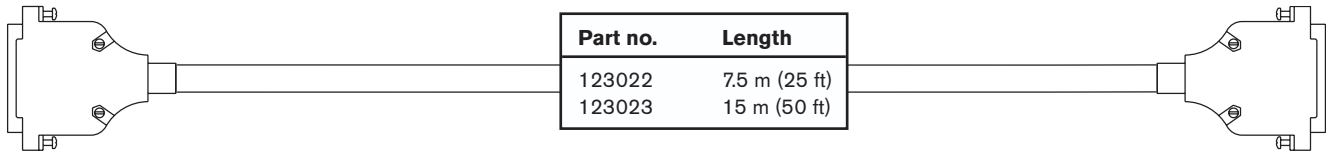


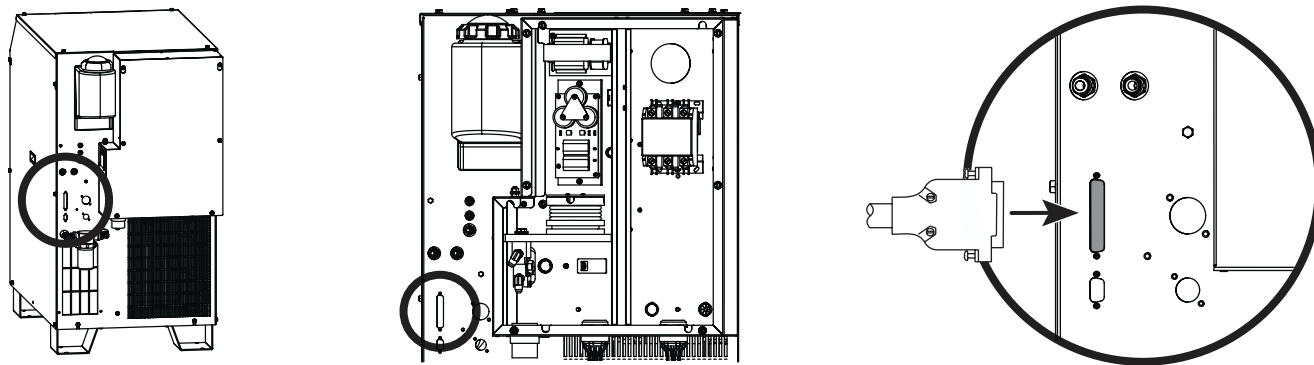
4 Power supply to CNC interface cable



Power supply

CNC

Wire color	Pin no.	Input/ Output	Signal name	Function	Input/ Output	Notes
Black	1	Input	None	Not used	Output	
Red	20	Input	None	Not used	Output	
Black	2	Output	None	Not used	Input	
Green	21	Output	None	Not used	Input	
Black	3		None	Not used		
Blue	22		None	Not used		
Black	4	Output	Motion E (-) Motion C (+)	Notifies the CNC that an arc transfer has occurred and to begin machine motion once the CNC's pierce delay has timed out.	Input	2
Yellow	23	Output			Input	
Black	5	Output	None	Not used	Input	2
Brown	24	Output	None	Not used	Input	
Black	6	Output	Rampdown error E (-) Rampdown error C (+)	Notifies the CNC that a rampdown error has occurred	Input	2
Orange	25	Output				
Red	7	Output	None	Not used	Input	2
White	26	Output	None	Not used		
Red	8	Output	None	Not used	Input	2
Green	27	Output	None	Not used	Input	
Red	9	Output	None	Not used	Input	2
Blue	28	Output	None	Not used	Input	
Red	10	Output	None	Not used	Input	2
Yellow	29	Output	None	Not used	Input	
Red	11		None	Not used		
Brown	30		None	Not used		
Red	12	Input	Corner - Corner +	CNC Notifies the plasma system that a corner is approaching and to reduce cut current (Cut current is CNC selectable or defaults to 75% of cut current)	Output	1
Orange	31	Input			Output	
Green	13	Input	Pierce - Pierce +	CNC Notifies the plasma system to maintain the shield preflow until the CNC releases the signal.	Output	1
White	32	Input				
Green	14	Input	Hold - Hold +	Not required without Command THC. Command THC requires signal to preflow gases during IHS.	Output	1
Blue	33	Input				
Green	15	Input	Start - Start +	CNC initiates the plasma arc.	Output	1
Yellow	34	Input			Output	
Green	16		None	Not used		
Brown	35		None	Not used		
Green	17		None	Not used		
Orange	36		Power ground	Ground		
White	18		Power ground	Ground		
Black	37		CNC +24 VDC	Available 24 VDC (200 milliamps maximum) See notes		3
	19		CNC + 24 VDC	Not connected		



Notes to CNC interface cable run list

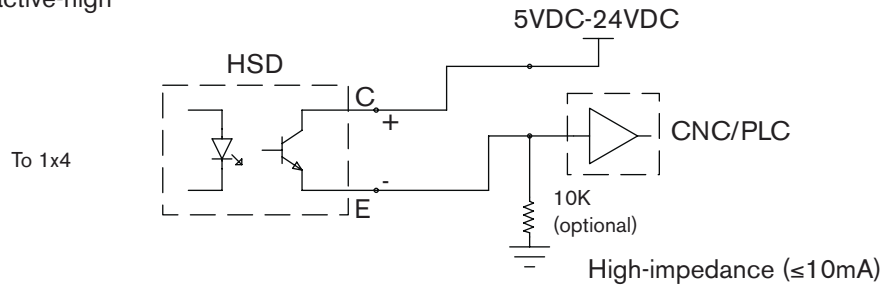
- Note 1. Inputs are relay coils. They require 24 VDC at 8.3 mA, or dry-contact closure.
- Note 2. Outputs are optically isolated, open-collector, transistors. The maximum rating is 24 VDC at 10 mA.
- Note 3. CNC +24 VDC provides 24 VDC at 200 mA maximum. A jumper is required on J300 to use 24 V power.

Caution: The CNC cable must be constructed using cable with 360 degree shielding and metal housing connectors at each end. The shielding must be terminated to the metal housings at each end to ensure proper grounding and to provide the best shielding.

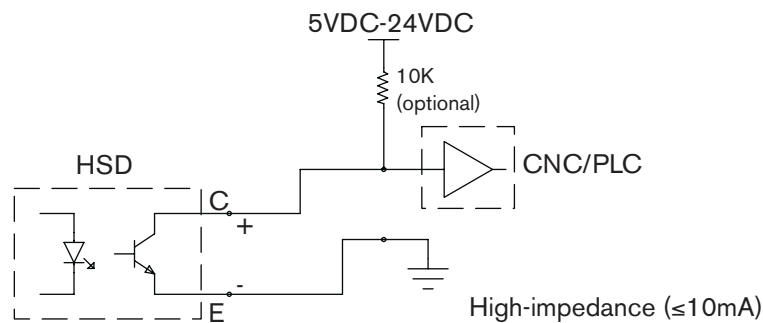


Examples of output circuits

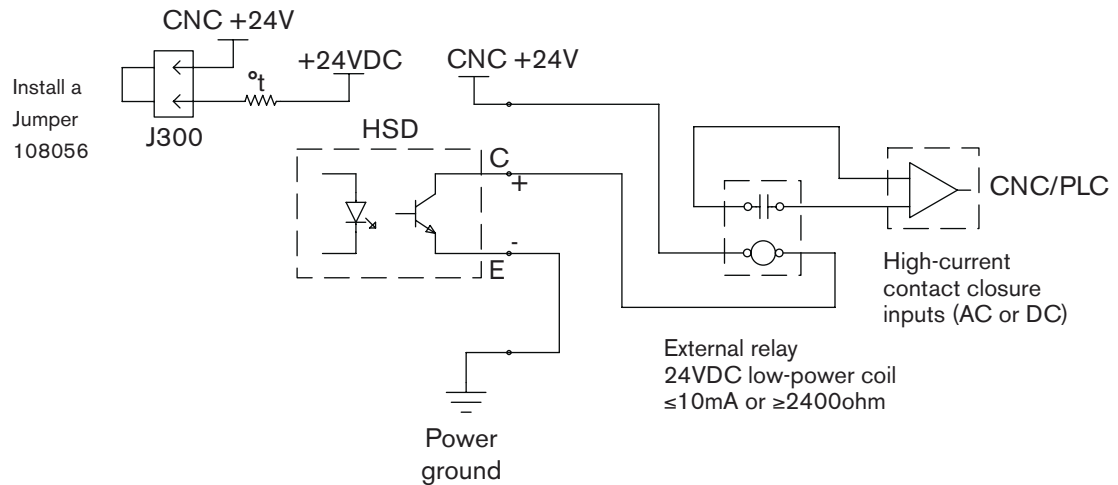
1. Logic interface, active-high



2. Logic interface, active-low



3. Relay interface



4. Do not use this configuration. Warranty will be void.

