VERSABUILT

HOW-TO CONNECT THE HAAS CYCLE START RELAY TO THE PLC

(PROGRAMMABLE LOGIC CONTROL)

APPLIES TO MACHINES BUILT AFTER SEPTEMBER 2017

DOCUMENT #D10040
REVISION: A
JULY 2018

Table of Contents

Table of Figures

Parts and Tools Required

Tools

1. Phillips head screwdriver
2. Flathead screwdriver
3. M4 Allen wrench
4. Zip ties

Parts

1. Haas Cycle Start Relay Cable Assembly (VersaBuilt P/N# 5002312)

FIGURE 1. 5002312- HAAS CYCLE START RELAY CABLE ASSEMBLY

Installation

1. Collect parts and tools, locate the Haas Control Panel (Figure. 2). **Make sure CNC is powered off**!
2. Open Haas Control Panel to show back of panel.
3. Dismount the back cover panel on the Haas Control Panel by unscrewing the 4 fasteners with a Phillips head screwdriver shown in Figure. 3.

FIGURE 2. HAAS CONTROL PANEL

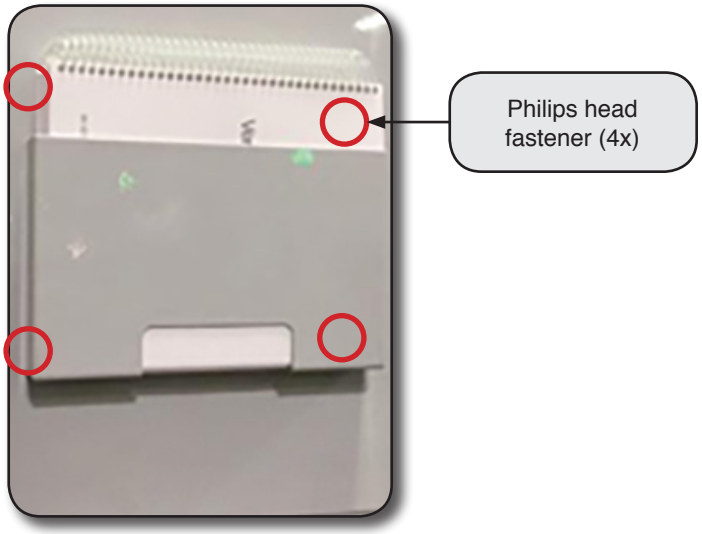

FIGURE 3. BACK COVER OF HAAS CONTROL PANEL

4. Locate the Cycle Start button (Figure. 4), on the right looking from the back of the Haas Control Panel. Remove the Cycle Start button backing with a flathead screwdriver so it is easier to work with. Connect the fork terminals coming from the **5002312-Cable Assembly** to the locations on the Cycle Start button backing. White (11) is inserted into the top (yellow) and black (14) is insert into the bottom (black) as shown in Figure 5.

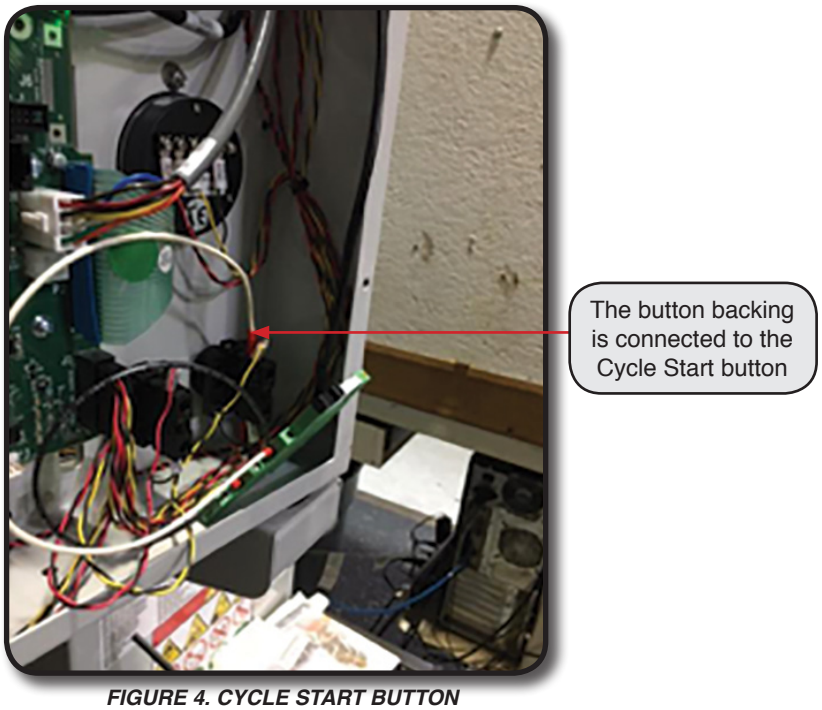

FIGURE 4. CYCLE START BUTTON

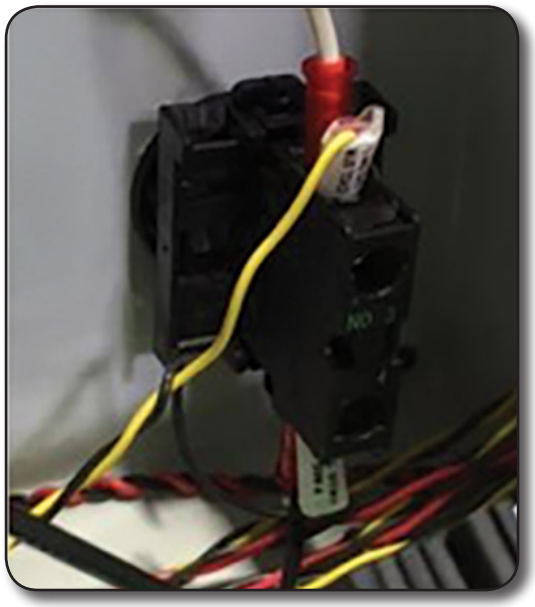

FIGURE 5. CYCLE START BUTTON BACKING

5. Route the M8 connector from the **5002312-HAAS Cycle Start Relay to PLC** through the cable routing hole on the top of the HAAS Control Panel (Figure. 6). Unmount the sheet metal bracket on top of the HAAS Control Panel (Figure 7) by loosening the 4 Button head cap screws with an M4 Allen wrench. Route the cable over the CNC through a protected wire-way, replace sheet metal bracket and fasten 4 screws with an M4 Allen wrench and put back sheet metal cover panel and fasten 4 screws with a Phillips screwdriver.

FIGURE 6. CABLE ROUTING

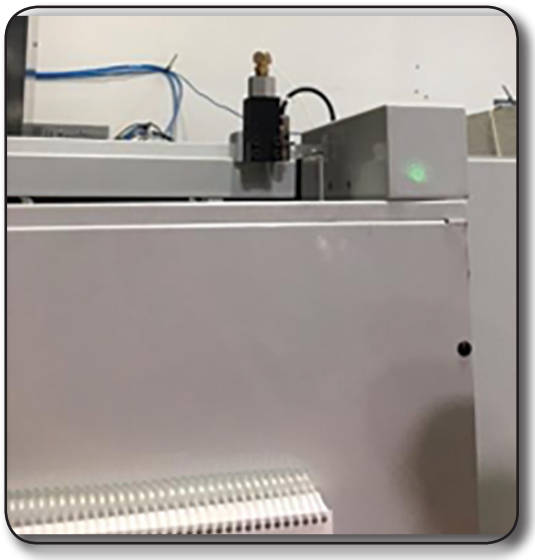

FIGURE 7. SHEET METAL COVER PANEL

6. On the PLC (Figure 8), plug the M8 3 pin connector (Figure. 9) to the 1st port of a 5001034-Splitter M8 4-pin Y x 2 M8 3-pin connectors. Then plug this into the X1 port of the 8 DO splice of the PLC.

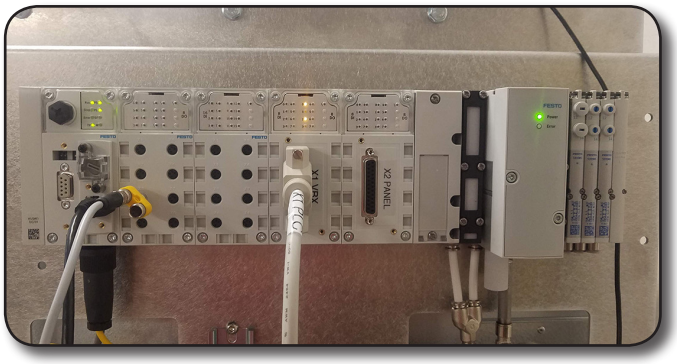

FIGURE 8. PLC

FIGURE 9. M8 3-PIN CONNECTOR