

CYCLE DESCRIPTION

The above operation diagram shows the sequence to be followed in order to move from position 1 to position 2, in clockwise rotation (with the turret tool-holder disk in front), and from position 2 to position 11 in anticlockwise rotation.

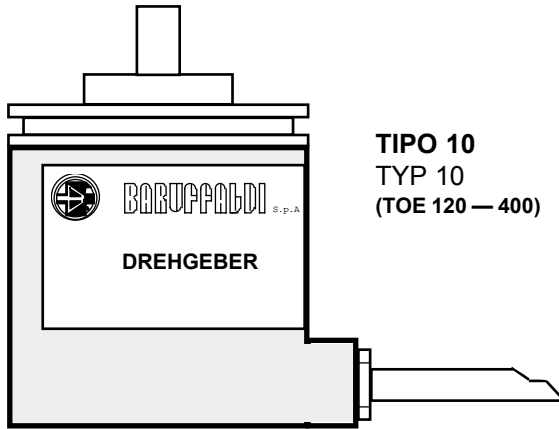
The brake is first de-energised and the motor feed for rotation in the direction selected. When the falling wavefront of the STROBE signal for the previous station is arrived at, the pre-indexing electromagnet is energised as quickly as possible (within the maximum permitted delay time).

With the electromagnet energised, the pre-indexing proximity switch signal is awaited, which confirms the rotation has been halted by means of the index key. Upon receipt of this signal the motor is immediately halted and the rotation sense is reversed after a 50 ms pause.

The locking proximity switch signal is then awaited, before halting the motor as rapidly as possible and energising the brake (within the maximum permitted delay time).

A safety check can be carried out at this point and consent for machining can be given, followed by electromagnet de-energising after a 200 ms pause.

NOTE: The maximum care should be taken regarding the permitted delays, particularly their repeatability. (Delays should be measured directly on the turret component devices).



TIPO 10
TYP 10
(TOE 120 — 400)

- A (1° BIT) WHITE
- B (2° BIT) YELLOW
- C (3° BIT) GREEN
- D (4° BIT) VIOLET
- PARITA' RED (parity)
- STROBE BLACK
- + 24 VOLT BROWN
- 0 VOLT BLUE

Screen YELLOW-GREEN

ENCODER CODE TABLE

POSIZIONE POSITION	A	B	C	D	PARITA' PARITY	STROBE
1	●				●	●
2		●			●	●
3	●	●				●
4			●		●	●
5	●		●			●
6		●	●			●
7	●	●	●		●	●
8				●	●	●
9	●			●		●
10		●		●		●
11	●	●		●	●	●
12			●	●		●

SPECIFICATIONS

- Power supply 24 Volt dc +/- 10 % Ripple 10 %
- PNP outputs (50 mA max) BINARY code
- PARITY Check and STROBE signal
- Reverse polarity protected
- Output short-circuit protected
- Connection to be made with 8-pole screened cable