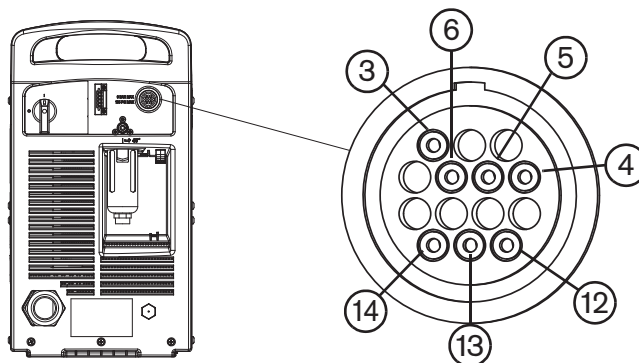


## 7 – Mechanized Cutting

### Machine interface pinout

Figure 2 – Connector sockets



Refer to *Table 11* when connecting the power supply to a torch height controller or CNC controller with a machine interface cable.

Table 11 – Machine interface cable signals

Signal	Type	Notes	Connector sockets	External cable wires
Start (start plasma)	Input	Normally open. 18 VDC open circuit voltage at START terminals. Requires dry contact closure to activate.	3, 4	Green, black
Transfer (start machine motion)	Output	Normally open. Dry contact closure when the arc transfers. 120 VAC/1 A maximum at the machine interface relay.	12, 14	Red, black
Ground	Ground		13	
Voltage divider	Output	Divided arc signal of 20:1, 21.1:1, 30:1, 40:1, 50:1 (provides a maximum of 16 V).	5 (-), 6 (+)	Black (-), white (+)