



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 relating to systems.

ISO 4413: Hydraulic fluid power -- General rules relating to systems.

IEC 60204-1: Safety of machinery -- Electrical equipment of machines .(Part 1: General requirements)

ISO 10218-1992: Manipulating industrial robots -Safety.

etc.



Caution

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



Warning

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



Danger

Danger indicates a hazard with a high level of risk which, if not avoided, will result in death or serious 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. Contact SMC beforehand and take special consideration of safety measures if the product is to be used in any of the following conditions.

1. Conditions and environments outside of the given specifications, or use outdoors or in a place exposed to direct sunlight.

2. Installation on equipment in conjunction with atomic energy, railways, air navigation, space, shipping, vehicles, military, medical treatment, combustion and recreation, or equipment in contact with food and beverages, emergency stop circuits, clutch and brake circuits in press applications, safety equipment or other applications unsuitable for the standard specifications described in the product catalog.

3. An application which could have negative effects on people, property, or animals requiring special safety analysis.

4. Use in an interlock circuit, which requires the provision of double interlock for possible failure by using a mechanical protective function, and periodical checks to confirm proper operation.



Safety Instructions

Caution

1. The product is provided for use in manufacturing industries.

The product herein described is basically provided for peaceful use in manufacturing industries.

If considering using the product in other industries, consult SMC beforehand and exchange specifications or a contract if necessary.

If anything is unclear, contact your nearest sales branch.

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.

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.

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.

Design / Selection

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.)

Please contact SMC when using a fluid other than compressed air.

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.**

Failure to provide such measures could accelerate the movement, which may be hazardous to humans, machinery, and other equipment.

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 **Make sure that the secured portions will not loosen.**

Be sure 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 power source related malfunctions that could occur.**

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

⑦ **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.

⑧ **Consider the behavior of the rotary actuator 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.

⑨ **Consider the action of the rotary actuator 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 actuator has to be reset to the starting position.

⑩ **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.

⑪ **Select a speed within the product's allowable energy value.**

If the 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.

- ⑫ 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.

- ⑬ Do not stop or hold the product at midpoint by keeping air pressure in the product.**

For a product without an external stopping mechanism, if a 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.

- ⑭ Do not use two or more rotary tables with the aim of synchronized movement.**

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

- ⑮ Do not use in a location where external leakage of lubricant could have an adverse effect.**

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.

- ⑯ Do not disassemble the product or make any modifications, including additional machining.**

This may cause human injury and/or an accident.

- ⑰ Refer to the Auto Switches Precautions when using with an auto switch.**

Caution

- ① Do not use below the 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 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**

With a double piston product, if the internal piston is stopped by coming into contact with the angle adjustment screw or the cover, 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 the product under hydraulic pressure.**

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

- ⑥ Do not use in a location where there are many temperature fluctuations.**

When using in lower temperature applications, take care not to allow frost inside the cylinder.

Operation may be unstable.

- ⑦ Perform speed adjustment in the environment in which the product is to be used.**

Speed adjustments may be necessary if the environmental conditions vary.

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 actuator 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 to be 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 a load that exceeds the values given in the catalog.

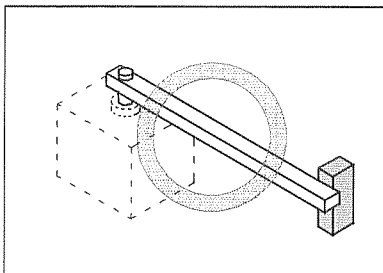
If a load that exceeds the allowable values is applied to the product, it could lead to equipment malfunction, a hazard to humans, and damage to the machinery and equipment.

⑪ Place an external stopper in a position away from the rotating shaft.

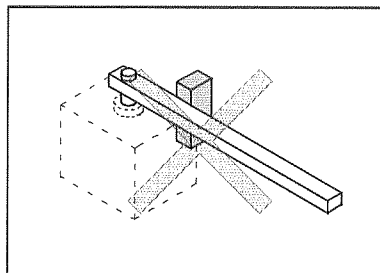
If the stopper is placed near the rotating shaft, the torque that is generated by the product itself will cause the reaction force which is directed to the stopper to be redirected and applied to the rotating shaft. This will lead to the breakage of the rotating shaft and bearing. As a result, it could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

Precautions when Using External Stoppers

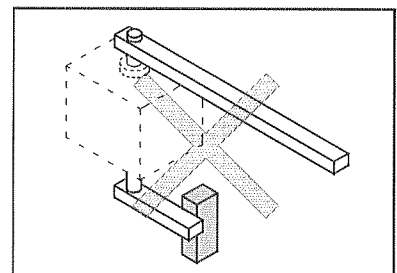
- Be sure to install external stoppers in the proper rotation end places. Installation in the wrong place can result in equipment breakage, which could damage other equipment or cause human injury.



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

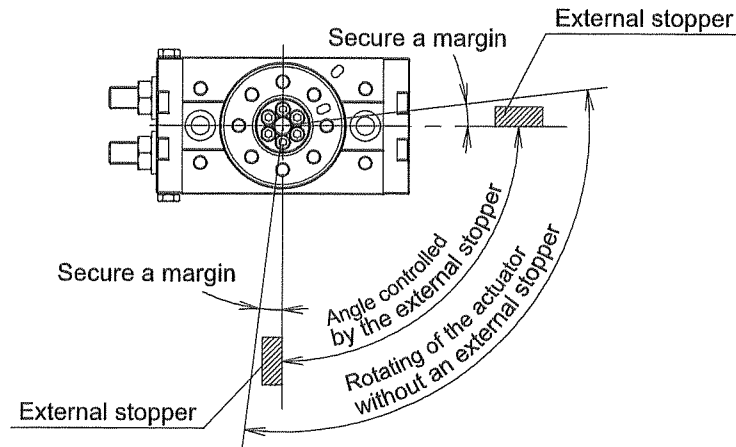


The external stopper becomes a fulcrum, resulting in the load's inertia force being applied to the table as a being moment.



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.

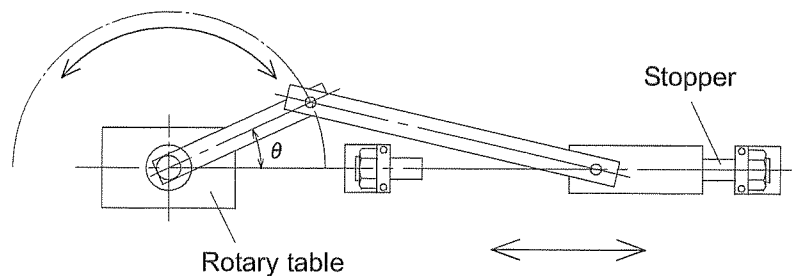
- Install external stoppers within the range of the rotating angle.
Installing an external stopper at the maximum rotation angle may result in an inability to fully absorb the kinetic energy generated, and damage to equipment may occur.



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.



⑫ 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.

⚠ Caution

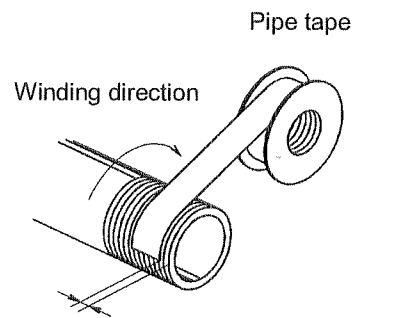
- ① **Do not use organic solvent to wipe the area of the name plate that shows the model.**
It will erase what is indicated on the name plate.
- ② **Do not hit the rotating table by securing the body or hit the body by securing the rotating table.**
These actions could cause the table to bend or damage the bearing. When a load must be coupled to the rotating table, secure the rotating table.
- ③ **Do not step directly onto the table or on the equipment that is coupled to the table.**
Standing directly on the rotating table could cause the rotating table or the bearing to become damaged.
- ④ **If a product is equipped with an angle adjustment function, use it within the specified adjustment range.**

If the product is used outside the specified adjustment range, it could lead to equipment malfunction or product damage. Refer to the product specifications for details on the adjustment range of the products.

Piping

Caution

- ① **Refer to the Fittings and Tubing Precautions (Best Pneumatics No.6) for handling one touch fittings.**
- ② **Preparation before piping**
Before piping is connected, it should be thoroughly blown out with air (flushing) or washed to remove chips, cutting oil and other debris from inside the pipe.
- ③ **Wrapping of pipe tape**
When screwing piping or fittings into ports, ensure that chips from the pipe threads or sealing material do not enter the piping. Also, if pipe tape is used, leave 1.5 to 2 thread ridges exposed at the end of the threads.



Leave approx. 2 threads exposed

Speed and Cushion Adjustment

Warning

- ① **To make a speed adjustment, gradually adjust starting from the low speed end.**
If the speed adjustment is performed from the high speed end, it could damage the product.
As a result, it could pose a hazard to humans and damage the machinery and equipment.

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**

Please consult with SMC when using the product in applications other than 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 extremely dry 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 consult with SMC.**

② **Install an air filter.**

Install an air filter upstream near the valve. Select an air filter with a filtration size of 5 μ m 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 containing corrosive gases, chemicals, sea water, water, steam, or where there is direct contact with any of these.**

Refer to the construction diagram for information on the materials used in the rotary table.

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 moisture 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 work pieces 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.

Auto Switches Precautions

Design / Selection

Warning

① **Confirm the specifications.**

Read the specifications carefully and use this product appropriately. The product may be damaged or malfunction if it is used outside the range of specifications of current load, voltage, temperature or impact.

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 make any modifications (including exchanging the printed circuit boards) to the product.**

This may cause human injuries and accidents.

Caution

① **Pay attention to the length of time when 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 **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 30m long, it is not able to adequately absorb the rush current and its life may be reduced.

It is again necessary to connect a contact protection box in order to extend its life. Please consult SMC in this case.

<Solid state>

3) Although wire length should not affect switch function, use a wire 100m or shorter.

Even if the length is less than 100m, longer wiring makes it more likely to be affected by noise.

When the wire length is long, we recommended a ferrite core should be attached to 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 the product construction.

③ **Do not use a load that generates surge voltage. If a surge voltage is generated, discharge may be generated at the contact, possibly reducing the product life.**

If driving a load such as a relay that generates a surge voltage.

<Reed>

Use an auto switch with built-in contact protection circuit or use a contact protection box.

<Solid state>

Use a built-in surge absorbing element type device.

④ **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 separation of 40mm between rotary tables. The auto switches may malfunction due to the interference from the magnetic fields.

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

⑤ **Pay attention to the internal voltage drop of the auto switch.**

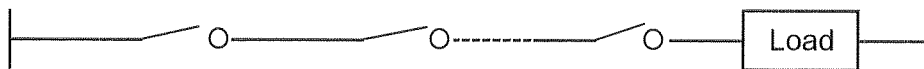
<Reed>

1) Auto switch with an indicator light

- If auto switches are connected in series as shown below, note that there will be a large voltage drop because of internal resistance in the LED. (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 an LED causes a problem, select an auto switch without an indicator light.

<Solid state / 2-wire type>

3) Generally, the internal voltage drop will be greater with a 2-wire solid state auto switch than with a reed auto switch. Take the same precautions as in 1).

Also, take note that a 12VDC relay is not applicable.

⑥ **Pay attention to leakage current.**

<Solid state / 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.

⑦ **Ensure sufficient clearance for maintenance activities.**

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

⑧ **Use the rotary table and auto switch in proper combination.**

The auto switch is pre-adjusted to operate properly for an auto-switch-capable SMC rotary table.

If the auto switch is mounted improperly, used for another brand of rotary table or used after changing the machine installation, the auto switch may not operate properly.

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.**

Never carry a rotary table by its lead wires. This may not only cause broken lead wires, but it may cause internal elements of the auto switch to be damaged by the stress.

④ **Fix the auto switch using the appropriate screws on the switch body. If other screws are used, the auto switch may be damaged.**

Wiring

Warning

① **Confirm proper insulation of wiring.**

Be certain that there is no faulty wiring insulation (contact with other circuits, ground fault, improper insulation between terminals, etc.). Damage may occur due to excess current flow into the auto switch.

② **Do not wire with power lines or high voltage lines.**

Wire separately from power lines or high voltage lines, avoiding parallel wiring or wiring in the same conduit with these lines. Control circuits containing auto switches may malfunction due to noise from these other lines.

③ **Avoid repeatedly bending or stretching lead wires.**

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

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

Fix the cable in the middle so that it is not movable in the area where it connects with the auto switch.

④ **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.

⑤ 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 prevention circuits.

If a load is short circuited, the auto switch will be instantly damaged as in the case of reed auto switches.

Take special care to avoid reverse wiring with the brown power supply line and the black output line on 3-wire type auto switches.

⑥ 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, the auto switch will operate, however, the LED will not light up.

Also, take note that a current greater than that specified will damage the LED and it will no longer operate.

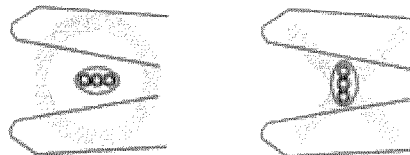
Applicable models : D-93, A93V

<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.

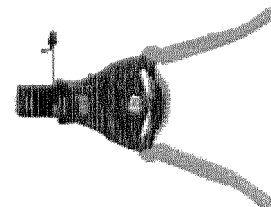
⑦ When the cable sheath is stripped, confirm the stripping direction. The insulator may be split or damaged depending on the direction. (D-M9□ only)



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.**

Auto switches are not designed with explosion-proof construction. Never use in an atmosphere containing explosive gas since this may cause a serious explosion.
Please contact SMC concerning ATEX compliant products.

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. (Please consult with SMC if a magnetic field resistant auto switch can be used.)

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 (JIS C 0920: watertight construction), do not use auto switches in applications where continually exposed to water splash or spray. Poor insulation or swelling of the potting resin inside auto switches may cause malfunction.

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

Please consult with SMC if auto switches will be used in an environment with coolant, cleaning solvent, various oils or chemicals. If auto switches are used under these conditions for even a short time, they may be adversely affected by 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.**

Please consult with SMC if switches are used where there are temperature cycles other than normal temperature changes, as there may be adverse affects inside 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). Please consult with SMC if a solid state auto switch can be used according to the environment.

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

<Solid state>

When there are units (solenoid lifter, high frequency induction furnace, motor, radio equipment etc.) which generate a large amount of surge in the area around the rotary table with solid state auto switches, this may cause deterioration or damage to the auto switch's internal circuit elements. Avoid sources of surge generation and crossed lines.

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

When a large amount of iron debris such as machining chips or spatter is accumulated, or a magnetic substance (something attracted by a magnet) is brought into close proximity with a rotary table with auto switches, or a rotary actuator, it may cause the auto switch to malfunction due to a loss of the magnetic force inside the rotary table.

⑧ **Please contact SMC concerning water resistance, elasticity of lead wires, usage at welding sites, etc.**

⑨ **Do not use in direct sunlight.**

⑩ **Do not mount the product in locations where it is exposed to radiant heat.**

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 actuators from moving suddenly.

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.

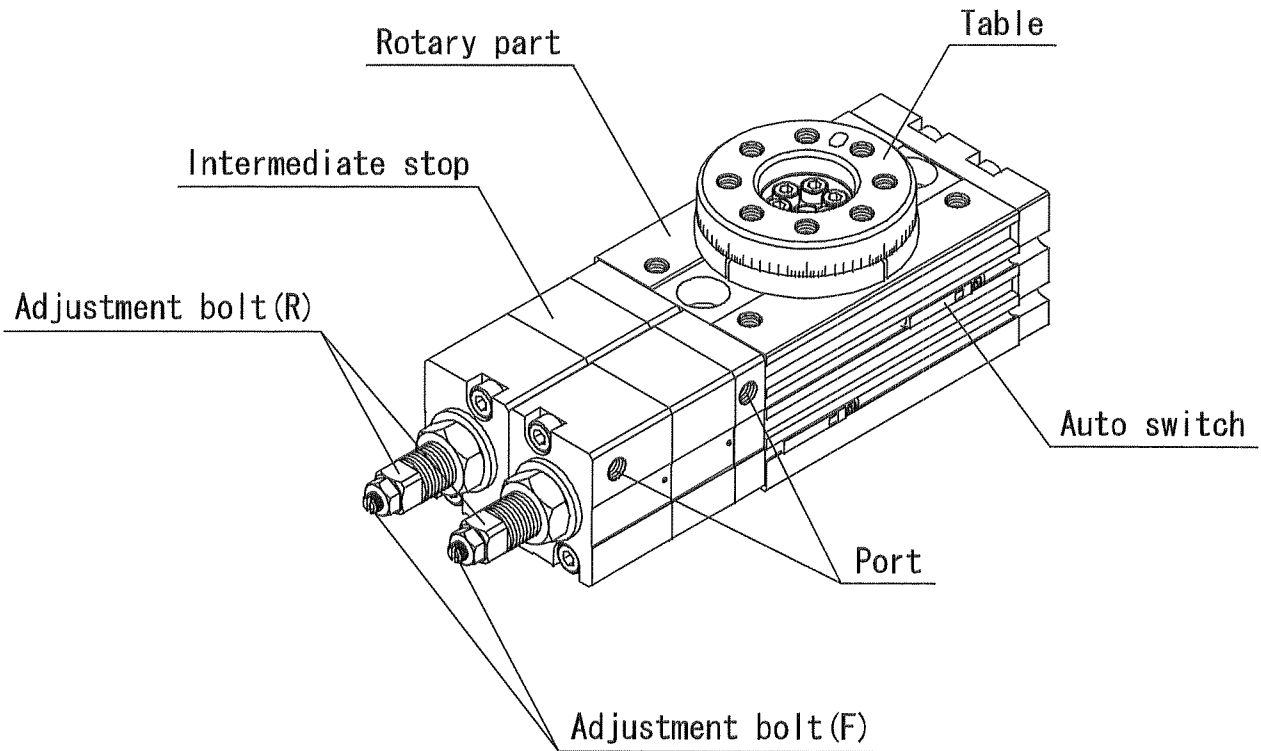
3) Confirm the lighting of the green light on the 2-color indicator type auto switch.

Confirm that the green LED is on when stopped at the established position. If the red LED is on, the mounting position is not appropriate. Readjust the mounting position until the green LED lights up.

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.

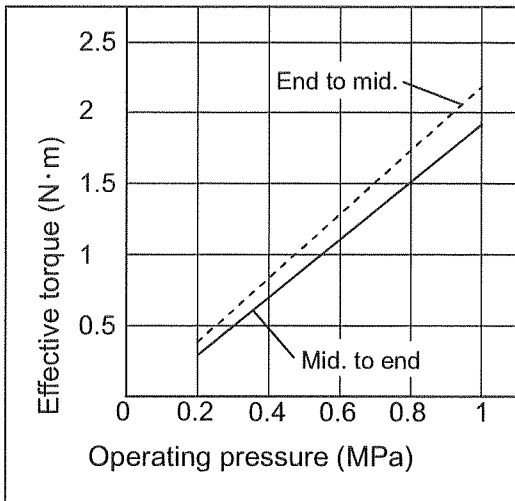
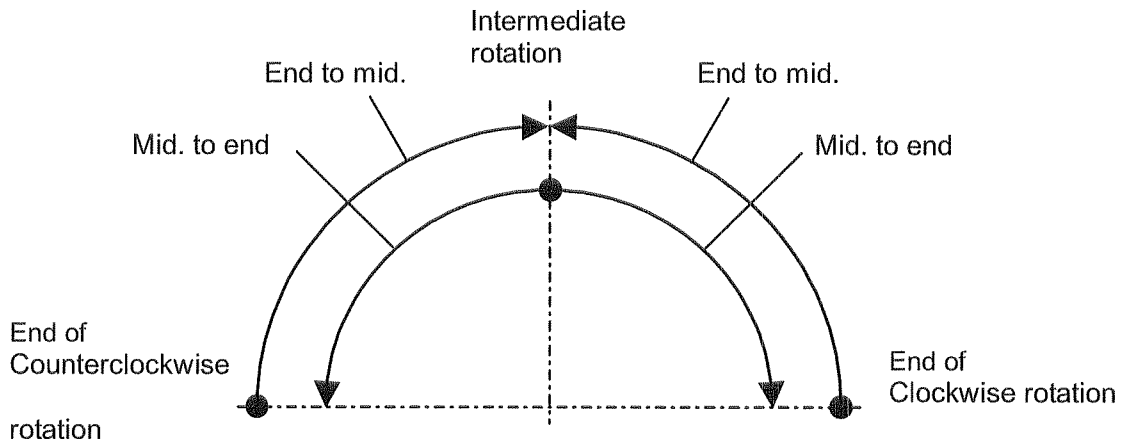
Effective output

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	

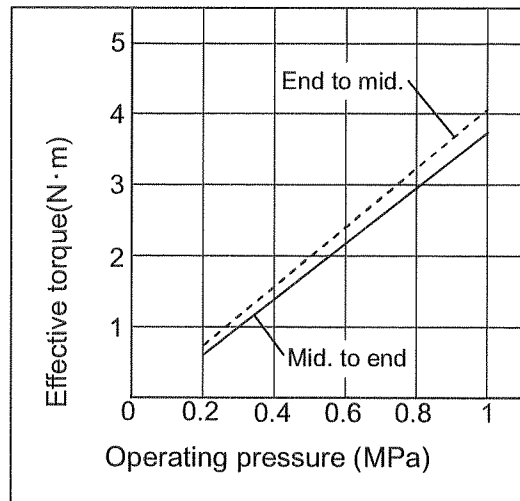
Note) The values shown in the table above are representative values and not to be considered as guaranteed values. These values are for reference only.

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

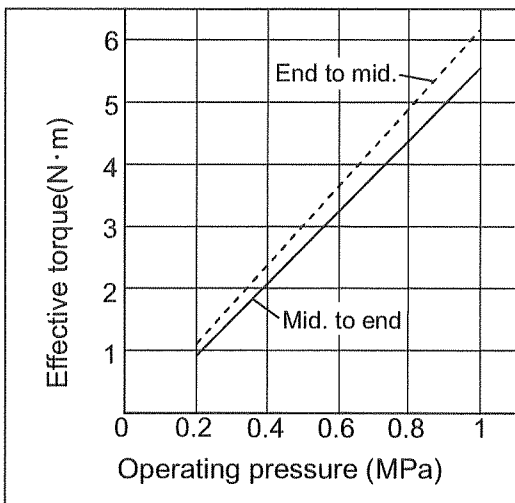
Fig. 1



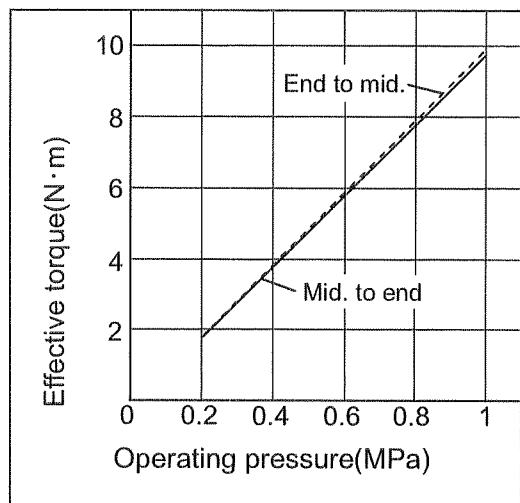
Size 10



Size 20



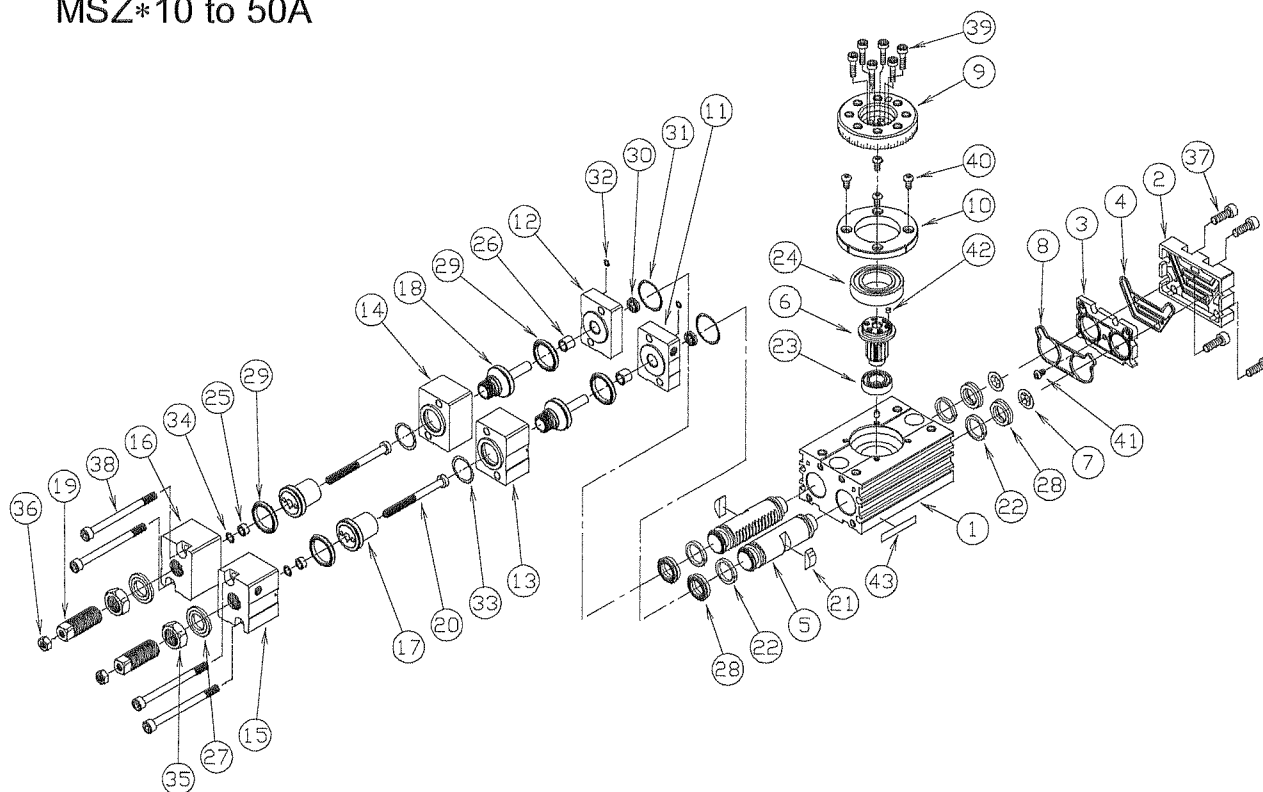
Size 30



Size 50

Disassembled view

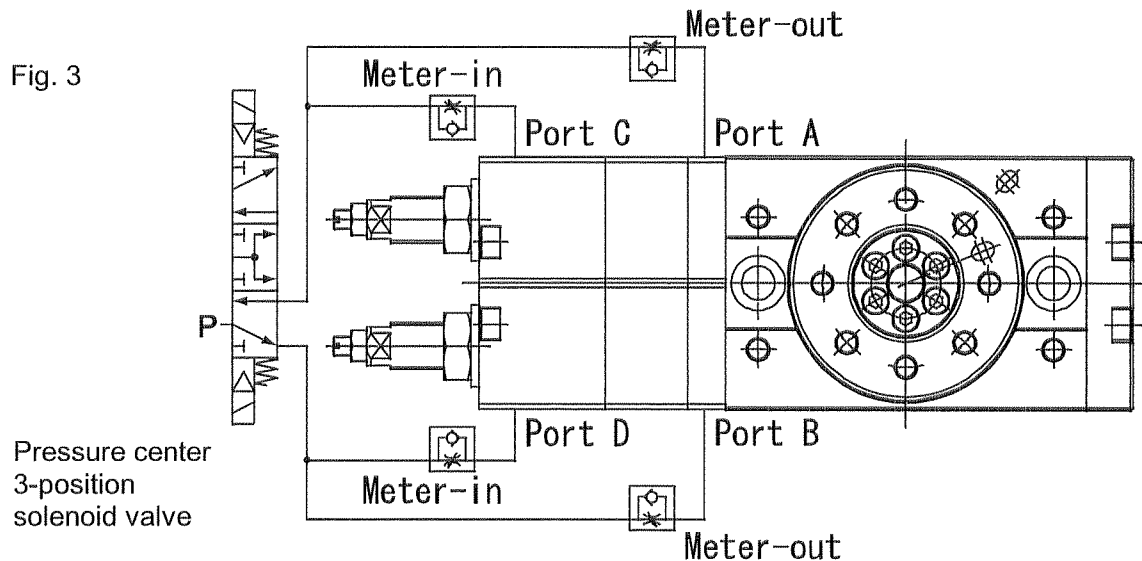
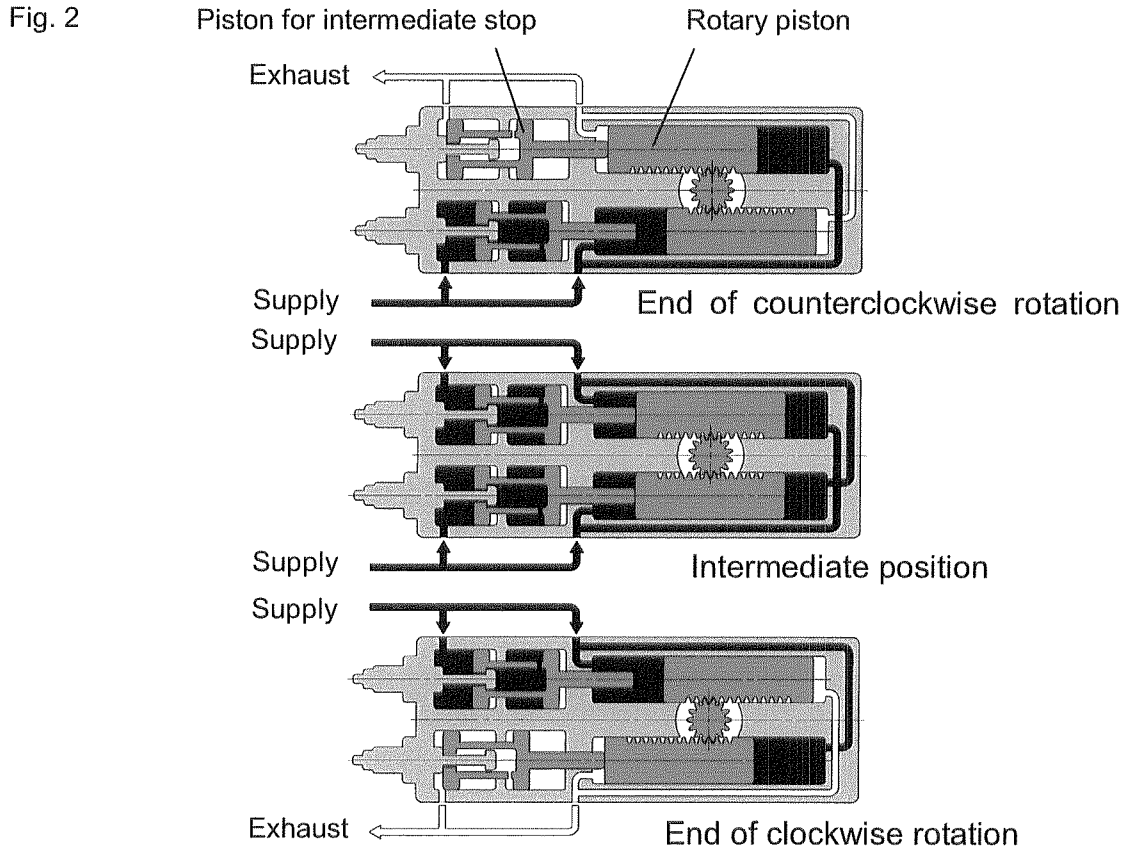
MSZ*10 to 50A



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.)

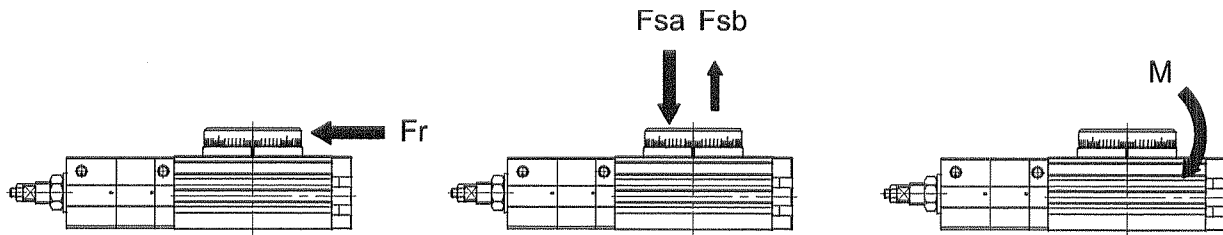


Fig. 4

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

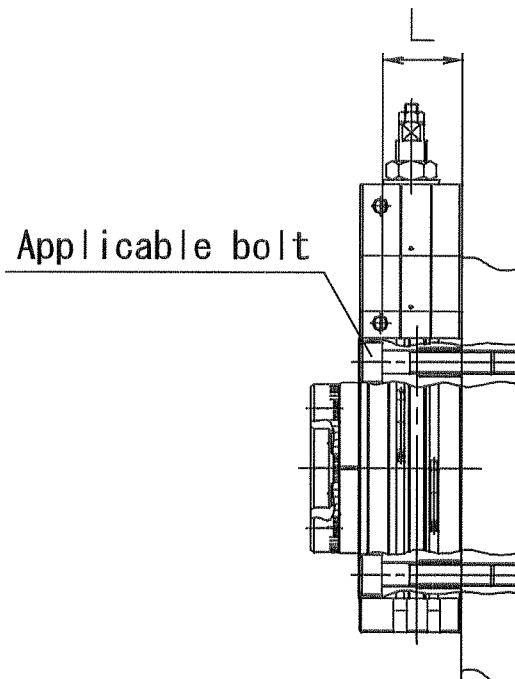
Flange application

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



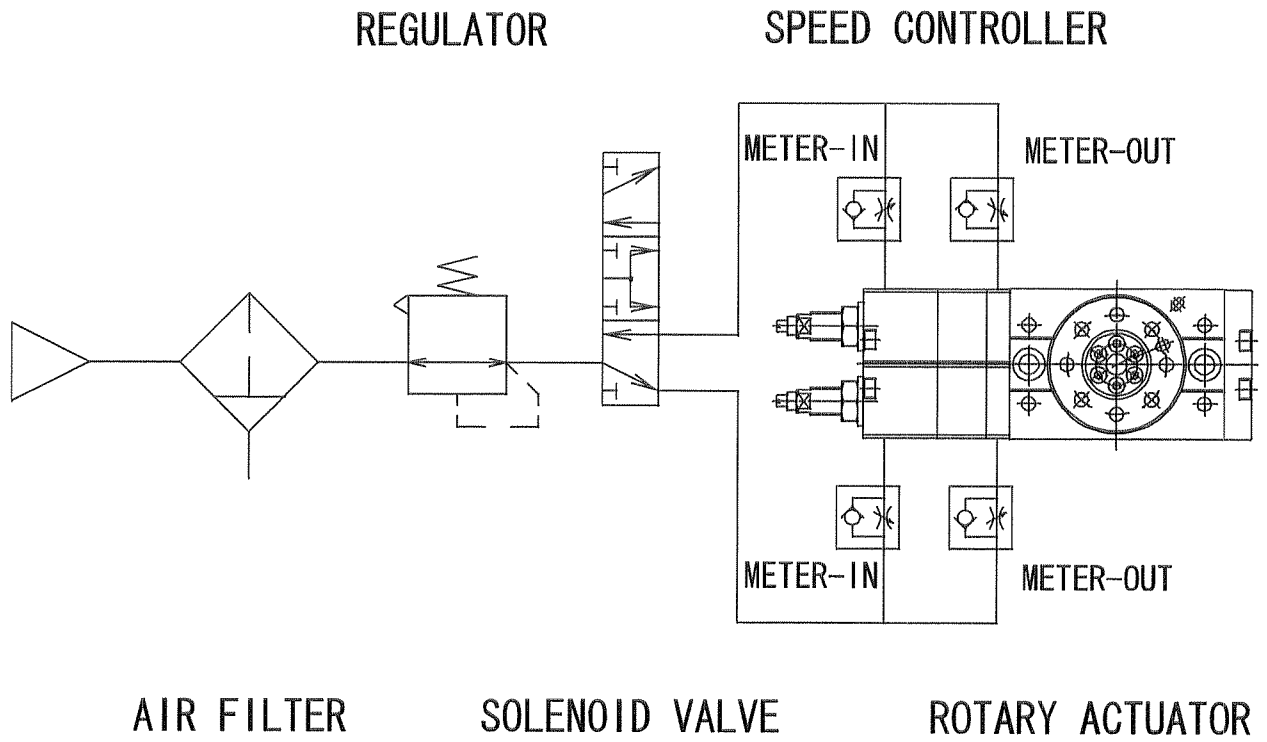


Fig. 6 Basic circuit

Position and size of piping ports

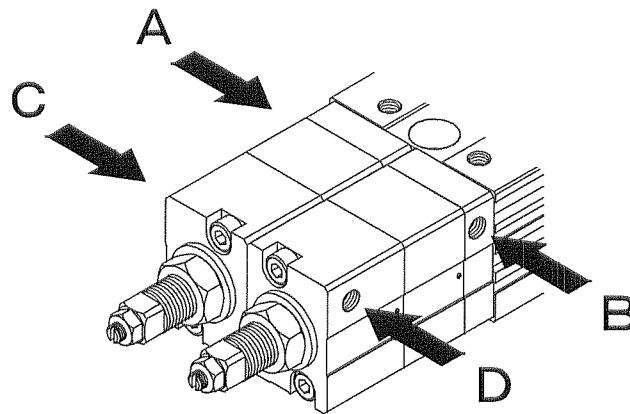
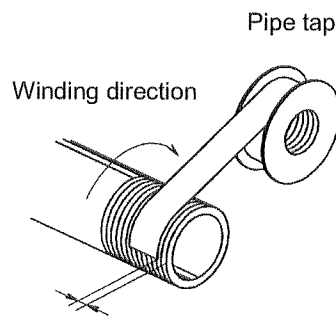


Fig. 7

Table 3 Port size

Size	Port size A, B, C, D
10	M5×0.8
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)



Leave approx. 2 threads exposed

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

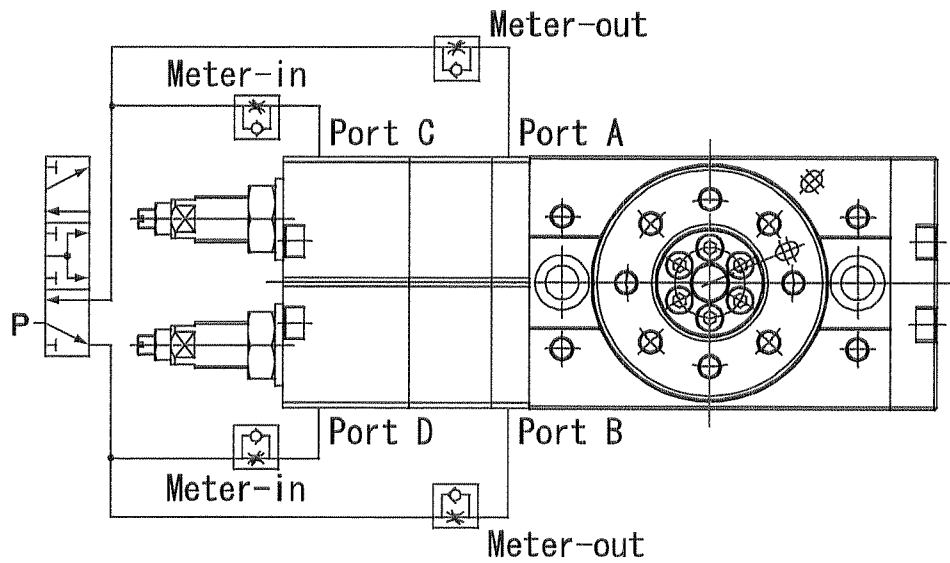
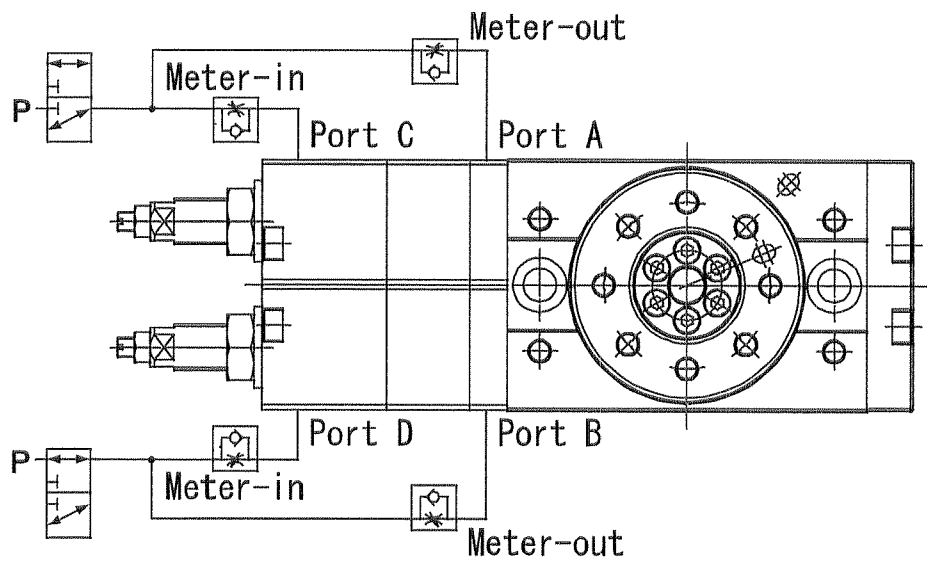


Fig.10



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

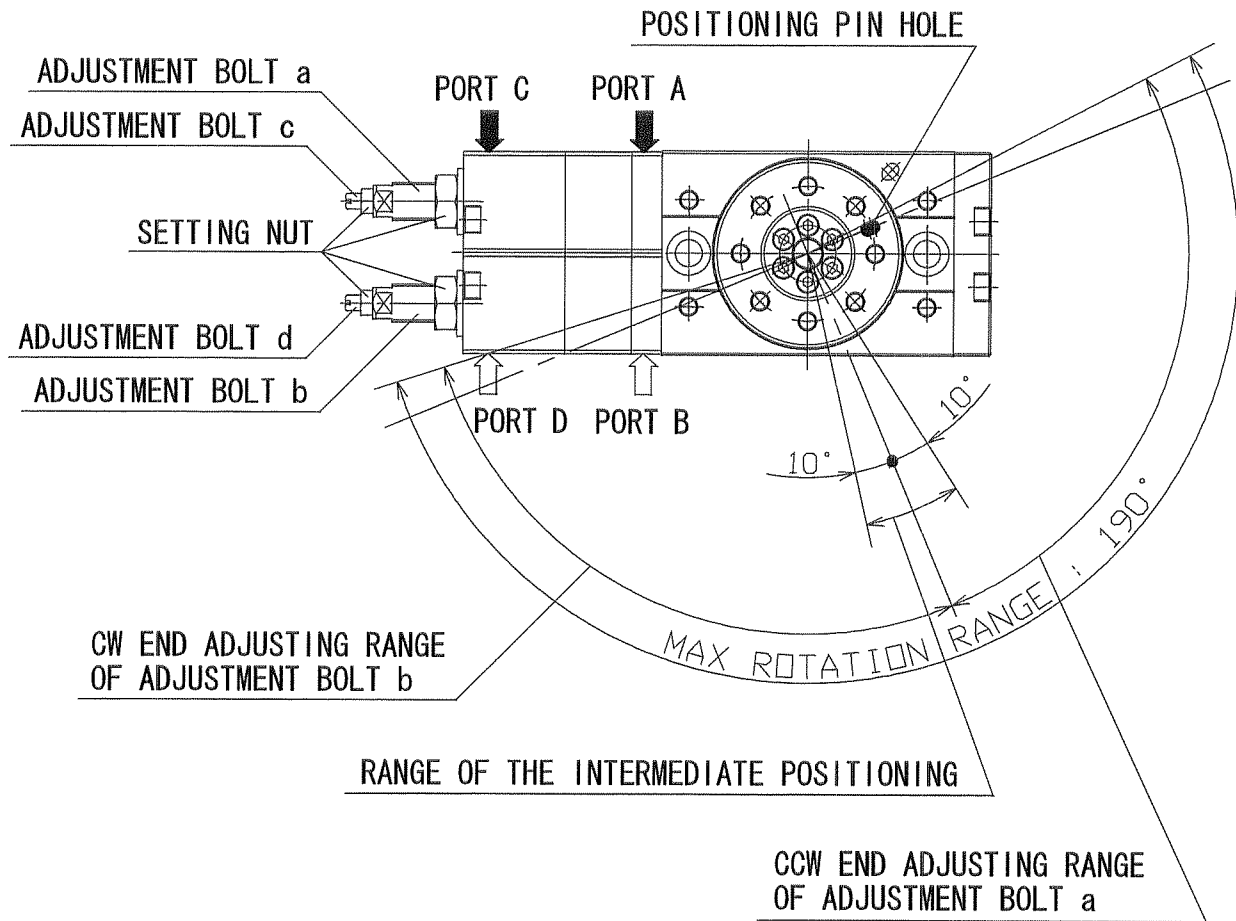
Rotating direction and angle

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.
- (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. *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°

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]

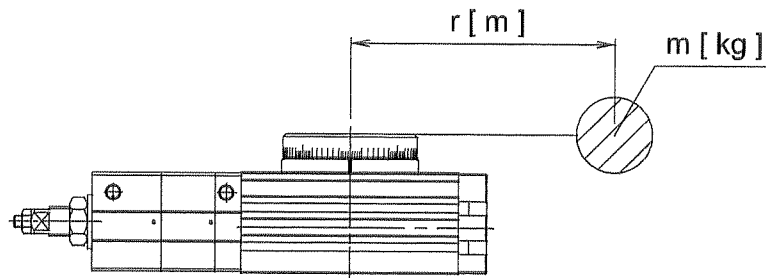


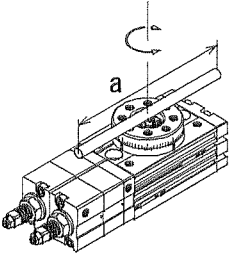
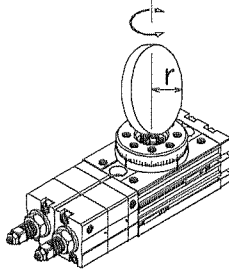
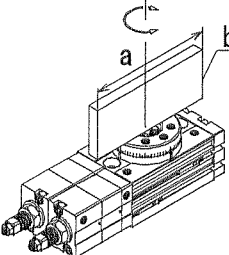
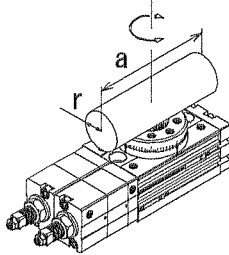
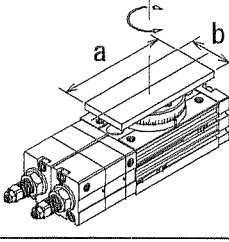
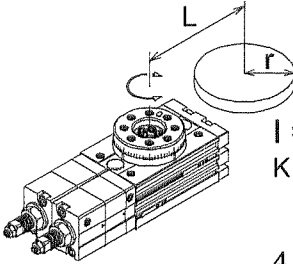
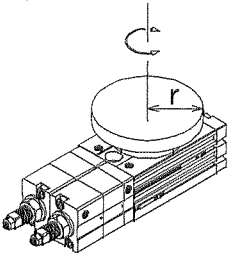
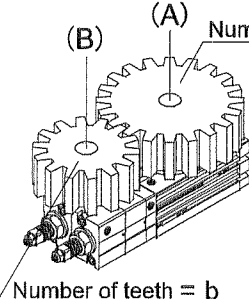
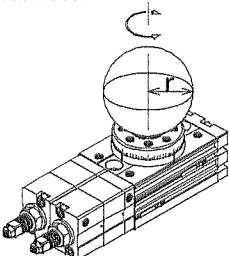
Fig.13

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>  <p>Number of teeth = a</p> <p>Number of teeth = b</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 7 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:

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

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

Table 7 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 ω after t seconds can be found as follows.

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

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

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 8. Reed auto switch

Part no.	Load voltage	Max. load current and load current range	Internal voltage drop	Indication light (illuminated when ON)	Applicable load
D-A90 D-A90V	AC DC 24V or less	50mA	—	Not provided	Relay PLC IC circuit
	AC DC 48V or less	40mA			
	AC DC 100V or less	20mA			
D-A93 D-A93V	DC24V	5 to 40mA	2.4V or less (up to 20mA) 3V or less (up to 40mA)	Provided	Relay PLC
	AC100V	5 to 20mA	2.7V or less		
D-A96 D-A96V	DC4 to 8V	20mA	0.8V or less	Provided	IC circuit

- Lead wire - D-A90(V) and D-A93(V): Oil proof vinyl cord
 $\varnothing 2.7$ 0.18mm² x 2-core (brown, blue) 0.5m
 D-A96(V): Oil proof vinyl cord
 $\varnothing 2.7$ 0.15mm² x 3-core (brown, black, blue) 0.5m
- Isolation resistance - 50M Ω or more at DC500VM (between lead wire and case)
- Withstand voltage - AC1500V for 1 minute (between lead wire and case)
- Operating time - 1.2ms
- Ambient temperature - -10 to 60°C
- Shock resistance - 300m/s²
- Current leakage - None
- Enclosure - Standard: IEC60529, watertight: IP67(JISC0920)

Table 9. Solid state auto switch specification (D-M9□)

Auto switch part no.	Output	Power voltage	Current consumption	Load voltage	Load current	Internal voltage drop	Current leakage	Applicable load
D-M9N D-M9NV D-M9NW D-M9NWV	NPN type	DC5·12·24V (4.5 to 28V)	10mA or less	DC28V or less	40mA or less	At 10mA 0.8V or less At 40mA 2V or less	100 μA or less at DC24V	Relay PLC IC circuit
D-M9P D-M9PV D-M9PW D-M9PWV	PNP type			—				
D-M9B D-M9BV D-M9BW D-M9BWV	—	—	—	DC24V (DC10 to 28V)	2.5 to 40mA	4V or less	0.8mA or less	DC24V Relay PLC

- Lead wire - D-M9B(V): Flexible vinyl sheath cable
2.7 x 3.2 ellipse 0.15mm² x 2-core (brown, blue) 0.5m
D-M9N(V), D-M9P(V): Flexible vinyl sheath cable
2.7 x 3.2 ellipse 0.15mm² x 3-core (brown, black, blue) 0.5m
- Isolation resistance - 50MΩ or more at DC500VM (between lead wire and case)
- Withstand voltage - AC1000V for 1 minute (between lead wire and case)
- Operating time - 1ms or less
- Ambient temperature - -10 to 60°C
- Shock resistance - 1000m/s²
- Enclosure - Standard: IEC60529, watertight: IP67(JISC0920)

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*:0.10~0.20 N·m. Use the designated slotted set screws.

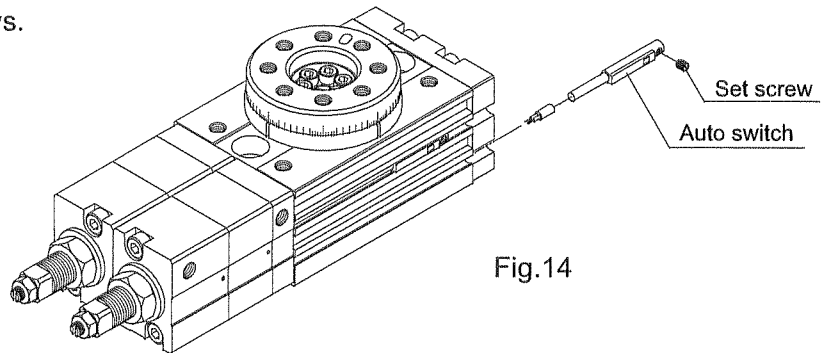


Fig.14

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

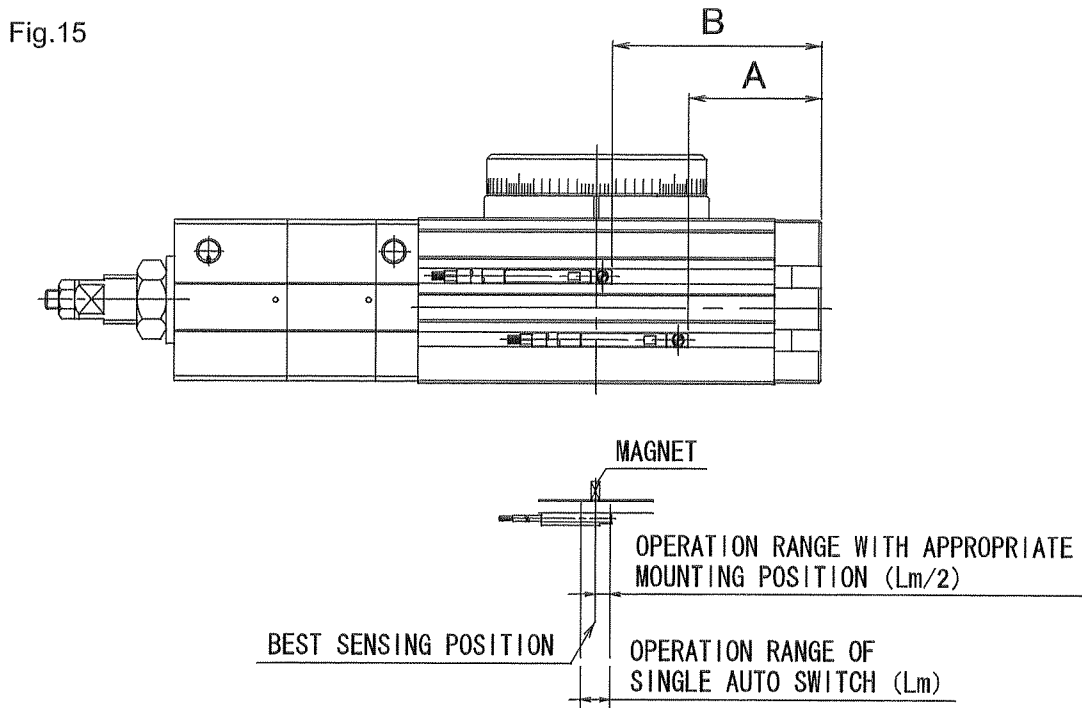


Table 10 Operation range, hysteresis, best sensing position of auto switch

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

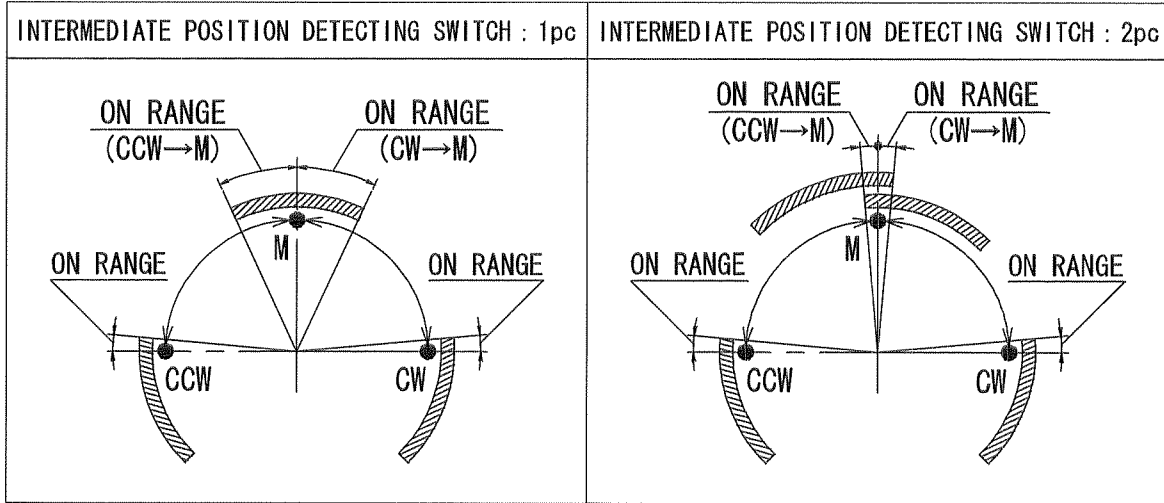
Hysteresis range : The value given by converting the auto switch's hysteresis to an angle

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.

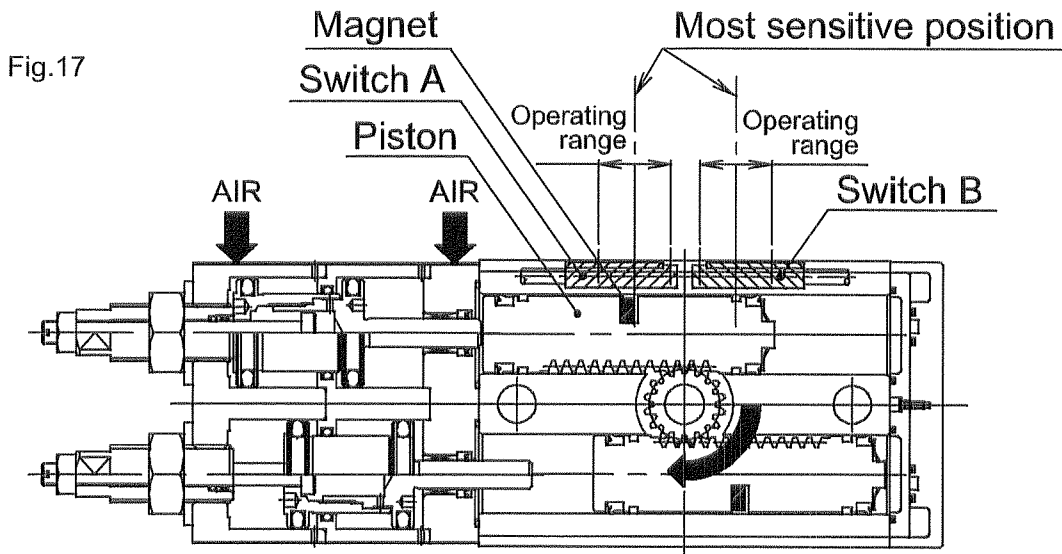


Fig.17

Specific product precautions

■ If not stopping at the intermediate position

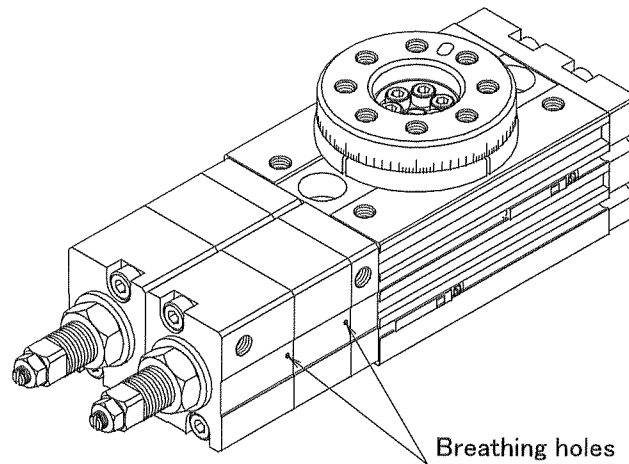
If the table operates from end to end without an intermediate stop, the table will slow down or stop for a moment around the intermediate position. This may last up to a maximum of 0.1s when the table rotates at high speed (0.2s/90°) or a maximum of 0.5s when the table rotates at low speed (1s/90°). 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 11 for the type of solenoid valve.

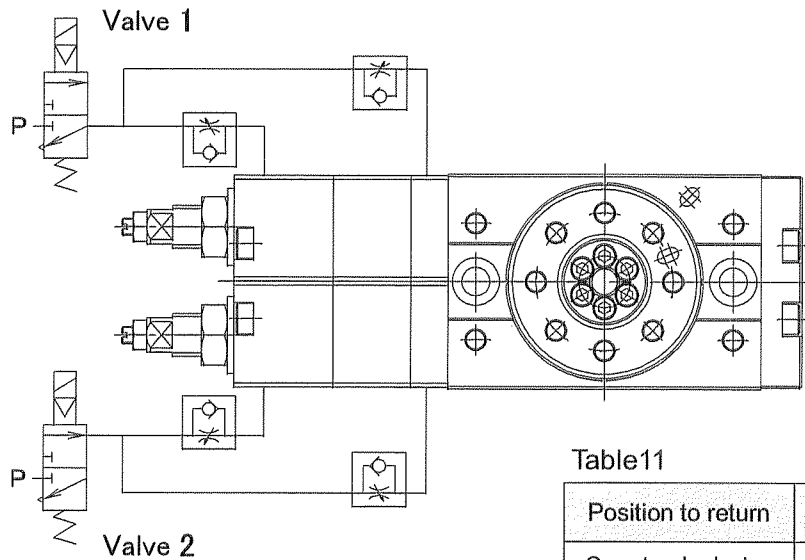
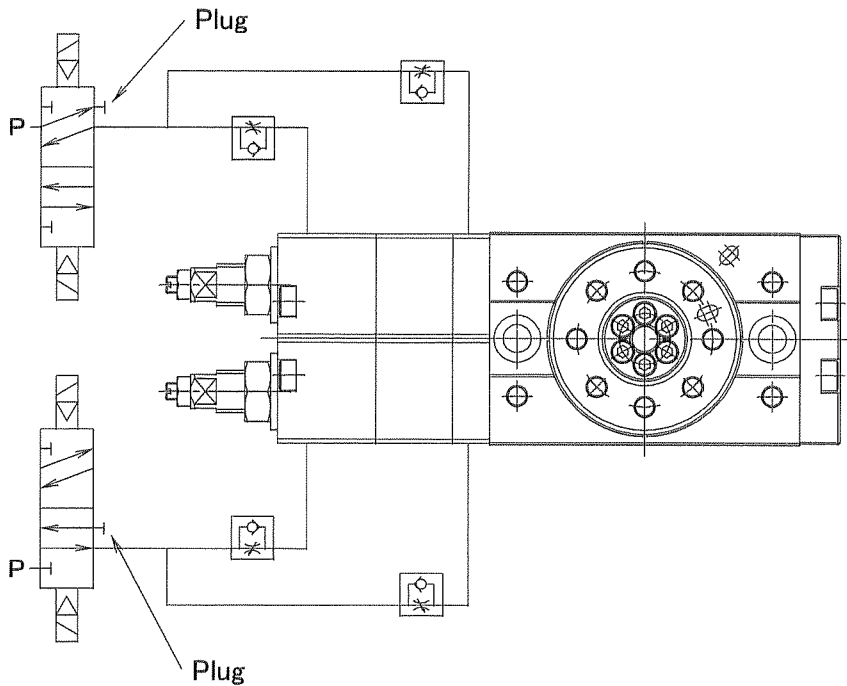


Fig.19

Table11

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.)



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

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