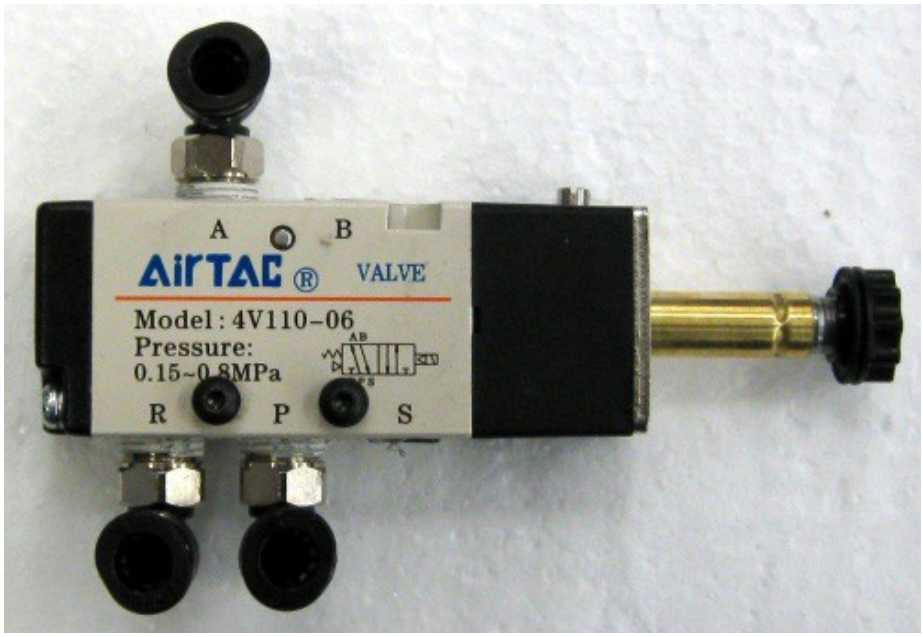
TB261 (Rev1) - GSA Rotary Table Solenoid Conversion

Purpose:

Currently the GSA rotary clamp requires 110VAC to be applied to unclamp the table. This presents a potential risk where if the 110VAC fails, the brake will be engaged allowing for damage to the rotary table if the operator tries to use the rotary table.
The solution is to change the ports on the air solenoid in the rotary table that engages and disengages the brake. When power is applied it engages the brake, making the default state unclamped instead of clamped. This eliminates the potential for damaging the rotary table if the 110VAC fails.

To modify the Air Solenoid follow these instructions:

1. Label air lines, then disconnect and remove air solenoid from rotary table.



2. Picture of Factory Solenoid
3. Remove the plugs on ports B and S.
4. Remove the air fittings from ports A and R.
5. Put new Teflon tape on plugs and install in ports A and R.
6. Put new Teflon tape on air fittings and install on ports B and S.
7. Once completed the modified air solenoid should look like this (see picture below)

8. Modified Air Solenoid
9. Re-install solenoid and connect air lines. The line connected to “P” will stay the same, line “A” will move to “B” and line “R” will move to “S”.
10. Once the rotary table is done you will need to rename the mfunc10.mac and mfunc11.mac, so mfunc10.mac will become mfunc11.mac and mfunc11.mac will become mfun10.mac.

Document History

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