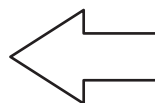


Cycle Start Inhibit Switch for G4 CNC:

This option helps prevent manual cycle-start before closing collet. Second-op jobs often require the operator to open collet, replace finished part with next part, clamp collet, then start the cycle. If the operator doesn't press the collet clamp push button before pressing the cycle start buttons, the cycle will begin with collet open. The pressure switch monitors the collet-clamped pressure, and disables palm-box cycle-start buttons if collet is not clamped.



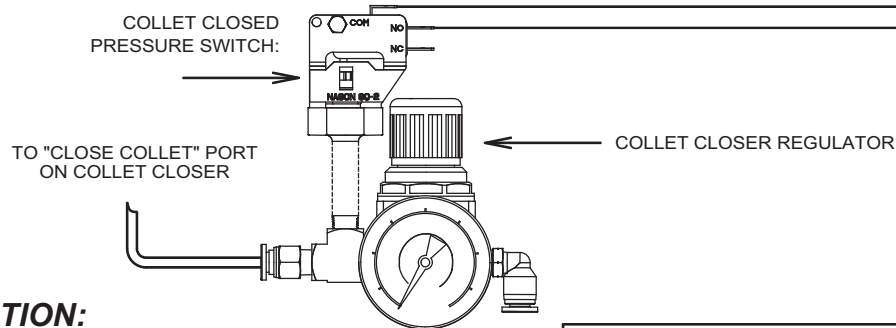
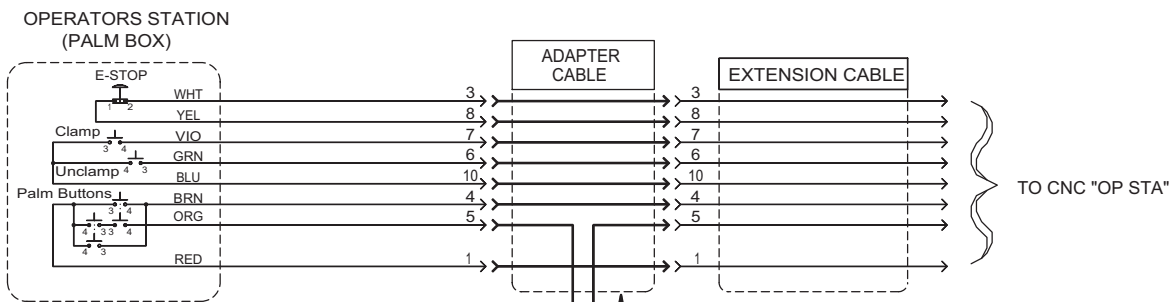
Cycle-start inhibit Adapter Cable
See next page for installation instructions.



Collet pressure switch installed

Cycle Start Inhibit Switch for G4 CNC:

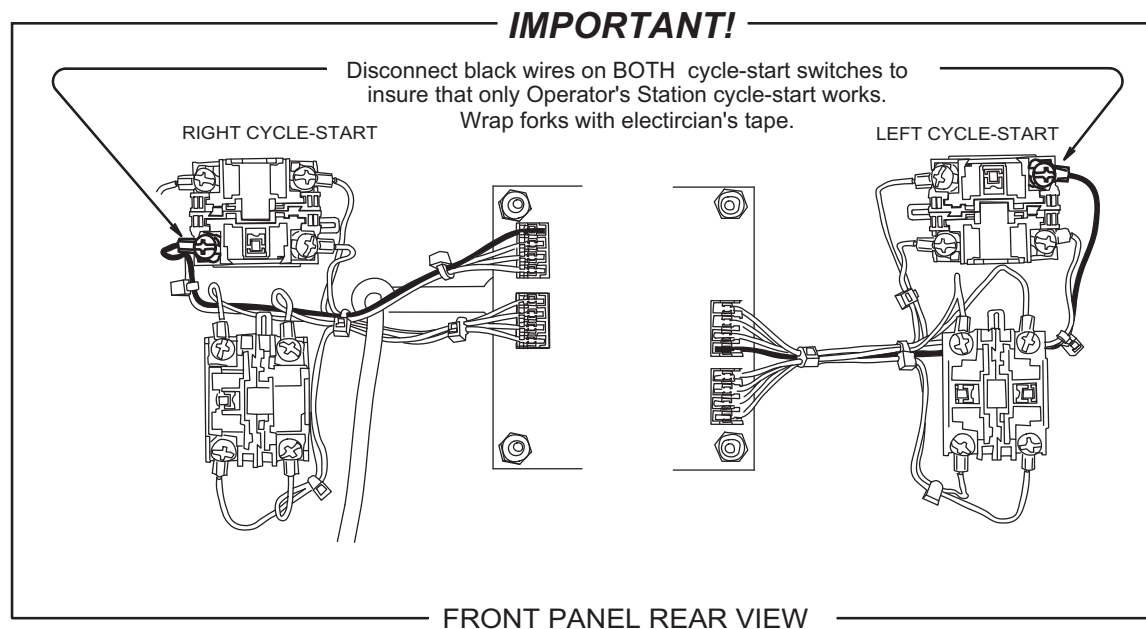
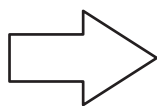
This option helps prevent manual cycle-start before closing collet.



INSTALL ADAPTER CABLE BETWEEN OP STA AND EXTENSION CABLE BEHIND SPINDE DRIVE ENCLOSURE ROUTE CABLE TO SWITCH AS SHOWN

INSTALLATION: (See photographs on previous page)

1. Install the Pressure Switch on the collet closer regulator.
2. Install Adapter Cable between Operator's Station cable and extension cable. This is located under the hopper, near the spindle drive box.
3. The switch should be pre-wired as shown; route the cable along the Operator's Station cable using zip ties (provided).
4. Disconnect both front panel Cycle Start switches as shown at right. Wrap fork terminals with electrical tape.
IMPORTANT NOTE: This step inhibits Cycle Start buttons on CNC Control.



cycle-start inhibit G4 adapter-cable-2.doc AUG 2020