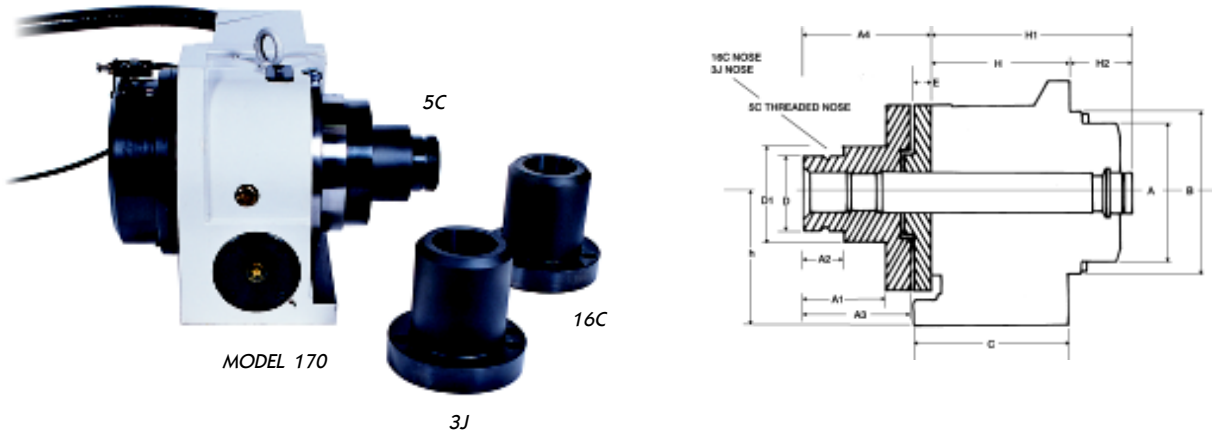
MODEL	A	B	D	d	d1	d2	E	E1	H	H1	H2	H3	H4	S	COLLET CHUCK ADAPTER PLATE
640-527 (170 Models)	3.48 (88)	5.07 (129)	5.41 (137)	2.17 (55)	4.95 (126)	3.02 (76.71)	1.32 (33.52)	8.04 (204)	5.31 (135)	4.97 (126.24)	3.86 (98)	6.07 (154.17)	16.33 (414.78)	5.25 (133.35)	553-617
640-523 (220 Models)	3.48 (88)	5.07 (129)	5.41 (137)	2.17 (55)	4.95 (126)	3.02 (76.71)	1.32 (33.52)	8.04 (204)	6.18 (157)	4.97 (126.24)	3.86 (98)	6.07 (154.17)	17.20 (436.88)	5.25 (133.35)	553-622

Note: Each 5C lever closer requires a collet chuck adapter plate.

DMNC/DRFT ACCESSORIES (cont.)

AIR OPERATED 5C (w/2 3/16"-10 threaded nose), 16C & 3J COLLET CHUCKS FOR ROTARY TABLE MODELS (170 & 220)

Our collet chucks (5C with 2 3/16"-10, 16C and 3J) are available for the 170 and 220 models for air operation. They feature our strongest pneumatic piston and drawtube (order separately), extension and nose piece. This allows for automatic collet actuation even for our largest collet chuck (3J) style. PLEASE NOTE: a collet chuck adapter plate is required to mount the nose piece, along with air piston and drawtube. See page #33 accessory page for both adapter plate and air collet system.



inch/(mm)

PART NUMBER	FOR MODEL	A	B	C	D	d1	E	H	H1	H2	A1	A2	A3	A4	h
640-637 (5C)	170	6.37 (162)	7.20 (183)	5.90 (150)	2.1875 (55.56)	3.000 (76.20)	.625 (15.8)	5.31 (135)	11.02 (280)	3.14 (80)	2.750 (69.85)	1.135 (28.82)	3.750 (95.25)	4.375 (111.12)	5.12 (130)
640-747 (16C)	170	6.37 (162)	7.20 (183)	5.90 (150)	N/A	3.375 (85.72)	.625 (15.8)	5.31 (135)	11.02 (280)	3.14 (80)	3.625 (92.07)	N/A	4.625 (117.47)	5.25 (133.35)	5.12 (130)
640-857 (3J)	170	6.37 (162)	7.20 (183)	5.90 (150)	N/A	3.375 (85.72)	.625 (15.8)	5.31 (135)	11.02 (280)	3.14 (80)	3.625 (92.07)	N/A	4.625 (117.47)	5.25 (133.35)	5.12 (130)
640-624 (5C)	220	6.37 (162)	8.42 (214)	6.88 (175)	2.1875 (55.56)	3.000 (76.20)	.585 (14.8)	6.18 (157)	12.20 (310)	3.14 (80)	2.750 (69.85)	1.135 (28.82)	3.750 (95.25)	4.335 (110.10)	6.29 (160)
640-723 (16C)	220	6.37 (162)	8.42 (214)	6.88 (175)	N/A	3.375 (85.72)	.585 (14.8)	6.18 (157)	12.20 (310)	3.14 (80)	3.625 (92.07)	N/A	4.625 (117.47)	5.21 (132.33)	6.29 (160)
640-826 (3J)	220	6.37 (162)	8.42 (214)	6.88 (175)	N/A	3.375 (85.72)	.585 (14.8)	6.18 (157)	12.20 (310)	3.14 (80)	3.625 (92.07)	N/A	4.625 (117.47)	5.21 (132.33)	6.29 (160)

THREE JAW PRECISION CHUCKS

Precision three jaw chucks are available for all DMNC/DRFT rotary table models, along with DMTRT tilting rotary tables. Our Accu-Chucks (585 Series) are offered for manual clamping (see page 86, of our workholding section) and the pneumatic chucks (583 Series, page 92) for automatic clamping. We now offer 3-jaw hydraulic chucks with large thru holes for very powerful clamping. NOTE: Each chuck, either manual or air operated, requires a 3-jaw chuck adapter plate.



585-108 8 3/4" Accu-Chuck (manual)



583-008 8 3/4" 3-Jaw air operated Accu-Chuck



588-008 Hydraulic chuck with 588-222 cylinder (shown with DMNC-220)

CNC ROTARY PRODUCTS



DMNC / DRFT ACCESSORIES (con't.)

TAILSTOCKS

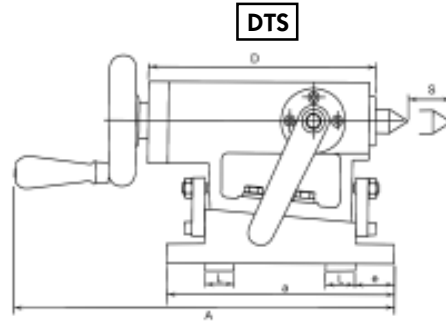
The DTS style tailstocks feature a solid main body dovetailed into the spindle block, for maximum rigidity, along with a Morse taper (MT) center bore, so that a live, bullnose or dead center can be used (optional). DTS series tailstocks are designed to the proper center height for each DMNC/DRFT model, with minimal adjustment. The DTS units are manually operated (using a handwheel). The **660 Series air operated Tailstocks** utilize a solid steel block (main body), (fixed center height) with a Morse Taper (MT-3) center bore, permitting the use of a bullnose, live or dead center (optional); (see page 118). A powerful air cylinder is used to drive the spindle, with a full 2.5" of stroke, providing up to 450 lbs. of thrust pressure. The spindle features a thru hole for easy removal of the center.



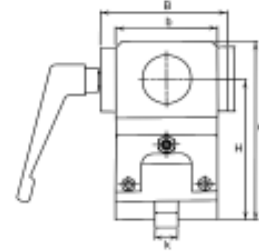
DTS-280



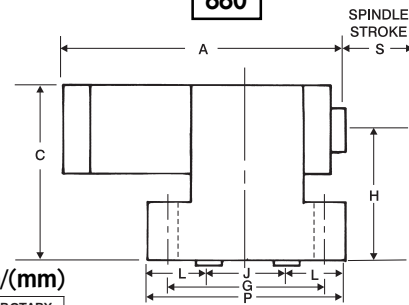
660-140



DTS

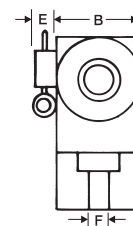


660



Inch/(mm)

MODEL	H	A	B	C	D	a	b	e	S	k	L	CENTER BORE	ROTARY MODEL
DTS-5C	4.33 (110)	11.77 (299)	3.93 (100)	5.51 (140)	7.12 (181)	7.08 (180)	3.15 (80)	1.18 (30)	1.18 (30)	0.71 (18)	0.94 (24)	MT-2	5C
DTS-130	4.13 (105)	11.77 (299)	3.93 (100)	5.31 (135)	7.12 (181)	7.08 (180)	3.15 (80)	1.18 (30)	1.18 (30)	0.71 (18)	0.94 (24)	MT-2	130
DTS-170	5.12 (130)	11.77 (299)	3.93 (100)	6.30 (160)	7.12 (181)	7.08 (180)	3.15 (80)	1.18 (30)	1.18 (30)	0.17 (18)	0.94 (24)	MT-2	170
DTS-220	6.30 (160)	13.93 (354)	5.47 (139)	8.58 (218)	9.13 (232)	8.66 (220)	3.15 (80)	1.57 (40)	2.36 (60)	0.17 (18)	0.94 (24)	MT-4	220
DTS-280	7.48 (190)	13.93 (354)	5.47 (139)	9.76 (248)	9.13 (232)	8.66 (220)	3.15 (80)	1.57 (40)	2.36 (60)	0.17 (18)	0.94 (24)	MT-4	280
DTS-320	8.66 (220)	13.93 (354)	5.47 (139)	10.9 (278)	9.13 (232)	8.66 (220)	3.15 (80)	1.57 (40)	2.36 (60)	0.17 (18)	0.94 (24)	MT-4	320
DTS-400	11.02 (280)	13.93 (354)	5.47 (139)	14.09 (358)	9.13 (232)	8.66 (220)	3.15 (80)	1.57 (40)	2.36 (60)	0.17 (18)	0.94 (24)	MT-4	400



Inch/(mm)

MODEL	H	A	B	C	S	F	E	P	G	J	L	CENTER BORE	KEY	UNIT
660-100	4.33 (110)	10.00 (254)	3.00 (76.20)	5.80 (147)	2.50 (63.50)	.630 (16)	.750 (19.05)	7.00 (177.80)	5.60 (142)	3.00 (76)	2.00 (51)	MT-3	0.71 (18)	5C(A) & 132 5C(L)
660-130	4.13 (105)	10.00 (254)	3.00 (76.20)	5.60 (142)	2.50 (63.50)	.630 (16)	.750 (19.05)	7.00 (177.80)	5.60 (142)	3.00 (76)	2.00 (51)	MT-3	0.71 (18)	130 MODELS
660-140	4.53 (115)	10.00 (254)	3.00 (76.20)	6.00 (152)	2.50 (63.50)	.630 (16)	.750 (19.05)	7.00 (177.80)	5.60 (142)	3.00 (76)	2.00 (51)	MT-3	0.71 (18)	140 MODELS
660-170	5.12 (130)	10.00 (254)	3.00 (76.20)	6.60 (167)	2.50 (63.50)	.630 (16)	.750 (19.05)	7.00 (177.80)	5.60 (142)	3.00 (76)	2.00 (51)	MT-3	0.71 (18)	170 MODELS
660-220	6.30 (160)	10.00 (254)	3.00 (76.20)	7.77 (197)	2.50 (63.50)	.630 (16)	.750 (19.05)	7.00 (177.80)	5.60 (142)	3.00 (76)	2.00 (51)	MT-3	0.71 (18)	220 MODELS
660-280	7.48 (190)	10.00 (254)	3.00 (76.20)	8.95 (227)	2.50 (63.50)	.630 (16)	.750 (19.05)	7.00 (177.80)	5.60 (142)	3.00 (76)	2.00 (51)	MT-3	0.71 (18)	280 MODELS

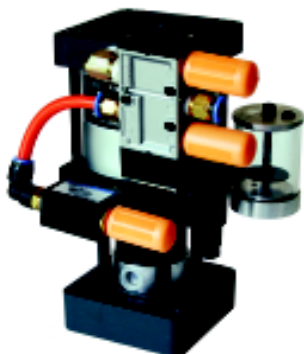
CNC ROTARY PRODUCTS

DMNC SERIES



MPG 300

This device is used for manually generating encoder pulses to the servo drive, enabling an incremental jog feature. Many times it is necessary to position the DMNC controller face to a "work zero" position, which can be a challenge. The MPG 300 (with 12 ft. cable) makes this task easy, because you can jog the rotary table while standing right in front of the machining area. The MPG 300 offers a hand wheel with detent and four-speed jog. Control both 4th and 5th axis when used with UDNC-M2 dual axis controller.



HYDRAULIC BOOSTER (PHB-100)

Our hydraulic brake option can use either hydraulic fluid only with a hydraulic pump, or you can purchase our hydraulic booster which requires only an air supply to push the hydraulic fluid into the brake chamber.



HYDRAULIC BRAKE PARTS (DHB-130~320)

The DMNC units offer a hydraulic brake option for increased spindle holding torque providing maximum rigidity for heavy milling cuts.

ACSU-5C, 5CA, 16C, 3J & 22J COLLET CHUCKS

These manually and air operated collet chucks are mounted on the front of the DMNC/DRFT rotary table. The T-slotted sub-plate is removed, then the appropriate collet chuck adapter plate is mounted to the rotary table spindle. The ACSU collet chuck is then mounted to the adapter plate. The same collet chuck adapter plate will fit all four collet chucks. These collet chucks are very rigid, and provide a "dead length" for accurate positioning of the workpiece. A simple 90° turn of the "collet lever" (supplied for manual chucks) is all that is required to open and close the collet. For the ACSU-5CA the air valve and hose connections are included with an easy turn of the switch for collet operation. **Note:** See pages 78 & 80 of the WORKHOLDING section for a detailed dimensional drawing.





CUSTOM TRUNION BLOCK AND FLAT PLATE FIXTURES

We design and build custom trunion blocks and flat plate fixtures using a variety of bearing and brake style end supports to customer specifications. In addition, our engineering staff design and build special jigs and fixtures using custom or "off the shelf" workholders to hold customer parts on these plate and trunion blocks.



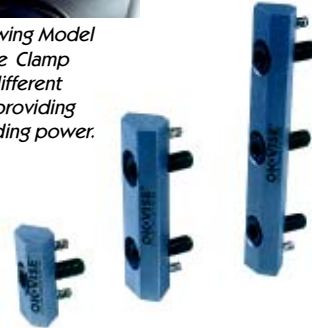
The above photo illustrates Model 220 rotary table with the new OK-Vise® edge clamps holding sample workpieces, with our Model SU-08170 brake style bearing end support.



Close-up showing Model 215-301 Edge Clamp holding two different work pieces providing maximum holding power.



Just let us know the size and shape of the trunion fixture and we will build it along with the end support and workpiece fixture components.



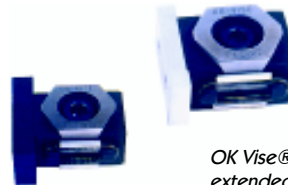
OK Vise® edge clamps are designed to be used along the corner edges of a trunion or tombstone fixture. This unique design permits clamping of two workpieces with one edge clamp.



Sample Work Stops



Model 280 shown with 6"x6"x24" aluminum block trunion and PN#640-528 end support.



OK Vise® Clamps with extended jaws

CNC ROTARY PRODUCTS

END SUPPORTS



SU-08170 with brake and dual tapered roller bearings



640-522 with sealed bearing



710-224 for Super Rapidex applications