# RLX 8 Tool Turret Field Installation

Written By: Dozuki System

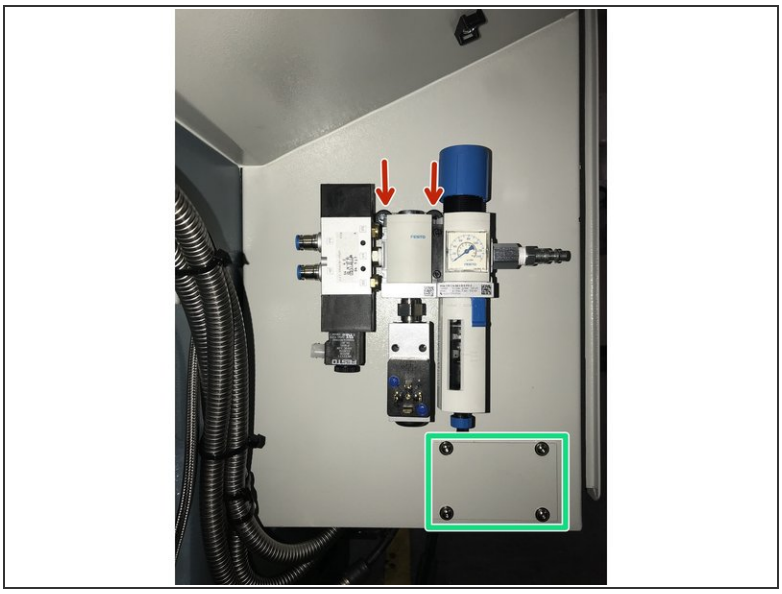


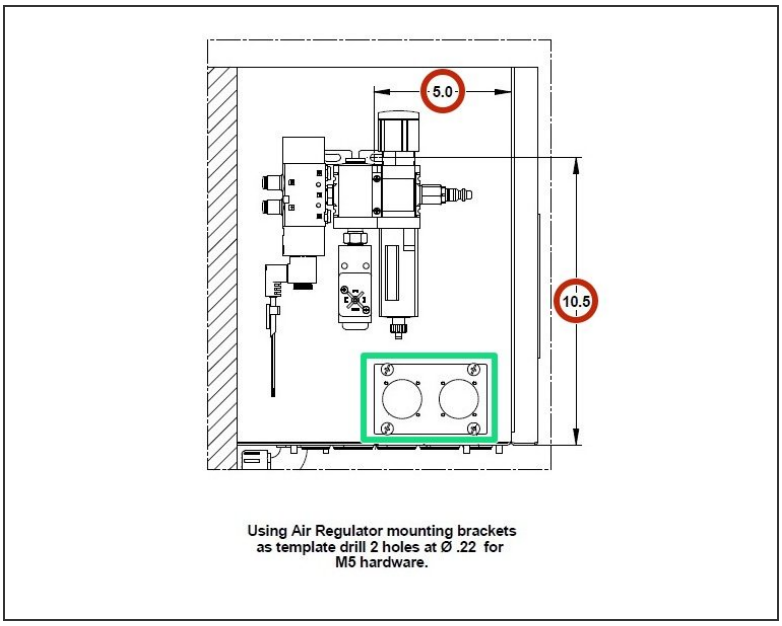
# INTRODUCTION



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## Step 1 — Mounting Air Regulator & Cable Entry Plate



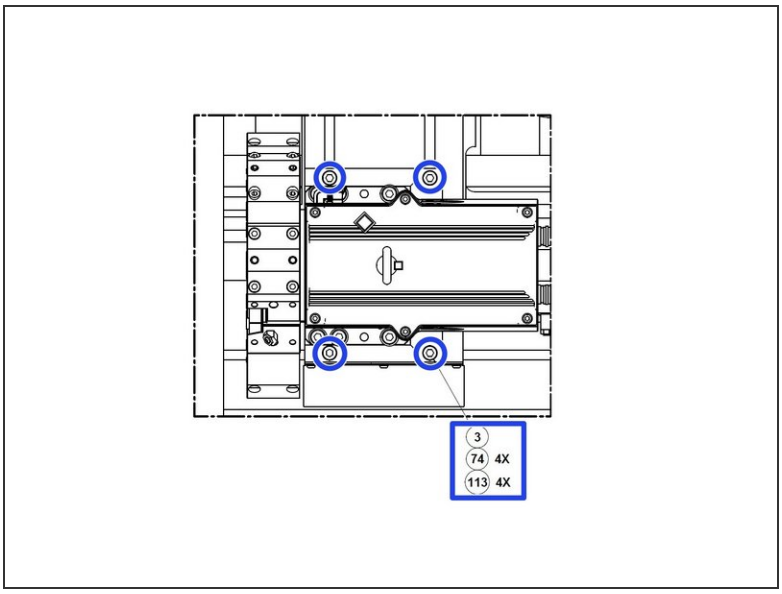



- Mount assembled air regulator to side of electrical cabinet using supplied M5 hardware (SHCS, belleville spring washer, flat washer and nut).

ⓘ Use dimensions given to ensure clearance of knockout plate for electrical connections.

- Remove knockout plate and replace with cable entry plate.

## Step 2 — Installing Mounting Base





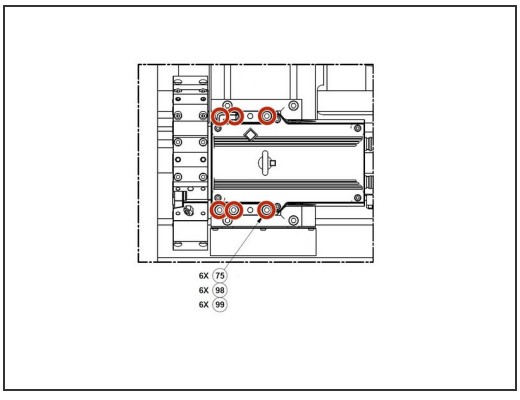


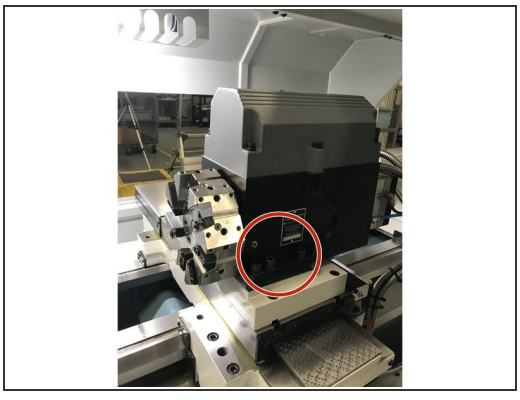
- Attach turret mounting base to cross slide using the supplied M10 hardware and M10 T-slot nuts. **Torque to 27ft/lbs.**

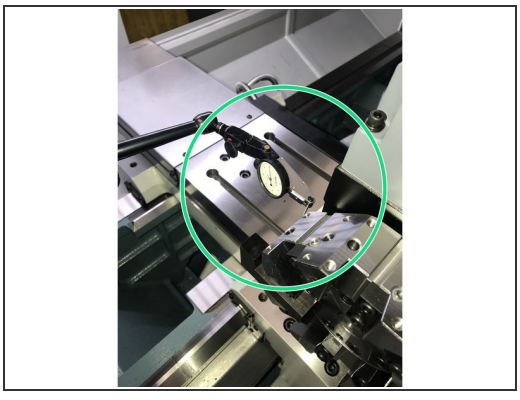
⚠ **Base must be at least 1" from edge of cross slide to avoid turret interference with sliding door.**

- Check flatness of base to confirm it is within 0.001 T.I.R.

## Step 3 — Installing Turret



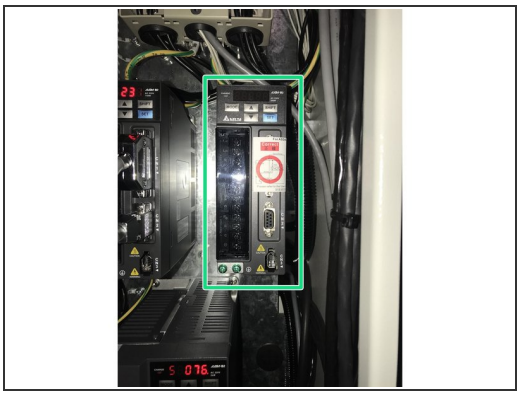



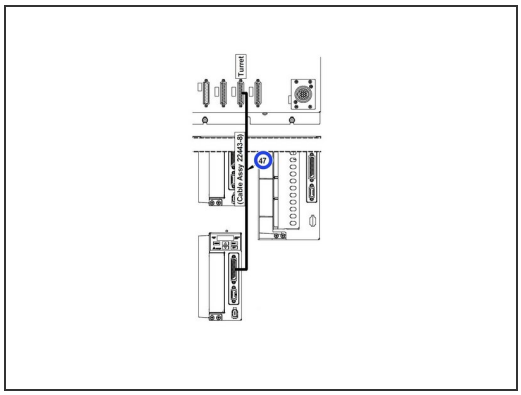


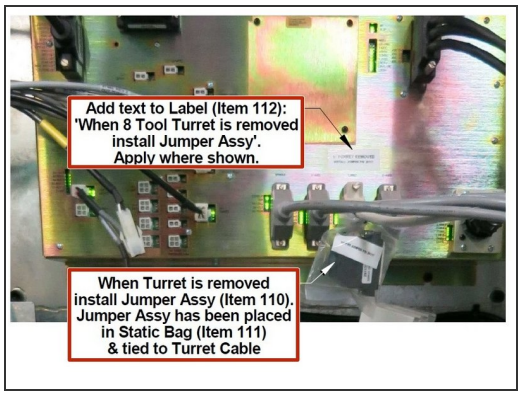
- Attach turret to mounting base using the supplied M12 hardware (SHCS, split lock washers & flat washers) and lightly snug fasteners allowing ability to tram in turret. *DO NOT tighten!*

- Tram in turret to 0.0005"

## Step 4 — Installing Delta Drive



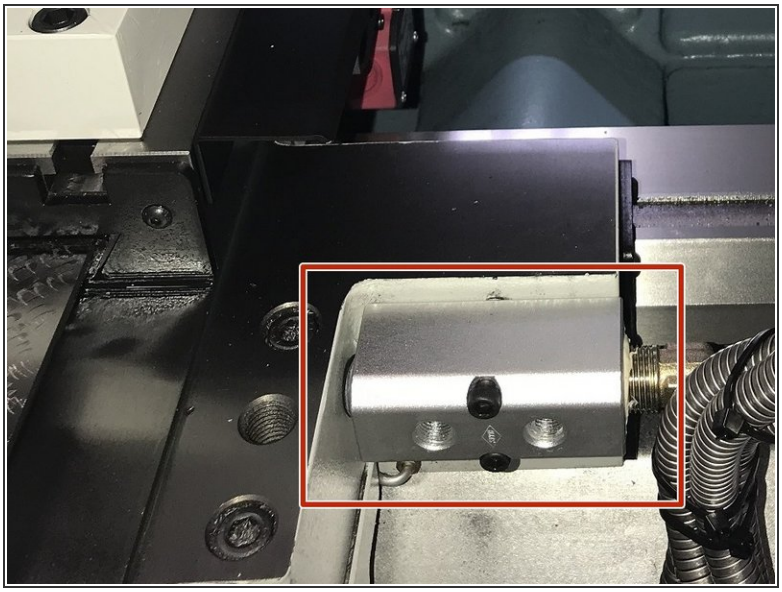


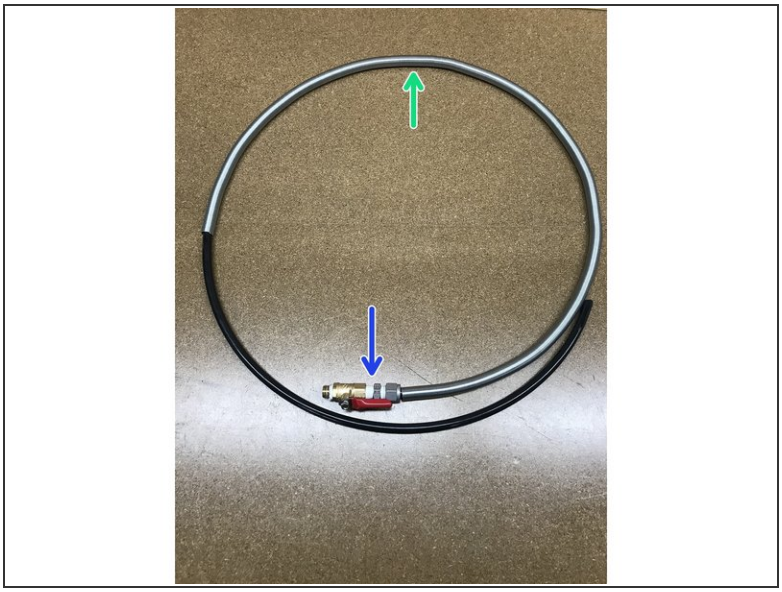



- Mount Delta Drive to cabinet using supplied M4 hardware (SHCS & flat washer).
- Connect logic cable from Delta Drive to Computer Module (Item 47).
- Zip tie 25 pin jumper to drive cable for turret as shown in image 3.

ⓘ Jumper is to be used when turret is removed to prevent a fault on the Pendant.

## Step 5 — Re-locate coolant manifold

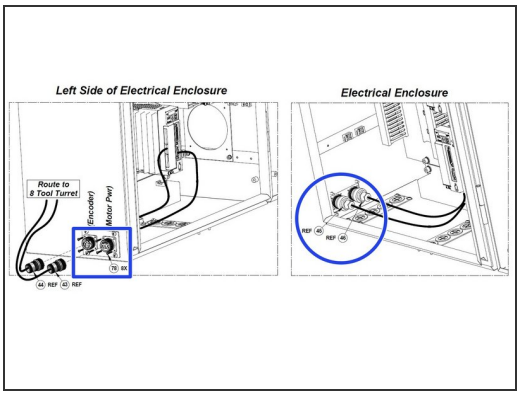


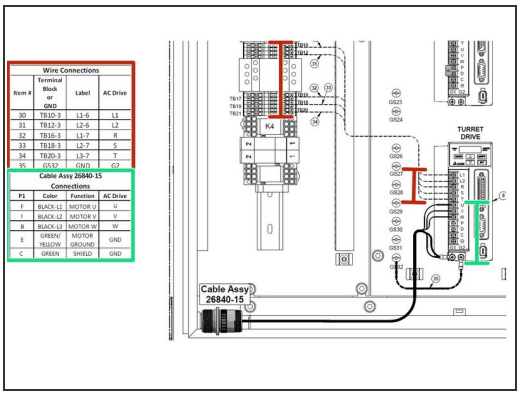


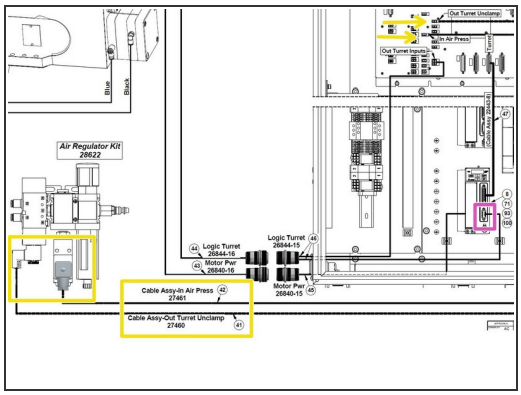
- Re-locate coolant manifold to edge of carriage on 1630 and 1845.
- Add wire coil cover to coolant hose (turret to coolant manifold).
- Add coolant shutoff valve to coolant hose.

ⓘ Coolant hose may need to be trimmed slightly so it is roughly the same length as the wire coil cover.

## Step 6 — Mounting Internal Cables & Connections

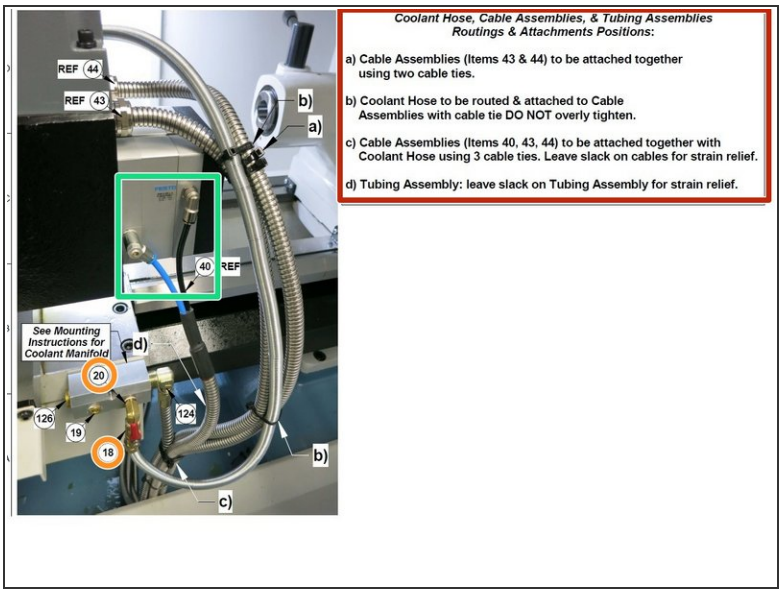


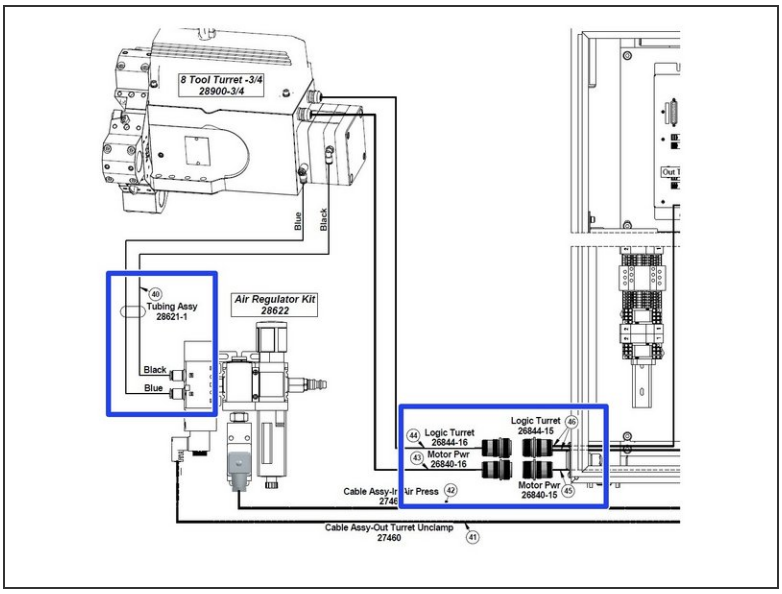




- Slide internal power and encoder cables through cable entry plate into the electrical cabinet, use supplied M3 hardware to attach flange to plate.
- Connect internal power cable to Delta Drive as shown in wiring table.
- Connect Motor circuit and Control circuit wires as shown in wiring table.
- Connect Input Air Pressure cable and Output Turret Unclamp cable into respective ports on computer module.
- Connect 9 pin logic cable into Delta Drive.

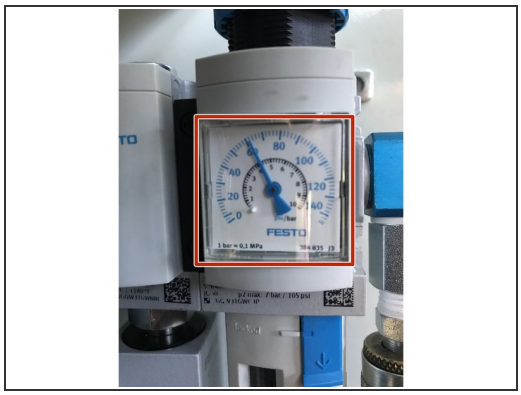
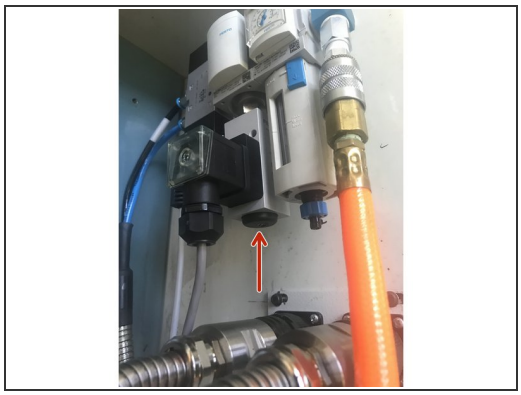
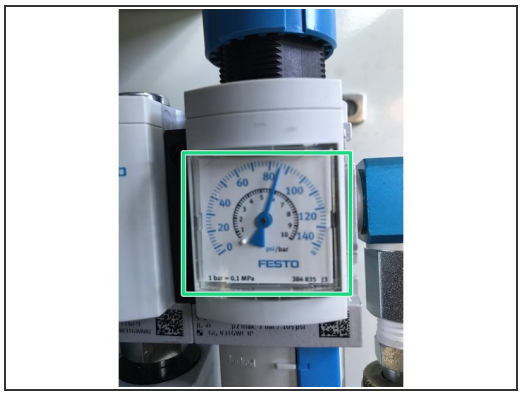
## Step 7 — Routing of Cables & Hoses




- Attach elbow (item 20) to coolant manifold and then attach coolant hose with shutoff valve (item 18) to elbow.
- Attach air lines to turret.
- Route cables and hoses underneath bed toward rear of machine as per instruction in image 1.
- Connect External Power and Logic Cables into connections on electrical cabinet. Connect air lines from turret to regulator assembly.

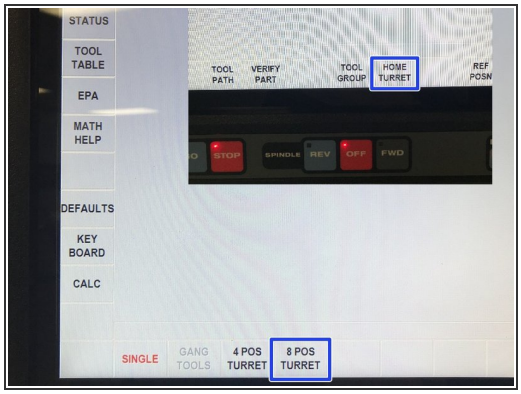
## Step 8 — Setting Air Pressure Switch

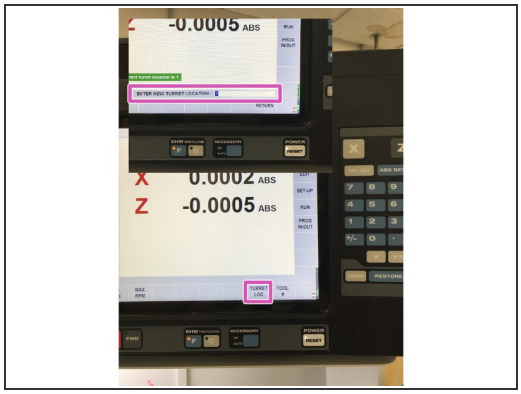




- Once supply air is installed, set air pressure to 60 PSI, find the adjustment screw on bottom of pressure switch. If LED on computer module labeled "AIR-IN PRESS" is off, rotate adjustment screw until LED turns on. If LED is on, rotate adjustment screw in opposite direction until LED is off.
- Once pressure switch is set, adjust incoming air pressure back to between 80-90 PSI.

## Step 9 — Check Turret Functionality







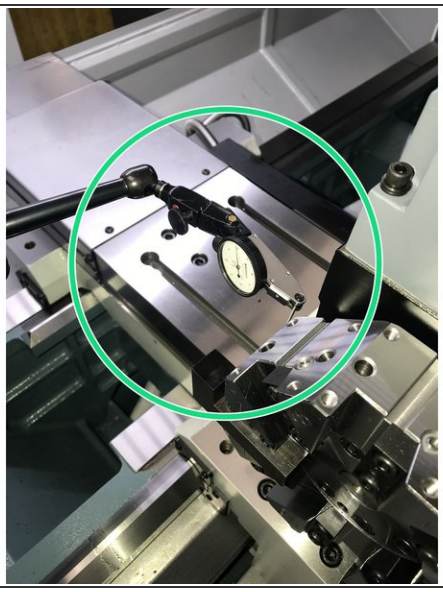

- Select SETUP then TOOL GROUP.
- Select 8 POS, then RETURN, HOME TURRET and then GO. ***Make sure door is closed, turret will not move if door is open.***

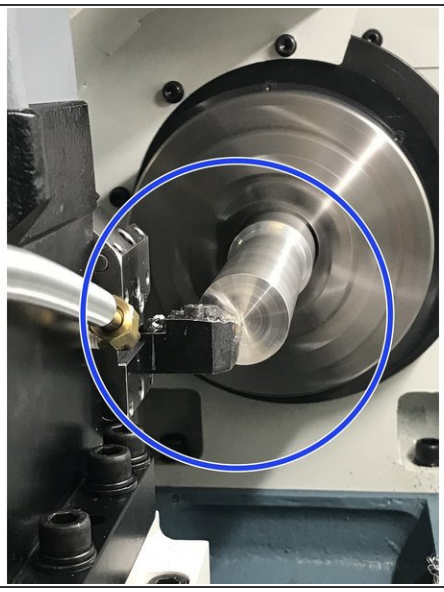
ⓘ Turret will begin to rotate slowly to location #1.

- Enter desired TURRET LOC, INC SET and then GO key. ***Make sure door is closed, turret will not move if door is open.***

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## Step 10 — Set Turret Height





- Tram in turret to within 0.0005".
- Face off a piece of cylindrical stock at least 4" long and 2" in diameter. Measure the material that is left untouched, divide by 2 and subtract no more than 0.005". Select shim stock value nearest to value without exceeding and install. Ideal final height should be between +0.002" & -0.005".
- Re-mount and tram in turret within 0.0005" and torque fasteners down to 40ft/lbs.