

External connections

Signal	Type	SS Relay	H/W Relay	Connection	Notes	
7176E						
X Home	Input	1		Digital In	24v/gnd N/O sw across relay trigger, in/24v across N/O load	
Y Home	Input	1		Digital In	24v/gnd N/O sw across relay trigger, in/24v across N/O load	
Y1 Home	Input	1		Digital In	24v/gnd N/O sw across relay trigger, in/24v across N/O load	
Z Home/Probe/Breakaway	Input	1		Digital In	24v/gnd N/O sw across relay trigger, in/24v across N/O load	
Laser	Output	1		Digital Out	5V/comm supply (non-isolated) across relay N/O load	
Ohmic enable	Output		1	Digital Out	Isolated 24v/comm supply across relay N/O load	
Torch On	Output	1		Digital Out	Cut60 pin 1 & 2 across relay N/O load	
Move OK (Arc OK)	Input	1		Digital In	Cut60 pin 9 & 10 across relay trigger, in/24v across N/O load	Optional?
THCAD10 FO-	Input			ENCA-		
THCAD10 FO+	Input			ENCA+		
THCAD10						
VDIV +	Input			IN+	Cut60 pin 6 (1:50)	
VDIV -	Input			IN-	Cut60 pin 4	
THCAD5						
Ohmic Probe +	Input			IN+	Isolated 24v supply	
Ohmic Probe -	Input			IN+	Isolated 24v supply	