



Operation Manual

PRODUCT NAME

3-Position Rotary Table

MODEL / Series / Product Number

*MSZ*10 to 50A*

SMC Corporation

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Safety Instructions

These safety instructions are intended to prevent hazardous situations and/or equipment damage. These instructions indicate the level of potential hazard with the labels of “**Caution**,” “**Warning**” or “**Danger**.” They are all important notes for safety and must be followed in addition to International Standards (ISO/IEC)^{*1)}, and other safety regulations.

*1) ISO 4414: Pneumatic fluid power - General rules and safety requirements for systems and their components
ISO 4413: Hydraulic fluid power - General rules and safety requirements for systems and their components
IEC 60204-1: Safety of machinery - Electrical equipment of machines - Part 1: General requirements
ISO 10218-1: Robots and robotic devices - Safety requirements for industrial robots - Part 1: Robots
etc.



Danger

Danger indicates a hazard with a high level of risk which, if not avoided, will result in death or serious injury.



Warning

Warning indicates a hazard with a medium level of risk which, if not avoided, could result in death or serious injury.



Caution

Caution indicates a hazard with a low level of risk which, if not avoided, could result in minor or moderate injury.

Warning

1. The compatibility of the product is the responsibility of the person who designs the equipment or decides its specifications.

Since the product specified here is used under various operating conditions, its compatibility with specific equipment must be decided by the person who designs the equipment or decides its specifications based on necessary analysis and test results. The expected performance and safety assurance of the equipment will be the responsibility of the person who has determined its compatibility with the product. This person should also continuously review all specifications of the product referring to its latest catalog information, with a view to giving due consideration to any possibility of equipment failure when configuring the equipment.

2. Only personnel with appropriate training should operate machinery and equipment.

The product specified here may become unsafe if handled incorrectly. The assembly, operation and maintenance of machines or equipment including our products must be performed by an operator who is appropriately trained and experienced.

3. Do not service or attempt to remove product and machinery/equipment until safety is confirmed.

1. The inspection and maintenance of machinery/equipment should only be performed after measures to prevent falling or runaway of the driven objects have been confirmed.
2. When the product is to be removed, confirm that the safety measures as mentioned above are implemented and the power from any appropriate source is cut, and read and understand the specific product precautions of all relevant products carefully.
3. Before machinery/equipment is restarted, take measures to prevent unexpected operation and malfunction.

4. Our products cannot be used beyond their specifications. Our products are not developed, designed, and manufactured to be used under the following conditions or environments. Use under such conditions or environments is not covered.

1. Conditions and environments outside of the given specifications, or use outdoors or in a place exposed to direct sunlight.
2. Use for nuclear power, railways, aviation, space equipment, ships, vehicles, military application, equipment affecting human life, body, and property, fuel equipment, entertainment equipment, emergency shut-off circuits, press clutches, brake circuits, safety equipment, etc., and use for applications that do not conform to standard specifications such as catalogs and operation manuals.
3. Use for interlock circuits, except for use with double interlock such as installing a mechanical protection function in case of failure. Please periodically inspect the product to confirm that the product is operating properly.



Safety Instructions

Caution

We develop, design, and manufacture our products to be used for automatic control equipment, and provide them for peaceful use in manufacturing industries.

Use in non-manufacturing industries is not covered.

Products we manufacture and sell cannot be used for the purpose of transactions or certification specified in the Measurement Act.

The new Measurement Act prohibits use of any unit other than SI units in Japan.

Limited warranty and Disclaimer/Compliance Requirements

The product used is subject to the following “Limited warranty and Disclaimer” and “Compliance Requirements”. Read and accept them before using the product.

Limited warranty and Disclaimer

1. The warranty period of the product is 1 year in service or 1.5 years after the product is delivered, whichever is first.*2)
Also, the product may have specified durability, running distance or replacement parts. Please consult your nearest sales branch.
2. For any failure or damage reported within the warranty period which is clearly our responsibility, a replacement product or necessary parts will be provided.
This limited warranty applies only to our product independently, and not to any other damage incurred due to the failure of the product.
3. Prior to using SMC products, please read and understand the warranty terms and disclaimers noted in the specified catalog for the particular products.

***2) Vacuum pads are excluded from this 1 year warranty.**

A vacuum pad is a consumable part, so it is warranted for a year after it is delivered.

Also, even within the warranty period, the wear of a product due to the use of the vacuum pad or failure due to the deterioration of rubber material are not covered by the limited warranty

Compliance Requirements

1. The use of SMC products with production equipment for the manufacture of weapons of mass destruction (WMD) or any other weapon is strictly prohibited.
2. The exports of SMC products or technology from one country to another are governed by the relevant security laws and regulations of the countries involved in the transaction. Prior to the shipment of a SMC product to another country, assure that all local rules governing that export are known and followed.

Warning

1. Confirm the specifications.

Products represented in this catalog are designed only for use in compressed air systems.

Do not operate at pressures or temperatures, etc., beyond the range of specifications, as this can cause damage or malfunction. (Refer to the specifications.)

We do not guarantee against any damage if the product is used outside of the specification range.

2. If the operation involves load fluctuations, ascending/descending movements, or changes in friction resistance, make sure to provide safety measures.

Operating speed will increase, and bodily injury may occur, or damage to the machinery itself may occur.

3. If there is a chance that the product will pose a hazard to humans, install a protective cover.

If the moving portion of the product will pose a hazard to humans or will damage machinery or equipment, provide a construction that prevents direct contact with those areas.

4. Be certain that the secured portions will not loosen.

Be certain to adopt a reliable connecting method if the rotary table is used very frequently or if it is used in a location that is exposed to a large amount of vibrations.

5. There may be cases in which a speed reduction circuit or a shock absorber is required.

If the driven object moves at high speeds or is heavy, it will be unfeasible for only the rotary table's cushion to absorb the shock. Therefore, provide a speed-reduction circuit to reduce the rotary table's speed before the thrust is applied to the cushion, or an external shock absorber to dampen the shock. If these countermeasures are taken, make sure to take the rigidity of the mechanical equipment into consideration.

6. Consider the possibility of a reduction in the circuit air pressure caused by a power failure.

When a rotary table is used as clamping mechanism, there is a danger of workpiece dropping if there is a decrease in clamping force, due to a drop in circuit pressure caused by a power failure. Therefore, safety equipment should be installed to prevent damage to machinery and bodily injury.

7. Consider the possibility of power source related malfunctions that could occur.

For the machinery equipment that rely on power sources such as compressed air, electricity, or hydraulic pressure, adopt countermeasure to prevent the equipment from causing a hazard to humans or damage to the machinery and equipment in the event of malfunction.

8. If a speed controller is provided in the exhaust restrictor, implement a safety design taking the residual pressure into consideration.

If air pressure is applied to the air supply side without residual pressure in the exhaust side, the rotary table will operate at abnormally high speeds, which could pose a hazard to humans and damage the machinery and equipment.

9. Consider the behavior of the rotary table in the event of an emergency stop.

Devise a safe system so that if a person engages the emergency stop, or if a safety device is tripped during a system malfunction such as a power failure, the movement of the rotary table will not cause a hazard to humans or damage the equipment.

10. Consider the action of the rotary table when restarting after an emergency stop.

Devise a safe design so that the restarting of the rotary table will not pose a hazard to humans or damage the equipment. Install manually controlled equipment for safety when the rotary table has to be reset to the starting position.

11. Do not use the product as a shock absorber.

If an abnormal pressure or air leakage occurs, the rotary table's speed reduction capability could become severely affected, which could pose a hazard to humans and damage the machinery and equipment.

12. Select a speed within the product's allowable energy value.

If the product's kinetic energy of the load exceeds the allowable value, it could damage the product, and cause a hazard to humans and damage the machinery and equipment.

13. Provide a shock absorber if the kinetic energy that is applied to the product exceeds the allowable value.

If the product's kinetic energy exceeds the allowable value, it could damage the product, and cause a hazard to humans and damage the machinery or equipment.

14. Do not stop or hold the product at midpoint by keeping air pressure in the product. (Air balancers etc.)

For a product lacking an external stopping mechanism, if the directional control valve is closed to keep the air pressure in the product, in an attempt to stop the product at midpoint, it might not be possible to maintain that stopped position due to an air leakage. As a result, it could pose a hazard to humans and cause damage to machinery and/or equipment.

15. Do not use two or more rotary tables with the aim of synchronized movement.

One of the rotary tables may bear the load of operation, making synchronized movement impossible, and possibly leading to deformation of the equipment.

16. Do not use in a location where adverse effect could be occurred by the oozing of the lubricant to the exterior.

The lubricant coating the interior of the product may leak to the outside of the product from connecting parts of the rotary body, cover, etc.

17. Do not disassemble the product or make any modifications, including additional machining.

This may cause human injury and/or an accident.

18. Refer to the Auto Switches Precautions for using with an auto switch.

Caution

1. Do not use below the speed adjustment range specified for the product.

If the product is used below the specified speed adjustment range, it could cause the product to stick, slip, or the movement to stop.

2. Do not apply an external torque to the product that exceeds the rated output.

If an external force that exceeds the product's rated output is applied to the product, it could damage the product.

3. The holding torque of the rotating end of the double piston type

If the internal piston of a double piston product comes in contact with the angle adjustment screen or the cover and stops, the holding torque at the rotating end is one half of the actual output.

4. If it is necessary to provide repeatability of the rotation angle, directly stop the load externally.

Even with a product that is equipped with an angle adjuster, there are times when the initial rotation angle could change.

5. Do not use under hydraulic pressure.

The product will be damaged if it is used by applying hydraulic pressure.

6. There is a possibility of backlash being generated when stopping the double piston style in the middle with a valve of the closed center type.

7. Do not use in a places where there are many temperature fluctuations.

When using in lower temperature applications, use caution so that frost does not occur inside the cylinder or the piston rod.

Operation may be unstable.

8. Adjust the speed control in the environment in which it will be used in.

Speed adjustment may be changed if the environment is different.

Mounting

Warning

1. Operation manual

Install the product and operate it only after reading the operation manual carefully and understanding its contents. Also, keep the manual in a location where it can be referred to as necessary.

2. Ensure sufficient space for maintenance activities.

When installing the products, allow access for maintenance.

3. Tighten threads with the proper tightening torque.

When installing the products, follow the listed torque specifications.

4. Before adjusting the angle by supplying air pressure, take appropriate measures to prevent the equipment from rotating unnecessarily.

When an adjustment is performed under air pressure, the equipment could rotate and fall during the adjustment, depending on the mounted posture of the equipment. As a result, it could pose a hazard to humans and damage the machinery and equipment.

5. Do not loosen the angle adjustment screw beyond the allowable adjustment range.

The angle adjustment screw could fall out if it is loosened beyond its allowable adjustment range, which could pose a hazard to humans and damage the machinery and equipment.

6. Do not place a magnetic object near the product.

The auto switch is a magnetic sensing type. If a magnetic object is placed close to it, the rotary table could operate suddenly, which could pose a hazard to humans and damage the machinery and equipment.

7. Do not perform additional machining to the product.

Additional machining to the product can result in insufficient strength and cause damage to the product. This can lead to possible human injury and damage to the surrounding equipment.

8. Do not enlarge the fixed throttle by modifying the pipe connectors.

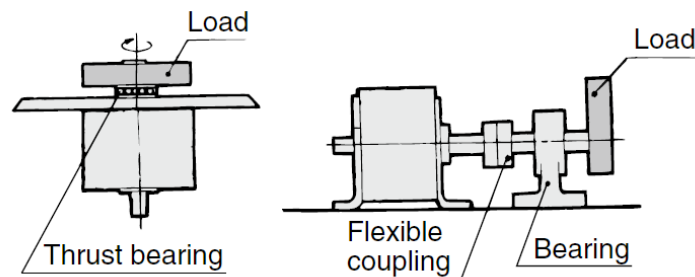
If the hole diameter is enlarged, the product's rotation speed will increase, causing the shock force to increase and damage to the product. As a result, it could pose a hazard to humans and damage the machinery and equipment.

9. If shaft couplings are used, use those with angular freedom.

If shaft couplings that lack angular freedom are used, they could scrape due to eccentricity, leading to equipment malfunction and product damage. As a result, it could pose a hazard to humans and damage the machinery and equipment.

10. Do not apply to the shaft a load that exceeds the values given in a catalog.

If a load that exceeds the allowable value is applied to the product, it could lead to equipment malfunction, a hazard to humans and damage to the machinery and equipment. Provided that a dynamic load is not generated, a load that is within the allowable radial / thrust load can be applied. However, applications in which the load is applied directly to the shaft should be avoided whenever possible. The methods such as those described below are recommended to prevent the load from being applied directly to the shaft in order to ensure a proper operating condition.



11. Do not use springs, etc., to add force in the rotational movement direction.

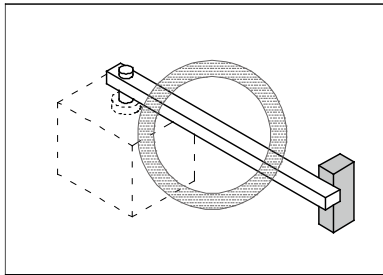
When rotational force from an external spring, etc., acts and generates negative pressure on the product's interior, breakage of the internal seal or acceleration of abrasion may occur.

12. Place an external stopper in a position that is away from the rotating table.

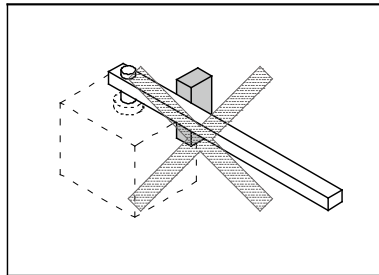
If the stopper is placed near the rotating table, the torque that is generated by the product itself will cause the reaction force which is directed to the stopper to be redirected and applied to the rotating table. This will lead to the breakage of the rotating table and bearing. As a result, it could pose a hazard to humans and damage the machinery and equipment.

Precautions when Using External Stoppers

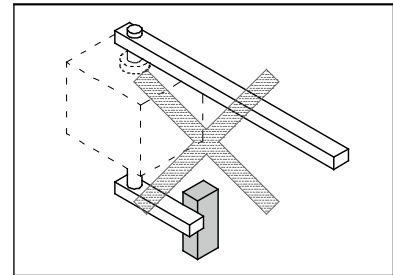
- Be sure to install external stoppers in the proper places. Installation in the wrong place can result in equipment breakage, which could damage other equipment or cause human injury.



Install the stopper at a sufficient distance from the rotating shaft.

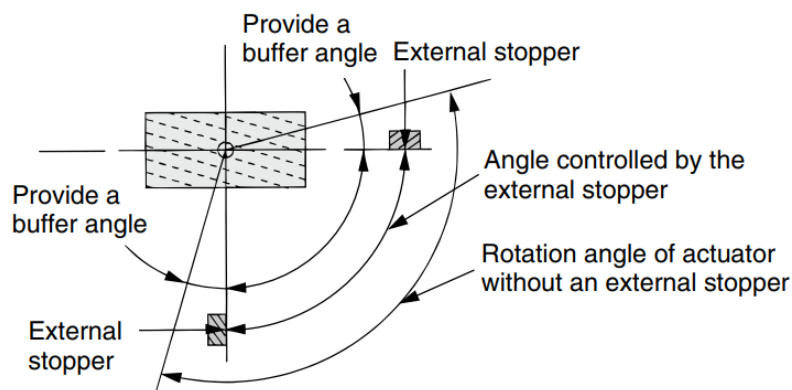


The external stopper becomes a fulcrum, resulting in the load's inertia force being applied to the table as a bending moment.



If an external stopper is installed on the opposite side of the load, the inertia force generated by the load is applied directly to the table.

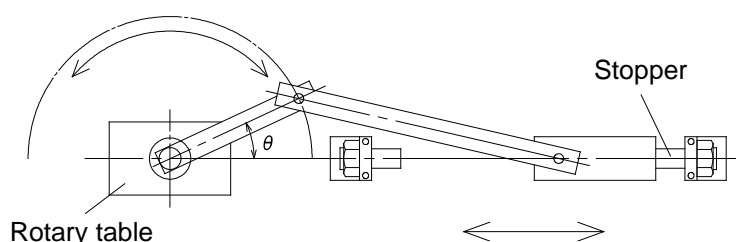
- Install external stoppers within the range of the rotating angle. Installing an external stopper at the maximum rotation angle may result in an inability to fully absorb the kinetic energy generated, and damage to equipment may occur.
- Angle adjustment is available for this product. When using an external stopper, set in a position so that that the adjusting bolt does not collide into the piston.



Precautions when Converting Rotational Motion to Linear Motion

When using a link mechanism, etc., to convert rotational motion to linear motion, and determining the operation end using the stopper on the linear motion end (see below), a small value for θ at the operation end may result in the torque of the rotary table causing excessive radial load to act on the output axle, and equipment breakage may occur.

Install a stopper on the rotation motion side, or increase the value of θ at the operation end, to make sure the load generated does not exceed the allowable value for the product.



Lubrication

Warning

1. This product should be used without lubrication. Although it will operate even if it is lubricated, it could lead to sticking or slipping.

Air Supply

Warning

1. **Type of fluids**

Use compressed air.

2. **When there is a large amount of moisture**

Compressed air containing a large amount of moisture can cause malfunction of pneumatic equipment. An air dryer or water separator should be installed upstream from filters.

3. **Drain flushing**

If condensation in the drain bowl is not emptied on a regular basis, the bowl will overflow and allow the condensation to enter the compressed air lines. This may cause malfunction of pneumatic equipment.

If the drain bowl is difficult to check and remove, installation of a drain bowl with an auto drain option is recommended.

4. **Use clean air.**

Do not use compressed air that contains chemicals, synthetic oils including organic solvents, salt or corrosive gases, etc., as it can cause damage or malfunction.

Caution

1. **When low dew point air is used as the fluid, degradation of the lubrication properties inside the equipment may occur, resulting in reduced reliability (or reduced service life) of the equipment.**

Please consider using low dew point products such as 25A-series.

2. **Install an air filter.**

Install an air filter upstream near the valve. Select an air filter with a filtration size of 5µm or smaller.

3. **Take measures to ensure air quality, such as by installing an aftercooler, air dryer, or water separator.**

Compressed air that contains a large amount of moisture can cause malfunction of pneumatic equipment such as rotary tables. Therefore, take appropriate measures to ensure air quality, such as by providing an aftercooler, air dryer, or water separator.

4. **Ensure that the fluid and ambient temperature are within the specified range.**

If the fluid temperature is 5°C or less, the moisture in the circuit could freeze, causing damage to the seals and equipment malfunction. Therefore, take appropriate measures to prevent freezing.

Operating Environment

Warning

1. **Do not use in an atmosphere having corrosive gases, chemicals, sea water, water, steam, or where there is direct contact with any of these.**
Refer to the construction for information on the rotary table material.
2. **Do not expose the product to direct sunlight for an extended period of time.**
3. **Do not use in a place subject to heavy vibration and/or shock.**
4. **Do not mount the product in locations where it is exposed to radiant heat.**
5. **Do not use in dusty locations or where water oil, etc., splash on the equipment.**

Maintenance

Warning

1. **Perform maintenance inspection according to the procedures indicated in the operation manual.**
If handled improperly, malfunction and damage of machinery or equipment may occur.
2. **Maintenance work**
If handled improperly, compressed air can be dangerous. Assembly, handling, repair and element replacement of pneumatic systems should be performed by a knowledgeable and experienced person.
3. **Drain flushing**
Remove drainage from air filters regularly.
4. **Removal of equipment, and supply/exhaust of compressed air**
When components are removed, first confirm that measures are in place to prevent workpieces from dropping, run-away equipment, etc. Then, cut off the supply pressure and electric power, and exhaust all compressed air from the system using the residual pressure release function.
When machinery is restarted, proceed with caution after confirming that appropriate measures are in place to prevent cylinders from sudden movement.

Caution

1. **For lubrication, use the designated grease for each specific product.**
The use of a non-designated lubricant could damage the seals.
Please refer to Table 19 on page 44 for where to apply grease and the grease to use.

Auto Switches Precautions

Design / Selection

Warning

1. **Confirm the specifications.**

If the product is used with excess load applied or beyond the specification range, this may cause the product to break or malfunction. We do not guarantee against any damage if the product is used outside of the specification range.

2. **Cautions for use in an interlock circuit.**

When an auto switch is used for an interlock signal requiring high reliability, devise a double interlock system to avoid trouble by providing a mechanical protection function, or by also using another switch (sensor) together with the auto switch.

Also, perform regular maintenance and confirm proper operation.

3. **Do not attempt to disassemble, modify (including exchanging the printed circuit boards), or repair the product.**

An injury or failure can result.

Caution

1. **Pay attention to the length of time that a switch is ON at an intermediate stroke position.**

When an auto switch is placed at an intermediate position of the stroke and a load is driven, at the time the piston passes the auto switch will operate, but if the speed is too great the operating time will be shortened and the load may not operate properly.

The maximum piston speed is:

$$V(\text{mm/s}) = \frac{\text{Auto switch operating range (mm)}}{\text{Load applied time (ms)}} \times 1000$$

2. **Take precautions when multiple rotary tables are used close together.**

When multiple auto switch rotary tables are used in close proximity, magnetic field interference may cause the auto switches to malfunction. Maintain a minimum cylinder separation of 40 mm. (When the allowable interval is specified for each cylinder series, use the indicated value.)

The auto switches may malfunction due to interference from the magnetic fields.

Use of a magnetic screen plate (MU-S025) or commercially available magnetic screen tape can reduce the interference of magnetic force.

3. **Ensure sufficient clearance for maintenance activities.**

When designing an application, be certain to allow sufficient clearance for maintenance.

4. **Do not mount rotary table with the auto switch on a footing.**

If work personnel gets on or puts the work personnel's foot on the footing accidentally, an excessive load is applied to the rotary table, causing the rotary table to break.

5. **Design the circuit so that any back-flow current does not flow in if a short-circuit trouble occurs or forced operation is performed to check the operation.**

If a back-flow current occurs, this may cause the switch to malfunction or break.

6. **When multiple auto switches are required.**

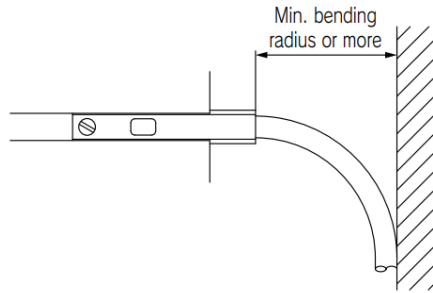
"n" indicates the number of auto switches which can be physically mounted on the rotary tables. Detection intervals depends on the auto switch mounting structure and set position, therefore some required interval and set positions may not be available.

7. **Limitations on detectable position**

There are positions or surfaces (bottom surface of the foot bracket, etc.) where the auto switch cannot be mounted due to the physical interference depending on the rotary table mounting status or mounting bracket. Select an appropriate auto switch setting position where the auto switch does not interfere with the rotary table mounting bracket (trunnion or reinforcing ring) after checking it sufficiently.

8. Provide enough space for the lead wire.

Applying stress to the lead wire and auto switch body connection part increases the risk of disconnection. Provide a space of at least the min. bending radius from the lead wire and auto switch body connection part.



9. Keep wiring as short as possible.

<Reed>

As the length of the wiring to a load gets longer, the rush current at switching ON becomes greater, and this may shorten the product's life. (The switch will stay ON all the time.)

- 1) Use a contact protection box when the wire length is 5m or longer.
- 2) Even if an auto switch has a built-in contact protection circuit, when the wiring is more than 30 m long, it is not able to adequately absorb the rush current and its life may be reduced.

<Solid state>

Be sure to use a wire length 100m or less.

When the wire length is long, we recommend the ferrite core should be attached to the both ends of the cable to prevent excess noise. A contact protection box is not necessary for solid state switches due to the nature of this product construction.

10. Do not use a load that generates surge voltage.

<Reed>

If a surge voltage is generated, the discharge occurs at the contact, possibly resulting in the shortening of product life.

If driving a load such as a relay that generates a surge voltage, use an auto switch with built-in contact protection circuit or use a contact protection box.

<Solid state>

If driving a load such as a relay that generates a surge voltage, use a built-in surge absorbing element type device.

11. Pay attention to the internal voltage drop of the auto switch.

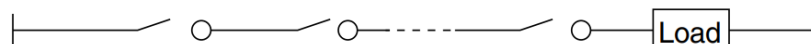
<Reed>

- 1) Auto switch with an indicator light

- If auto switches are connected in series as shown below, take note that there will be a large voltage drop because of internal resistance in the light emitting diodes. (Refer to the internal voltage drop in the auto switch specifications.)

[The voltage drop will be "n" times larger when "n" auto switches are connected.]

Even though an auto switch operates normally, the load may not operate.



- In the same way, when operating under a specified voltage, although an auto switch may operate normally, the load may not operate. Therefore, the formula below should be satisfied after confirming the minimum operating voltage of the load.

$$\text{Supply voltage} - \text{Internal voltage drop of auto switch} > \text{Minimum operating voltage of load}$$

- 2) If the internal resistance of a light emitting diode causes a problem, select an auto switch without an indicator light.

<Solid state / 2-wire type>

Generally, the internal voltage drop of the solid state auto switch is larger than that of the reed auto switch. When the auto switches ("n" pcs.) are connected in series, the voltage drop is multiplied by "n". In this case, the auto switches operate correctly, but the loads may not operate. Additionally, note that the 12 VDC relay does not apply to the auto switch.

12. Pay attention to leakage current.

<2-wire type>

Current (leakage current) flows to the load to operate the internal circuit even when in the OFF state.

$$\text{Operating current of load (OFF condition)} > \text{Leakage current}$$

If the criteria given in the above formula are not met, it will not reset correctly (stays ON). Use a 3-wire switch if this specification will not be satisfied.

Moreover, leakage current flow to the load will be "n" times larger when "n" auto switches are connected in parallel.

13. Output operation of the solid state auto switch is not stable for 50 [ms] after powered ON.

In the output operation immediately after powered ON or AND connection operation, the input device (PCL or relay, etc.) may judge the ON position as OFF output or the OFF position as ON output. So, please make the setting on the equipment so that the input judgement signal is set disabled for 50 [ms] immediately after powered ON or AND connection. When using SMC's AHC system (Auto Hand Changing System) Series MA, please also make this setting.

Mounting / Adjustment

 **Warning**

1. Do not drop or bump.

Do not drop, bump or apply excessive impacts (300m/s² or more for reed auto switches and 1000m/s² or more for solid state auto switches) while handling. Although the body of the auto switch may not be damaged, the inside of the auto switch could be damaged and cause malfunction.

2. Observe the proper tightening torque for mounting an auto switch.

When an auto switch is tightened beyond the range of tightening torque, auto switch mounting screws, auto switch mounting brackets or auto switch may be damaged.

On the other hand, tightening below the range of tightening torque may allow the auto switch to slip out of position.

3. Do not carry a rotary table by the auto switch lead wires.

This may cause disconnection of the lead wire or the internal element to break.

4. Do not use screws other than the set screws installed on the auto switch body to secure the auto switch.

If using other screws, auto switch may be damaged.

5. Mount an auto switch at the center of the operating range.

In the case of 2-color display auto switch, mount it at the center of the green LED illuminating range. Adjust the mounting position of the auto switch so that the piston stops at the center of the operating range. (The mounting position shown in the catalog indicates the optimum position at stroke end.) If mounted at the end of the operating range (around the borderline of ON and OFF), operation will be unstable depending of the operating environment. Also there are some rotary tables with individual setting methods for auto switches. If so, mount it in accordance with the indicated method.

Even if 2-color indication solid state auto switches are fixed at a proper operating range (the green light lights up), the operation may become unstable depending on the installation environment or magnetic field disturbance.

(Magnetic body, external magnetic field, proximal installation of rotary actuators with built-in magnet and actuators, temperature change, other factors for magnetic force fluctuation during operation, etc.)

6. Check the actual actuation status and adjust the auto switch mounting position.

According to the installation environment, the rotary table may not operate even at its proper mounting position. Even when setting at a midpoint of the stroke, check the actuation status and make the adjustment in the same manner.

7. Be very careful when handling the auto switch mounting band, as it has a thin structure.

Wiring

Warning

1. Confirm proper insulation of wiring.

If there is any improper insulation (mixed contact with other circuit, grounding fault, or improper insulation between terminals, etc.) in the wiring, an over-current flows in, causing the auto switch to break.

2. Wire separately from power lines of high voltage lines, avoiding parallel wiring of wiring in the same conduit with these lines.

If an inrush current is generated, the noise may cause the auto switch to malfunction.

3. Be certain to connect the load before power is applied.

<2-wire type>

If the power is turned ON when an auto switch is not connected to a load, the auto switch will be instantly damaged because of excess current (short circuit).

It is the same as when the 2-wire brown lead wire (+, output) is directly connected to the (+) power supply terminal.

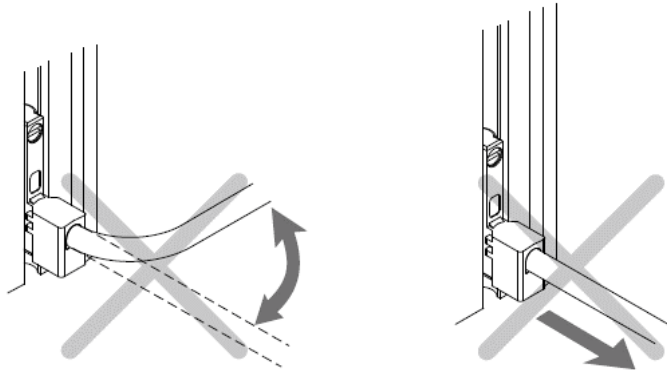
4. Carry out the wiring work after shutting down the power.

If the wiring work is performed with the power turned ON, this may cause electric shock, malfunction, or damage to the auto switch.

5. Avoid repeatedly bending or stretching lead wires.

Broken lead wires will result from repeatedly applying bending stress or stretching force to the lead wires.

Stress and tensile force applied to the connection between the lead wire and auto switch increases the possibility of disconnection.



6. Do not allow short-circuit of loads.

<Reed>

If the power is turned ON with a load in a short circuit condition, the switch will be instantly damaged because of excess current flow into the switch.

<Solid state>

PNP output type auto switches do not have built-in short circuit protection circuits. Carefully handle as the auto switch may be damage.

7. Avoid incorrect wiring.

<Reed>

A 24 VDC auto switch with indicator light has polarity. The brown lead wire or terminal No.1 is (+), and the blue lead wire or terminal No.2 is (-).

- 1) If connections are reversed, an auto switch will operate, however, the light emitting diode will not light up.

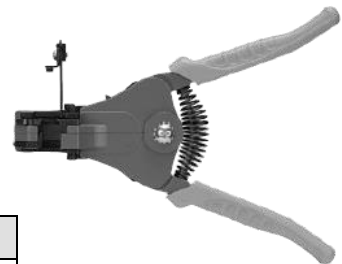
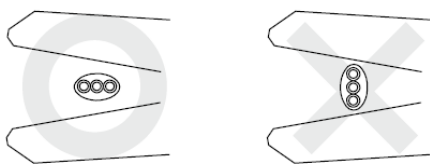
Also, take note that a current greater than that specified will damage a light emitting diode and it will no longer operate.

Applicable model: D-93, A93V

<Solid state>

- 1) If connections are reversed on a 2-wire type auto switch, the auto switch will not be damaged if protected by a protection circuit, but the auto switch will always stay in an ON state. However, it is still necessary to avoid reversed connections, since the auto switch could be damaged by a load short circuit in this condition.
- 2) If connections are reversed (power supply line + and power supply line-) on a 3-wire type auto switch, the auto switch will be protected by a protection circuit. However, if the power supply line (+) is connected to the blue wire and the power supply line (-) is connected to the black wire, the auto switch will be damaged.

8. When the lead wire sheath is stripped, confirm the stripping direction. The insulator may be split or damaged depending on the direction. (D-M9□ only)



Recommended Tool

Description	Model
Wire stripper	D-M9N-SWY

* Stripper for a round cable (Ø2.0) can be used for a 2-wire type cable.

Operation Environment

Warning

1. Never use in an atmosphere with explosive gases.

The structure of auto switches is not intended to prevent explosion. This may lead to explosion hazard.

Caution

1. Do not use in an area where a magnetic field is generated.

Auto switches will malfunction or magnets inside rotary tables will become demagnetized.

2. Do not use in an environment where the auto switch will be continually exposed to water.

Although auto switches satisfy IEC standard IP67 construction expect some models (D-A3□, A44□, G39□, K39□, RNK, RPK) do not use auto switches in applications where continually exposed to water splash or splay. This may cause improper insulation or malfunction.

3. Do not use in an environment with oil or chemicals.

If auto switches are used in an environment containing coolant, cleaning solvent, various oils, or chemicals even for a short period of time, this may adversely affect the auto switches, resulting in improper insulation, malfunction due to swelling of the potting resin, or hardening of the lead wires.

4. Do not use in an environment with temperature cycles.

If temperature cycles other than normal temperature changes are applied, this may adversely affect the insides of the auto switches.

5. Do not use in an environment where there is excessive impact shock.

<Reed>

When excessive impact (300m/s^2 or more) is applied to a reed auto switch during operation, the contacts may malfunction and generate or cut off a signal momentarily (1ms or less).

6. Do not use in an area where surges are generated.

<Solid state>

If there is an equipment unit (electromagnetic lifter, high-frequency induction furnace, motor, or radio, etc.) that generates large surges or electromagnetic waves around cylinders with solid state auto switches or actuators, this may cause the circuit element inside the auto switch to break.

7. Avoid accumulation of iron waste or close contact with magnetic substances.

If many iron particles, such as cutting chips or spatters accumulate around a rotary table with the auto switches if a magnetic substance (attracted by a magnet) is put close to a rotary table with the auto switch, the magnetic force inside the rotary table loses, causing the auto switch to malfunction.

8. Do not use in direct sunlight.

9. Do not mount the product in locations where it is exposed to radiant heat.

10. Take appropriate measures against the lightning surge on the equipment side as the auto switches do not have any lightning surge resistance specified in the CE marking.

Maintenance

Warning

1. Removal of equipment, and supply/exhaust of compressed air.

Before any machinery or equipment is removed, first ensure that the appropriate measures are in place to prevent the fall or erratic movement of driven objects and equipment, then cut off the electric power and reduce the pressure in the system to zero. Only then should you proceed with the removal of any machinery and equipment.

When machinery is restarted, proceed with caution after confirming that appropriate measures are in place to prevent rotary tables from moving suddenly.

2. Do not touch a terminal during energizing.

Touching a terminal during energizing may cause electric shock, malfunction, or auto switch breakage.

Caution

1. Perform the following maintenance periodically in order to prevent possible danger due to unexpected auto switch malfunction.

1) Secure and tighten auto switch mounting screws.

If screws become loose or the mounting, position is dislocated, retighten them after readjusting the mounting position.

2) Confirm that there is no damage to lead wires.

To prevent faulty insulation, replace auto switches or repair lead wires, etc., if damage is discovered.

3) Confirm the detection setting position.

• Red light of 1-color display auto switch

Confirm that the set position stops at the center of the operating range (red display area).

• Conform the green light and position of the 2-color display auto switch.

Conform that the set position stops at the center of the appropriate operating range (green display area). If stopped with the red LED lit, the operation may become unstable due to effects of the equipment environment or external disturbance. So, set the mounting position at the center of the appropriate operating range again.

2. Do not use solvents such as benzene, thinner etc. to clean the product.

They could damage the surface of the body and erase the markings on the body. For heavy stains, use a cloth lightly dampened with diluted neutral detergent, then wipe up any residue with a dry cloth.

Handling Precautions

Caution

1. Do not remove the protective cover attached to the auto switch (D-A9 · (V)/Z7 · /Z80 type) product body until immediately before the product is to be mounted to the rotary table.

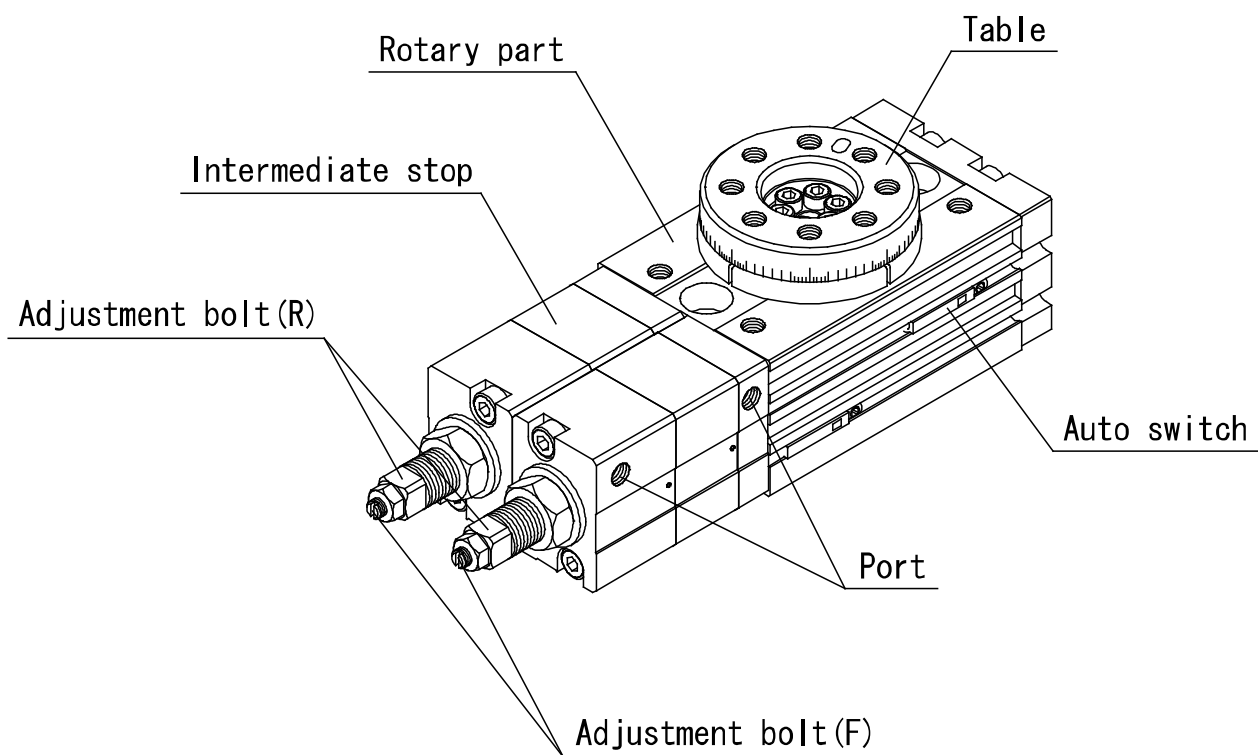
The protective cover attached to the body of the D-A9 · (V)/Z7 · /Z80 type auto switch is intended to reduce impact during handling and prevent the auto switch holding screw from falling out.

In particular, it reduces impact to the auto switch body if it is accidentally bumped when mounting a connector or tubing to the auto switch, so do not remove it until immediately before mounting it to the rotary table.

Names of parts

Names of parts of product

MSZ*10 to 50A



Outline

Specifications

Size	10	20	30	50
Operating fluid	Air (non-lube)			
Max. operating pressure	1MPa			
Min. operating pressure	0.2MPa			
Ambient temperature and operating fluid temperature	0 to 60°C (no freezing)			
Cushion	Not provided			
Allowable kinetic energy	0.007 [J]	0.025 [J]	0.048 [J]	0.081 [J]
Angle adjusting range	0 to 190°			
Max. rotating angle	190°			
Range of all swing angle adjustment	0.2 to 1.0 s/90°			
Adjusting range for intermediate position	±10°			
Piston size	Ø 15	Ø 18	Ø 21	Ø 25
Port size	M5x0.8			

Mass

Size	10	20	30	50
Basic type	700	1300	1670	2570
High precision type	730	1400	1790	2730

Note) The values above do not include auto switch mass.

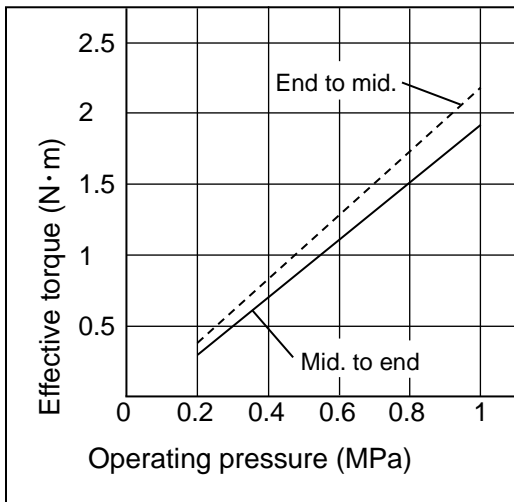
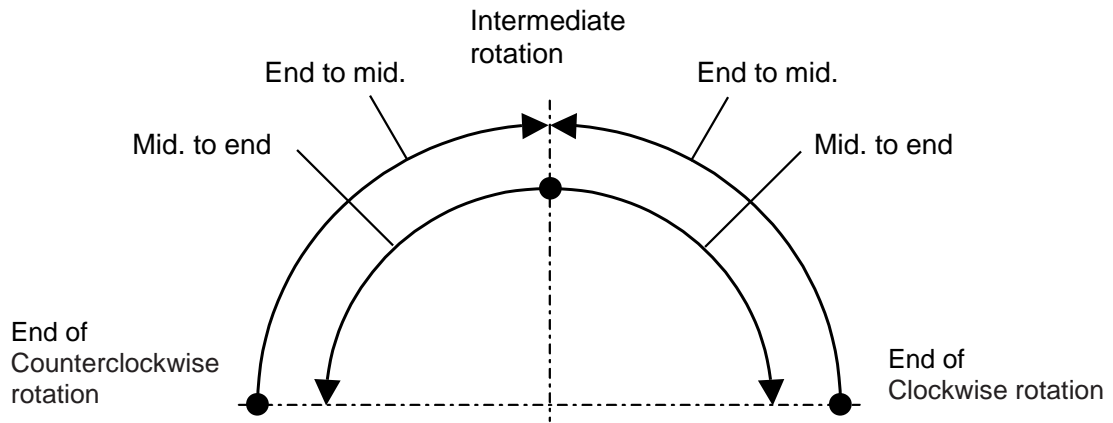
Effective output

Size	Operating direction	Pressure (MPa)								
		0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0
10	End to mid.	0.38	0.60	0.83	1.06	1.28	1.51	1.73	1.96	2.18
	Mid. to end	0.29	0.50	0.70	0.90	1.10	1.30	1.51	1.71	1.91
20	End to mid.	0.72	1.14	1.55	1.97	2.39	2.81	3.22	3.64	4.06
	Mid. to end	0.62	1.01	1.40	1.78	2.17	2.56	2.95	3.34	3.73
30	End to mid.	1.09	1.72	2.36	3.00	3.63	4.27	4.90	5.54	6.18
	Mid. to end	0.91	1.49	2.07	2.65	3.23	3.81	4.39	4.97	5.55
50	End to mid.	1.83	2.83	3.84	4.84	5.84	6.85	7.85	8.85	9.85
	4.75				5.74	6.74	7.73	8.72	9.72	

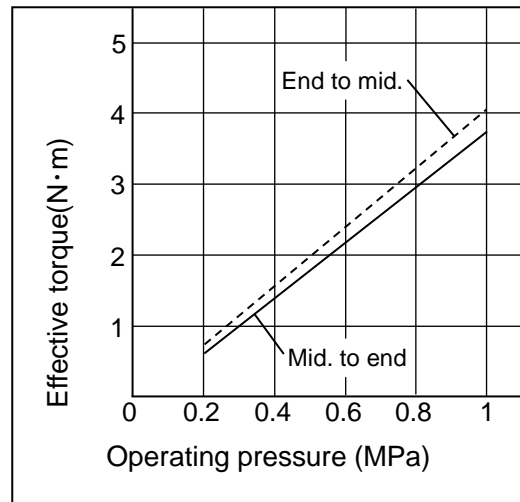
Note) The values shown in the table above are representative values and not to be considered as guaranteed values. These values are for reference only.

Torque varies slightly depending on the rotating direction. Refer to Figure 1 for rotating direction.

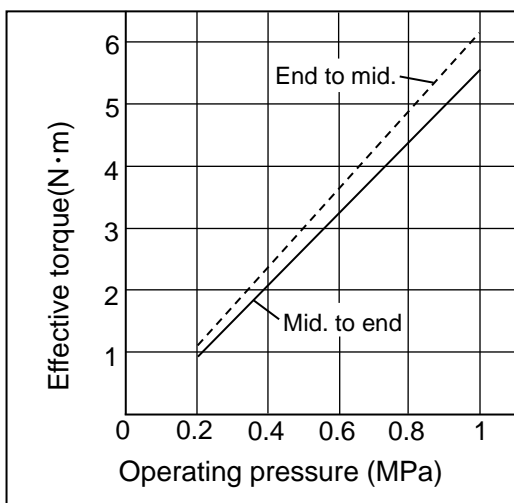
Fig. 1



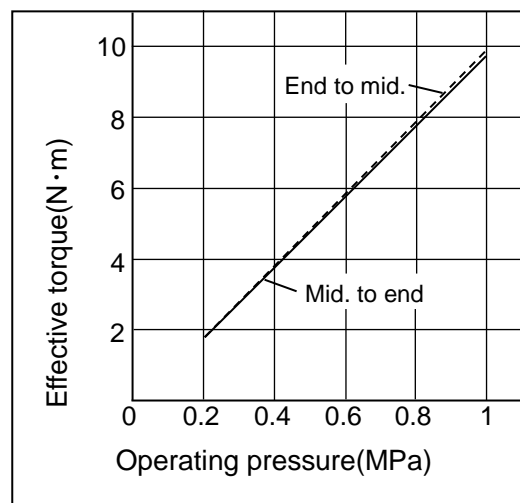
Size 10



Size 20



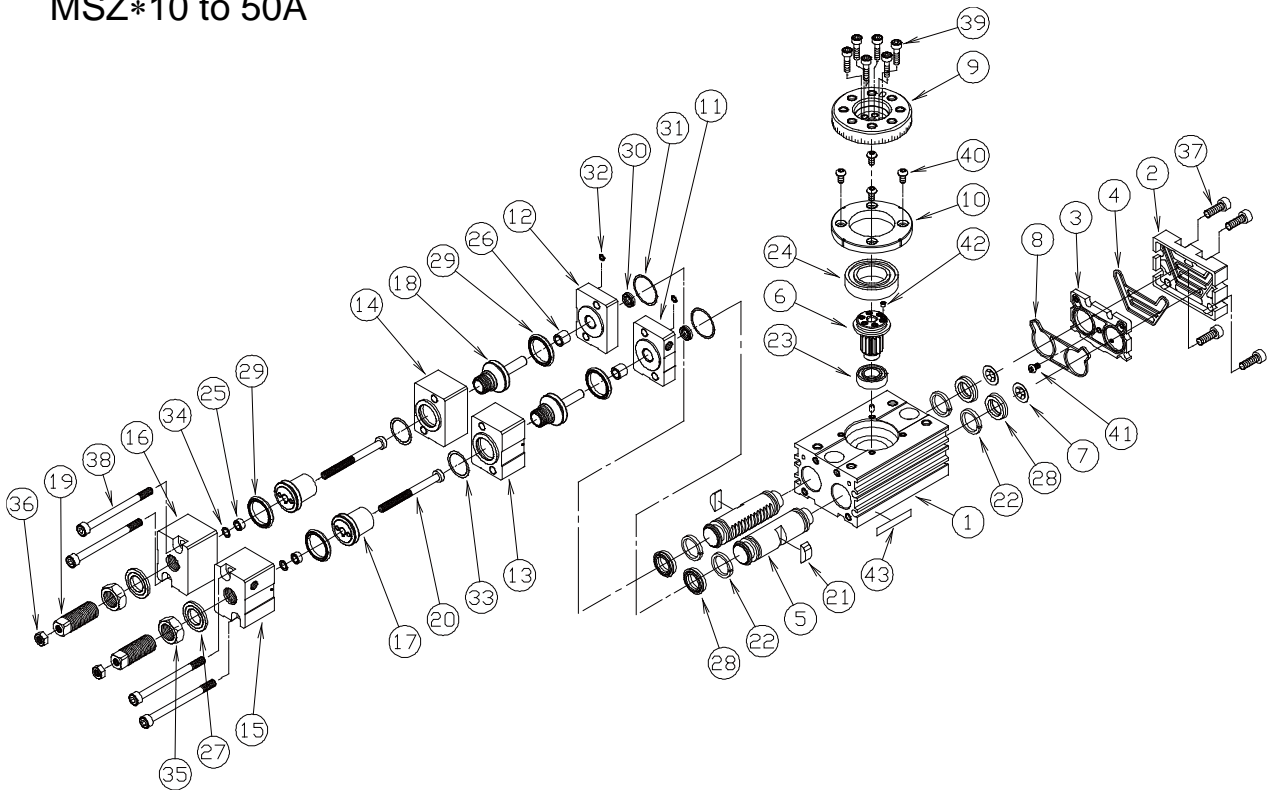
Size 30



Size 50

Disassembled view

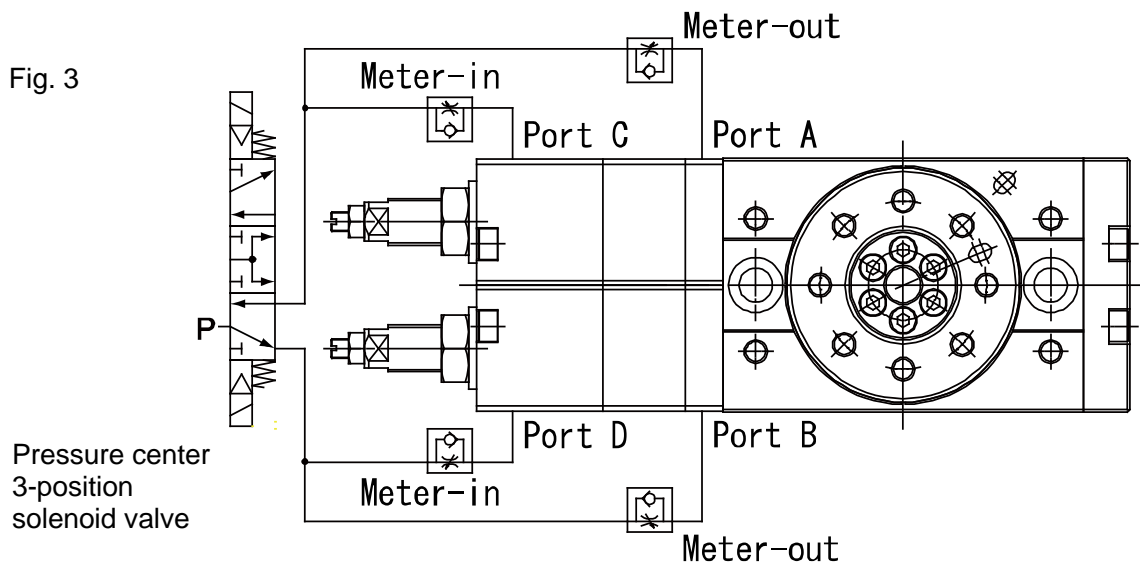
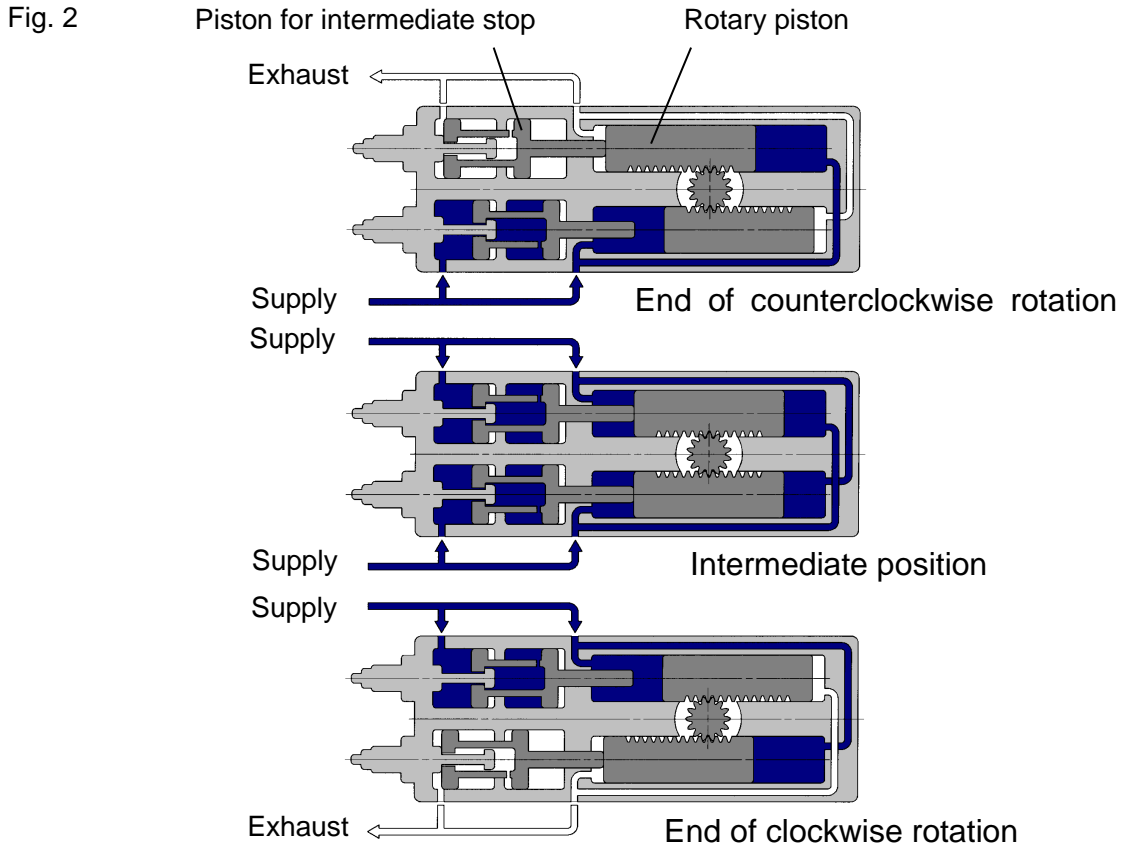
MSZ*10 to 50A



23	Bearing	1					
22	Wear ring	4					
21	Magnet	2					
20	Adjustment bolt(F)	2		43	Product label	1	
19	Adjustment bolt(R)	2		42	Parallel pin (B type)	1	
18	Sub-piston (F)	2		41	Round head Phillips screw No.0(type 1)	1	
17	Sub-piston (R)	2		40	Hexagon thin socket head bolt	4	Size 10 is a round head Phillips screw
16	Tube cover (B)	1		39	Hexagon socket head cap screw	6	
15	Tube cover (A)	1		38	Hexagon socket head cap screw	4	
14	Cylinder tube (B)	1		37	Hexagon socket head cap screw	4	
13	Cylinder tube (A)	1		36	Hexagon nut	2	
12	End cover (B)	1		35	Small hexagon nut	2	
11	End cover (A)	1		34	O-ring	2	
10	Bearing holder	1		33	O-ring	2	
9	Table	1		32	O-ring	2	
8	Gasket (for cover)	1		31	O-ring	2	
7	Push nut	2		30	Rod seal	2	
6	Pinion	1		29	Piston seal	4	
5	Piston	2		28	Piston seal	4	
4	Seal	1		27	Seal washer	2	
3	Plate	1		26	Bushing	2	
2	Cover	1		25	Bushing	2	
1	Body	1		24	Bearing	1	High precision type has angular contact bearing
No.	Description	Qty.	Remark	No.	Description	Qty.	Remark

Operating principle

A pressure center 3-position solenoid valve is used with the rotary table as shown in Fig. 3. Initially, the piston for the intermediate stop is at the end receiving pressure from the ports at one side. Then, the piston for the intermediate stop will move forward while it presses the rotary piston when pressure is supplied to the ports on both sides (Fig 2, top or bottom condition). This is because the pressure on the right and left is equalized and the thrust disappears. The rotary piston stops intermediately as the two pistons for the center intermediate stop reach the forward end and touch with the two rotary pistons. (Fig. 2, middle condition)



Mounting

Allowable load

Set the load and moment to be applied to the table within the allowable values shown in the table below. (Values exceeding the allowable range will cause excessive play, reduce accuracy, and shorten service life.)

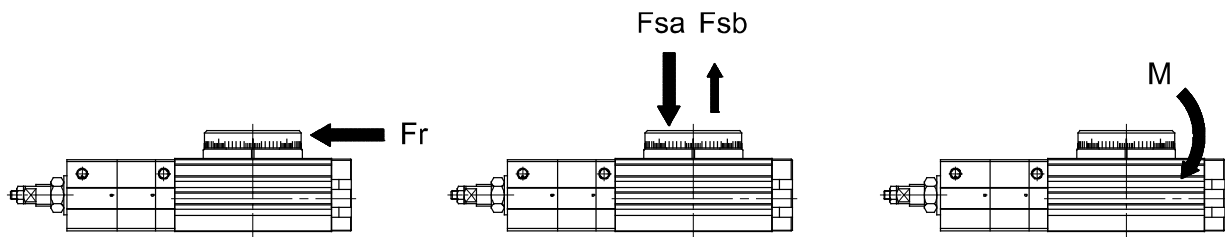


Fig. 4

Table 1

Basic type

Size	Load direction			
	Fr[N]	Fsa[N]	Fsb[N]	M[Nm]
10	78	78	74	2.4
20	147	137	137	4.0
30	196	363	197	5.3
50	314	451	296	9.7

High precision type

Size	Load direction			
	Fr[N]	Fsa[N]	Fsb[N]	M[Nm]
10	86	107	74	2.9
20	166	197	137	4.8
30	233	398	197	6.4
50	378	517	296	12.0

Flange application

The L dimension of the body is shown in Table 2.

If a hexagon socket head cap screw, complying with JIS standard, is used, the bolt head will fit within the counter bore.

Table 2 Mounting bolt dimension [mm]

Size	L	Applicable bolt
10	27	M6
20	28	M8
30	31	M8
50	35	M10

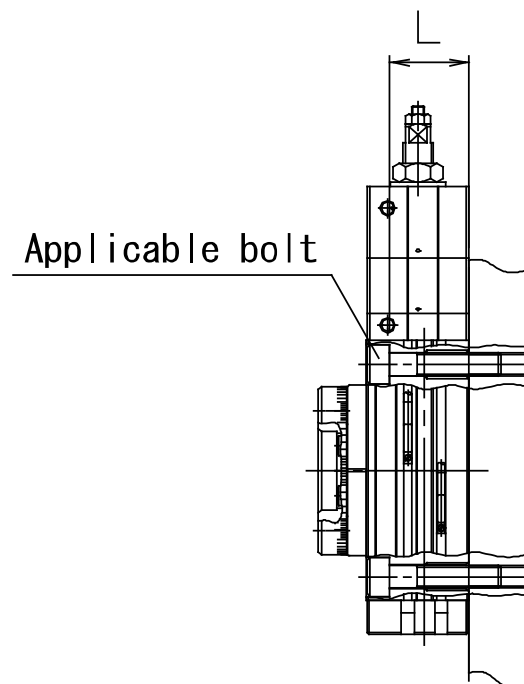


Fig. 5

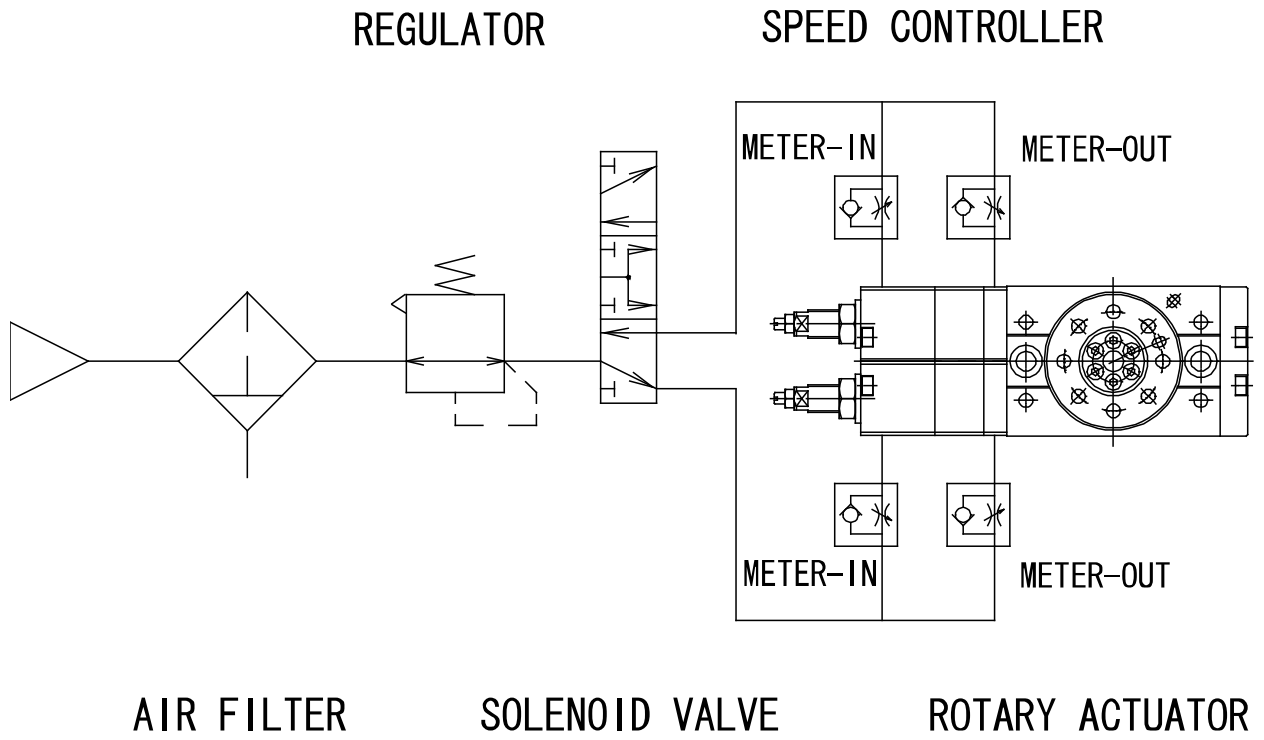


Fig. 6 Basic circuit

Position and size of piping ports

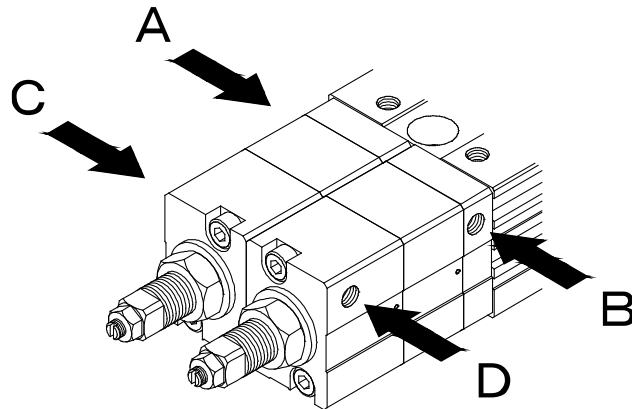


Fig. 7

Table 3 Port size

Size	Port size A, B, C, D
10	M5x0.8
20	
30	
50	

- The port of the rotary table has a restrictor. Do not enlarge this port because if it is enlarged, the rotating speed will increase. Also, it will increase the impact resulting in the possible damage to the product. Perform the following when piping.
 - a) The dust and chips located in the piping before a filter can be removed with the filter, but those after the filter cannot. They will enter the solenoid valve or rotary table which may result in malfunction and/or shorten the product life. Therefore, thoroughly blow the pipe before piping.
 - b) When attaching piping or fittings to the ports, ensure that chips from the pipe threads or sealing material do not enter the piping. When pipe tape is used, leave 1.5 to 2 threads exposed at the end of the pipe. (See Fig. 8)

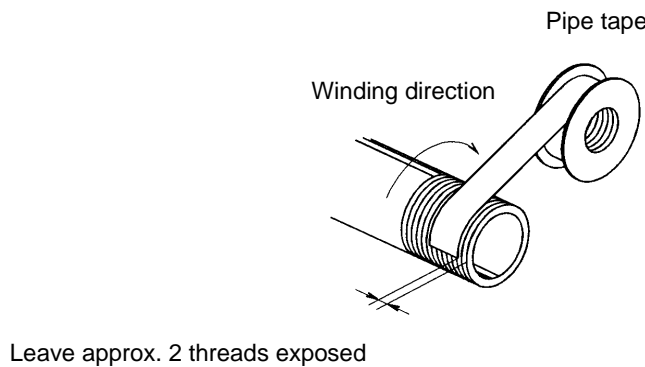


Fig. 8

Air supply

The air supplied to the rotary table should be filtered and cleaned.
This product should be used without lubrication.

Piping method

- Use one 3-position pressure center solenoid valve (Fig. 9) or two 3-port solenoid valves (Fig.10).
- Use meter-out speed controllers for port A and B, and meter-in for port C and D.
(Fig. 9 and 10 show port B and D pressurized.)

Fig. 9

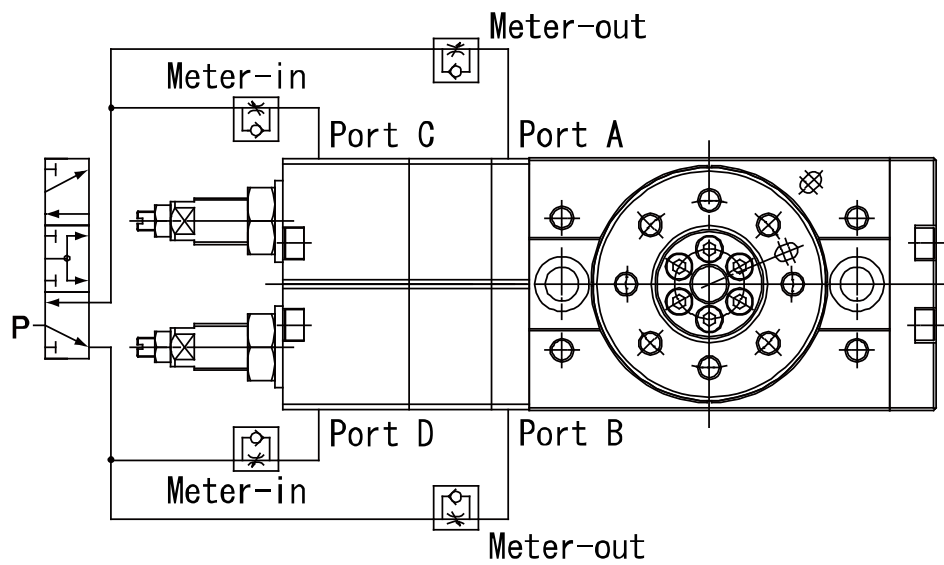
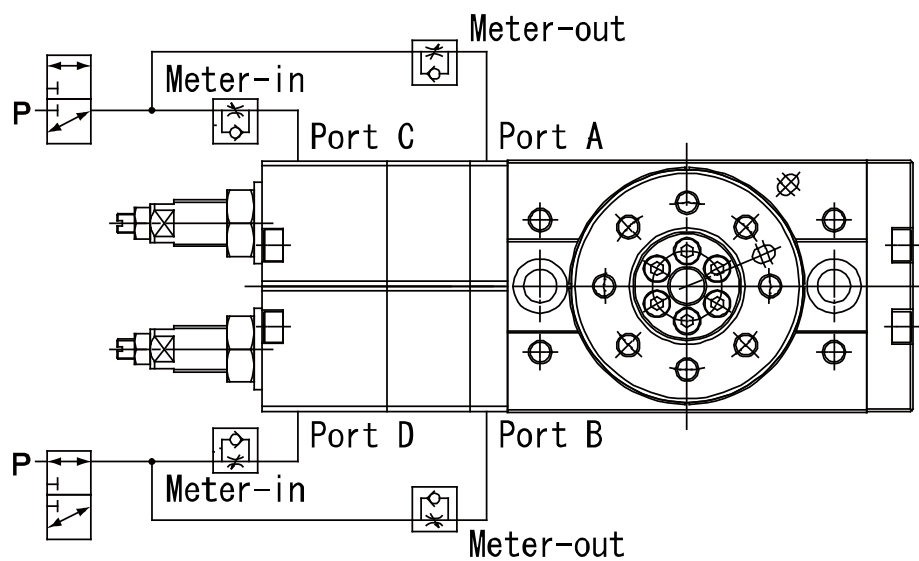


Fig.10



Setting and Adjustment

Operation and speed control

Fig.11 shows the operation of the rotary table, and Table 4 shows the pressure ports and speed controllers which adjust the speed at each operation.

Fig.11

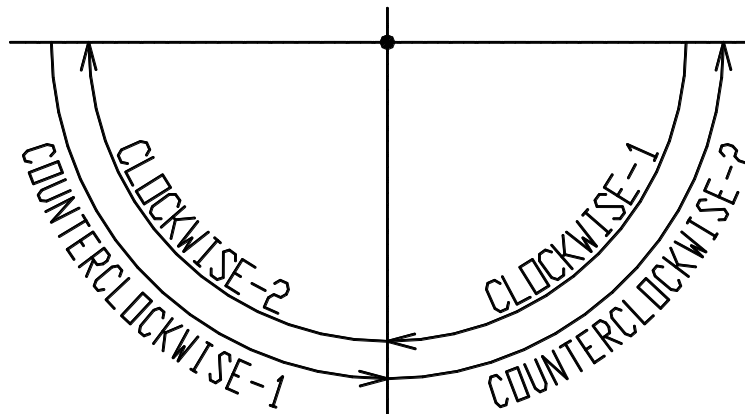


Table 4 Pressure ports and speed controller

Operation	Pressure port		Speed controller
	A, C	B, D	
Clockwise-1	●	●	Port C
Clockwise-2	●	—	Port B
Counterclockwise-1	●	●	Port D
Counterclockwise-2	—	●	Port A

Angle Adjustment

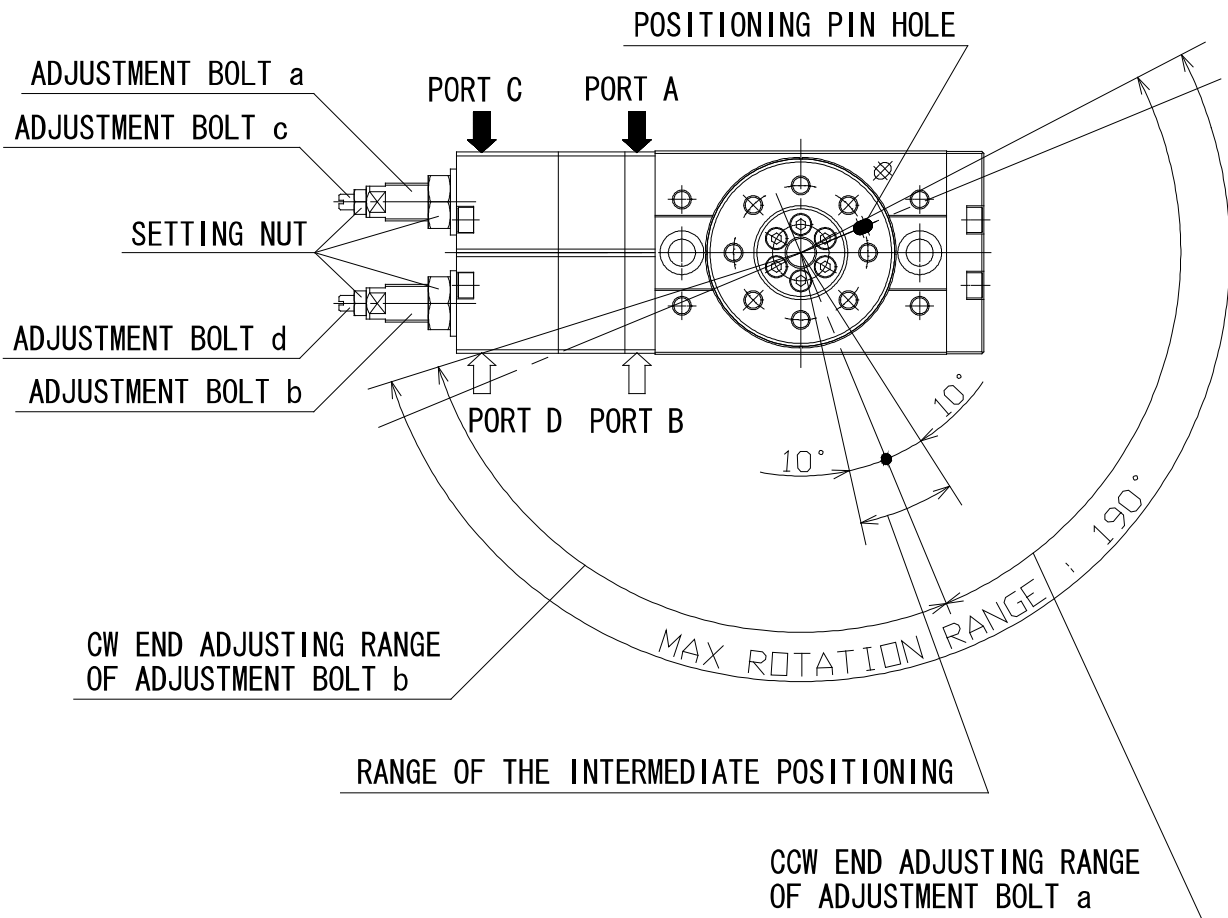
Rotating direction and angle

The adjuster bolts shown in Fig.12 are used to adjust the stopping positions of this product.

- Adjustment bolts a and b are for rotation end adjustment, and adjustment bolts C and d are for intermediate position adjustment.
- When ports A and C are pressurized, the table will rotate clockwise.

The adjustment bolt can be used to set the rotation end and intermediate position within the range shown in the figure.

Fig.12 Rotating direction and angle



Note)

- The figure shows the rotating range of the positioning pin hole.
- The pin hole position in the figure shows the counterclockwise rotation end when the adjustment bolts A and B are tightened equally and the rotation is adjusted 180°.

■ Angle adjustment

Angle adjustment can be performed by supplying air to the product. (A low pressure such as 0.2MPa is recommended.)

- (1) First, adjust the positions of both rotation ends.
 - Supply pressure to port A and C to adjust adjustment bolt b.
 - Supply pressure to port B and D to adjust adjustment bolt a.
 - After the adjustment, lock the setting nut. (Tightening torque : Table 7-1)
- (2) Finally, supply pressure to port A to D to adjust the intermediate position.
 - Loosen the setting nuts for adjustment bolt c and d.
 - Turn adjustment bolt c and d to the right until the adjustment bolts are hidden behind the setting nut. (The table can be rotated manually.)
 - Follow procedure R or L , whichever is applicable, in Table 5.

Table 5 Adjustment for intermediate position

	R: Clockwise adjustment	L: Counterclockwise adjustment
1	Rotate the table counterclockwise manually until resistance is increased.	Rotate the table clockwise manually until resistance is increased.
2	When adjustment bolt d is loosened, the table turns clockwise. Set it at the required position.	When adjustment bolt c is loosened, the table turns counterclockwise. Set it at the required position.
3	Loosen adjustment bolt c until the resistance is increased. (Check the table for rotation backlash.)	Loosen adjustment bolt d until the resistance is increased. (Check the table for rotation backlash.)
4	Turn adjustment bolts c and d to the right, at approx. 45°. *1	Turn adjustment bolts c and d to the right, at approx. 45°. *1
5	Lock adjustment bolts c and d with setting nuts. (Tightening torque : Table 7-2) *2	Lock adjustment bolts c and d with setting nuts. *2

*1 Since the position of the adjustment bolt will depend on the amount of screw gap, turn the bolts to the right by that amount (approx. 45°) in advance.

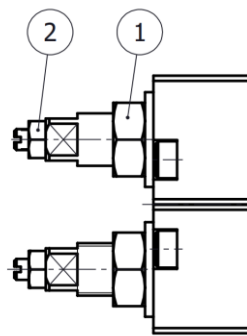
*2 If the table has rotation backlash after the nut is tightened, adjust it again.

Table 6 Adjusted angle per rotation of angle adjustment screw

Size	Adjustment bolt a and b (for the end position)	Adjustment bolt c and d (for intermediate position)
10	10.2°	5.1°
20	9.0°	3.6°
30	8.2°	3.3°
50	8.2°	4.1°

Table 7 Tightening torque for nuts (N·m)

Size	1	2
10	8.0	1.6
20	9.0	3.4
30	9.0	3.4
50	11.0	5.8



Note) The tightening torques in the table above are for reference only.

Fixing nuts may loosen depending on the operating environment and operating conditions.

Setting of rotation time

Even if the torque that is required by the load in the rotation movement is small, the internal parts could become damaged depending on the inertia of the load.

Therefore, select an appropriate model for your application by taking the load's moment of inertia, kinetic energy, and rotation time into consideration. (A chart that depicts the moments of inertia and the rotation time is provided to facilitate the selection process.)

Moment of inertia

Moment of inertia is the tendency of a still object to resist rotation, or, conversely, the tendency of a rotating object to resist stopping.

When the actuator moves an object (load), inertia (kinetic energy) is generated in the object.

The actuator stops at the rotation end, but due to inertia, a large shock (kinetic energy) is applied to the rotary table. The kinetic energy can be calculated using the formula below.

$$E = \frac{1}{2} \cdot I \cdot \omega^2$$

E: Kinetic energy [J]

I: Moment of inertia [kg·m²]

ω: Angular speed [rad/s]

There is a threshold of kinetic energy that a rotary actuator allows. Therefore, by finding the moment of inertia, it is possible to find the threshold value of the rotation time.

The basic formula for finding the moment of inertia is shown below.

$$I = m \cdot r^2$$

m: Weight [kg]

r : Center of gravity of load and distance of rotational axis [m]

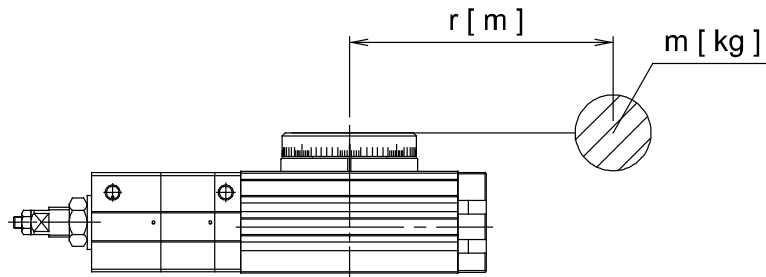
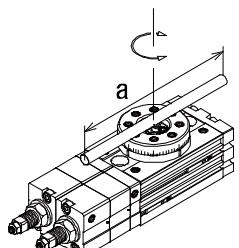
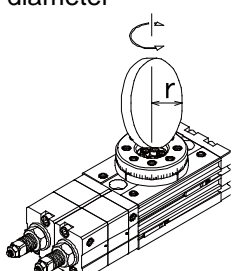
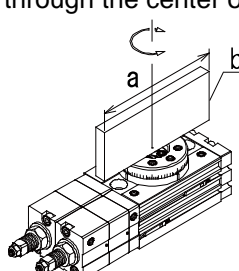
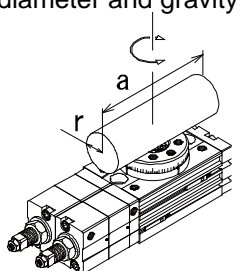
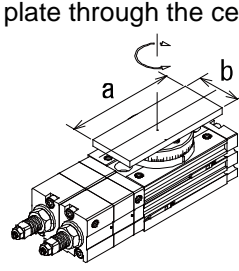
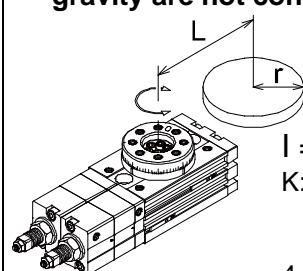
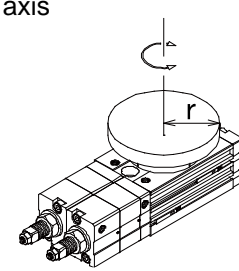
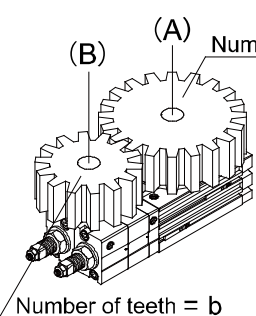
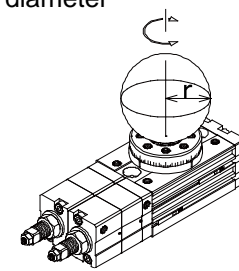


Fig.13

This represents the moment of inertia for a shaft with mass m, which is located at distance r from the shaft. The formula for finding the moment of inertia depends on the shape of the object. A table of formulae for calculating moment of inertia is shown on the following page.

Calculation formulae for moment of inertia

I: Moment of inertia [kg · m²] m: Load mass [kg]

<p>1. Thin shaft Position of rotational axis: Perpendicular to the shaft through the center of gravity</p>  $I = m \cdot \frac{a^2}{12}$	<p>6. Thin round plate Position of rotational axis: Through the center of diameter</p>  $I = m \cdot \frac{r^2}{4}$
<p>2. Thin rectangular plate Position of rotational axis: Parallel side b and through the center of gravity</p>  $I = m \cdot \frac{a^2}{12}$	<p>7. Cylinder Position of rotational axis: Through the center of diameter and gravity</p>  $I = m \cdot \frac{3r^2 + a^2}{12}$
<p>3. Thin rectangular plate (Including Rectangular parallelepiped) Position of rotational axis: Perpendicular to the plate through the center of gravity</p>  $I = m \cdot \frac{a^2 + b^2}{12}$	<p>8. When the rotational axis and load center of gravity are not consistent</p>  $I = K + m \cdot L^2$ <p>K: Moment of inertia around the load center of gravity</p> <p>4.Round plate $K = m \cdot \frac{r^2}{2}$</p>
<p>4. Round plate (Including column) Position of rotational axis: Through the center axis</p>  $I = m \cdot \frac{r^2}{2}$	<p>9. Gear transmission</p>  <ol style="list-style-type: none"> 1. Find the moment of inertia I_B for the rotation of shaft (B). 2. I_B is converted to the rotation of the shaft (A). $I_A = \left(\frac{a}{b}\right)^2 \cdot I_B$
<p>5. Solid sphere Position of rotational axis: Through the center of diameter</p>  $I = m \cdot \frac{2r^2}{5}$	

Kinetic energy

Table 8 shows the allowable kinetic energy of the rotary table.

Here, the angular speed ω can be found from the formula below.

$$\omega = \frac{2\theta}{t}$$

θ : Rotation angle [rad]

t : Rotation time [s]

The kinetic energy E can be found from the formula below.

$$E = \frac{1}{2} \times I \times \omega^2$$

Therefore, the rotation time of the rotary actuator is:

$$t \geq \sqrt{\frac{2 \times I \times \theta^2}{E}}$$

E : Allowable kinetic energy [J]
 θ : Rotation range [rad]
 I : Moment of inertia [kg · m²]

Table 8 Allowable kinetic energy

Size	Allowable kinetic energy J	
10	0.007	0.039
20	0.025	0.116
30	0.048	0.116
50	0.081	0.294

During uniform acceleration, the angular acceleration $\dot{\omega}$ after t seconds can be found as follows.

$$\omega = \dot{\omega} \cdot t \quad \dots (1)$$

$$\theta = \dot{\omega} dt = \frac{1}{2} \dot{\omega} t^2 + C \quad \dots (2)$$

When $t = 0$, rotation angle $\theta = 0$, so the integration constant is $C=0$.

$$\theta = \frac{1}{2} \dot{\omega} t^2 = \frac{1}{2} \omega t$$

thus,

$$\omega = \frac{2\theta}{t}$$

Applicable auto switches

The rotary table can have an auto switch to detect the table position.

■ Auto switch specification

Table 9. Reed auto switch

Auto switch model	Load voltage	Load current range and Maximum load current	Internal voltage drop	Indicator light	Applicable load
D-A90 D-A90V	24V AC or less DC	50mA	—	None	Relay PLC IC circuit
	48V AC or less DC	40mA			
	100V AC or less DC	20mA			
D-A93 D-A93V	24VDC	5 to 40mA	D-A93 2.4V or less (up to 20mA) 3V or less (up to 40mA) D-A93V 2.7V or less	Red LED illuminates when turned ON.	Relay PLC
	100VAC	5 to 20mA	2.7V or less		
D-A96 D-A96V	4 to 8VDC	20mA	0.8V or less	Red LED illuminates when turned ON.	IC circuit

- Lead wire — D-A90(V) and D-A93(V): Oil proof vinyl cabtire cord
Ø2.7 0.18mm²×2-core (brown, blue) 0.5m
D-A96(V): Oil proof vinyl cabtire cord
Ø2.7 0.15mm²×3-core (brown, black, blue) 0.5m
- Insulation resistance — 50 MΩ or more (500 VDC measured via megohmmeter)
(between lead wire and case)
- Withstand voltage— 1000 VAC for 1 minute (between lead wire and case)
- Operating time — 1.2ms
- Ambient temperature — -10 to 60°C
- Impact resistance — 300m/s²
- Leakage current — None
- Enclosure — IEC60529 Standard IP67

Table 10 Solid state auto switch specification (D-M9□)

Auto switch model	Output type	Power supply voltage	Current consumption	Load voltage	Load current	Internal voltage drop	Leakage current	Applicable load
D-M9N D-M9NV D-M9NW D-M9NWW	NPN	5·12· 24VDC (4.5 to 28V)	10mA or less	28VDC or less	40mA or less	At 10mA 0.8V or less At 40mA 2V or less	100μA or less at 24VDC	Relay PLC IC circuit
D-M9P D-M9PV D-M9PW D-M9PWW	PNP			—				
D-M9B D-M9BV D-M9BW D-M9BWW	—	—	—	24VDC (10 to 28VDC)	2.5 to 40mA	4V or less	0.8mA or less	24VDC Relay PLC

- Lead wire — D-M9B(V): Flexible vinyl sheath cable
2.7×3.2 ellipse 0.15mm²×2-core (brown, blue) 0.5m
D-M9N(V), D-M9P(V): Flexible vinyl sheath cable
2.7×3.2 ellipse 0.15mm²×3-core (brown, black, blue) 0.5m
- Insulation resistance — 50 MΩ or more (500 VDC measured via megohmmeter)
(between lead wire and case)
- Withstand voltage— 1000 VAC for 1 minute (between lead wire and case)
- Operating time — 1ms or less
- Ambient temperature — -10 to 60°C
- Impact resistance — 1000m/s²
- Enclosure — IEC60529 Standard IP67

Mounting of auto switch

Use a watchmaker's screwdriver of grip diameter 5 to 6mm to tighten the auto switch mounting screws to a tightening torque of D-M9*:0.05 to 0.15N·m, D-A9*:0.10 to 0.20 N·m. Use the designated slotted set screws.

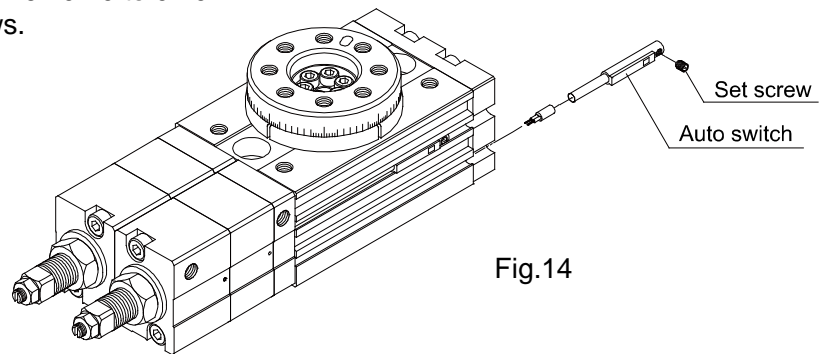


Fig.14

Operation range, hysteresis, and optimum sensing position of auto switch

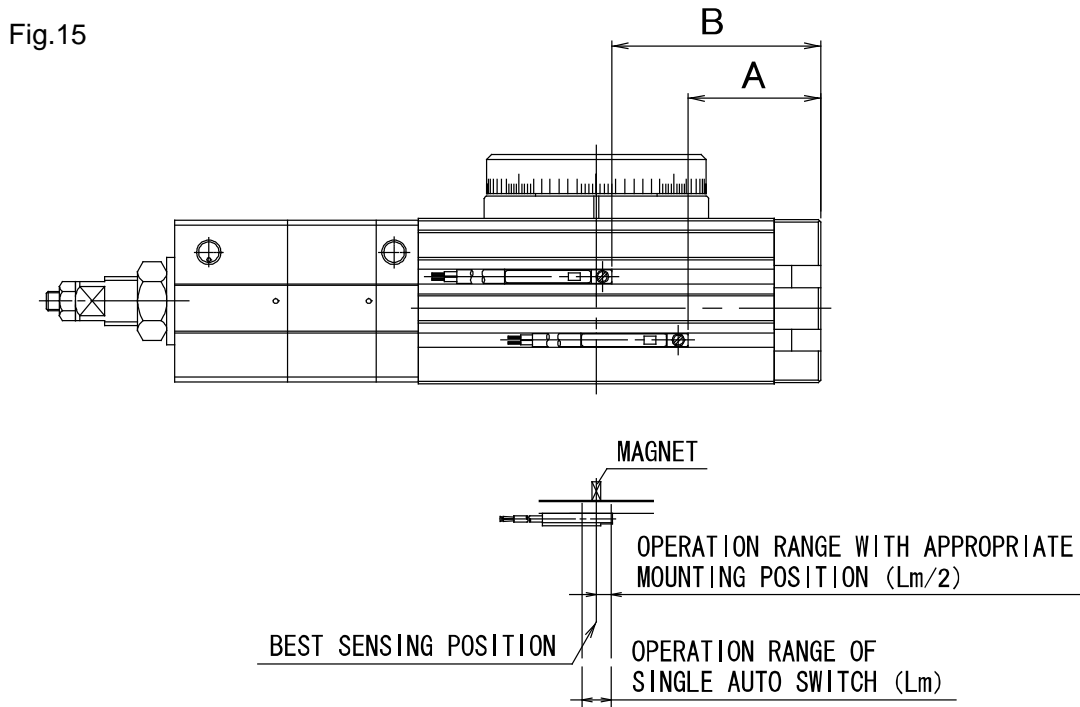


Fig.15

Table 11 Operation range, hysteresis, best sensing position of auto switch

Size	Rotation	Reed switch				Solid state switch			
		A	B	Operating range θ_m	Hysteresis range	A	B	Operating range θ_m	Hysteresis range
10	190°	27	45	53°	10° or less	31	49	37°	5° or less
20	190°	35	62	50°	10° or less	39	66	33°	5° or less
30	190°	39	68	43°	10° or less	43	72	29°	5° or less
50	190°	49	83	33°	10° or less	53	87	22°	5° or less

Operating range θ_m : The value given by converting the operating range of the single auto switch, L_m , to an angle

Hysteresis range : The value given by converting the auto switch's hysteresis to an angle

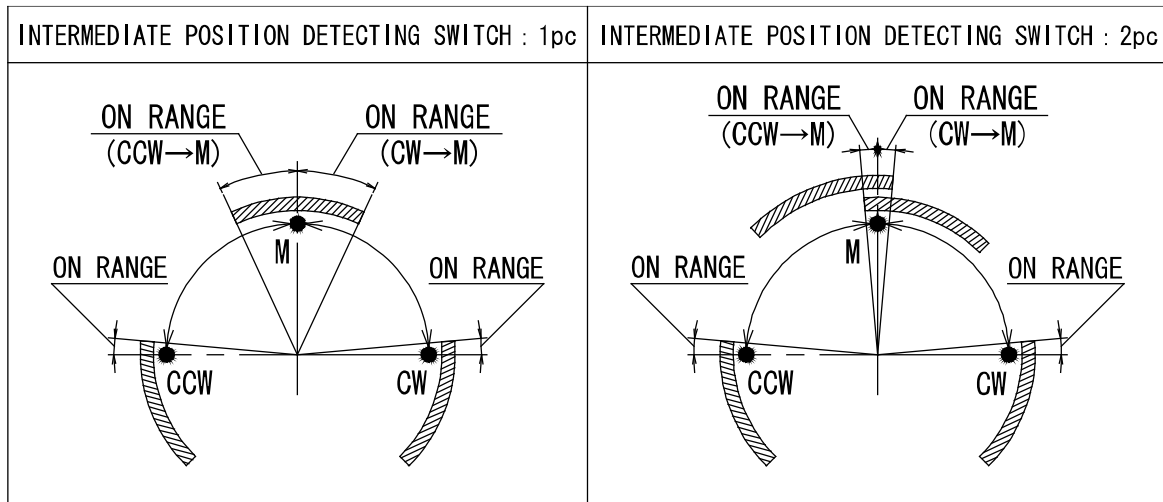
Note) The above values are only provided as a guideline, and they are not guaranteed.

In the actual setting, adjust them after confirming the auto switch operating condition.

Detection of Intermediate Position

The appropriate mounting position for detecting the intermediate position is in the middle of dimensions A and B.

However, the auto switch will turn on in the range of the actuating angle, θ_m , as shown in Table 10. Therefore, if one auto switch is used for detecting the intermediate position, the switch will turn on before the intermediate position, as shown in Figure 16 (left). For the auto switch to detect when the intermediate position is reached, use two switches as shown in Fig. 16 (right). One switch operates clockwise to the intermediate position, and the other one operates counterclockwise to the intermediate position.




 : SWITCH OPERATING RANGE
 CCW : END OF COUNTERCLOCKWISE ROTATION
 M : INTERMEDIATE POSITION
 CW : END OF CLOCKWISE ROTATION

Fig.16

Internal structure and operation principle

When switch A is turned on and pressure is supplied in the direction indicated by the arrows in Fig. 12, the piston moves and the table rotates clockwise.

At this point, magnet A goes out of switch A's operation range to turn off switch A. Then the piston moves further, and the magnet goes into switch B's operation range to turn on switch B.

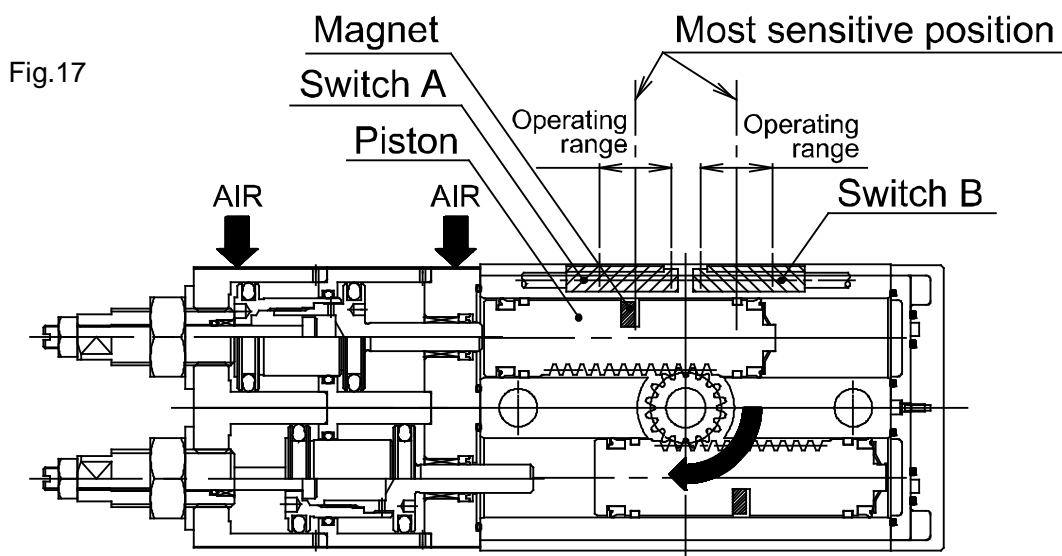


Fig.17

Specific product precautions

■ If not stopping at the intermediate position

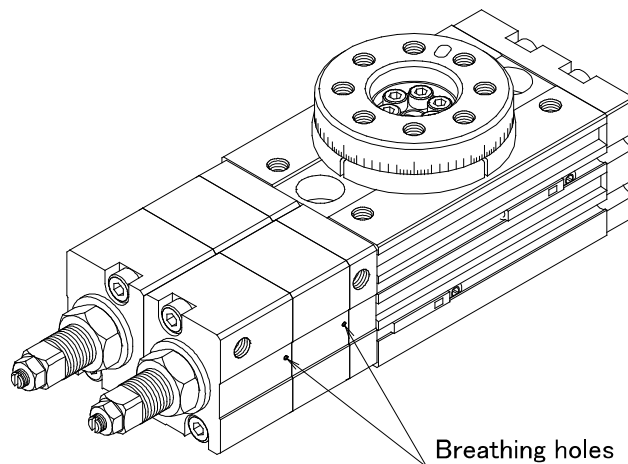
If the table operates from end to end without an intermediate stop, the table will slow down or stop for a moment around the intermediate position. This may last up to a maximum of 0.1s when the table rotates at high speed (0.2s/90°) or a maximum of 0.5s when the table rotates at low speed (1s/90°). Do not use the product in an application which is sensitive to a speed change between one end and the other end.

■ Mounting

• Breathing holes

The breathing holes located at the intermediate stopping part are for repeated breathing by the piston during operation. Be careful not to block the breathing ports during mounting work.

Fig.18



■ Mounting direction

Although the mounting direction can be freely set, the rotating speed will be unstable if the gravity acting on the workpiece acts on the direction of the table rotation (such as when the rotating axis is horizontal and the gravity of the load and the rotating center do not align.)

This occurs especially when the speed from the end, to the intermediate position is controlled by meter-in control. Therefore, if the moving direction meets with the gravity acting direction, the acceleration due to gravity cannot be controlled. This may cause a bounce when the movement is stopped.

■ Table backlash at intermediate position

Backlash of the table in the rotating direction can be avoided by correctly adjusting the intermediate position. However, a backlash (about 0.1°) may occur as the number of cycles increases. In this case, adjust the intermediate position again.

■ Operation when power is cut

When a 3-position solenoid valve with pressure center (PAB) is used, the solenoid valve and the table of this product return to the intermediate position if the power supply for the product is cut. If the returned position needs to be at either the clockwise or counterclockwise rotation end when the power is cut, the circuit should have two 3-port solenoid valves. The type of solenoid valve depends on the return position. See Table 12 for the type of solenoid valve.

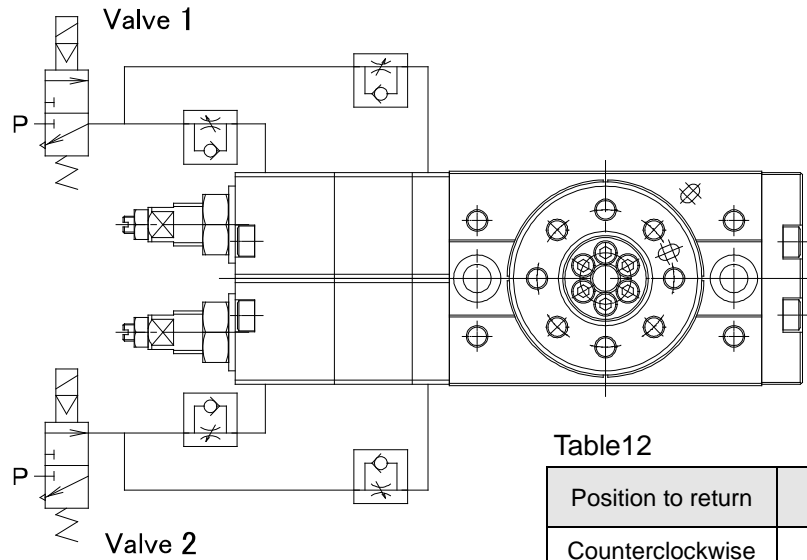


Fig.19

Table12

Position to return	Valve 1	Valve 2
Counterclockwise end	N.C.	N.O.
Clockwise end	N.O.	N.C.

If the stopped position needs to be held when the power is cut, the circuit should have two 5-port double-solenoid valves. (The unused A port or B port should be plugged.)

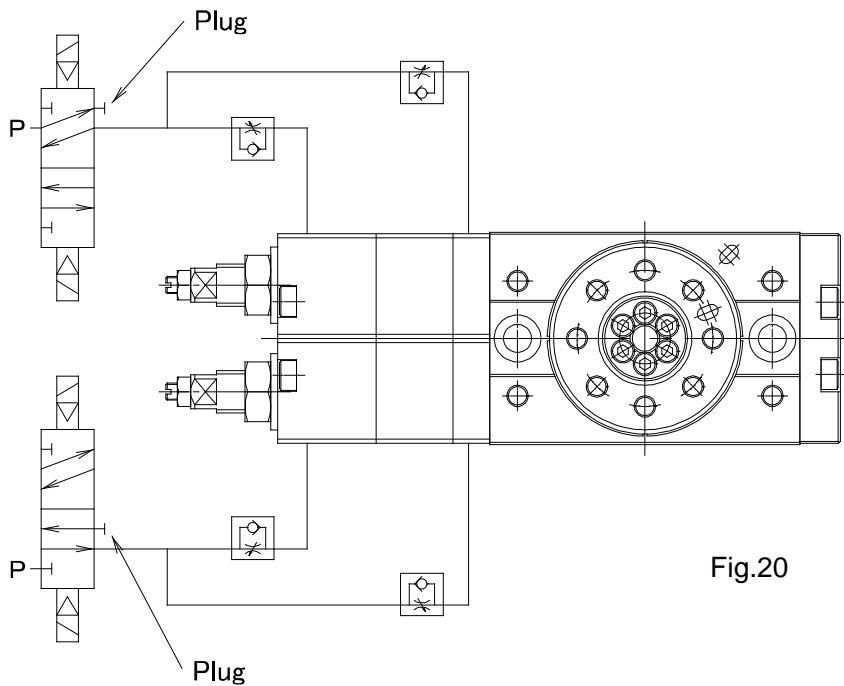


Fig.20

Maintenance and Inspection

In order to use the rotary table in an optimal condition, it is necessary to perform maintenance regularly depending on the operating conditions. It is preferable to perform maintenance of the rotary table once a year in general. Even if no problem is found, seal parts replacement is recommended every three years.

■ Regular inspection

■ Inspected points

The regular inspection should be performed on the following items.

- (1) Looseness of the bolt used for fixing the rotary table
- (2) Looseness at the frame for fixing rotary table
- (3) Smooth operation
- (4) External air leakage

If any items are found by the inspection that require repairing, tighten any loose parts.

<Caution> This product cannot be disassembled since a special tool is needed for disassembly.
If it needs repair or seal replacement, contact SMC.

■ Inspection frequency

To use the Series MSZ rotary table in the best condition, inspection needs to be performed once or twice a year.

Troubleshooting

Problem	Possible cause	Solution
Rotary table does not move	Supply pressure is not applied correctly.	Correctly set the regulator at the supply pressure side.
	The directional switching valve (such as a solenoid valve) does not switch.	Correctly apply a signal to the directional switching valve (such as a solenoid valve).
	Air leakage from piping	Inspect the piping and stop the leakage.
	The restrictor in the port is clogged.	Clean the restrictor. Take the following countermeasures: (1) Blow air through the piping again. (2) Inspect the air filter.
Operation is not smooth. (stick-slip)	The load has some friction.	Reduce the friction resistance.
	The rotation table and the item used with it are not aligned.	Align the two centers or use a flexible fitting.
	Insufficient output due to a low supply pressure	To obtain stable operation, adjust the supply pressure to make the load ratio appropriate.
	Speed controller is restricted too much.	Adjust the speed controller so that the rotating marks will be in the adjusting range.
Extreme rotating angle changes.	Internal parts are broken.	Replace with a new rotary table. Then calculate the kinetic energy applied to the rotary table, and adjust the load and rotating speed so that the kinetic energy will be within the allowable range.
Air leakage from the table	Piston seal is worn out.	The seal parts need to be replaced. Contact SMC.

Problem	Possible cause	Solution
The pinion gear is broken.	Excessive kinetic energy was applied to the rotary table.	Replace with a new rotary table. Then calculate the kinetic energy applied to the rotary table, and adjust the load and rotating speed so that the kinetic energy will be within the allowable range.
	Excessive external torque was applied to the rotary table.	Replace with a new rotary table. Then take countermeasures to prevent excessive external torque from being applied.
Insufficient rotating angle.	The adjustment bolt for angle adjustment is set at a smaller angle than required.	Set the adjustment bolt correctly.
The auto switch will not operate or operates incorrectly.	The auto switch is mounted in an inappropriate position.	Mount the auto switch in the correct position.
	Effect of an external magnetic field	Check that there is no strong magnetic field present.
	Trouble with the electrical circuit	Check that there is no trouble with the electrical circuit.
	Trouble with the electrical specification	Check there is no trouble with the electrical specification.

Revision history

- A: Complete revision due to product review.
- B: Revised safety instructions.
- C: Add tightening torque for nuts. (P29)

SMC Corporation

Tel: + 81 3 5207 8249 Fax: +81 3 5298 5362

URL <https://www.smcworld.com>

Note: Specifications are subject to change without prior notice and any obligation on the part of the manufacturer.
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