

TB3-PIN	I/O	SYSTEM	HAL-PIN	TB2-PIN	I/O	SYSTEM	HAL-PIN
1	INPUT0	Back gear LH		1	INPUT16	NC-Start	
2	INPUT1	Back gear RH		2	INPUT17	E-Stop	
3	INPUT2	Back gear Mid		3	INPUT18	Indramat-Ready	
4	INPUT3	Back gear LH-Mid		4	INPUT19	Spindle And Feed Stop	
5	INPUT4	Midrange LH		5	INPUT20	Machine Spindle Stopped	
6	INPUT5	Midrange RH		6	INPUT21		
7	INPUT6	Midrange Mid		7	INPUT22		
8	INPUT7	Midrange LH-Mid		8	INPUT23		
9	INPUT8	Input stage LH		9	INPUT24		
10	INPUT9	Input stage RH		10	INPUT25		
11	INPUT10	Input stage Mid		11	INPUT26		
12	INPUT11	Input stage LH-Mid		12	INPUT27		
13	INPUT12			13	INPUT28		
14	INPUT13			14	INPUT29		
15	INPUT14			15	INPUT30		
16	INPUT15			16	INPUT31		
17	OUTPUT0	Select Mid Position		17	OUTPUT8	CNC-Ready	
18	OUTPUT1	Backgear		18	OUTPUT9	Tool Relise	
19	OUTPUT2	Mid Range		19	OUTPUT10	Coolant On M8	
20	OUTPUT3	Input Stage		20	OUTPUT11	Spindle CW M3	
21	OUTPUT4	Reverse Direction		21	OUTPUT12	Spindle CCW M4	
22	OUTPUT5	Start		22	OUTPUT13	Main Spindle On	
23	OUTPUT6	Twich CW		23	OUTPUT14		
24	OUTPUT7	Twich CCW		24	OUTPUT15		