

Parts Diverter Chute Installation

Parts Diverter Chute Description

The OmniTurn Parts Diverter (893-01-300) is a telescoping chute which guides finished parts out of the collet and onto a conveyor to be moved out of the machine.

The assembly mounts to the parts conveyor option (499-39-100) and can be operated with the standard auxiliary M25 function.

The simple track-loader option (793-39-101) can be used to auto-load parts into a spring-loaded collet. The finished parts are ejected into the chute for delivery outside the cutting area.

The vertical cut-off option (693-39-101) can be used for bar-jobs with unrestricted tool placement on the tooling plate.

A table-mounted cut-off tool can be used, but the other tools must be placed so as to allow clearance for the chute to be extended during part-off cycle.



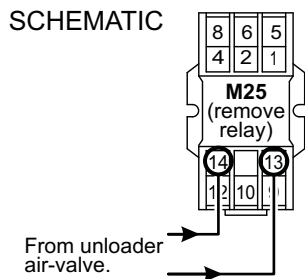
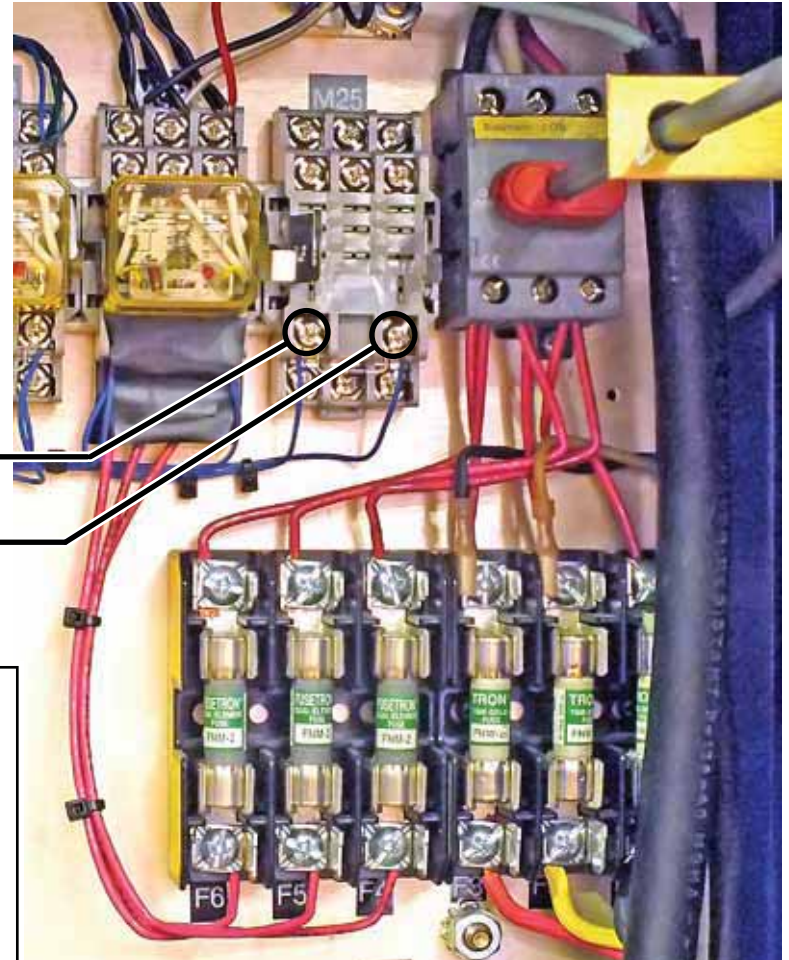
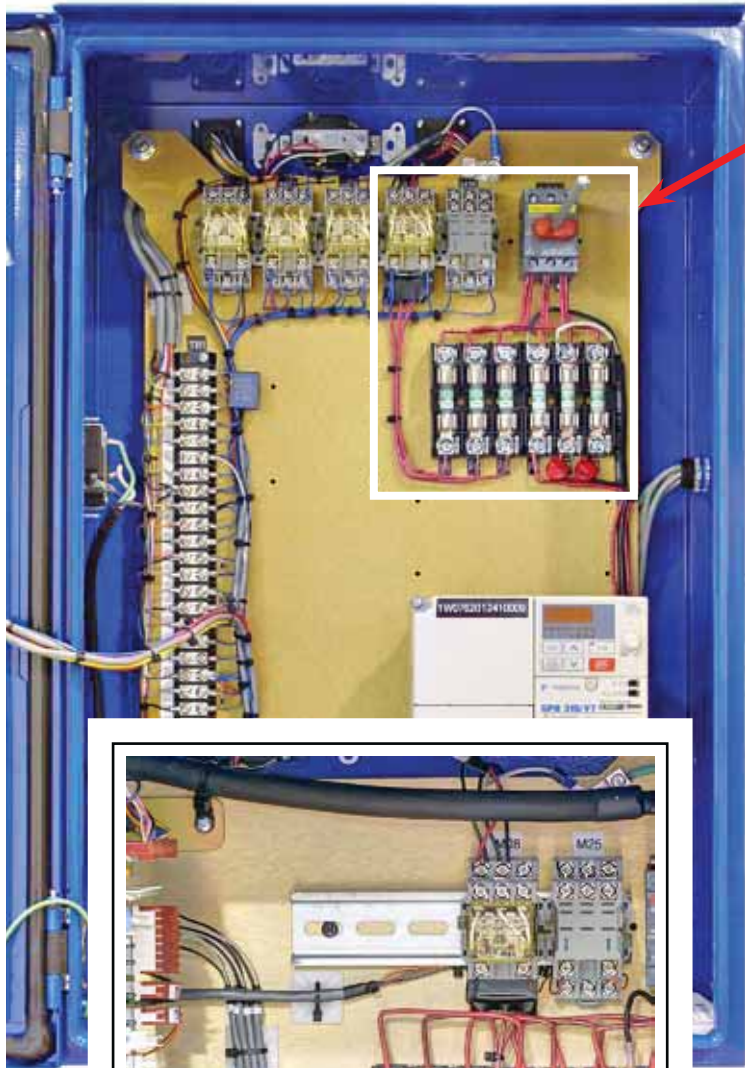
Spindle Drive Panel with TB1
(See inset for panel with PWB)

NOTE: If you are replacing parts catcher, no electrical modification is necessary.

Area enlarged at right

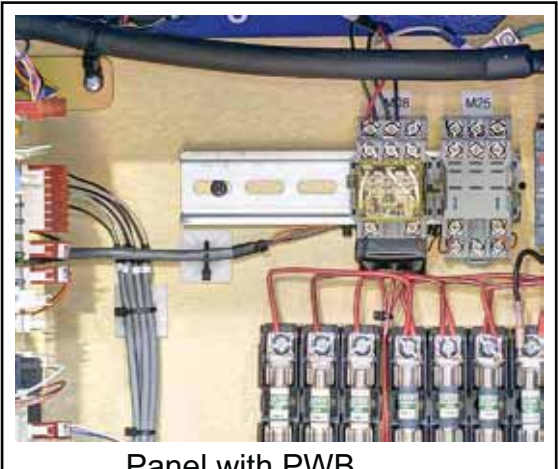
WIRING:

1. Remove the relay from M25 socket to reduce load on driver.
2. Route cable from new air-valve to M25-14 (clear) and M25-13 (black).

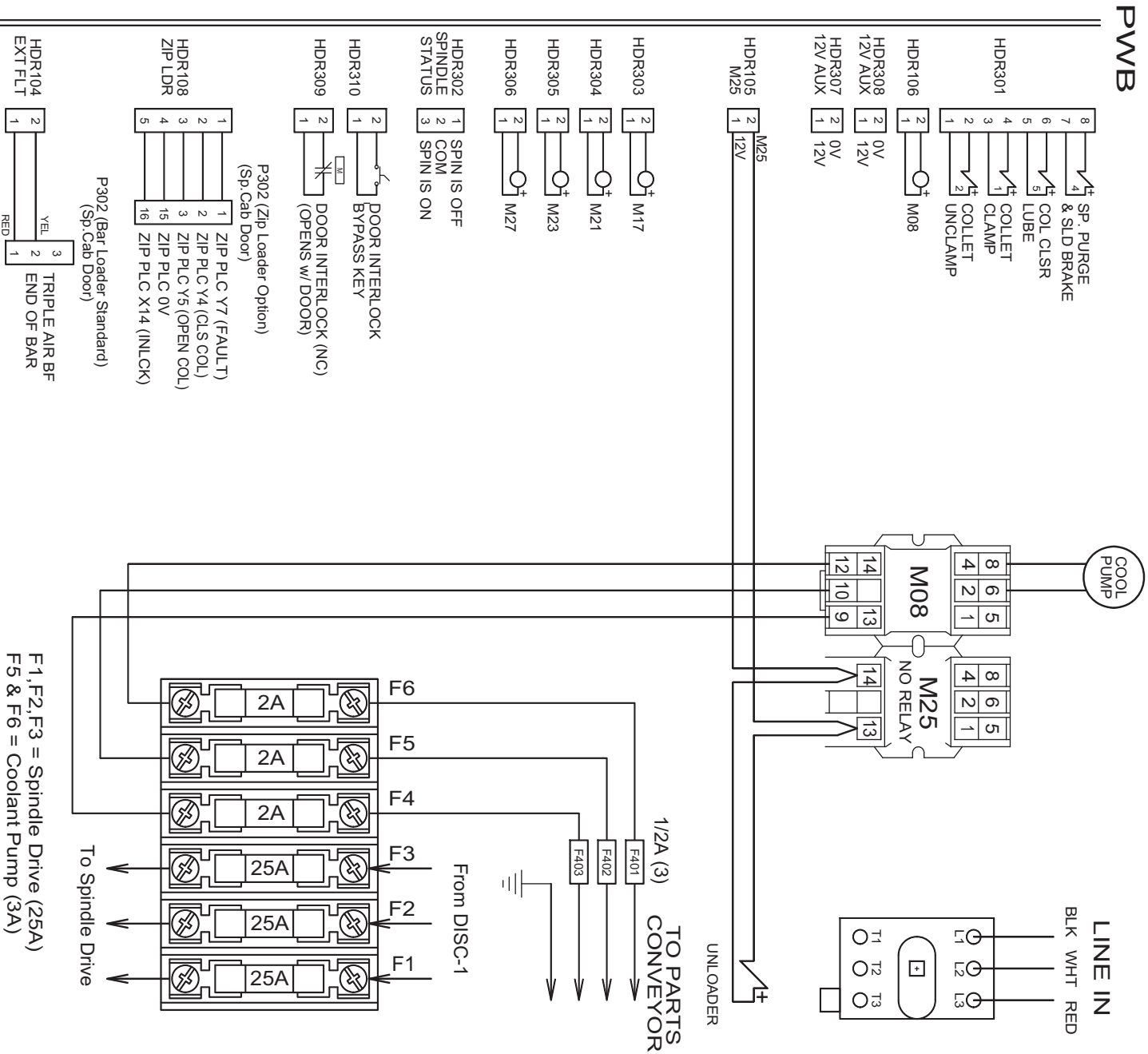


Route cable from unloader air-valve through liquid-tight on side of spindle cabinet where other solenoid cables go through.

NOTE: If you find any wires on M25 relay except at 13 & 14, DO NOT continue installation! Call (541) 332-7004 for assistance.



Panel with PWB

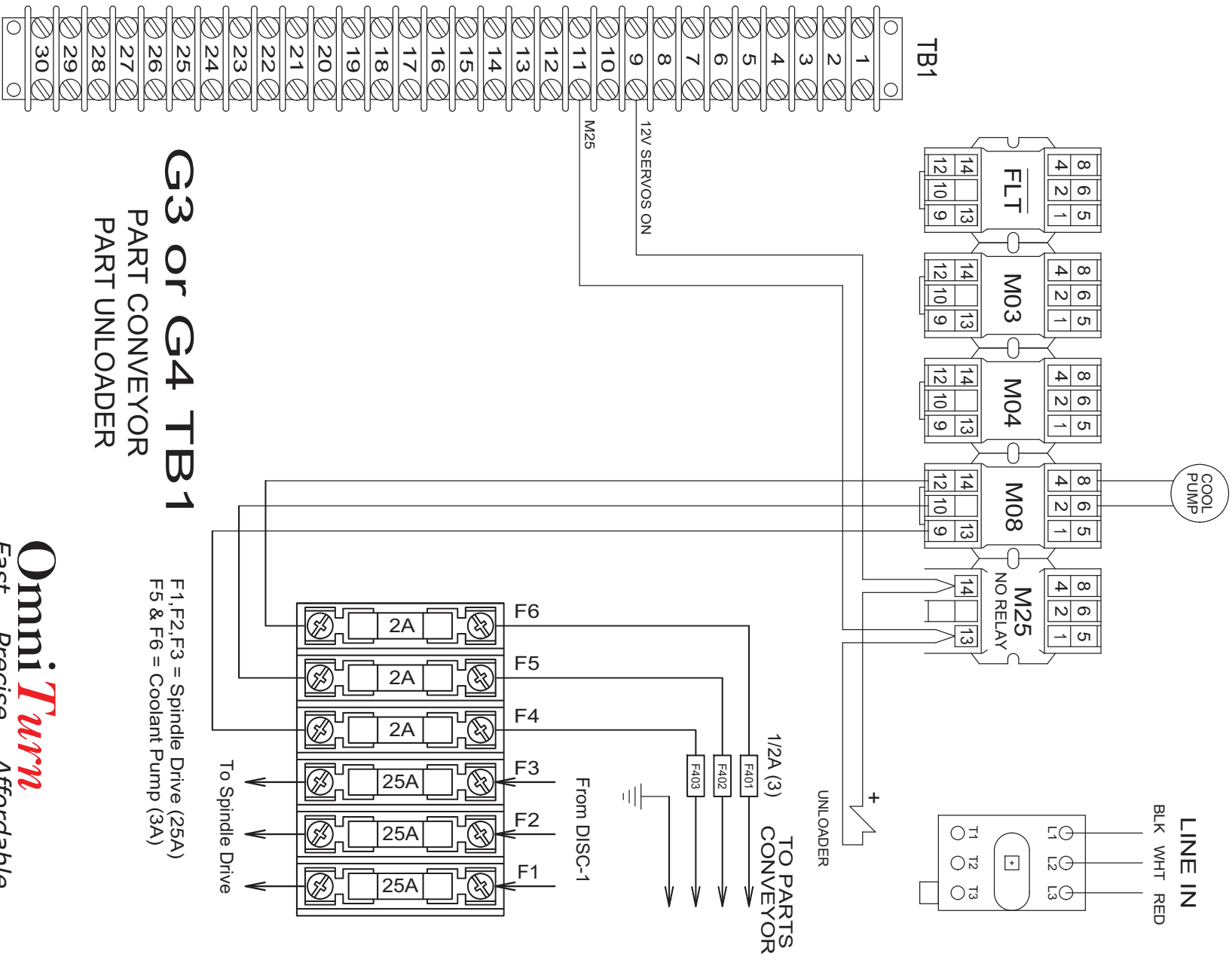


G4 CNC
Printed Wiring Board
PART CONVEYOR
PART UNLOADER

spindle_cab_pwb_conveyor&unloader-1bl.dcd mar 2021

OmniTurn
Fast... Precise... Affordable...
SPINDLE DRIVE PANEL

F1, F2, F3 = Spindle Drive (25A)
F5 & F6 = Coolant Pump (3A)



G3 or G4 TB1
PART CONVEYOR
PART UNLOADER

F1, F2, F3 = Spindle Drive (25A)
F5 & F6 = Coolant Pump (3A)

spindle_cab_tb1_conveyor&unloader-1bl.dod mar 2021

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Fast... Precise... Affordable...
SPINDLE DRIVE PANEL

Tool Clearances With Table-mounted Cut-off (Chute Extended)

Assuming a part-off tool at top of table, the drawing shows approximate area on tooling plate that must be kept clear of tools. Note: with optional Vertical Cutoff (VCO) this clearance is not required.

