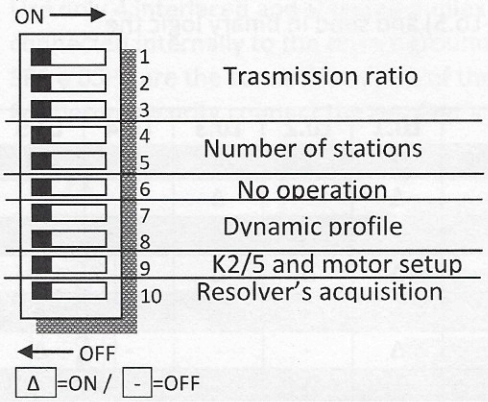
[5.1] DIPSWITCH: Selection of Turret type

Turret type selection must be performed before switching the machine on, as actuator, once powered on(+24Vcc), shall load all parameters relevant to the turret and to the dynamic profile suitable for the toolholder disk and tools used.



DIP	DESCRIPTION	VALUE
1	Trasmission ratio	bit 1
2		bit 2
3		bit 4
4	Number of stations	bit 1
5		biit 2
6	No operation	
7	Dynamic profile	bit 1
8		bit 2
9	K2/5 and motor setup	On/Off
10	Resolver's acquisition	On/Off

Trasmission ratio

	DIP N°			Description
Dec.	1	2	3	
0	-	-	-	Tb..120/160
1	Δ	-	-	Tb..200/250
2	-	Δ	-	Tb..320
3	Δ	Δ		Tb..400
7	Δ	Δ	Δ	Tb..

Selects the type of turret with its mechanical ratio. Profile n° 7 to load a custom profile defined using the supervisor's software.

Number of stations

	DIP N°		Description
Dec.	4	5	
0	-	-	8
1	Δ	-	12
2	-	Δ	16
3	Δ	Δ	24

Selects the total nr of turret's positions.

Dynamic profile

	DIP N°		Description
Dec.	7	8	
0	-	-	Universal
1	Δ	-	Low inertia
2	-	Δ	Medium inertia
3	Δ	Δ	Max inertia

Depending on the applied inertia (see datasheet 1 next page)
the drives is regulated accordingly, through the parameters such as speed, acceleration, deceleration, inertia

K2/5 and motor setup*

	DIP N°	Description
Dec.	9	
0	-	No operation
1	Δ	Start function

*Since firmware 8.5 and next
See the instructions on the chapter 5.12: with this function is possible change the drive's setup and switch between standard turret K2 or absolute turret K5 and load a different motor.

Resolver's acquisition

	DIP N°	Description
Dec.	10	
0	-	No operation
1	Δ	Start resolver's acquisition

See chapter 5.7.

[5.7] Mod. 7 - Resolver Position Acquisition

When all mod.bit Li.1+Li.2+Li.3 are on (+24Vdc) the resolver position acquisition mode is selected. This procedure stores in the drive the position of resolver in which turret is in mechanical position ONE. If this mode is not correctly executed, it will not be possible to call any position.
This operation is implemented in factory and is necessary repeat only in following cases:

- Replacement / disassembly of brushless motor
- Replacement of servo-amplifiers

Operations to be carried out in order to execute this procedure are:

1. Check that the turret is correctly connected and feed the drive.
2. Set all MOD BITS Li.1-Li.2-Li.3= On
3. Input one START command
   [turrets unlocks]
4. Manually move turret to mechanical position 1
5. Input one START command
   [turrets locks]

in case operation is successfully completed, ST INDEX, ST LOCK are activated and position Feedback = 1.
Display show the position 1.

ATTENTION!

Alternative procedure for acquisition of resolver position using dipswitch

The drive has a different procedure for the resolver's position acquisition through the pin 10 setting of the dip switch.

1. Check that the turret is correctly connected and feed the drive.
2. Manually move the turret to the mechanical position 1 and check correct locking.
3. Set On modality 1 (Li.1 > ON) [1]
4. Set On the Pin 10 of the dipswitch:
   On the display starts a count of 5"
5. Set Off the Pin 10 of the dipswitch:
   On the display starts a countdown up to 0".

After the countdown the display will indicate the position 1, that the outputs St Index, St lock are on and the Position's feedback is =1.

[1] Since the FIRMWARE 8.4 and then it's not necessary set on the mod.bit 1 (Li.1)