

# TB141 (Rev1) - 110 Volt Rotary Table MS Connectors

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## Overview

This Tech Bulletin is about the 4th Axis Rotary table connectors on Centroid Controls configured for 110 Volt rotary tables.

## Problem

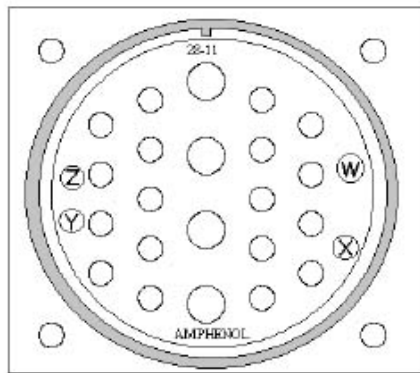
Before the week ending April 26th 2002 Centroid shipped every Control setup for 4th axis in the same way, regardless of whether it was setup for 24V or 110V operation. This has been known to cause problems if someone would try and connect the Rotary table setup for 24V operation to a Control set for 110V.

## Solution

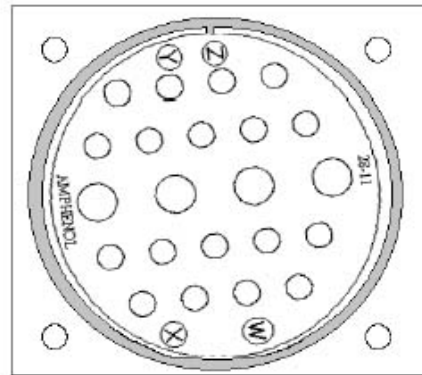
To combat this problem Centroid will begin shipping Controls setup for 110V Rotary operation with the MS connector in a different configuration. The new configuration for the MS connector is what is called the 'Z' position. The cables shipped for 110V operation will also be set to the 'Z' position. You can clearly see the difference between the 'Z' position and the normal position in the diagrams below. All diagrams show the connectors when looking from the front.

### Female MS Connector Set For 24V: Female MS Connector in 'Z' For 110V:

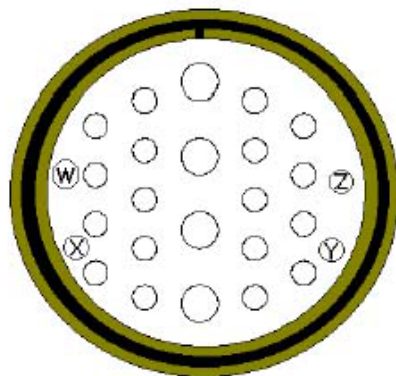
Female MS Connector Set For 24V:



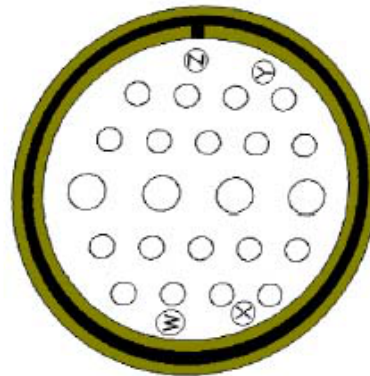
Female MS Connector in 'Z' For 110V:



Male MS Connector Set For 24V:



Male MS Connector in 'Z' For 110V:



It is recommended that all Controls in the field have the connectors changed to the 'Z' position if they are set for 110V operation. This ensures that there will be no confusion in the future with these machines and the cables. Note. It is still just as important to have the correct cable for the rotary table in use.

**Instructions for changing connector configuration:**

To set up the connectors to the 'Z' position you need to follow the simple steps below:

***Female:***

1. Remove socket from cabinet
2. Remove snap ring on back of socket holding connector together
3. Slide out center of connector
4. Rotate to 'Z' position.

Note: You may have to remove some material from the center section in order for it to slide into the 'Z' position. To do this simply use a Dremel or a Exacto-Knife to remove the material as needed.

5. Slide center back into connector body
6. Replace snap ring
7. Replace socket back in cabinet

***Male:***

1. Unscrew back of connector
2. Remove snap ring in back of connector
3. Slide out center section of connector
4. Rotate center section to the 'Z' position.

Note: You may have to remove some material from the center section in order for it to slide into the 'Z' position. To do this simply use a Dremel or an Exacto-Knife to remove the material as needed.

5. Slide center section back into socket
6. Replace snap ring
7. Screw back of connector back into place

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**Document History**

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