

TB0390 Fitting SR Datum Sensor

Due to the SR Axis losing its datum position an additional datum sensor is to be fitted.

 Difficulty **Medium**

 Duration **30 minute(s)**

Contents

Introduction

Step 1 - Fit U Bolt and Sensor Bar

Step 2 - Remove 2x M8 screws

Step 3 - Fit Flag and Bracket to Motor Plate with 2x M8 x 50 Screws

Step 4 - Ensure Bracket is far right in the slots

Step 5 - Check sensor is activated

Step 6 - ELECTRICAL

Step 7 - SOFTWARE SETUP

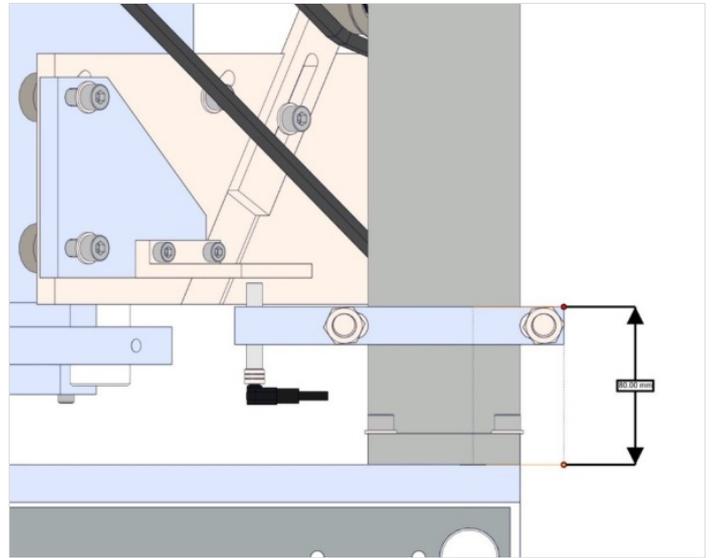
Comments

Introduction

Item Number	Part Number	Description	Qty
1	D0015489	Saw Turntable Sensor Bar	1
2	D0015490	Saw Turntable Sensor Flag	1
3	D0015491	Saw Turntable Flag Bracket	1
4	E0000336	8mm Threaded Proximity Sensor	1
5	E0000337	M8 90° Lead	1
6	F0000543	U Bolt 3" with Nuts	1
8	F0000059	M8 Washer	2
9	F0000014	M6 x 20 SKT CAP SCREW	2
10	F0000028	M8 x 50 SKT CAP SCREW	2

Step 1 - Fit U Bolt and Sensor Bar

Fit U Bolt and Sensor Bar to Table Post on infeed side of saw. See Image for height



Step 2 - Remove 2x M8 screws

Remove 2x M8 screws holding Motor Plate.

Step 3 - Fit Flag and Bracket to Motor Plate with 2x M8 x 50 Screws

Fit Flag and Bracket to Motor Plate with 2x M8 x 50 Screws

Step 4 - Ensure Bracket is far right in the slots

Ensure Bracket is far right in the slots and sensor flag is parallel to turntable base.

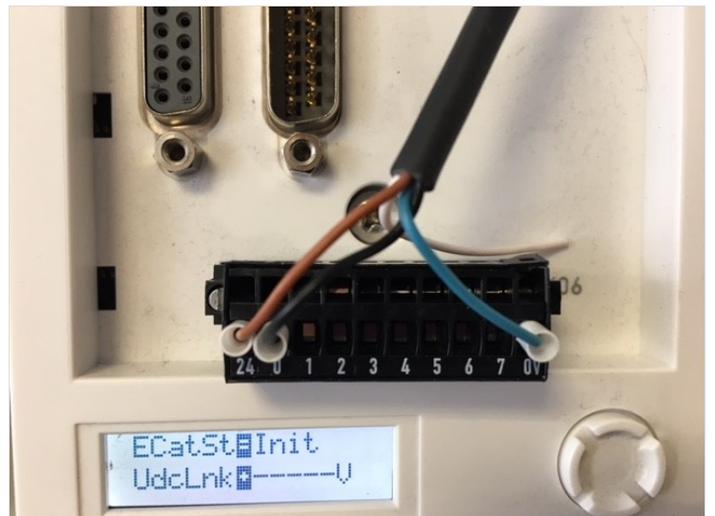
Step 5 - Check sensor is activated

Check sensor is activated by the flag and stays on when turntable is in maximum position

Step 6 - ELECTRICAL

Sensor wiring should be

Cable Colour	IO Terminal
Brown	24v
Blue	0v
Black	0



Step 7 - SOFTWARE SETUP

Drive must be set up to map IO values through to Drive_IO_Status[Axis] array. This is done in 2 steps

1. Add the Digital Inputs State PDO P-0-0801 to S-0-0016 for the SR drive. If a dual axis drive used, ensure you select the correct PDO from the PDO List as there is one for each axis. This is all in the Process Data tab.
2. Link the Digital inputs word to to Drive_IO_Status[9] – simply double click it in the list of IO for the drive

