

Indexer Electrical Connections

M-Function

We use industry standard M-function relay, wiring and signal protocols.

The indexer finish relay is normally open by default. This can be changed in the menu setup.

The indexer finish relay is closed for 500ms. If the CNC needs a longer time, increase the INI settings FINISHTIME value in a PC text editor.

Pin definitions on the circular DIN connector:

- **Only touch Black +24 volts to White to test cycle start.**

Pin 1	Red	Servo Control Finished relay
Pin 2	Green	Servo Control Finished relay
Pin 3	Black	CNC Start Relay (+24 Volts out from Servo Control)
Pin 4	White	CNC Start Relay (Cycle Start on Servo Control)

The CNC M-function start signal will be wired to the N/O relay coil.

Use a voltage meter to measure across the Black and White relay terminals:

24VDC when the relay is open.

0VDC when the relay is closed (Indexer will start).

