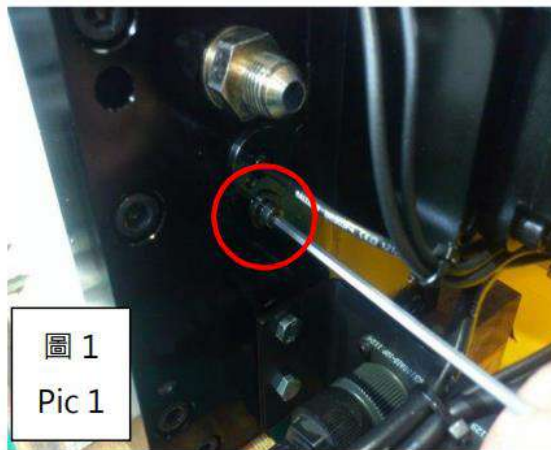


S1 原點近接開關更換作業

S1 Proximity switch replacement procedure

步驟 1. 拆除背板上 S1 固定壓塊 (圖 1) , 並使用小一字起子將 S1 固定座拉出 (圖 2)

Step1. Remove S1 plug (Pic 1) from back plate, and use a flathead screwdriver to pull out S1 fixing seat (Pic 2).



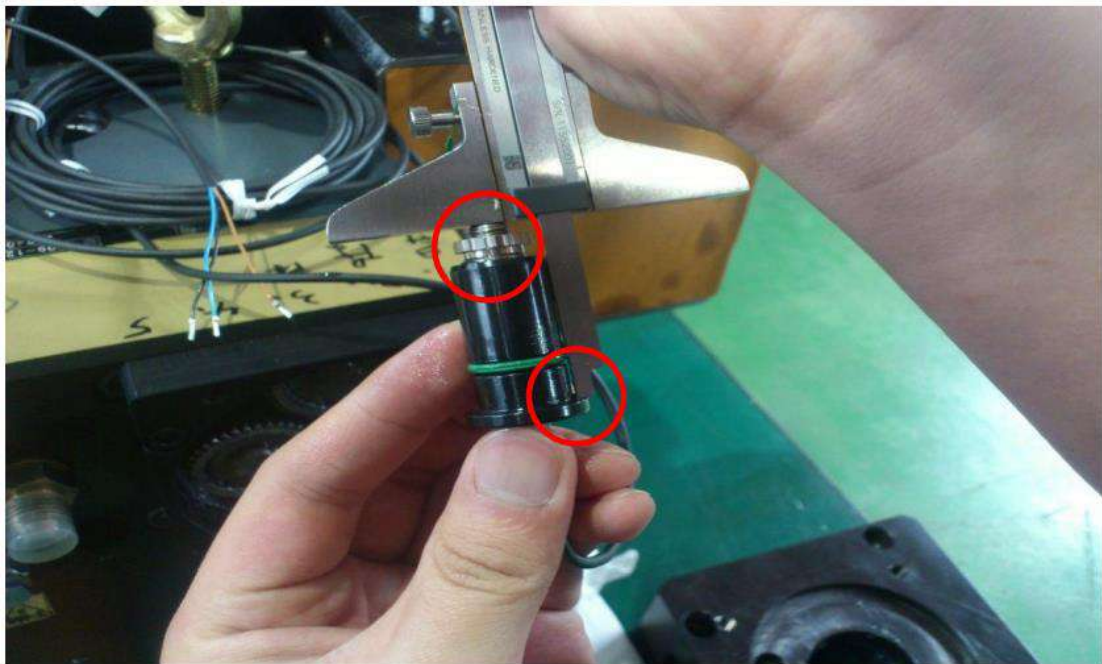
步驟 2. S1 固定座拉出後 , 將近接開關接頭鬆開後把線路移除

Step2. After pulling out S1 fixed seat, loosen the connector and remove the cables.



步驟 3. 使用游標卡尺量測 S1 距離，並記錄。(此距離為感測安全距離，若太近 S1 會被齒輪軸撞壞，若太遠則 S1 感應不到刀塔無法轉動。感應距離為 0.40mm) 。

Step3. Use a vernier scale to measure the distance of S1 and record it. This value will be used for setting sensor distance. If the distance is too close, then S1 proximity switch might be damaged by gear shaft; however, if the distance is too far, then S1 will not detect, and turret will not rotate.)



步驟 4. 用開口板手將固定螺帽拆除後，旋轉 S1 拿出固定座並換上新 S1。

Step4. Use an open wrench to remove fixing nut, rotate S1 to take out fixing seat, and then replace with a new S1.





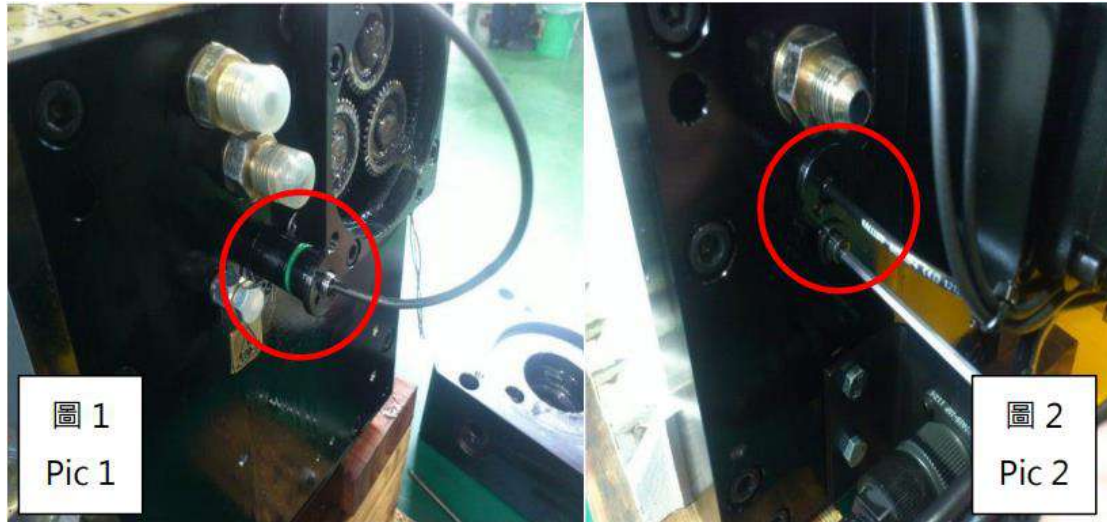
步驟 5. 換上新 S1 後，使用游標卡尺，將 S1 調整至同步驟 3 所記錄之距離後，再將固定螺帽鎖緊，再量測一次距離是否正常。

Step5. After replacement of new S1, follow Step3 to confirm the correct distance.



步驟 6. 距離量測完成後，將 S1 放回背板(圖 1),並將固定壓塊鎖緊 (圖 2)。

Step6. After distance measurement. Install S1 back to the back plate (Pic 1), and fasten the plug (Pic 2).



步驟 7. 將 S1 線路接回近接開關接頭。

Step 7. Reconnect cables of S1 to the connector.

軍規腳位圖：

Military diagram



S1/S8/S9/S10/S11 近接開關線路 (軍規接線/5PIN)			
NO	線色 Color	線路定義(號碼圖) Sensor	軍規接腳 Military PIN
1	黑 Black	S1	1
2	黑 Black	S8	2
3	黑 Black	S9,S10,S11	3
4	藍 Blue	OV	4
C	棕 Brown	24V	5