TRAK Machine Tools
Southwestern Industries, Inc.

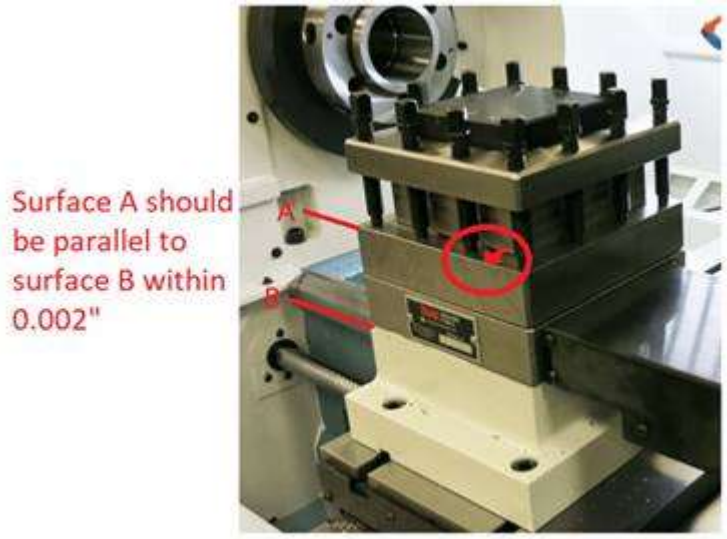
TRAK CNC Turret Specifications – 4 Station

Specifications

- The accuracy of the 4-tool turret is provided by the hirth coupling that is used to position the unit. The accuracy specification of the hirth coupling is +/- 6 arc seconds (+/- 0.0017º).

- The repeatability of the 4-tool turret is provided by the hirth coupling that is used to position the unit. The repeatability specification of the hirth coupling is +/- 2 arc seconds (+/- 0.0006º).

- The tool mounting surface that the tools sit on should be parallel to the bottom of the turret as shown below. It should be no more than 0.002" across all 4 tool spots. In other words, if you set zero in 1 corner of the turret, you should rotate between all 4 locations and not see more than 0.002" TIR on the indicator. If you see -0.001" and +0.0015" then this is out of spec. In addition to this, you should see no more than 0.0003" along the short distance shown below in the circle for each tool position.



- Maximum variance of tool height on datum A when checking all 4 tool spots - 0.003".

- Centerline height tolerance of turret = +0.002" to -0.005"