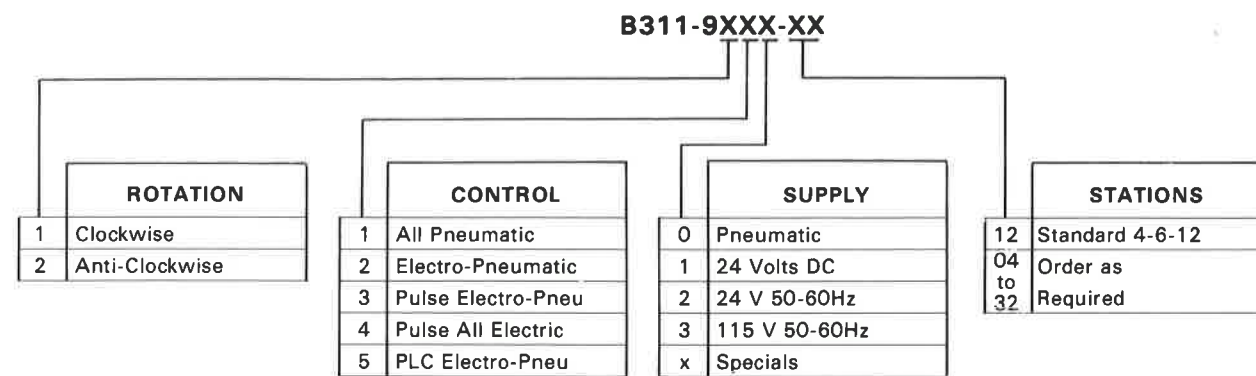


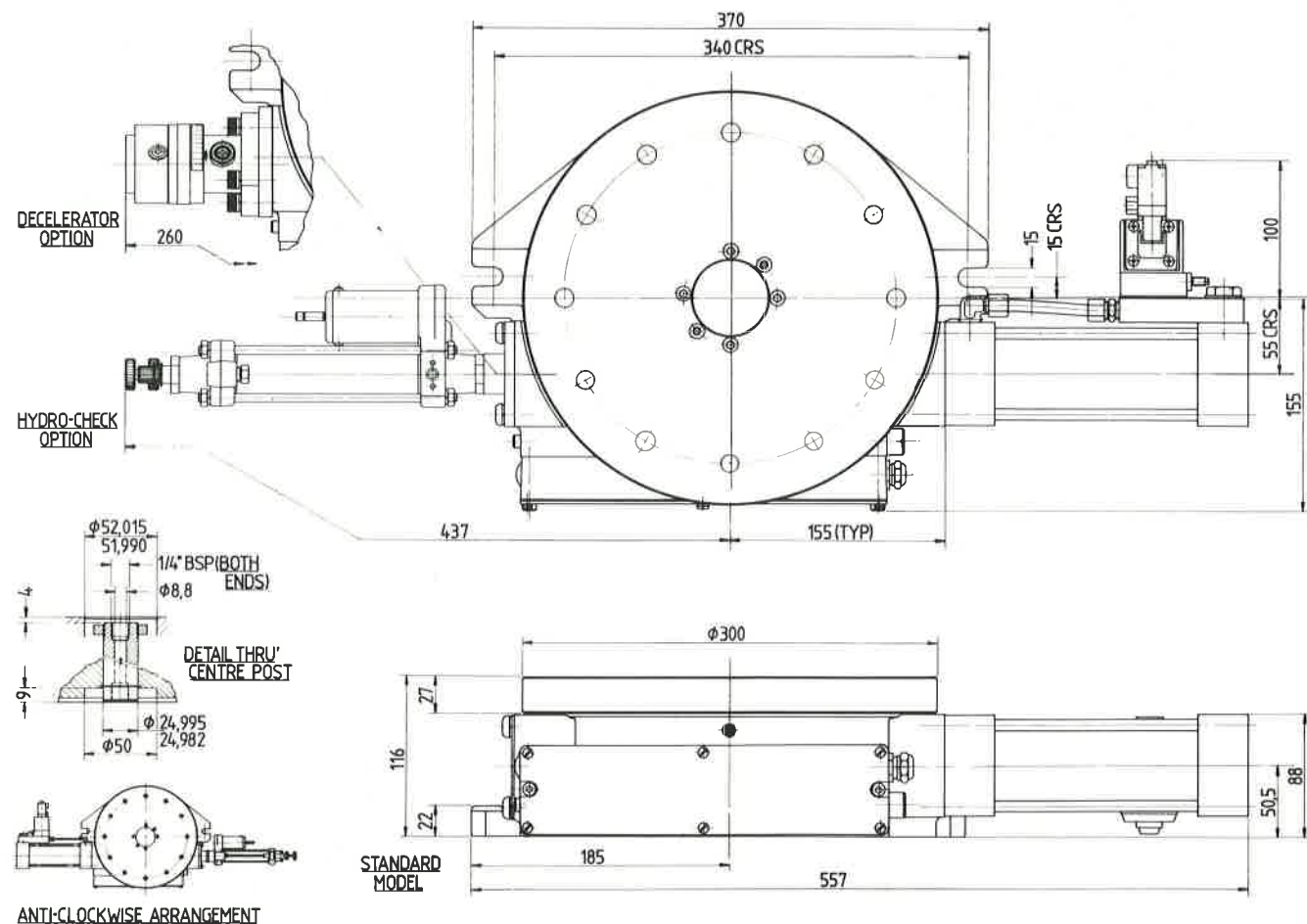
HOW TO ORDER



Use the above coding to order your selected Rotary Table, together with accessories and service spares from the list below:-

B1801-2406	Hydro-check and Mounting Kit complete.
B712-504	Oil Decelerator and Mounting Kit complete.
B732-539	Service kit for cylinder and main valve.
B732-504	Service kit for Hydro-check.
H154-511	Spare Micro-switch (page 6, items P & R)
H154-506	Spare Timer Switch (page 6, item S)
M43303C	Spare Pilot Valve (page 6, item L & M)

DIMENSIONS



ROTARY FEED TABLES

SPEED-LOAD CAPACITY

The B311-9 Rotary Feed Table is designed to move its combined load of added table top, jigs and components smoothly and safely from station to station. The time needed for this is directly related to the angle of rotation (number of stations), the total weight of the load and diameter of the table top. As these increase, the driving speed of the air cylinder is reduced by adjusting the main valve speed controls (see page 6).

The following graphs are presented as a practical guide to realistic operation and the speeds and loads indicated should not be exceeded. As a typical example, the weights of total jigs and components are assumed to equal the weight of the added table top and distributed in a ring as shown in Fig. 1.

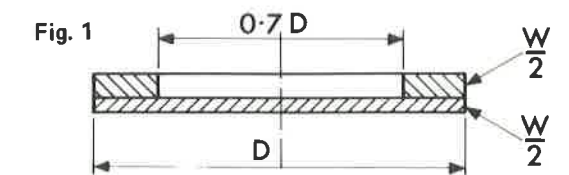


Fig. 2 shows desired minimum times (max. speeds) for added loads, from zero to 100 kilos, on sub-tables up to 500mm dia., air pressure 5.5 bars (80 psig).

Fig. 3 shows the minimum permissible times when using a hydraulic decelerator kit B712-504, accommodating loads up to 150kgs. Note that this facility should be used with 4, 6 or 8 stations only.

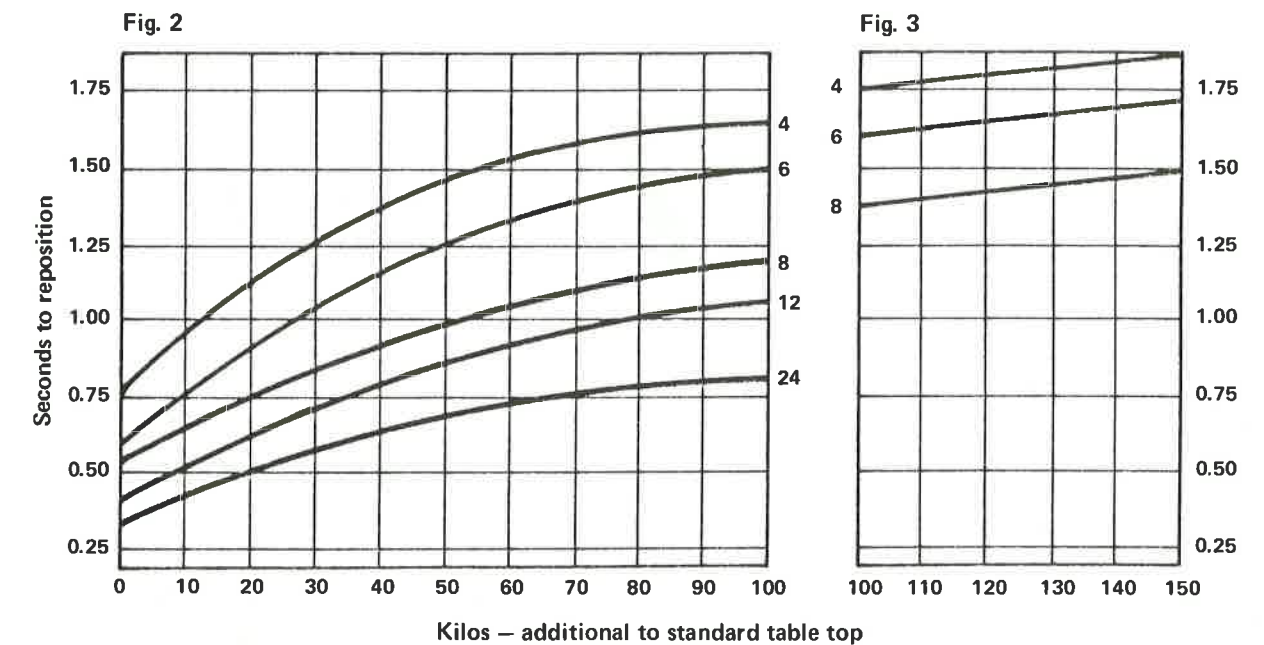


Fig. 4

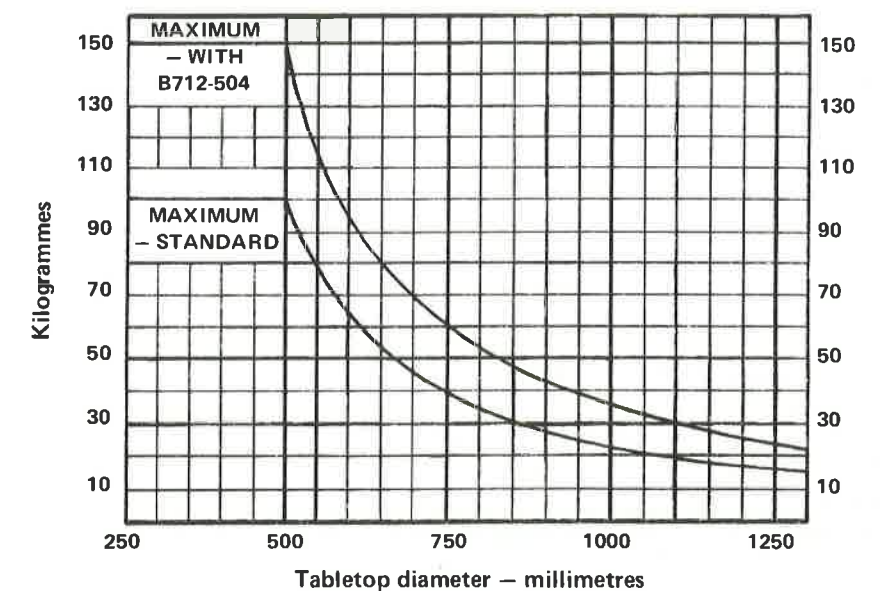


Fig. 4 indicates how the maximum combined weights must be reduced when using larger table tops, up to 1.3 metres dia. The lower curve is for standard air cushioned tables and the higher for those fitted with oil deceleration kit B712-504.



Schrader Bellows Production Machine Components are playing an increasing part in the automation of existing plant — and in the building of Special Purpose Machines.

The proven range of Drills and Tappers, now including the new 20mm Capacity B201-5 Air Hydraulic Drill, are shown above processing components positioned by the B311 Rotary Feed Table.

Schrader Bellows also specialise in the control systems and whether it be a simple cycle of electro pneumatic sequence control or a sophisticated multi-programme micro-processor base, the complete package is proved and tested before leaving our factory for installation on your machine.

OPERATING CIRCUITS.

