Indexing Machine Bases and Dial Plates
Everything from a single source

Indexing units, machine bases and dial plates:

Basic idea

Stationary and rotating plates

Systems
Advantages at a glance

- **Guaranteed quality – No surprises**
  All your equipment with regards to design, dimensions and colour can be delivered to you from a single source including a test report.

- **Short delivery times**
  Based on our standard designs we can supply a mechanically built rotary assembly machine in as little as 6 weeks.

- **Save time and money – No surprises**
  Reduce your time from installation to production with minimal engineering, design and manufacturing.

- **Design**
  We offer attractive base designs in round, square or according to your requirements.

- **Surface treatment**
  Aluminium – anodised
  Steel – chemically nickel plated or coloured brown
  Fabricated steel sections powder coated

www.weiss-gmbh.de
SR Series

- Select the rotary indexing table suitable for your application
- Series TC-T, TR/NR, NC-T or TO. All are available in various model sizes (please refer to appropriate brochure)
- The overall height of your machine will be determined by the height of the indexing unit used and the length of the support legs.

Special Features:

- 5 standard sizes: BG 100R, BG 200R, BG 300R, BG 400R, BG 500R
- 3 - 4 standard ribbed legs depending on diameter
- Customised diameters / designs available on request

Additional Rotating Dial Plates

- Our aluminium dial plates are manufactured in a controlled temperature environment from at least 3 month aged material
- Dimensions, manufacturing and surface treatments according to your specification
- Supplied with a quality certificate
SK Series

Technology that inspires

Special Features:
- 3 standard sizes: BG 100K, BG 200K, BG 300K
- Integrated switch cabinets available
- Sheet metal infills possible
- Sizes available up to 2100 mm x 2100 mm (2900 mm diagonal measurement possible)
- Customised sizes available upon request

Base Plates
- Round, square or rectangular
- Dimensions, material and processing according to your specification
- Machining according to your drawing
- T-slots possible
- Cable ducts standard

Basic Frames
- Round and square standard sizes
- Height adjustment possible
- Customised design upon request
- High quality rigid fabricated construction
- Height adjustable and shock absorbing feet
- Switch cabinets can only be fitted into square bases

Additional Stationary Top Plates
- With integrated lip seal between stationary and rotating indexing plate
- In aluminium or steel, manufactured according to your drawing
- T-slots possible
## SR Series

### Table of dimensions for standard version

(Attention! New type designation)

<table>
<thead>
<tr>
<th>Type</th>
<th>Recommended rotary table type</th>
<th>ØA (Standard)</th>
<th>B</th>
<th>B*</th>
<th>H</th>
<th>ØI</th>
<th>ØJ</th>
<th>ØK</th>
<th>M*</th>
</tr>
</thead>
<tbody>
<tr>
<td>BG 100R</td>
<td>TC 150T, TC 220T, TC 320T, TO 150C, TO 220C, TO 750C</td>
<td>1300</td>
<td>35</td>
<td>40</td>
<td>575</td>
<td>960</td>
<td>615</td>
<td>960</td>
<td>760</td>
</tr>
<tr>
<td>BG 200R</td>
<td>TC 220T, TC 320T, TC 500T, TR/NR 750, TR/NR 1100, TO 750C</td>
<td>1500</td>
<td>35</td>
<td>40</td>
<td>485</td>
<td>1200</td>
<td>815</td>
<td>1200</td>
<td>760</td>
</tr>
<tr>
<td>BG 300R</td>
<td>TC 320T, TC 500T, TC 700T, TR/NR 750, TR/NR 1100, PM 1500</td>
<td>1800</td>
<td>35</td>
<td>40</td>
<td>615</td>
<td>1350</td>
<td>967</td>
<td>1350</td>
<td>760</td>
</tr>
<tr>
<td>BG 400R</td>
<td>TC 500T, TC 700T, TR/NR 1100, TR/NR 1500</td>
<td>2200</td>
<td>35</td>
<td>40</td>
<td>690</td>
<td>1800</td>
<td>1357</td>
<td>1800</td>
<td>760</td>
</tr>
<tr>
<td>BG 500R</td>
<td>TR/NR 1500, TR/NR 2200</td>
<td>2500</td>
<td>35</td>
<td>40</td>
<td>656</td>
<td>2200</td>
<td>1700</td>
<td>2200</td>
<td>760</td>
</tr>
</tbody>
</table>

General tolerances in conformity with DIN ISO 2768-m. Special tolerances upon request.

**Notes:** The positioning of the legs may not be symmetrical depending upon the indexing unit selected. For dimensions please request a drawing. See the relevant rotary indexing table brochure for permissible loads on stationary or rotary indexing plates. Special machining according your drawing.

### Optional raised support dimensions

for indexing rings TR / NR.

<table>
<thead>
<tr>
<th>Table type</th>
<th>Name</th>
<th>ØDS</th>
<th>ØdS</th>
<th>Height</th>
<th>Name</th>
<th>ØDR</th>
<th>ØdR</th>
<th>Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>NR 750, TR/NR 750, TC 750</td>
<td>ZH 750S</td>
<td>485</td>
<td>410</td>
<td>21,5</td>
<td>ZH 750A</td>
<td>770</td>
<td>440</td>
<td>variable</td>
</tr>
<tr>
<td>TR 1100, TR/NR 1100, TC 1100</td>
<td>ZH1100S</td>
<td>795</td>
<td>720</td>
<td>32</td>
<td>ZH1100A</td>
<td>1100</td>
<td>740</td>
<td>variable</td>
</tr>
<tr>
<td>TR 1500, TR/NR 1500, TC 1500</td>
<td>ZH1500S</td>
<td>1130</td>
<td>1055</td>
<td>32</td>
<td>ZH1500A</td>
<td>1420</td>
<td>1080</td>
<td>variable</td>
</tr>
</tbody>
</table>

Indexing ring with base frame and raised supports

Raised support for fixed centre plate

Raised support for rotating ring (up to 70 mm in height: ring of solid material)
SR Series Dimensions

Technology that inspires

Please download the selected machine base from www.weiss-gmbh.de (in 2D or 3D) directly into your CAD drawing. This will ensure you are using the latest model.

*Please see our TC-T und TR/NR brochures for recommended dimensions and Ø.
### SK Series

#### Table of dimensions for standard version

(Attention! New type designation)

<table>
<thead>
<tr>
<th>Type</th>
<th>Recommended rotary table type</th>
<th>ØA</th>
<th>B</th>
<th>B*</th>
<th>H</th>
<th>ØI</th>
<th>ØJ</th>
<th>ØK</th>
<th>M*</th>
</tr>
</thead>
<tbody>
<tr>
<td>BG 100K</td>
<td>TC 150T, TC 220T, TC 320T</td>
<td>1300</td>
<td>35</td>
<td>40</td>
<td>410</td>
<td>1000</td>
<td>615</td>
<td>1000</td>
<td>760</td>
</tr>
<tr>
<td>BG 200K</td>
<td>TC 220T, TC 320T, TC 500T, TR/TR 750</td>
<td>1480</td>
<td>35</td>
<td>40</td>
<td>610</td>
<td>1300</td>
<td>1007</td>
<td>1300</td>
<td>760</td>
</tr>
<tr>
<td>BG 300K</td>
<td>TC 320T, TC 500T, TC 700T, TR/NR 750, TR/NR 1100, (Pik-o-mat) PM 1100, PM 1500</td>
<td>1800</td>
<td>35</td>
<td>40</td>
<td>710</td>
<td>1610</td>
<td>1310</td>
<td>1610</td>
<td>760</td>
</tr>
</tbody>
</table>

General tolerances in conformity with DIN ISO 2768-m. Special tolerances upon request.

* with T-slots

**Notes:** The positioning of the legs may not be symmetrical depending upon the indexing unit selected. For dimensions please request a drawing. See the relevant rotary indexing table brochure for permissible loads on stationary or rotary indexing plates. Special machining according your drawing.

Example detailing SK 300K, TC 320, dial and stationary plates.
SK Series Dimensions

Technology that inspires

Please download the selected machine base from www.weiss-gmbh.de (in 2D or 3D) directly into your CAD drawing. This will ensure you are using the latest model.

*Please see our TC-T und TR/NR brochures for recommended dimensions and Ø.
Additional Plates

Stationary Plate
- Standard model with integrated sealing lip between stationary and rotating plate in steel or aluminium
- Delivered with assembly hole and bore pattern (incl. middle bore) appropriate for the table, T-slots possible
- Manufactured in Flatness Quality B including 3 off blanked machining holes
- Please note! All drill holes are blind in order to avoid the accidental blocking of the rotary indexing table

Rotary Indexing Plate
- Precision machined from aged material in a controlled temperature environment
- Recommended to be manufactured from aluminium to minimise weight
- With appropriate assembly holes and bore patterns (plate is located on the rotary indexing table with two dowel pins)

Base Plate
- 3 cable ducts as standard
- Including cut out for drive when mounted on underside, if required
- Prior to positioning your automation equipment please observe the standard hole pattern for fixing the base plate to the base frame
- T-slots possible

Guaranteed Precision
- We guarantee the highest precision for flatness and repeatability. Measurements are taken from the indexing dial plate when assembled to the rotary indexing unit. The precision is documented in an inspection certificate.
- Indexing accuracy of hole patterns – up to Ø 1800 mm ± 3” over Ø 1800 mm ± 8”
- Please forward your drawing by eMail in DXF format

Manufacturing Note
- 3 off tapped holes are machined in plates for manufacturing purposes. (blanked on stationary plates only)

Axial accuracy for additional indexing plates

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Thickness</th>
<th>Flatness Quality A (mm)</th>
<th>Flatness Quality B (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>≤ 600</td>
<td>≥ 20</td>
<td>0.04</td>
<td>0.10</td>
</tr>
<tr>
<td>&lt; 20</td>
<td></td>
<td>0.06</td>
<td>0.15</td>
</tr>
<tr>
<td>≤ 800</td>
<td>≥ 20</td>
<td>0.06</td>
<td>0.15</td>
</tr>
<tr>
<td>&lt; 20</td>
<td></td>
<td>0.07</td>
<td>0.18</td>
</tr>
<tr>
<td>≤ 1100</td>
<td>≥ 20</td>
<td>0.07</td>
<td>0.18</td>
</tr>
<tr>
<td>&lt; 20</td>
<td></td>
<td>0.08</td>
<td>0.20</td>
</tr>
<tr>
<td>≤ 1400</td>
<td>≥ 25</td>
<td>0.08</td>
<td>0.20</td>
</tr>
<tr>
<td>&lt; 25</td>
<td></td>
<td>0.10</td>
<td>0.25</td>
</tr>
<tr>
<td>≤ 1800</td>
<td>≥ 25</td>
<td>0.10</td>
<td>0.25</td>
</tr>
<tr>
<td>&lt; 25</td>
<td></td>
<td>0.20</td>
<td>0.50</td>
</tr>
<tr>
<td>≤ 2500</td>
<td>≥ 30</td>
<td>0.15</td>
<td>0.40</td>
</tr>
<tr>
<td>&lt; 30</td>
<td></td>
<td>0.25</td>
<td>0.55</td>
</tr>
</tbody>
</table>

Delivery Time
- Depending on the diameter within 4 to 6 weeks including drilling work.
- Standard dimensions can be supplied at short notice. (outer diameters: 600, 700, 800, 1000, 1100, 1200 and 1600)
- Surface treatment: 1 week additional processing time required
- Aluminium: anodised
- Steel: chemically nickel-plated or coloured brown
Dear Customer,

Thank you for your interest in our equipment. To ensure we construct the machine to the exact requirements of your application, we kindly ask you to answer the following questions:

**Stationary plate**

Material:  
- Steel  
- AlMg4,5Mn  
- Special

Surface Treatment:  
- Alum/Steel  
- anodised  
- chem. nickel-plated  
- coloured brown

Seal:  
- flush  
- not flush  
- Special

Dimensions Ø E __________ mm
Dimensions F __________ mm - 1 mm air gap = thickness
Dimensions Ø G __________ mm
Processing according to drawing No. __________

**Rotating dial plate**

Material:  
- Steel  
- AlMg4,5Mn  
- Special

Surface Treatment:  
- Alum/Steel  
- anodised  
- chem. nickel-plated  
- coloured brown

Flatness of Ring:  
- A  
- B  
- Special

Standard assembly and bore hole pattern:  
- with countersinking  
- without countersinking

Dimensions Ø C __________ mm  
Thickness D __________ mm
Processing according to drawing No. __________

**Spacer Height**

- for rotating ring: Height __________ mm
- for stationary centre plate: Height __________ mm

**Base Plate**

Material:  
- Steel  
- AlMg4,5Mn  
- Special

Surface Treatment:  
- Alum/Steel  
- anodised  
- chem. nickel-plated  
- coloured brown

Cable duct:  
- Standard  
- According to drawing No. __________

T-slots:  
- no  
- yes

Processing according to drawing No. __________

Round: Dimensions Ø A __________ mm  
Thickness B __________ mm
Square/Rect. Dim. A1 __________ mm  
Dim. A2 __________ mm  
Thickness B __________ mm

**For technical enquiries**

Company: ____________________________________________
Name: ________________________________________________
Department: __________________________________________

Desired delivery date: __________________________________
Phone: ___________________    Fax: ______________________
eMail: ________________________________________________

12/2006
Rotary Indexing Tables TC
Rotary Indexing Rings TR/NR
Numeric Controlled Heavy Duty Indexing Ring CR
Numeric Controlled Indexing Tables NC
Torque rotary table TD
Compact model
Ring construction
Handling device HP 140
Flexible Assembly Machine Pick-o-Mat
Side loading rotary unit TH
Fast Cycling Linear Assembly System LS 280
Indexing Machine Bases SR/SK
Additional indexing plate

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