

Function features

INPUTS:

Signals from the turret

BSV-N, BSA, BD80	TRM-N
INP 00: Bit weight 1 absolute encoder;	INP 00: Switch for position n°1
INP 01: Bit weight 2 absolute encoder;	INP 01: Switch for position n°2
INP 02: Bit weight 4 absolute encoder;	INP 02: Switch for position n°3
INP 03: Bit weight 8 absolute encoder;	INP 03: Switch for position n°4
INP 04: Bit 'STROBE' absolute encoder;	INP 04: Switch for position n°5
INP 05: Bit 'PARITY' absolute encoder;	INP 05: Switch for position n°6
INP 06: Indexing switch signal;	INP 06: Indexing switch signal;
INP 07: Locking switch signal;	INP 07: Locking switch signal;

Signals from the numeric Control

INP 08: Bit weight 1 position required by CNC;
 INP 09: Bit weight 2 position required by CNC;
 INP 0A: Bit weight 4 position required by CNC;
 INP 0B: Bit weight 8 position required by CNC;
 INP 0C: Rotation direction selection;
 INP 0D: Rotation direction automatic selection;
 INP 0E: START rotation start;
 INP 0F: RESET command: when it is low, all outputs are disabled and all possible alarms are reset;

Position coding

The required position has to be binary-coded according to the following table:

POSITION	INPUT0B	INPUT0A	INPUT09	INPUT08
non-valid	0	0	0	0
1	0	0	0	1
2	0	0	1	0
3	0	0	1	1
4	0	1	0	0
5	0	1	0	1
6	0	1	1	0
7	0	1	1	1
8	1	0	0	0
9	1	0	0	1
10	1	0	1	0
11	1	0	1	1
12	1	1	0	0
non-valid	1	1	0	1
non-valid	1	0	1	0
non-valid	1	0	1	1

Any requirement for a position which is not allowed by the turret is ignored.

Direction of rotation

The direction of rotation can be chosen automatically by UCN or selected externally using the following table.

Direction	INPUT0D	INPUT0C
Automatic	0	X
CW	1	0
CCW	1	1

Timings

The input signals have to be stable for at least 10 ms.
 The required position has to be set at least 10 ms. before the START command is performed.