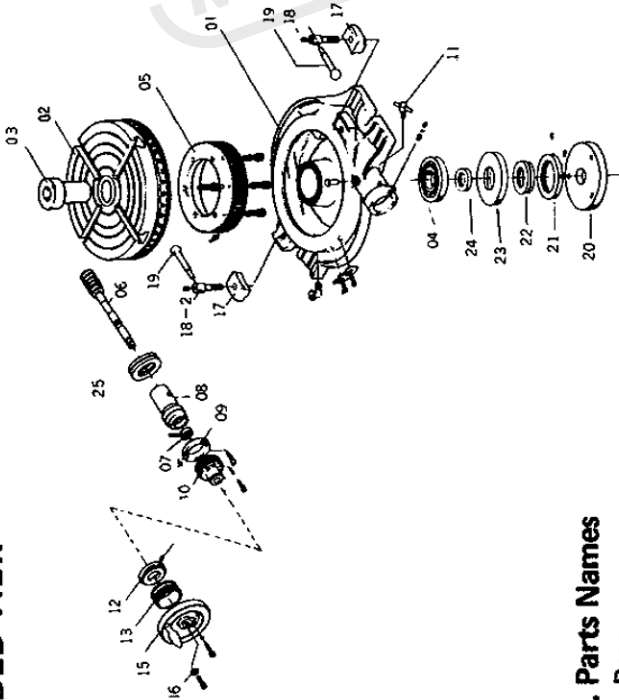


RT

Horizontal Rotary Table

EXPLODED VIEW



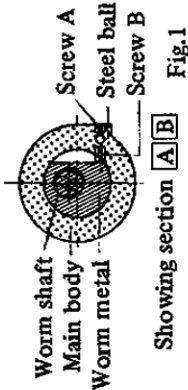
Part No. Parts Names

- RT-01 Base
- RT-02 Table
- RT-08 Worm metal
- RT-11 Metal setting screw
- RT-17 Clamp piece
- RT-18 Clamp bolt
- RT-19 Clamp handle

Operating Instruction and Function of Each Unit

1. Turn the handle clockwise at all times. When this handle has been turned until it passes the desired position, turn back it once counterclockwise to a great extent and then softly rotate it clockwise so as not to cause the backlash of the gear.
2. When turning the right and left table stoppers 19 inwards concurrently, they are pushed down because the projected part of the stopper Piece 17 is fitted into the slot section on the center of the side of the table, thus clamping the table. The bolt 18-2 is a left-handed screw and the bolt 18 is a right-handed one.

3. The center hole has a Morse tapered sleeve, so that jigs and measuring apparatus can be fitted with precision.
4. The worm gear ratio is 1:90. As a result, 90 turns of the handle lead to one turn of the table, and the table moves 4 ($360^\circ \div 90 = 4^\circ$) for one turn of the handle.
5. Dividing of 2 to 100 can be carried out quickly and accurately by attaching a Dividing Mechanism (See Page 5).
6. Loosen the metal clamp handle 11 and rotate the switch metal 10 until it touches the stopper. The worm gear and wheel have now been disengaged, thus enabling to turn the table manually.



1. **Adjusting Mesh of Worm Gear:** Loosen the metal clamp handle and turn the switch metal clockwise until it touches the stopper. The worm gear has now been disengaged. Turn it counterclockwise until it touches the stopper, the worm and gear wheel will engage. Tighten the metal clamp handle after engagement. An additional adjustment can be obtained by removing the screw A and steel ball and turning the inner screw B counterclockwise, so bringing the worm in closer engagement with the gear wheel. Turning clockwise brings the worm away from the wheel. After adjustment insert the steel ball and tighten the screw A.
2. **Axial Adjustment of Worm Shaft:** When axial slack occurs gear adjustment is carried out by tightening the inside worm shaft nut after the handle, vernier ring and switch metal have been removed. After adjustment, lock the nut on the shaft by means of the set screw. (The RT-150 has an adjusting nut, which can be used after removal of the handle.)

HV Horizontal and Vertical Rotary Table
EXPLODED VIEW

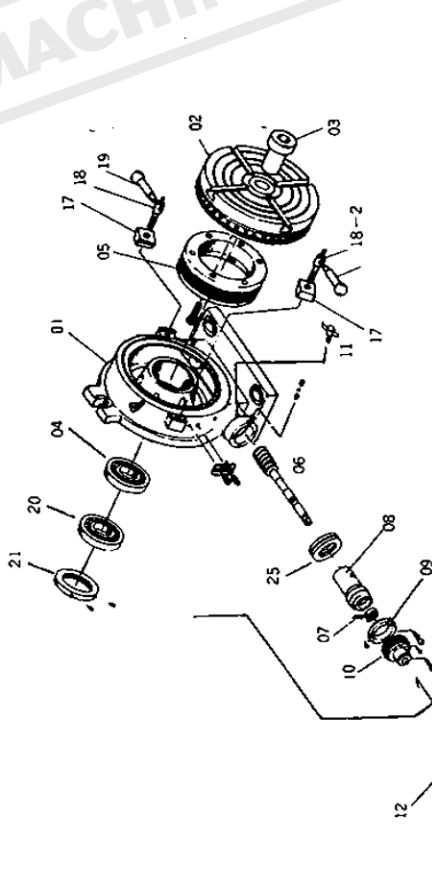
- 2. Dividing of 2 to 100 can be carried out quickly and accurately by attaching a Dividing Mechanism.
- 3. Center work can also be carried out by using the base in the vertical position in conjunction with a tailstock. (See Page 4.)
- 4. The worm gear engagement is adjusted by the switch metal in the same manner as that of (RT). (See Page 2.)

*** Suggestions for Order**

The parts names expressed in the operation and service manual are abbreviated for description.

Therefore, when ordering parts for replacement, be sure to specify article marks, article Nos. and component Nos., which are shown in the table of Order No. & Dimensions.

RT	-	200	-	19
Article Mark		Article No.		Component No.



Parts No.	Parts Names	HV -12	HV -13	HV -17	HV -18	HV -19
HV -01	Main body	Vernier ring	Micro-collar	Clamp piece	Clamp bolt	Clamp handle
HV -02	Table					
HV -05	Worm wheel					
HV -08	Worm metal					
HV -11	Metal setting screw					

Operating Instruction and Function of Each Unit

- 1. The worm gear ratio is 1 : 90.
 - One turn of the handle moves the table by 4°
 - Micro-collar is graduated in steps of 1min.
 - Vernier scale makes settings down to 10 seconds possible. (20 seconds for HV-150)