SHERLINE PRODUCTS
INCORPORATED 1974

MASSO Rotary Table Limit Switch Interference on the Tilting Angle Table

Using the Rotary Table on the Tilting Angle Table with the Limit Switch in Place

The rotary table will work with the limit switch connected when the tilting angle table is at 90 degrees (see Figure 1). There is clearance for both the limit switch and the trigger in this position. You may need to move and readjust your limit switch slightly. The best way to mount the rotary table to the tilting angle table is to first position your tilting angle table at 90 degrees. Then mount your rotary table to the tilting angle table taking care to not damage the limit switch.
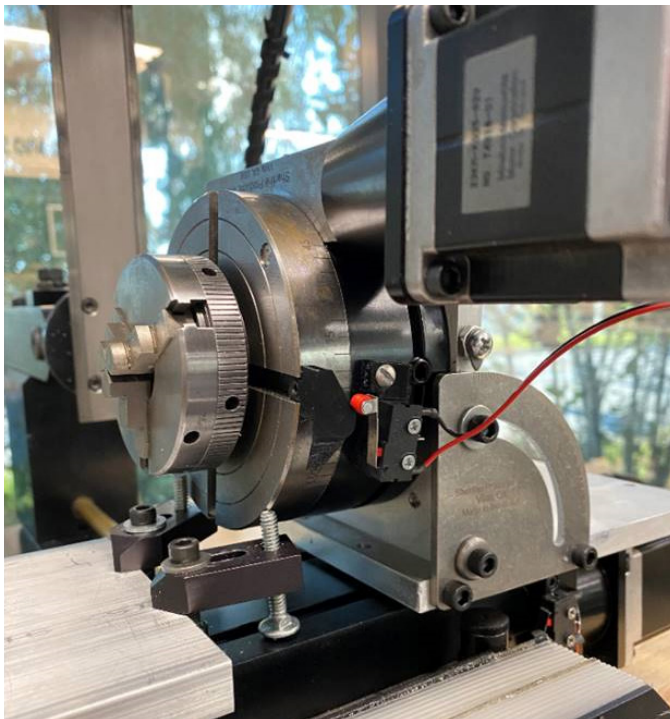

FIGURE 1—This image shows the rotary table with the attached limit switch mounted to the tilting angle table in the 90° position.

The limit switch and the trigger will hit the side plate on the tilting angle table if the tilting angle table is at any angle less than 90 degrees. For angles less than 90 degrees you must remove the limit switch and the trigger.

How to Use the Rotary Table on the Tilting Angle Table without the Limit Switch

1. Remove the limit switch and the trigger from the rotary table and place them out of harm's way.
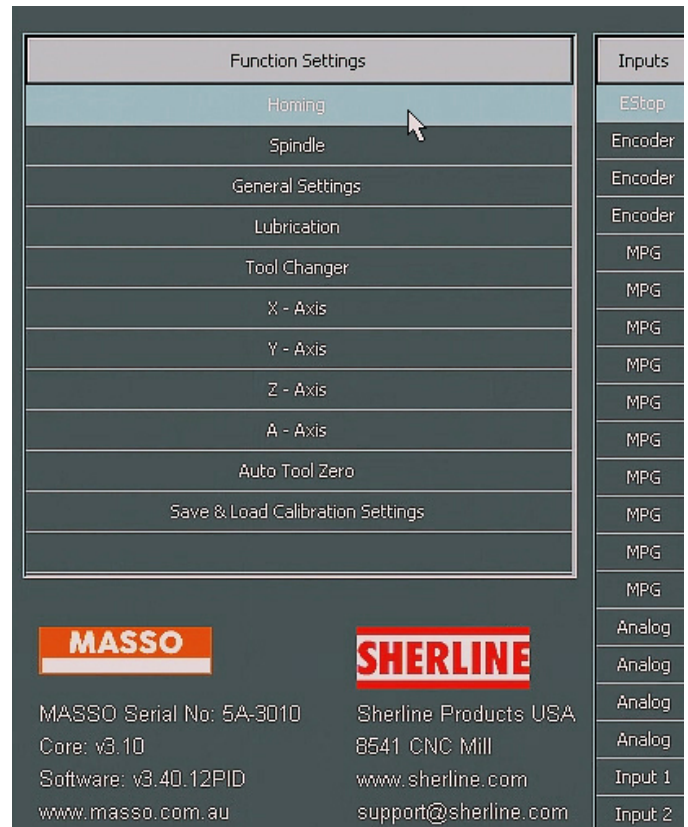
2. Go to the F1-SETUP screen.

3. Click on "Homing."

FIGURE 2—The "Homing" selection is located just under the "Function Settings" header.

4. On "Seq 4," change the "A" to blank (no check mark).

5. Click on "Save."

6. Now turn your controller off.

7. Disconnect the power cable from the rotary table stepper motor so you will not damage the drive when you move the A-axis manually.

8. Manually move your rotary table to the desired "A Zero" position.

9. Once the rotary table is at the A0 position, reconnect the stepper motor power cord.

10. Write down the rotary table handwheel position so you can put the rotary table back to the same A0 position if needed.

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11. When you turn the controller back on, the position screen will automatically show the A-axis as "0.000 degrees" (see Figure 3). This is why you want to set the rotary table at the zero position prior to turning the controller on.
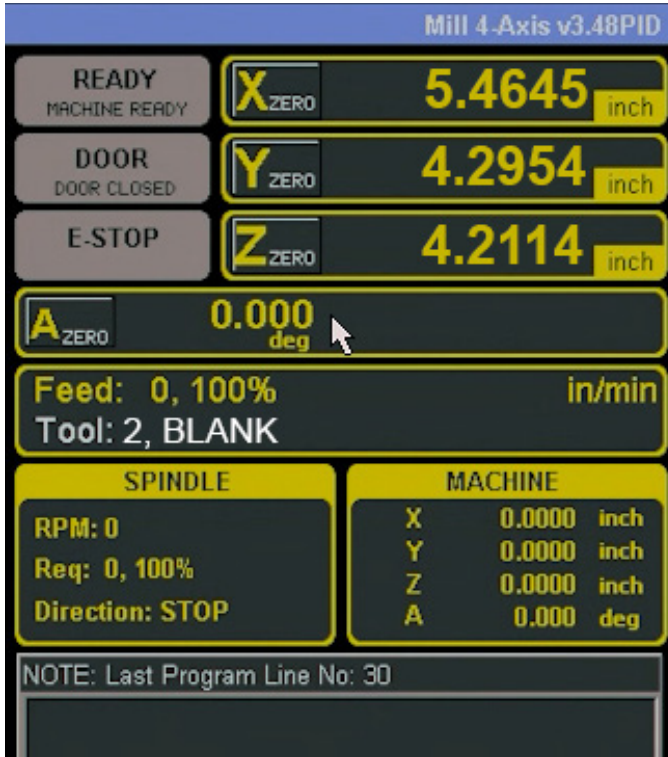

FIGURE 3—The cursor arrow is pointing to the A zero position with 0.000 degrees.

12. From this point on, you can move the A-axis in Jog, MDI, or program mode and it will retain the A 0.000 degrees position. The A-axis will operate the same as it did with the limit switch connected except that the A-axis will not do a homing sequence.

NOTE: Before you power down the controller, move the A-axis back to the A 0.000 position. This way the A-axis will be at the correct position when you turn the controller back on. If not, you will need to go through steps 6-10 again.

Thank you,
Sherline Products Inc.