

EASOM

AUTOMATION SYSTEMS, INC.

HARMONIC MOTION INDEX TABLES

TO BE APPLIED WITH
SELECTION & APPLICATION BULLETIN



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EASOM AUTOMATION SYSTEMS, INC.

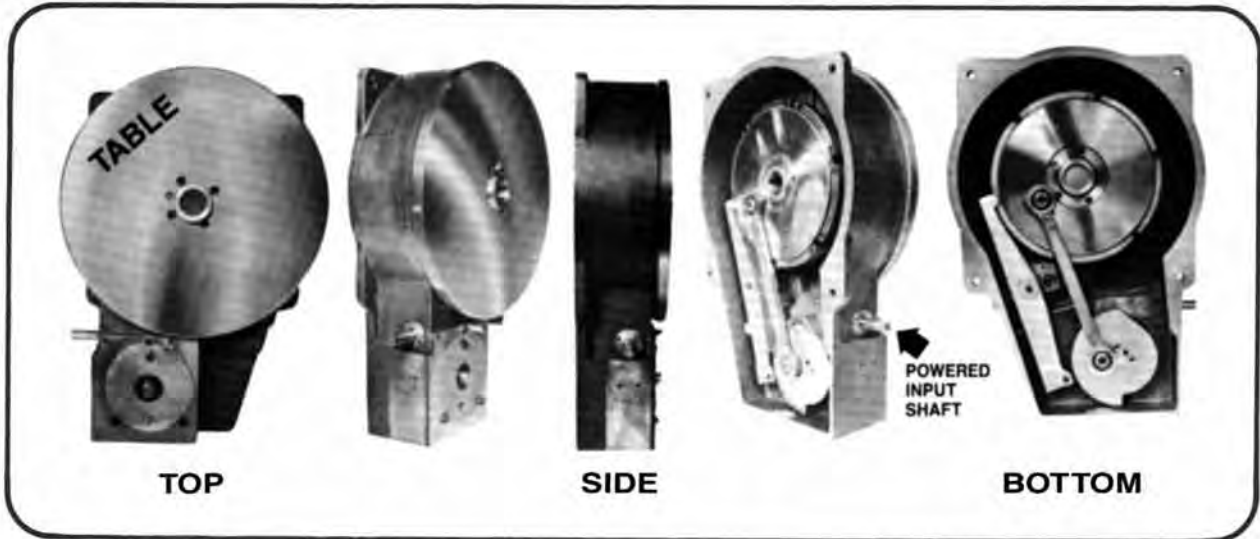
32471 INDUSTRIAL DRIVE • MADISON HEIGHTS, MI 48071 • PHONE (248) 307-0650 • FAX (248) 307-0897

WWW.EASOMENG.COM

05 CAT

THE EASOM INDEX TABLE

"A Heavy Duty Cast Iron-Steel Machine Tool of American Quality for Continuous Production"



- Full Range of Sizes
- Station Patterns: 4-6-8-12-16-24 Standard — Specials on Request.
- Table Top Rotation: Clockwise (standard), or counter-clockwise.

SMOOTH HARMONIC INDEXING MOTION

Ideal Harmonic Indexing Motion is achieved, very simply, by fully utilizing the merits of the Crank Drive Principle. The full 180° of the powered crank drive is applied for indexing, giving Harmonic acceleration and deceleration of the work load with the smoothest start and the smoothest stop ever achieved in the moderately priced field. Graphical presentation is on the next page.

POSITIVE ACCURATE LOCK

Alternating with indexing, the mechanical "V" in the "V" principle of positive repeat lock positioning is held with cam actuated flexing lever force. The Lock Arm Bracket has a tightening screw provision to assure tautness of the Lock Arm and to compensate for wear. The Index Table is definitely in either the locked or indexing position. Graphical presentation is on the next page.

Accuracy of index (station to station) is held by precision grinding the hardened "V" slots of the Index Ring. The hardened "V" of the Lock Arm is machined for fullest matching contact. Positive repeat accuracy is assured within $\pm .001$ " at the outside diameter of the Top Plate on the smaller tables through the 18" Diameter.

CHOICE OF DRIVES—ELECTRIC, AIR OR HYDRAULIC

ELECTRIC MOTOR, ROTARY AIR MOTOR or ROTARY HYDRAULIC MOTOR are your choices of power. Fractional horsepower is ample. The basic design of the Index Table incorporates a worm-gear construction to give high resultant torque to the fixture Plate to fully handle any reasonable load requirement. Bracket or shaft mounted power drives are catalogued.

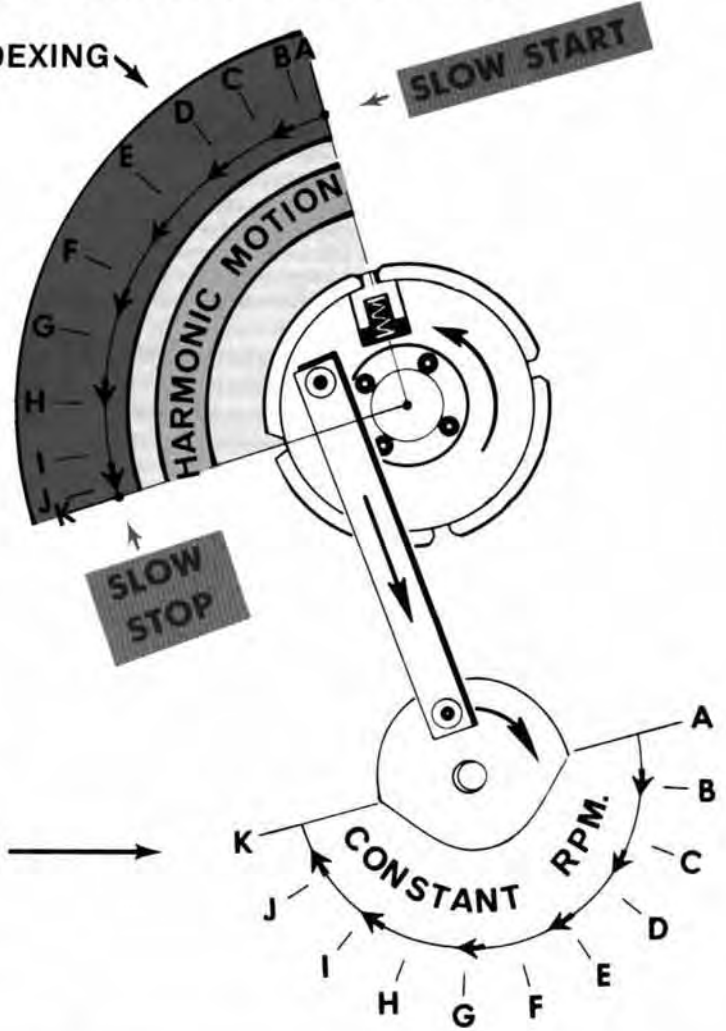
HARMONIC INDEXING MOTION

DRIVEN ASSEMBLY — HARMONIC INDEXING

A station (4 station — 90° indexing illustrated) of the INDEX TABLE DRIVEN ASSEMBLY is indexed with True HARMONIC MOTION. Note graphic travel, A through K, and chart figures.

SECTION	DRIVEN ASSEMBLY TRAVEL DISTANCE	DRIVE ASSEMBLY TRAVEL DISTANCE	TIME
A → B	.150	.300	.1 Sec.
B → C	.250	.300	.1 Sec.
C → D	.300	.300	.1 Sec.
D → E	.425	.300	.1 Sec.
E → F	.525	.300	.1 Sec.
F → G	.425	.300	.1 Sec.
G → H	.375	.300	.1 Sec.
H → I	.275	.300	.1 Sec.
I → J	.200	.300	.1 Sec.
J → K	.075	.300	.1 Sec.
A → K	3.000 IN.	3.000 IN.	1.0 SEC.

One second time is used, in chart, to rotate from A through K. The same relative result is achieved on any Indexing Motion timing and on all Index Table sizes and station patterns.



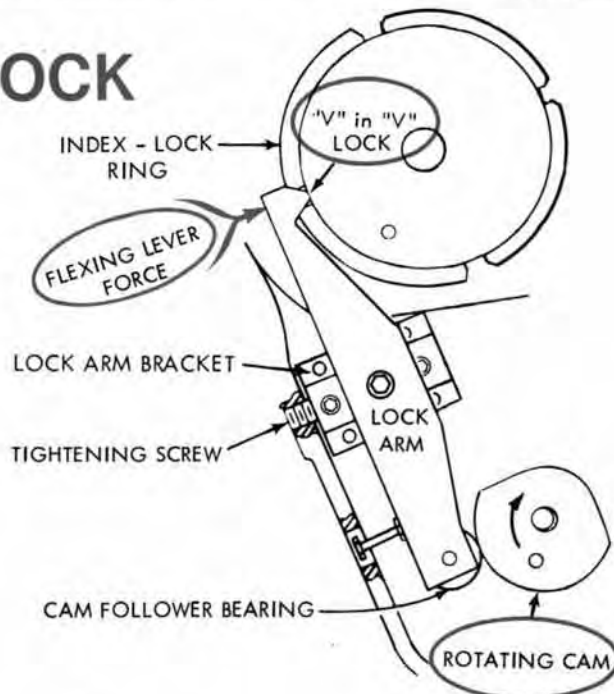
DRIVE ASSEMBLY — CONSTANT RPM

The powered Crank Drive rotates 180° (A through K) at a CONSTANT RPM to achieve the Ideal Harmonic 90° Indexing Motion imparted to the Driven Assembly.

The two functions of an Index Table (Indexing and Locking) are separated on this page to present the full merits of each. Complete Index Table sequence and assembly are presented on pages 3 and 4.

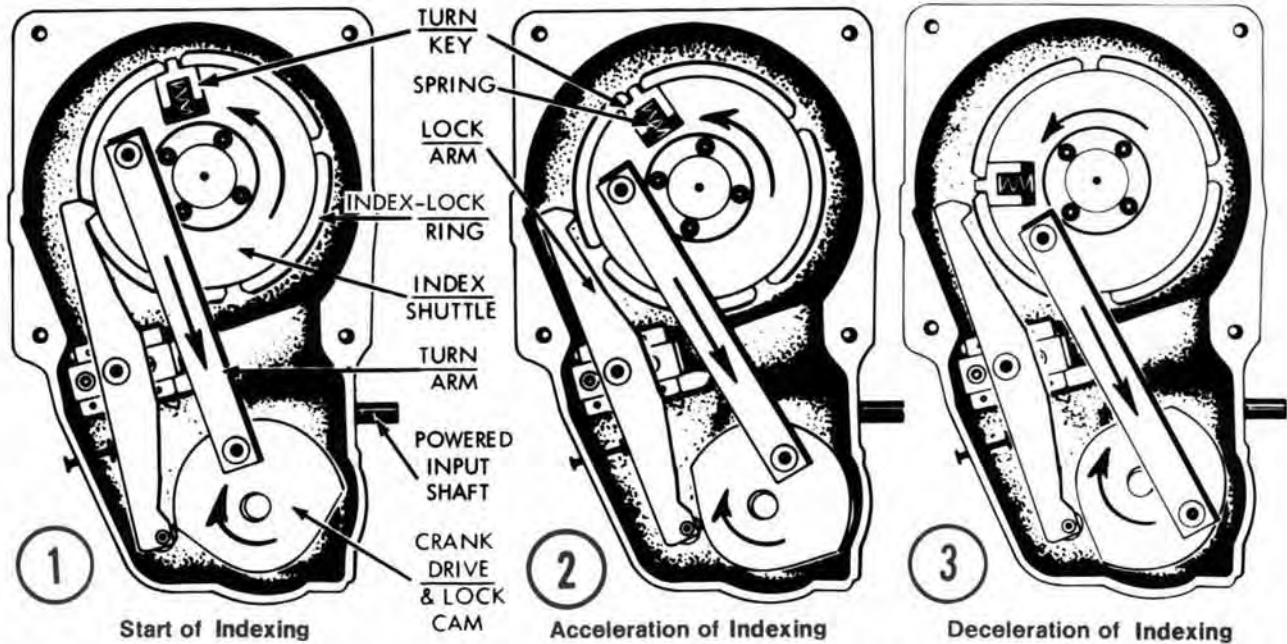
POSITIVE REPEAT LOCK

The Cam actuation assures flexing lever force to the hardened "V" in "V" lock contacts when the Index Table is in the locked position.



SEQUENCE OF OPERATIONS

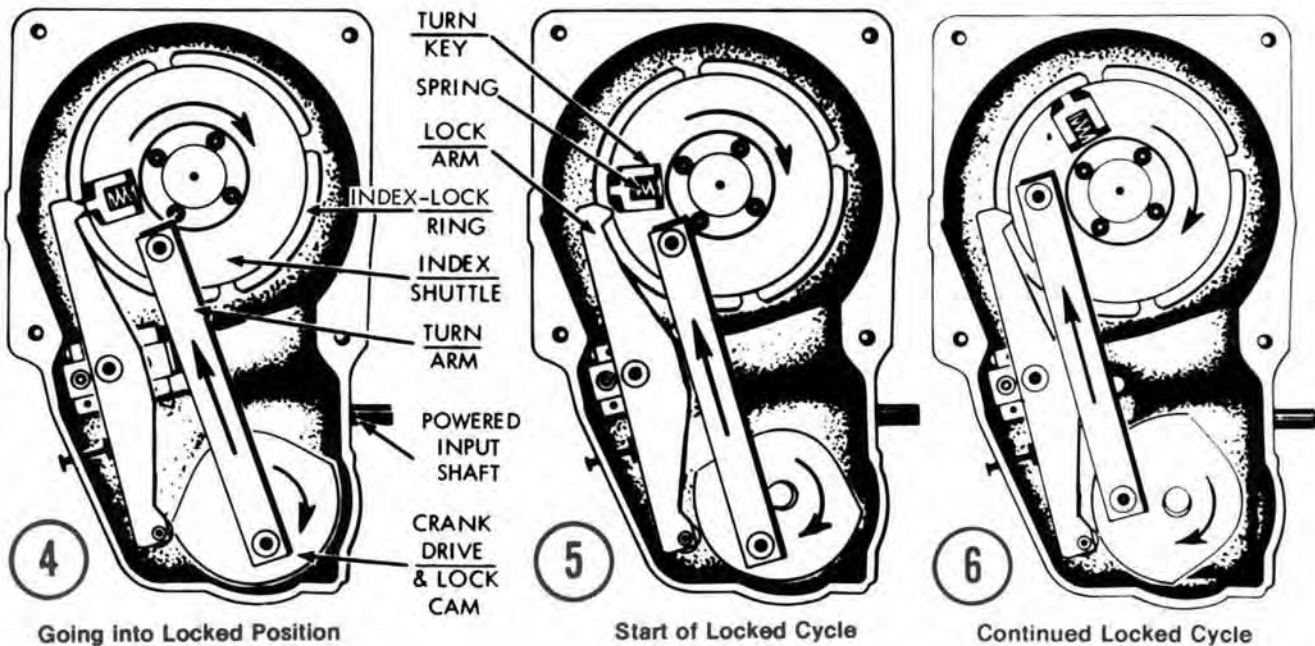
INDEXING MOTION



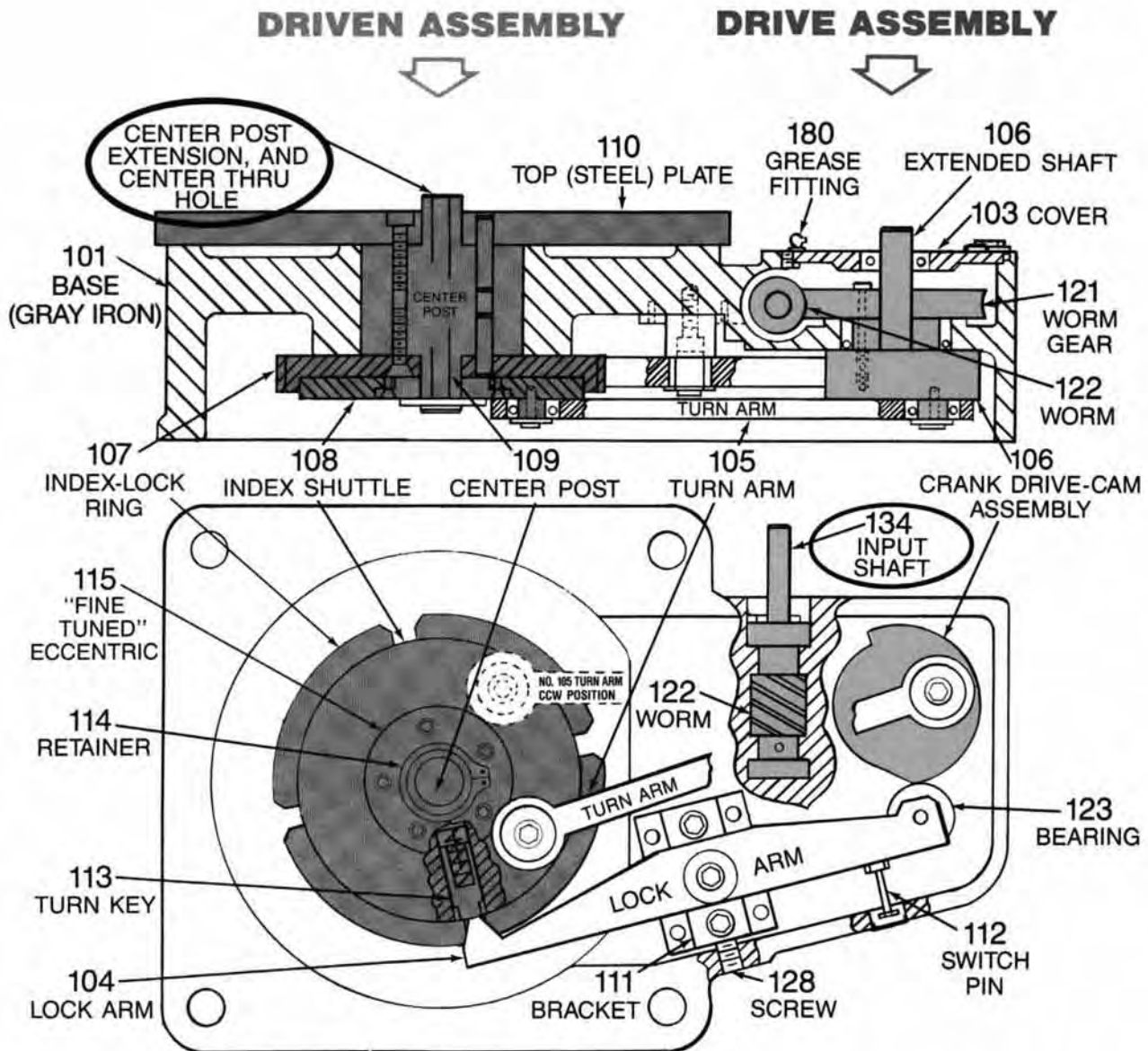
THE CRANK DRIVE IS LOCATED 360° TO GIVE ONE COMPLETE (INDEXING AND LOCK) CYCLE TO THE INDEX TABLE. 180° IS USED FOR INDEXING AND 180° FOR LOCKED POSITION. CONTINUOUS ROTATION IS PRESENTED FROM BOTTOM VIEW OF INDEX TABLE. CLOCKWISE TABLE TOP ROTATION IS ILLUSTRATED.

① The spring-loaded Turn Key, housed in the Index Shuttle, is exactly positioned to drop into the Index-Lock Ring slot as the Turn Arm stops to change direction. ② Harmonic acceleration indexing motion starts and ③ harmonic deceleration takes place. ④ As the Turn Arm stops to change direction, the Lock Arm is actuated from the Crank Drive Cam, pushing in the Turn Key and imparting positive "V" in "V" flexing lever locking to the Index-Lock Ring. The Turn Key is disengaged from the Index-Lock Ring by the Lock Arm. ⑤ and ⑥ continued rotation of the Crank Drive is achieved in the locked position, which advances the Turn Key to the next slot. As a general rule, power is taken away at ⑥ until work is completed. Next cycle starts when the Turn Key drops into the next Index-Lock Ring slot at position ①.

LOCKED POSITION



CROSS SECTIONAL VIEW



The Driven Assembly (Gray Areas) and Drive Assembly (Blue Areas) shown above are each Unitized Assemblies installed in the base casting. The Turn Arm and Lock Arm are interlocks of these two assemblies. Application of either Air, Hydraulic or Electric Rotary Power applied to the No. 134 Input Shaft results in a 100% Mechanical Sequence with Ideal Index Motion and Positive Accurate Lock.

Ability to accelerate and move a comparative heavy load is inherent in the Index Table assembly. Small input power to the No. 134 Input Shaft through the Worm-Gear Assembly gives very high resultant torque to the Index Table No. 110 Top Plate. The standard 40:1 Worm-Gear ratio simply means that 20 revolutions of the Input Shaft are used for Indexing Motion and 20 turns are utilized in the Locked position. 20:1 Worm-Gear ratio is available according to the index speed.

STANDARD INDEX TABLES:

Item A

TOP PLATE DIAMETER	4 STATION	6 STATION	8 STATION	12 STATION	16 STATION	24 STATION
	MODEL NO.	MODEL NO.	MODEL NO.	MODEL NO.	MODEL NO.	MODEL NO.
8"	T-8-4	T-8-6	T-8-8	T-8-12	T-8-16	NOT AVAILABLE
10"	T-10-4	T-10-6	T-10-8	T-10-12	T-10-16	NOT AVAILABLE
14"	T-14-4	T-14-6	T-14-8	T-14-12	T-14-16	T-14-24
18"	T-18-4	T-18-6	T-18-8	T-18-12	T-18-16	T-18-24

Special Index Tables with equally spaced stations from five to maximum listed are available on request.

- DIMENSIONAL DATA IS PRESENTED ON PAGES 6-7.
- LIMIT SWITCHES WITH INTERLOCKS ARE PRESENTED ON PAGE 8.
- POWER EQUIPMENT CHOICE IS PRESENTED ON PAGES 9 AND 10.

D.C. ELECTRIC MOTOR AND MOUNTED AIR CLUTCH IS AVAILABLE;
REQUEST BULLETIN FROM FACTORY OR REPRESENTATIVE.

SELECTION & APPLICATION

Request from factory or representative the bulletin on Selection and Application of the Jackson Index Table which includes:

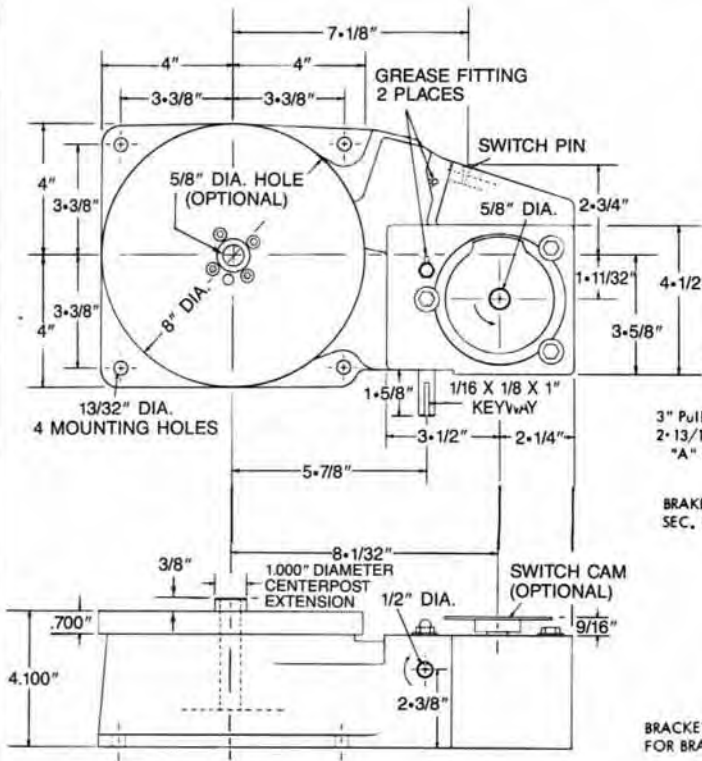
- Chart for selecting proper size index table for specific application.
- Instructions on mounting the index table.
- Precautions and Methods for proper design and operation.
- Electrical Interlock instructions in detail.
- Chart on index speed with required input RPM.
- Air motor and hydraulic motor operating pressure including volume requirements.
- Chart on proper Worm-Gear Ratio Selection.
- Detailed installation information on power drives.
- Electrical Schematic Principle.

Maintenance Information and Parts List on the basic index table and power accessories are furnished with each index table.

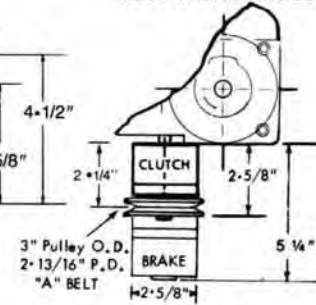
DIMENSIONAL DATA

MODEL T-8 with 8 inch Diameter Top Plate

ALL DIMENSIONS AVAILABLE ON AUTO CAD DISC UPON REQUEST

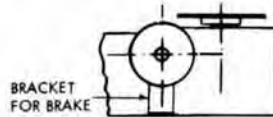


No. 200
ELECTRIC CLUTCH
DETAILS ON PAGE 13
AUTO CAD FILE T-8 EC

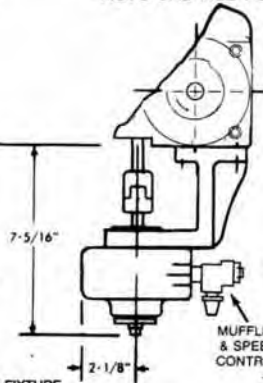


BRAKE REQUIRED AT 4/10
SEC. INDEX TIME OR FASTER

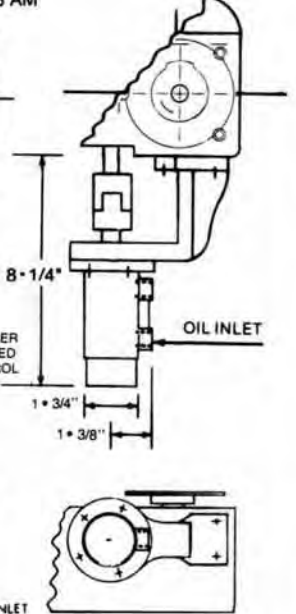
AIR MOTOR LIMITS FIXTURE
PLATE DIAMETER TO 17 IN.
UNLESS 5/16" THICK RISER
IS ADDED TO THE TABLE TOP



No. 207
AIR MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-8 AM



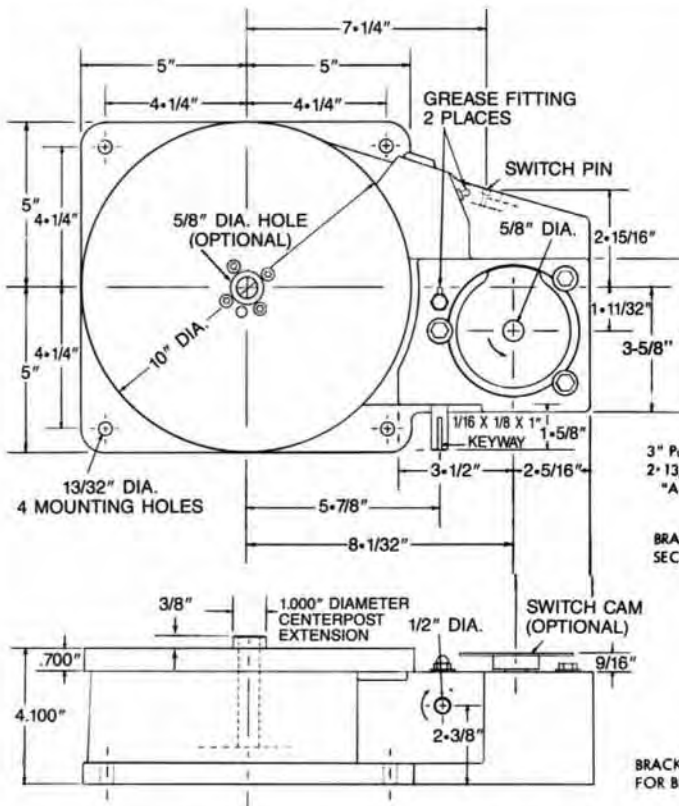
No. 240
HYDRAULIC MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-8 HM



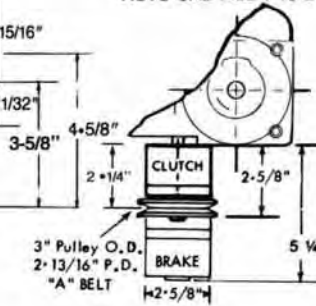
WEIGHT - 65 LBS. CLOCKWISE ROTATION STANDARD — COUNTER CLOCKWISE ROTATION ON REQUEST
OUTSIDE DIMENSIONS DO NOT CHANGE ON COUNTER CLOCKWISE ROTATION
STANDARD STATIONS: 4 - 6 - 8 - 12 - OR 16

MODEL T-10 with 10 inch Diameter Top Plate

ALL DIMENSIONS AVAILABLE ON AUTO CAD DISC UPON REQUEST

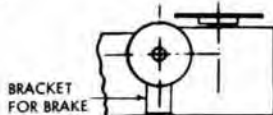


No. 200
ELECTRIC CLUTCH
DETAILS ON PAGE 13
AUTO CAD FILE T-10 EC

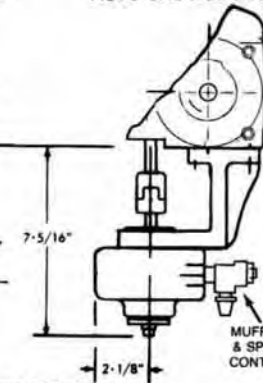


BRAKE REQUIRED AT 4/10
SEC. INDEX TIME OR FASTER

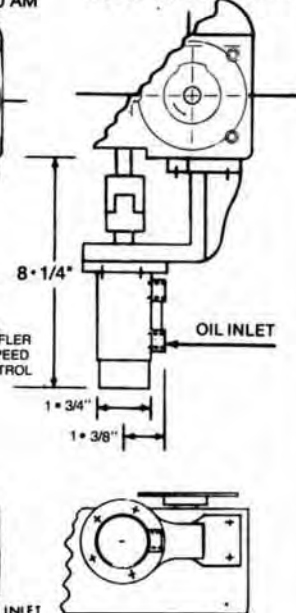
AIR MOTOR LIMITS FIXTURE
PLATE DIAMETER TO 18 IN.
UNLESS 5/16" THICK RISER
IS ADDED TO THE TABLE TOP



No. 207
AIR MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-10 AM



No. 240
HYDRAULIC MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-10 HM



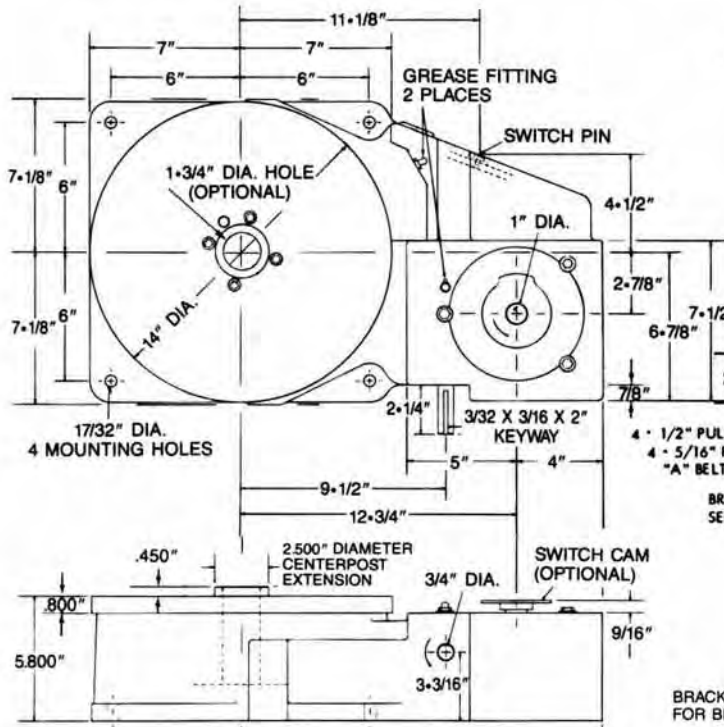
WEIGHT - 90 LBS. CLOCKWISE ROTATION STANDARD — COUNTER CLOCKWISE ROTATION ON REQUEST
OUTSIDE DIMENSIONS DO NOT CHANGE ON COUNTER CLOCKWISE ROTATION
STANDARD STATIONS: 4 - 6 - 8 - 12 - OR 16

DIMENSIONAL DATA

MODEL T-14

with 14 inch Diameter Top Plate

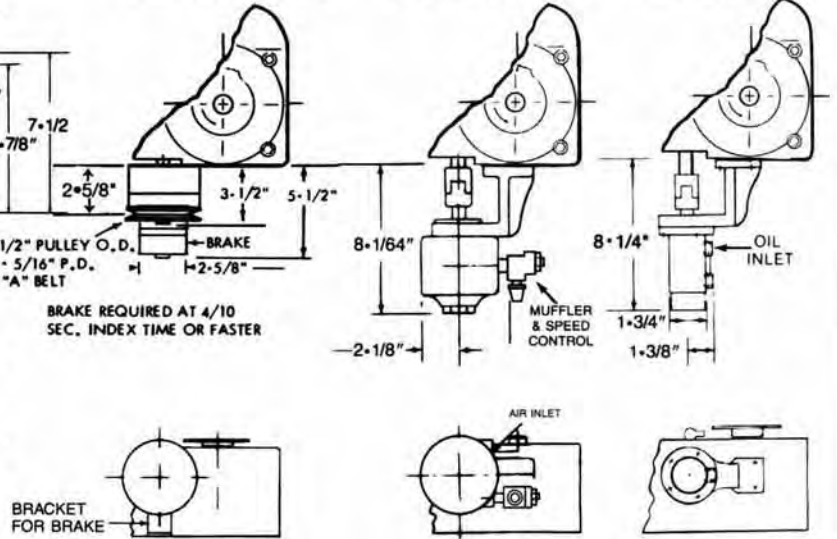
ALL DIMENSIONS AVAILABLE ON AUTO CAD DISC UPON REQUEST



No. 200
ELECTRIC CLUTCH
DETAILS ON PAGE 13
AUTO CAD FILE T-14 EC

No. 207
AIR MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-14 AM

No. 240
HYDRAULIC MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-14 HM

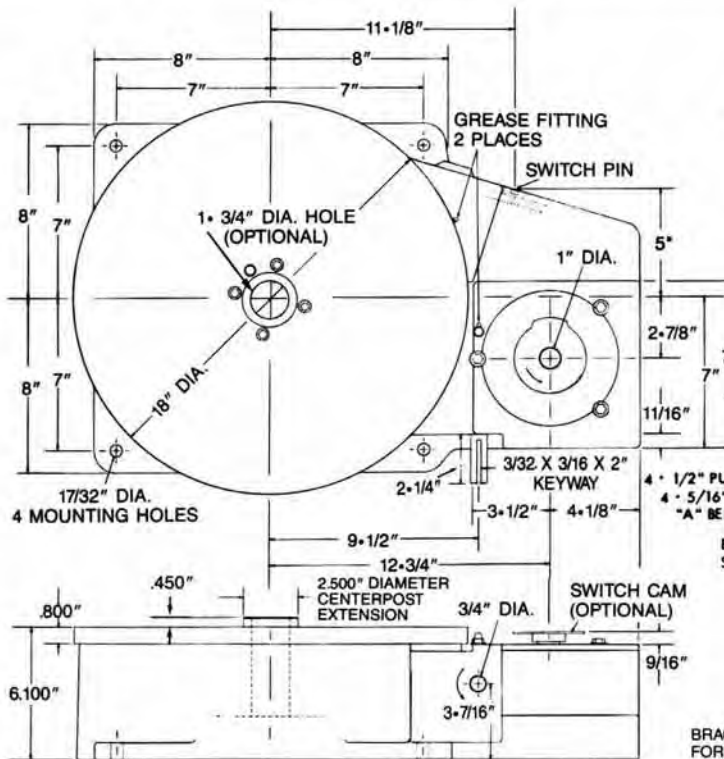


WEIGHT - 200 LBS. CLOCKWISE ROTATION STANDARD—COUNTER CLOCKWISE ROTATION ON REQUEST
 OUTSIDE DIMENSIONS DO NOT CHANGE ON COUNTER CLOCKWISE ROTATION
 STANDARD STATIONS: 4 - 6 - 8 - 12 - 16 - OR 24

MODEL T-18

with 18 inch Diameter Top Plate

ALL DIMENSIONS AVAILABLE ON AUTO CAD DISC UPON REQUEST



No. 200
ELECTRIC CLUTCH
DETAILS ON PAGE 13
AUTO CAD FILE T-18 EC

No. 207
AIR MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-18 AM

No. 240
HYDRAULIC MOTOR
DETAILS ON PAGE 14
AUTO CAD FILE T-18 HM

WEIGHT - 320 LBS. CLOCKWISE ROTATION STANDARD—COUNTER CLOCKWISE ROTATION ON REQUEST
 OUTSIDE DIMENSIONS DO NOT CHANGE ON COUNTER CLOCKWISE ROTATION
 STANDARD STATIONS: 4 - 6 - 8 - 12 - 16 OR 24

INDEX TABLE OPERATIONAL EQUIPMENT

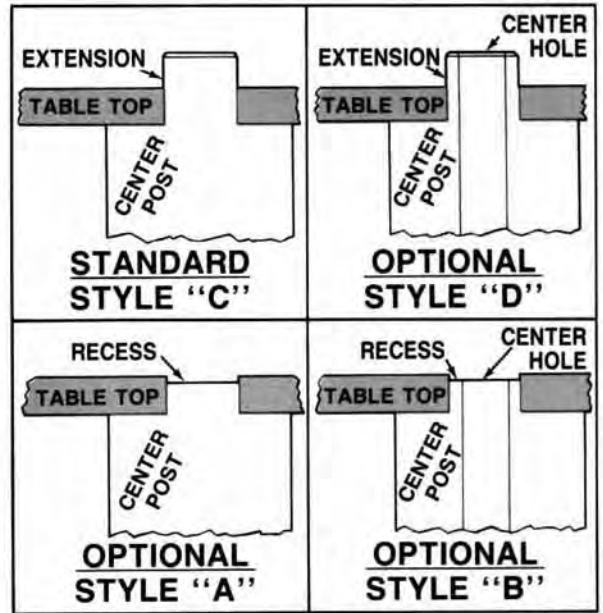
Item B

ROTATION: CLOCKWISE (CW) IS STANDARD (Top View).
Counterclockwise (CCW) on request.

Item C

CENTERPOST OPTIONS: (Assembly shown top of page 4)
 Style C Standard - Extension with no Hole.
 Style D Option - Extension with Drilled Hole provided.
 Style A Option - Recessed below Top Plate - No Hole
 Style B Option - Recessed below Top Plate - With Drilled Hole

Centerpost Extension is used to radially located fixtures from the true rotation axis. It is an integral part and ground with the O.D. surface of the No. 109 Centerpost. The Hole through the Centerpost is used to bring supply lines through from the bottom of the Index table. Center hole and extension rotate with the table top. The center hole diameter maximum possible is as indicated on page 6 through 11.



Item D

40:1 Worm-Gear Ratio for Index Speeds of 5/10 second or slower (exception 1 sec. or slower on all hydraulic motor drives). Alternative worm gear ratio according to the index speed item "E" below (Assembly shown on page 4). 40:1 worm-gear ratio is designated with the letter "S" on name plate, and paper work.

Item E

20:1 Worm-Gear Ratio for Index Speeds of 4/10 second or faster (exception 9/10 sec. or faster on all hydraulic motor drives). Assembly shown on page 4: 20:1 worm-gear ratio is designated with the letter "D" on name plate, and paper work.

Item F

FOR CUSTOMER MOUNTING OF THEIR TOOLING PLATE

(NOT REQUIRED ADDITIONALLY WHEN JACKSON MACHINE PRODUCTS SUPPLIES THE TOOLING PLATE)

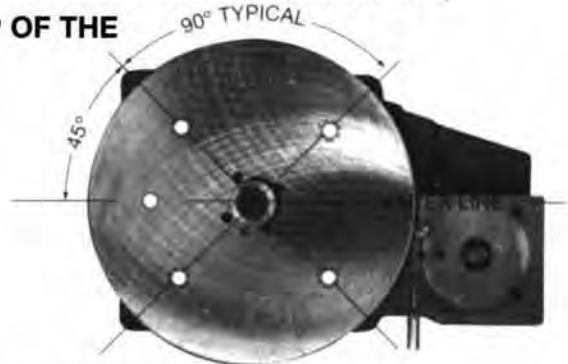
4 TAPPED AND 1 DOWEL HOLE IN THE TABLE TOP OF THE INDEX TABLE UPON REQUEST

MODEL: T-8 & T-10

(4) 1/4-28 x 3/8 Tapped Holes, (1) 5/16" DIA x 3/8 Dowel Hole on 5" Bolt Circle

MODEL: T-14 & T-18

(4) 3/8- 24 x 1/2 Tapped Holes, (1) 3/8" DIA. x 1/2 Dowel Hole on 10" Bolt Circle



INTERLOCKS AND LIMIT SWITCHES

Item G

NO. 172 ADJUSTABLE CAM ON EXTENDED GEAR SHAFT

The No. 172 Cam is mounted on the extended gear shaft which rotates 360° for each work and indexing cycle. Its purpose is to actuate No. 178 Limit Switch at the **end** of the lock position to de-energize power to the index table, and send a signal for work to perform.

No. 172 ADJUSTABLE CAM



No. 178 LIMIT SWITCH

No. 179 LIMIT SWITCH

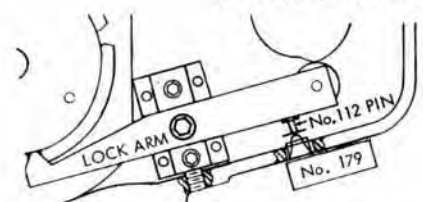
Item H

LIMIT SWITCH MOUNTED

No. 178 Single Pole Double Throw Oil Tight Limit Switch Mounted on Index Table in conjunction with No. 172 Cam.

Item I

No. 179 Single Pole Double Throw Oil Tight Limit Switch Mounted on Index Table in conjunction with No. 112 Lock Arm Switch Pin. The No. 179 Limit Switch de-energizes power to the Index Table and sends a signal for work to perform similar to No. 178 Limit Switch, but at the **beginning** of the lock position. Not recommended with hydraulic motor driven applications.



ELECTRIC MOTOR POWER

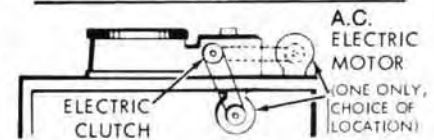
Item J

A.C. ELECTRIC MOTOR

Furnished by the customer. Provides power to the index table through a V Belt and pulley drive. The No. 200 Electric clutch is required as described below to interrupt power to the index table to obtain a longer dwell time than index time. Capacity is 75 starts and stops per minute.

RECOMMENDED H.P.:

Model T- 8 and T-10	1/4 H.P.
Model T-14 and T-18	1/2 H.P.
Model T-23 and T-28	1 H.P.

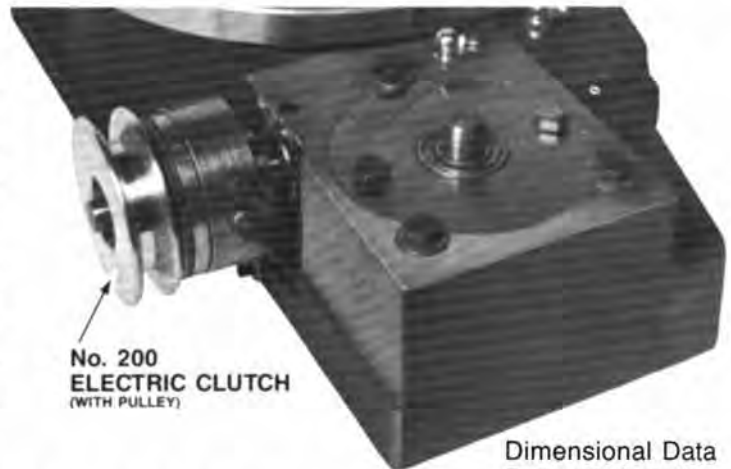


ELECTRIC CLUTCH

Item K

The A.C. Electric Motor runs continually, rotating the pulley on the Clutch in the de-energized (disengaged) position. When Indexing Motion is required, the Clutch is energized, engaging power to the Index Table input shaft. Then the Clutch is again de-energized in the original locked position.

No. 178 or No. 179 Limit Switch are utilized to energize and de-energize the Clutch. Exacting repetitive indexing motion time requirement is achieved from selection of electric motor RPM, Worm-Gear ratio and pulley size ratio from page 14 of the Selection & Application Bulletin.



Dimensional Data
Pages 6 thru 11

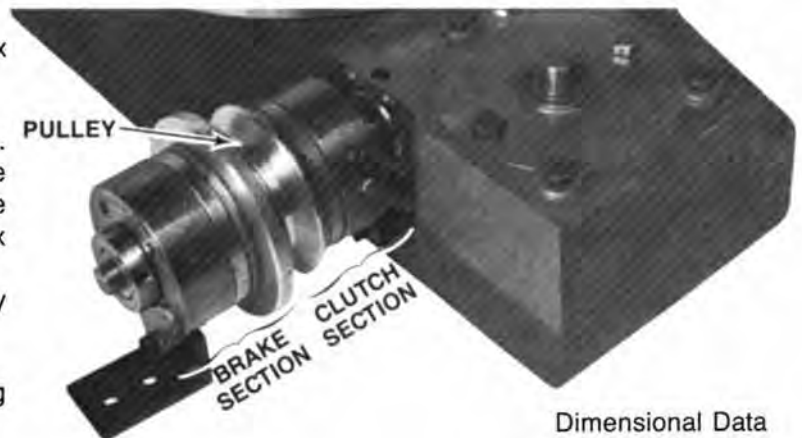
ELECTRIC BRAKE

Item L

The Brake need not be considered unless Index Motion Time is faster than 4/10 second.

No. 250 Electric Brake is an addition to the No. 200 Clutch. It is shaft mounted (adds 2" to the Clutch length) and gives instant braking for the small inertia of the Clutch to prevent the Index Table from coasting into the next Index position. A small bracket is furnished to loosely fasten the Brake to the machine bed.

Not intended to stop the Index Table during the Index cycle.



Dimensional Data
Pages 6 thru 11

RECTIFIER

Item M

A No. 214 Rectifier (Conversion Unit) is wired into the A.C. electric supply line so that the Clutch or Clutch with Brake receives full 90V DC voltage with immediate response from a 115V 60 Cy. AC power source.

DIMENSION:
2" x 2 5/8" x 2 3/4"
All Models

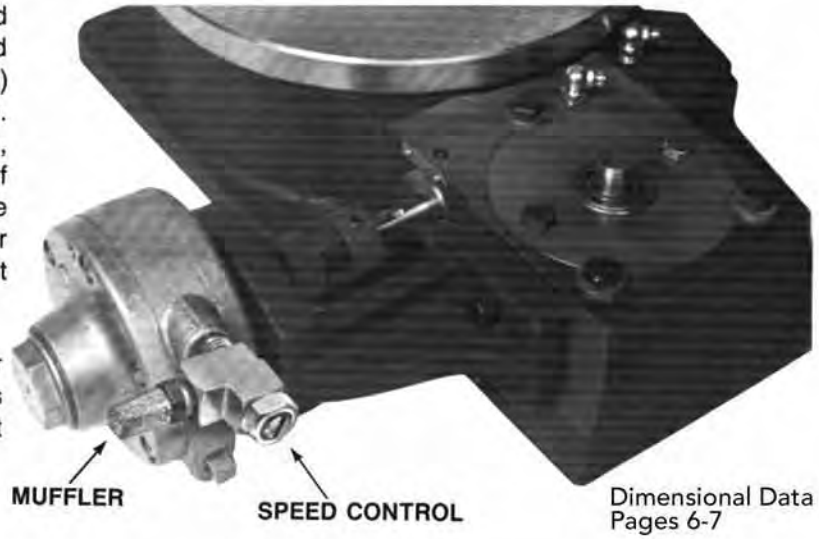


Item O

AIR POWER

No. 207 Rotary Vane type Air Motor is furnished Bracket Mounted on the Index Table. A speed control valve is utilized to control RPM (Index Speed) by restricting the air flow. A signal is sent from No. 178 or No. 179 Limit Switch to a straightway valve, piped in the exhaust port, to give instant on-off response (Dwell Time) to the No. 134 Index Table Input Shaft. A full 3/8" regulated and lubricated air line must be supplied. (Straightway valve is not furnished.)

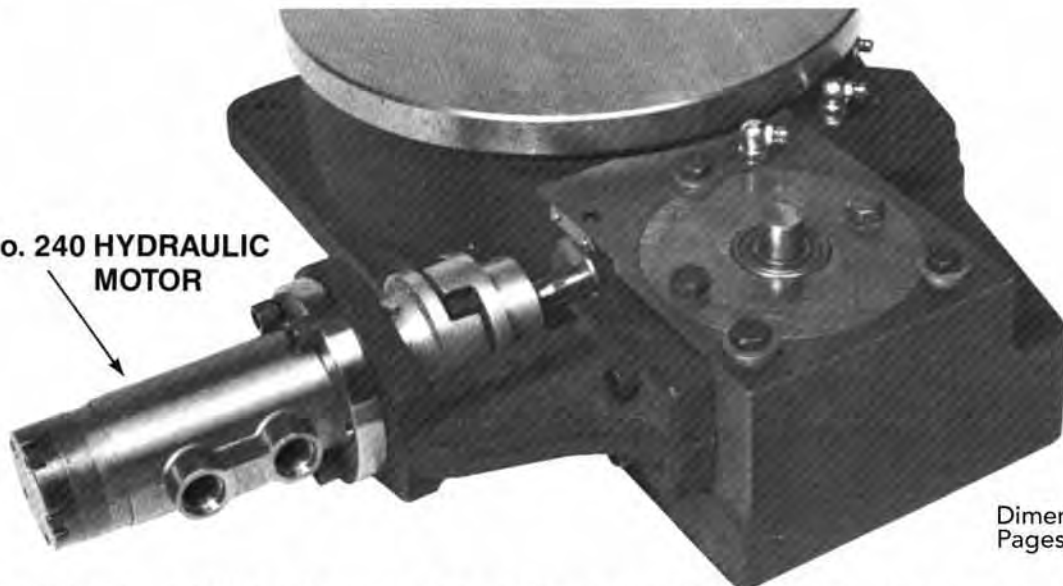
"V" - Belt Drive is applied at 1 1/2 sec. Index Time or slower on models T-8, T-10, T-14 and T-18. It is furnished at the same price as the published direct coupled price.



Item P

HYDRAULIC POWER

No. 240 HYDRAULIC MOTOR



The No. 240 Hydraulic Motor is furnished Bracket Mounted on the Index Table. At 1.0 sec. index time or slower a 40:1 gear ratio is applied, at 9/10 sec. index time or faster a 20:1 gear ratio is applied. A flow control valve is required to give exacting input RPM requirement (Index Speed). A signal is sent from No. 178 or No. 179 Limit Switch to a straight way valve piped to the inlet port for instant on-off response (Dwell Time) of the No. 134 Index Table input shaft. (Straightway valve not furnished)

TABLE MODIFICATIONS - SPECIALS

SKIP STATION

METHOD OF INDEXING THRU A STATION THAT IS NOT TO BE USED

Item Q

Index table will index to a non-productive station, rest at a non-productive station (equal to index time that approached station) and index to next non-productive or work station at 3 equal time sequences.

Any of total number of stations can be skipped.

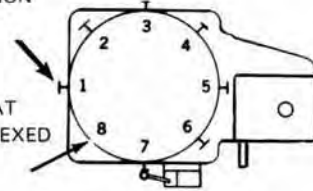
No. 172 Cam, No. 178 Limit Switch, and No. 179 Limit Switch are eliminated.

Not recommended with hydraulic motor driven application.

Increases inertia load capacities.

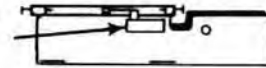
Ex. 2 station 180° index time is equal to 4 station 90° index time with double indexing for 180°.

NO. 301
TRIP DOG AT STATION THAT IS REQUIRED TO DWELL



TRIP DOG VOIDED AT STATION TO BE INDEXED THRU

NO. 300
LIMIT SWITCH MTD. TO RECEIVE ACTUATION FROM TRIP DOG (USE N.O. CONTACTS), AND SEND SIGNAL TO DWELL



MODEL TC CONTINUOUS ROTATION TABLE

Item R

LIMITS	MODELS	
	TC-8 TC-10	TC-14 TC-18
Max. Table Top R.P.M.	90	50
Min. Table Top R.P.M.	10	3
20:1 Gear Ratio Required If Table Top R.P.M. Faster Than:	45	25

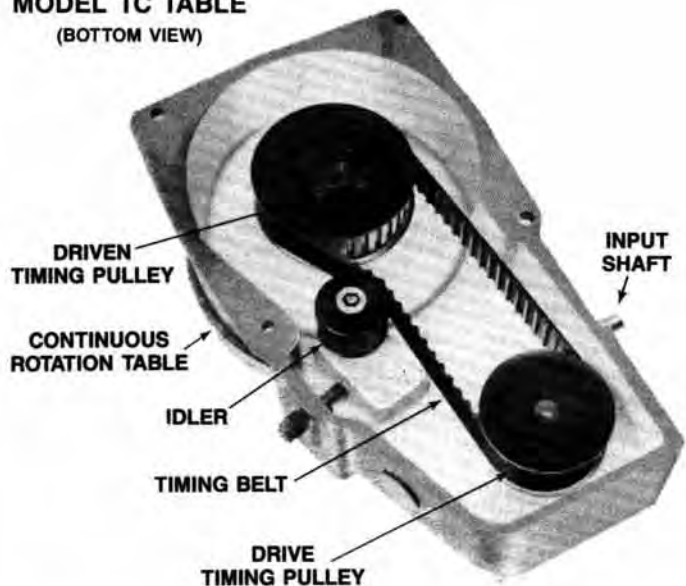
For requirements where a flat steel plate is required that is totally supported and will rotate 360° under power. Application with the required tolerances are to be furnished when placing the order.

Dimensions and outside view is the same as all 6 standard models as shown on pages 6, 7.

Standard electric, air and hydraulic power units can be applied as shown on pages 6, 7, 8 and 10, depending on the R.P.M. limitation of each type of power drive.

Two timing pulleys with an idler and timing belt are substituted for the conventional indexing and lock mechanism.

MODEL TC TABLE
(BOTTOM VIEW)



There is a backlash inherent in the timing belt, and worm gear. This unit should not be used for milling.

(EXAMPLE) — STEPS TO PLACE A COMPLETE ORDER — (EXAMPLE)

Item A.

Select Index Table Model Numbers from chart on Page No. 5.

Example: T-10 4 (T is for Table, 10 is Table Top Plate Diameter in inches, 4 is the number of equally spaced stations on the Index Table).

Item B. Rotation: (Top View)

Clockwise (Standard)
Counter-clockwise on request

C. Centerpost Construction: (Page 12).

Style C Standard: Extension & No Hole
Style D Option: Extension With Hole.
Style A Option: Recess & No Hole.
Style B Option: Recess With Hole.

D. 40:1 Worm-Gear Ratio (Page 12)

E. 20:1 Worm-Gear Ratio (Page12)

Item F. Table Top Mounting Holes (Page12)

INTERLOCKING ELECTRIC SWITCHES (Page 12).

Item G. No. 172 Adjustable Cam

H. No. 178 Electric limit Switch, mounted.

I. No. 179 Electric Limit Switch, mounted

ELECTRIC MOTOR POWER (Page 13).

Item J. Purchase locally:

Electric Motor with Pulley, and "A" belt to fit.

K. No. 200 Shaft Mounted Electric Clutch with pulley furnished. (Page 13).

L. No. 250 Shaft Mounted Electric Brake (when index time is 0.4 seconds, or faster) in addition to clutch. (Page13).

M.No. 214 Conversion Unit. (Standard) (Page 13).
Customer's Alternative:

N. No. 290 Adjustable Torque Control with Conversion unit. (Page 14).

AIR MOTOR POWER (Page 14).

Item O. No. 207 Air Motor, Bracket Mounted, with Speed Control Valve, and Muffler.

Purchase locally: Filter, Regulator & Lubricator and Air Valve.

HYDRAULIC MOTOR (Page 14).

Item P. No. 240 Hydraulic Motor, Bracket Mounted.

Purchase locally: All necessary hydraulic equipment including Flow Control Valve.

"HOW TO ORDER" EXAMPLE

Quantity ()

Item A. Model T-10-4

B. Clockwise Rotation

C. Style D Centerpost

D. 40:1 Worm-Gear Ratio

F. No. 172 Adjustable Cam

G. No. 178 Limit Switch

J. No. 200 Electric Clutch, Shaft Mounted with Pulley.

L. No. 214 Conversion Unit.

Advise Name of person who will

provide APPLICATION INFORMATION.

Warranty

JAN. 2006

At the discretion of Easom Automation Systems, any reasonable problem with a new or completely rebuilt product in material or workmanship deemed the fault of Easom Automation Systems will be warranted up to 100 days from date of shipment. Notification of any warranty claim must be presented to Easom Automation Systems and all warranty work completed within the 100 day warranty period.

Easom Automation Systems reserves the right to do all warranty and/or adjustments at our plant. Expenses such as shipping, customs, etc. are not the responsibility of Easom Automation Systems. Any work done outside of our plant voids the warranty. Charge-back invoices will not be honored. Easom Automation Systems' only obligation is limited to replacement of those parts which, in our opinion, are found defective. We are not liable for delays, nonperformance, injury, loss of production or profit, any damage which may be directly or indirectly implied. The total dollar amount of liability is limited to the total amount on our invoice. All sales are final.

A completed Application information form signed by a responsible employee of the claimant and received by Easom Automation Systems before shipment is necessary for validation of warranty.

All precautions and methods in the Selection and Application Bulletin must be adhered to for validation of warranty. Improper application or lack of maintenance voids this warranty.

All claims resulting from transit must be made directly to the carrier. Claims of shortage must be received by Easom Automation Systems within 30 days of shipment. All incorrectly quoted or typographical errors are subject to correction. The right to change design and specifications is reserved.

The above is in lieu of all other warranties expressed or implied.



3 Models Available

TECMES ASSEMBLY MACHINES

Complete with index table, pick and place, and rise and fall for up to 90 assemblies per minute - ready for your tooling.

Request TECMES Bulletin for Quotation Purposes

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