



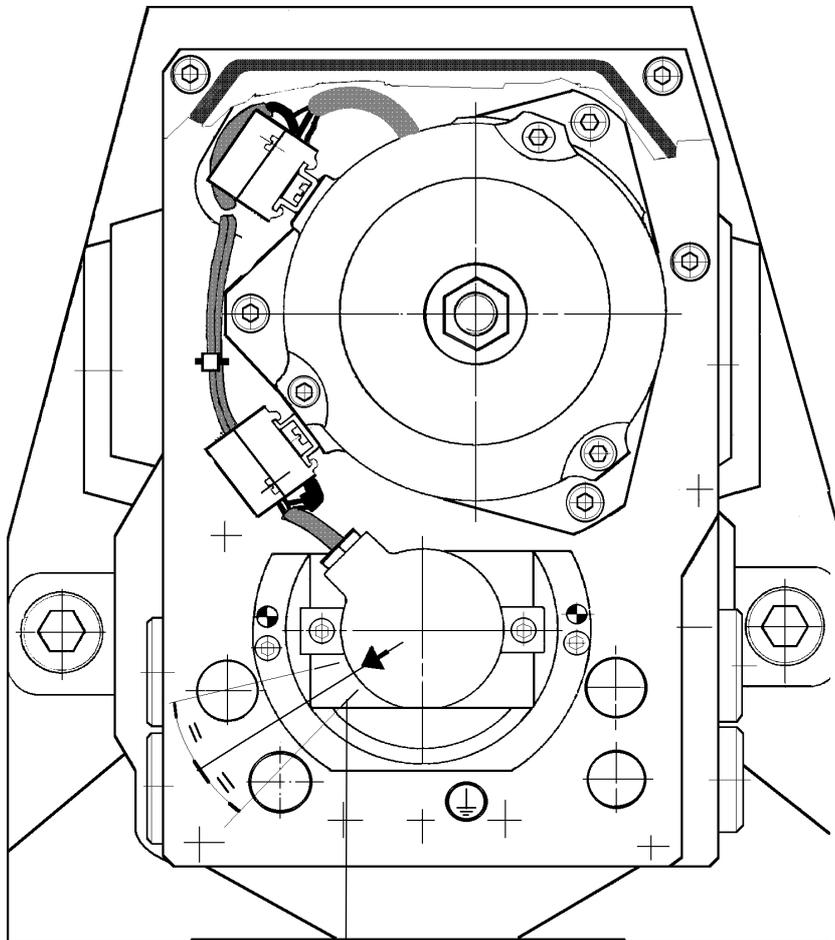
Remove the rear cover 011, disconnect the encoder leads from the terminal block 310, remove the stirrups 067 and extract the encoder. Remove the driving hub 035 and mount it on the new encoder.
Remount the encoder following the above instructions in reverse and connect it to the terminal blocks. Before finally fixing the encoder set it as follows:

Lock the turret in any position, rotate the encoder slowly until the STROBE signal disappears (this can be checked on the control system or with a voltmeter).

Mark the encoder and make a corresponding mark on its support. Slowly turn the encoder in opposite direction until the STROBE signal again disappears, and mark the new position on the support.

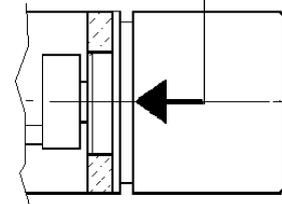
This define the region in which there is a STROBE signal. Slowly turn the encoder until the mark on the shaft is a half way between the two marks on the support.

Tighten the stirrups 067 and replace the rear cover.



Marks on the encoder support

Mark on the encoder





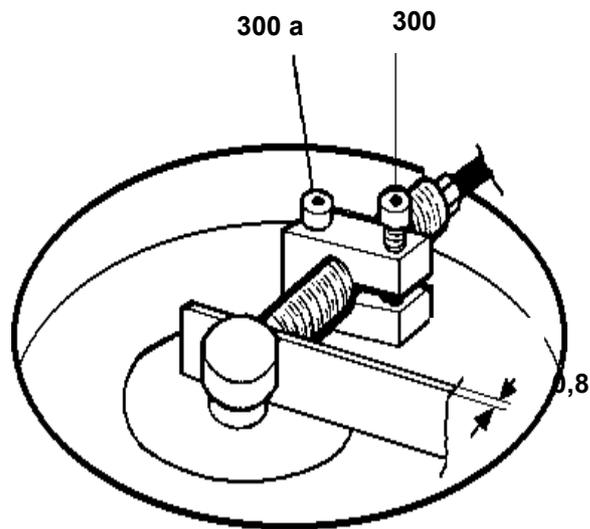
Remove the top cover 044, remove the support 042 together with the proximity switch 301. Remove the rear cover 011, disconnect the proximity switch leads from the terminal block 310, and remove the proximity switch. Screw the new proximity switch into the support until it projects by the correct amount "X".

Assemble the support fixing it with the screw 300a in such a way that LED (luminous indicator) on the end of the proximity switch is visible. Insert a 0,8 mm thickness gauge (see figure) and bring the proximity switch into contact with the thickness gauge. Tighten the screws 300 - 300a with a torque of 3 Nm and block them with LOCTITE.

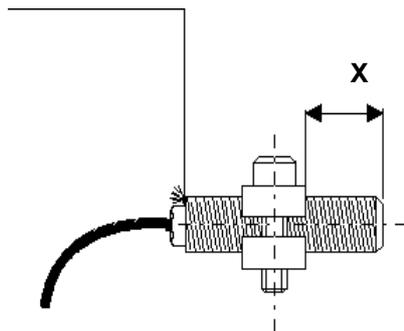
Connect the leads to the terminal block, and check that the proximity switch operates correctly when live, as follows:

- with a turret closed (locked) on lowering the end of the electromagnet by an amount between 1,8 and 2,5 mm the luminous "red" indicator on the back part of the proximity switch should light up.

Replace the rear cover and the top cover.



Luminous indicator



Turret size	X (mm)
TOE 120	18,3
TOE 160	18,3
TOE 200	18,3
TOE 250	18,3
TOE 320	18,3
TOE 400	18,3