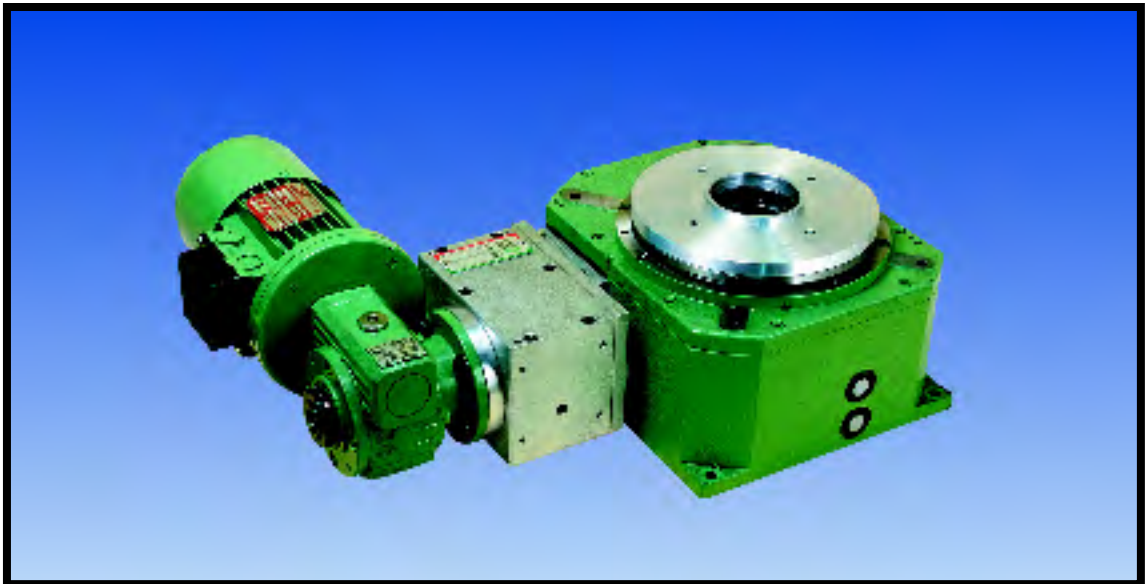


ROTARY INDEX TABLE TYPE TAP

30 to 256 Stations



autorotor
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32471 INDUSTRIAL DRIVE • MADISON HEIGHTS, MI 48071
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Model TAP Multi-Station Index Tables

The Model TAP Autorotor Index Drives consist of an Autorotor Model T Continuous Rotation Table as well as an Autorotor Model AP Parallel Axis Drive. By combining these two components a station pattern of equally spaced stations in larger numbers can be achieved which can not be accomplished by a standard barrel cam indexing drive.

By Keying the Parallel Axis Drive output shaft to the input shaft of the Continuous Rotation Table the motion laws that are provided on the cam for the Parallel Axis Drive are transmitted to the continuous barrel cam of the Continuous Rotation Table. Therefore each index will experience a smooth acceleration and deceleration.

By applying this method, the number of stations on the Parallel Axis Drive multiplied by the number of cam followers in the Continuous Rotation Table determines the number of stations transmitted to the table top output.

For example, if an eight station Parallel Axis Drive is applied to a Continuous Rotation Table with 15 cam follower bearings the resulting number of stations on the table top output would be 8* x 15* or 120* stations.

*Example per below.

Maximum No. of Stations Available Per TAP Model

Model AP Parallel Axis Drive Available # of Stations		Model T Continuous Rotation Table Max # of Cam Followers		Max. # of Stations for Model TAP Multi-Station Index Table	
AP 55 (2, 3, 4, 5, 6, 8)*	x	T-15 (15)*	=	TAP 15 ()	← (120)* Example
AP 70 (2, 3, 4, 5, 6, 8)	x	T-25 (18)	=	TAP 25 ()	
AP 70 (2, 3, 4, 5, 6, 8)	x	T-35 (20)	=	TAP 35 ()	
AP 110 (2, 3, 4, 5, 6, 8)	x	T-55 (24)	=	TAP 55 ()	
AP 110 (2, 3, 4, 5, 6, 8)	x	T-75 (26)	=	TAP 75 ()	
AP 135 (2, 3, 4, 5, 6, 8)	x	T-95 (32)	=	TAP 95 ()	

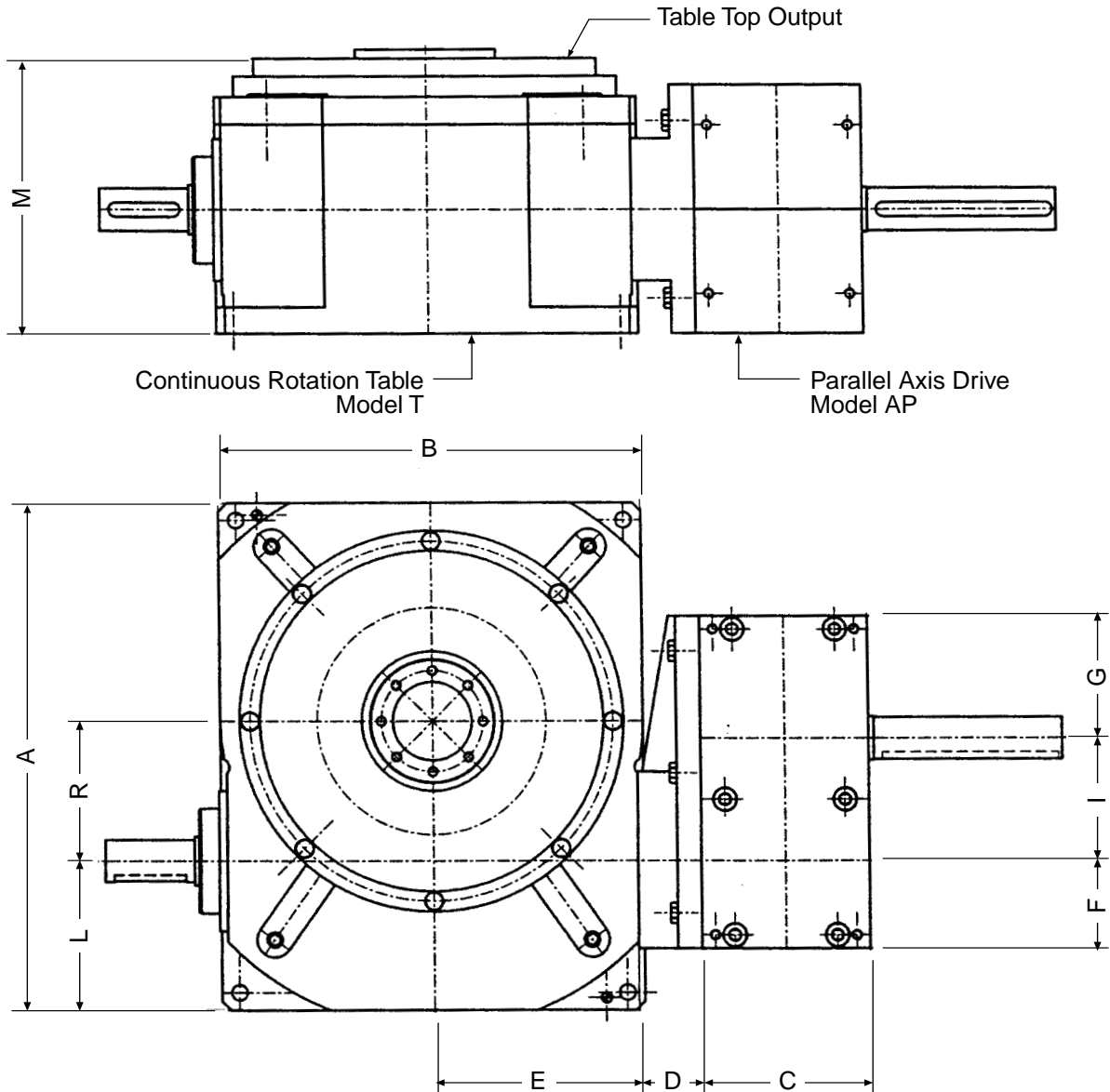
Degrees of CAM Rotation Angle Performing the Transfer Movement

Remaining Degrees of the 360°s CAM Rotation is the Dwell (Locked) Portion

Model AP Station #	Transfer (Indexing) Angle (°)						
2			150°	180°	210°	240°	270°
3		120°	150°	180°	210°	240°	270°
4	90°	120°	150°	180°	210°	240°	270°
5		120°	150°	180°	210°	240°	270°
6			150°	180°	210°	240°	270°
8		120°	150°	180°	210°	240°	270°

For basic information related to index tables and parallel axis intermittent drives, please see specific catalogs.

TAP 15 to 95 Overall Dimensions



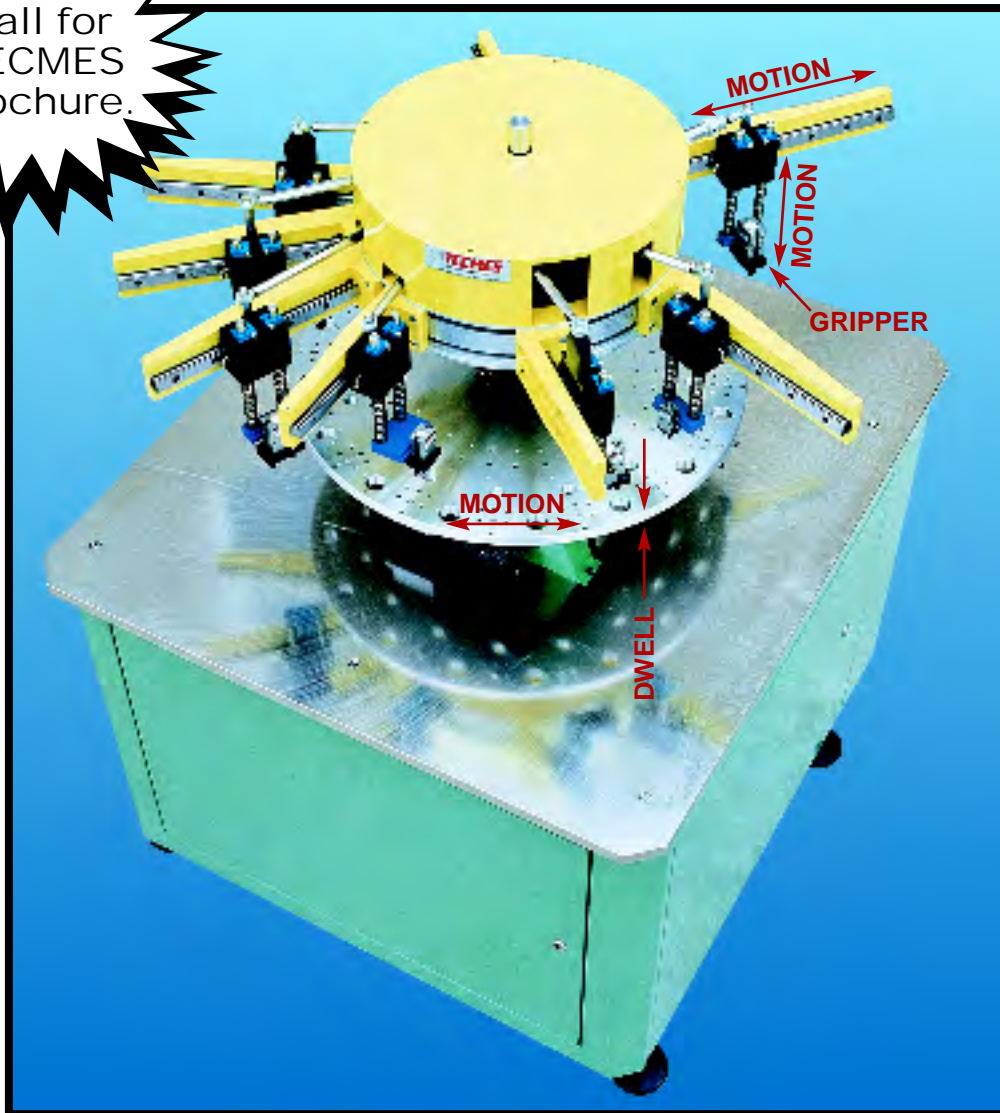
Motor size, gear box and flange mount to the indexer, are specified and dimensioned on the print that is forwarded with the quotation. Limit switch with cam actuation are found at the top of Page 30 of the Autorotor General Catalog.

Model	Minimum # Stations	Maximum # Stations	A	B	C	D	E	F	G	I	L	M	R	Lbs. Weight
TAP 15	30	120	8.07	6.70	3.54	.55	3.25	1.57	2.36	2.16	2.60	5.31	1.97	64
TAP 25	36	144	11.42	9.45	3.74	1.44	4.59	1.97	2.75	2.75	3.35	6.10	3.15	121
TAP 35	40	160	13.78	11.22	3.74	1.44	5.41	1.97	2.75	2.75	4.13	7.67	3.94	205
TAP 55	48	192	18.11	15.75	5.90	2.05	7.48	3.35	4.13	4.33	4.72	10.04	5.51	504
TAP 75	52	208	24.41	21.26	5.90	1.77	9.84	3.35	4.13	4.33	5.51	12.60	8.27	1056
TAP 95	64	256	31.50	27.56	7.09	2.28	12.60	4.13	5.12	5.31	7.09	16.54	10.63	2277

For other dimensions, please see our standard catalog.

DIMENSIONS ARE ORIGINALLY METRIC, CONVERTED TO INCHES.
TO CONVERT INCHES TO MILLIMETERS, MULTIPLY INCHES BY 25.4.

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**3 Models Available
8 to 36 Stations**

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.

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