



# Wire Probe (VQCPS) - OMI-SSR to OMI-2H Optical Interface Conversion

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Translation Available




## VF-0-11, MM, EC-400, GR-510/512 - VQCPS - OMI-SSR to OMI-2H Conversion - Introduction

OMI replacement kits for VQCPS now use 2-channel hardware. When you use this kit to replace the VQCPS hardware, you must:

1. Install a new OMI.
2. Install a new work probe body.
3. Change the probing macro programs.




 **Caution:** When you do maintenance or repair on CNC machines and their components, you must always follow basic safety precautions. This decreases the risk of injury and mechanical damage.

Do these steps before you do work in the machine or in the control cabinet:

- Set the main circuit breaker to the **[OFF]** position.
- Use an approved lock with an approved safety tag. Always follow lock-out procedures in accordance to local government rules.
- After turning off the machine, wait at least 5 minutes before working in the control cabinet, to allow power to dissipate. Wait for the voltage indicator LED on the vector drive to go off completely.
- Always turn off the main air supply when you work on any part of the pneumatic system.
- Make sure to rest the spindle head on a block of wood when work is done on a vertical axis. This will prevent any unintended movement that could result in the axis falling.
- Never alter any safety circuits on the machine.

You should not do machine repair or service procedures unless you are qualified and knowledgeable about the processes. Serious damage to the machine components can result in costly repairs. The service technicians at your Haas Factory Outlet (HFO) have the training and experience, and are certified to do these tasks safely and correctly. The repair and service work performed by your HFO is protected with a limited warranty.

 **Danger:** Some service procedures can be dangerous or life-threatening. DO NOT attempt a procedure that you do not fully understand. If you have any doubts about doing a procedure contact your Haas Factory Outlet (HFO) and schedule a service visit.

### Machine Compatibility

All machines with the Visual Quick Code Programming System (VQCPS), except VS-1/3 machines. For VS-1/3 machines use kit P/N 93-2382, VS-1/3 - VQCPS - OMI-SSR to OMI-2H Conversion.

### Parts Included

KIT PN: 93-2376, OMI-SSR TO OMI-2H CONVERSION KIT. QTY: 1



**[A]** 32-0750 QTY: 1  
OMI, W/8.5FT CONDUIT 26FT CABLE  
2 CHANNEL



**[B]** 60-0050 QTY: 1  
PROBE, OMP40, SPINDLE PROBE KIT  
2 CHANNEL



**[C]** 33-0605 QTY: 1  
CABLE, 1070 VQCPS OMI 2-CHANNEL  
ADAPTER

## VQCPS - OMI-SSR to OMI-2H Conversion - Optical Machine Interface (OMI) and Work Probe Replacement

### STEP 1

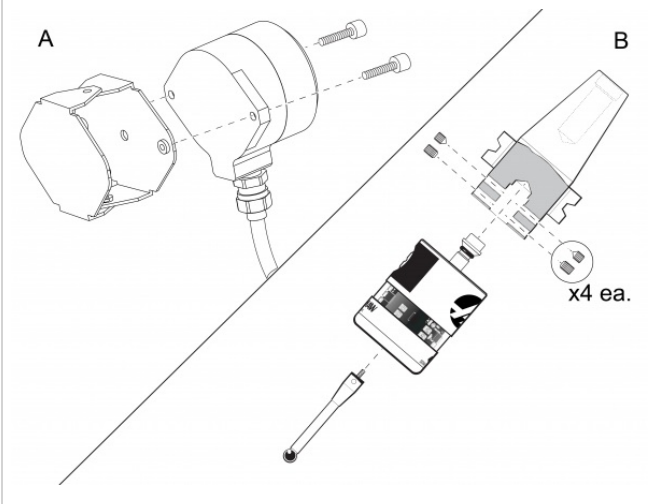


Press **[POWER OFF]**.

Set the main circuit breaker to the **OFF** position.

Lock the main circuit breaker. Use an approved lock with an approved safety tag.

## STEP 2



1. Remove the 1-channel Optical Machine Interface (OMI-SSR) **[A]** from the OMI bracket on the machine, and install the 2-channel OMI in its place.
2. Install the 2-channel OMI (OMI-2H) cable along the same route as the OMI-SSR cable. Use the 33-0605 cable adapter **[C]** between the OMI-2H cable and the machine probe interface. Note that on VS machines, the OMI bracket is on the spindle head and it moves with the Y and Z Axes.
3. Discard the OMI-SSR.
4. Remove the 1-channel work probe assembly from the tool holder, and install the 2-channel work probe body **[B]** in its place. Install the probe tip. Follow the instructions included with the probe body.
5. Discard the 1-channel work probe body.

## STEP 3

Unlock the main circuit breaker.

Set the main circuit breaker to the **ON** position.



Press **[POWER ON]**.

Put the work probe assembly into the spindle.

Align the work probe. Follow the instructions included with the probe body.

**VS-1/3 machines:** Jog the Y and Z Axes to their full travel. Make sure that the OMI cable has enough slack to travel correctly with the spindle head. Make sure that it does not get caught on other components. If necessary adjust the cable route.

# VQCPS - OMI-SSR to OMI-2H Conversion - Probing Macro Program Edits

## STEP 1

Change the value of Setting 23, **9XXX PROGS EDIT LOCK**, to **OFF**.

## STEP 2

Edit program O9832. Remove or comment out the second **M63** command in the program. This example shows the program with the command commented out:

```
%  
O9832 (REN M-CODE ON) ;  
"" ;  
"" ;  
END1 ;  
N3 ;  
M63 ;  
G04 P200 ;  
M53 (*M CODE TO SWITCH ON PROBE) ;  
G04 P200 ;  
(M63) ;  
#3001=0 ;  
%
```

### STEP 3

Edit program O9833. Remove or comment out the first **M63** command in the program. This example shows the program with the command commented out:

```
%  
O9833 (REN M-CODE OFF) ;  
"" ;  
"" ;  
END1 ;  
N3 ;  
(M63) ;  
G04 P200 ;  
M53 (*M CODE TO SWITCH ON PROBE) ;  
G04 P200 ;  
M63 (REPLACE WITH REQUIRED M-CODE) ;  
#3001=0 ;  
%
```

### STEP 4

Change the value of Setting 23, **9XXX PROGS EDIT LOCK**, to **ON**.

### STEP 5

Test the work probe:

Put the work probe into the spindle.

In MDI mode, type **M53** ; and press **[CYCLE START]** to activate the work probe.

Touch the probe stylus. Listen for a "beep" from the control.

Press **[RESET]** to deactivate the work probe.

### STEP 6

Test the table probe:

In MDI mode, type **M52** ; and press **[CYCLE START]** to activate the table probe.

Touch the probe stylus. Listen for a "beep" from the control.

Press **[RESET]** to deactivate the table probe.