

Sequence of Dual Arm ATC Operation When Used With Fadal Control

Feedback

Tool Up Sensor: (Magnetic reed switch mounted at Bottom of Air Cylinder- normally open – “Tool Up” LED)

Tool Down sensor: (Magnetic reed switch mounted at Top of Air Cylinder- normally open -“Tool Down” LED)

Above sensors have a LED mounted into the sensor and 1330-0 card that is lit when switch is closed.

Arm Stop (Proximity current sensor #1 mounted at Top on Arm – “Stopping Sensor” LED)

Arm Tool (Proximity current sensor #2 mounted at Center on Arm – “Arm at Spindle” LED)

Arm Home (Proximity current sensor #3 mounted at Bottom on Arm – “Arm at Home” LED)

Tool Count Sensor (Proximity current sensor mounted under Turret Motor – “Tool Count” LED)

Drawbar sensor (Hall Effect sensor mounted under Drawbar Cylinder – “Drawbar” LED)

Above sensors have a LED mounted on the 1330-0 card that is lit when switch is closed.

Part Numbers

Magnetic Reed Switches ELE-1186

Proximity Current Sensors ELE-1185

Hall Effect Sensors ELE-2064

Carousal solenoid failure (or sensor)	Tool count sensor not seen
Drawbar solenoid failure (or no air)	The drawbar cylinder could not be moved down to extract tool. Check air supply and check tool.
Drawbar sensor failure	The drawbar cylinder piston could not return home.
ATC arm is not in home position	The ATC arm did not return home
ATC bucket up solenoid/sensor failure	The ATC bucket cylinder did not arrive at bottom (bucket moved up).
ATC bucket down solenoid/sensor failure	The ATC bucket did not arrive at top (bucket moved down).
ATC arm solenoid sensor home/sensor failure	The ATC arm could not move away from the home position.
ATC tool arm obstructed	The ATC arm did not arrive at spindle
ATC tool sensor failure	The ATC arm tool sensor was not seen
ATC tool clamping failure	The ATC arm could not move away from the spindle.
ATC unclamping failure	The ATC arm could not leave tool holders
ATC interlock is on	
ATC communication error with 1330 card	1400-5 cannot communicate with the 1330.
ATC ambiguous bucket position	ATC bucket is neither up nor down. Neither reed switch is seen.
ATC ambiguous turret position	ATC switch is between buckets. Turret sensor is not seen.

Give us a call if you cannot get your DATC working as there are many ways of finding the problem and we can help.