Remove the top cover 044, unscrew screw 314, extract the support 049, take off the rear cover 011, disconnect the leads of proximity switch 313 from the terminal block. Unscrew the ring nut 048, unscrew and remove the wire clip 058, and remove the proximity switch.

Screw the new proximity switch into the support by amount needed to make dimension "Z" equal to figures in the table below. The dimension given for "Z" in the table are however only indicative, and correct setting of the operating distance "P" may require departure from those values.

The amount of the operating distance is obtained by difference:

(P) 0,8 mm = V - Z

where "V" and "Z" are actual measured values

To measure "V" the closing sector (i) of the roller ring 006 must be against the proximity switch, that is to say with the turret in the locked condition.

If it is not in this state carry out the closing operation manually.

After adjusting the value of the operating distance "P" screw down the ring nut (tightening torque 3 Nm).

Peen over the edges of the ring nut, thread the wire clip 058 on the proximity switch leads.

Replace and screw on the support 049.

Connect the proximity switch leads on the terminal block (see wiring scheme).

With the proximity switch live the red luminous indicator on the end of the proximity switch should be visible through the upper hole "n" in the support 049.

When this indicator is lit the turret is in the locked condition.

Replace the wire clip, the rear cover and the top cover.
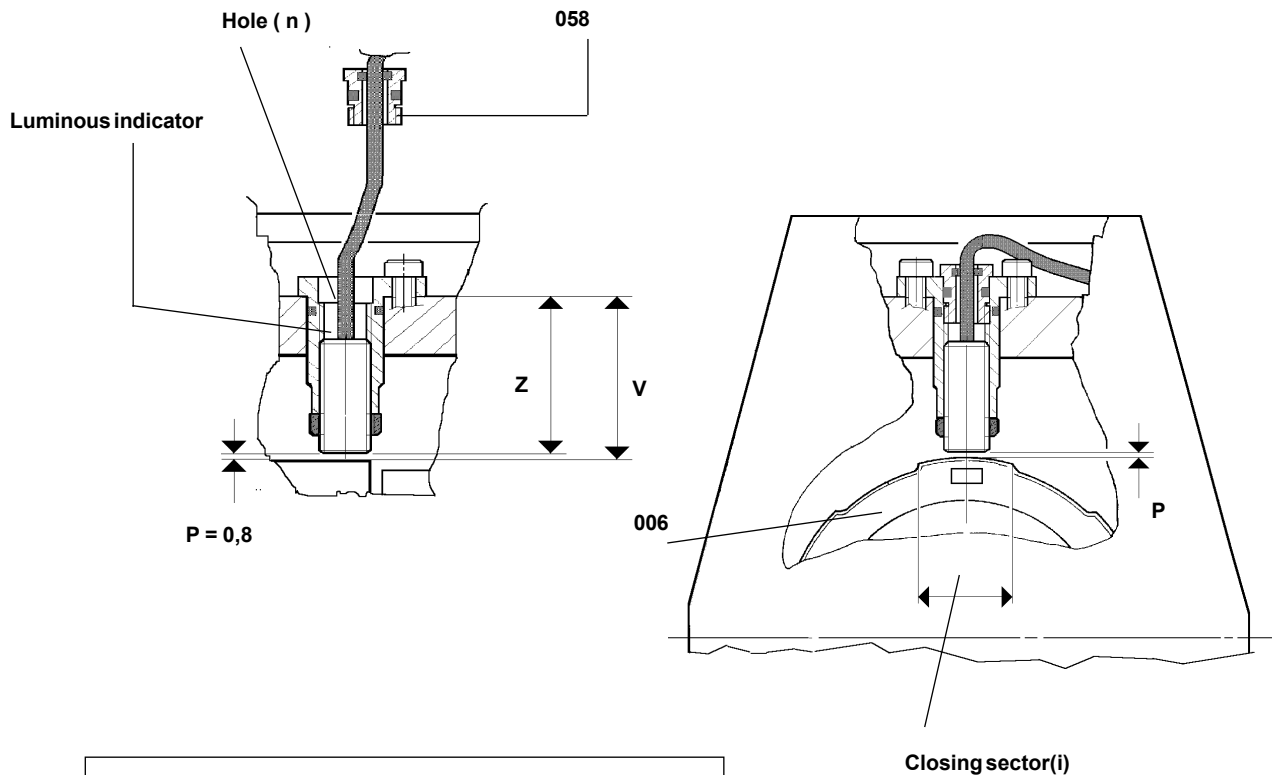
Turret size	Indicative value of Z (mm)
TOE 120	60,7
TOE 160	59,7
TOE 200	60,7
TOE 250	75,7
TOE 320	66,7
TOE 400	99,2

BARUFFALDI S.p.A

OPERATIONS TO BE CARRIED OUT IN CASE THE POSITIONING CYCLE HAS NOT BEEN COMPLETED
an emergency or accidental stop occurred

Pagina N°.
Page Nr. **24**

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Call up from the console a "tool change" (the nearest one) keeping to the same direction of rotation that the turret (the toolholder disk) had when it stopped. If this is not known and the "change" called for does not go through to completion (namely not locking or bringing about the operation of the heat sensor), proceed as follows:
- Noted the direction of the disk rotated during the attempted (unsuccesfully) "tool change"; call up from the console the nearest station which can be reached by rotating the disk from its present position in the opposite direction to that of the previous attempt.

If the control refuses to accept a "tool change" starting from the condition of "turret unlocked", then carry out the necessary operations manually as follows:
- Remove the rear cover 011 and the top cover 044, unscrew and partially extract the wire clip 058, disconnect the motor and the brake leads from the terminal block 310 (still keeping the proximity switches connected; please note the order of the motor wires, in order to avoid wrong connection at the end of operations).
Using a hexagonal spanner (see table) turn the motor shaft 012 by hand so that the toolholder disk rotatesin the same direction as it did when it stopped and at the same time push the core 073 of the electromagnet 200 until the latch 017 enters recess in the divider 005.
Keeping the core pushed reverse the rotation of motor shaft until the red indicator of proximity switch 313 lights up and can be seen from above through the hole (n).
Make the shaft rotate for another turn but working so that the indicator still remain lit.
If the direction in which the disk was rotating when it stopped is not known and a mechanical block is encountered after the reversal and the turret will not lock, the shaft must be made to rotate in the same sense as that proceeding the reversal.
Screw on the wire clip, reconnect the leads to the terminal block (care the phases of the motor leads), replace top and rear covers.

Turret size	Size of spanner CH (mm)
TOE 120	5
TOE 160	5
TOE 200	5
TOE 250	5
TOE 320	6
TOE 400	6

**IMPORTANT: for an automatic positioning call,
see the electrical instructions**