

# Indexer Electrical Connections

## M-Function

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

The finish relay setup is normally open by default.

Pin definitions on the circular DIN connector:

- **DO NOT allow Red and Green wires to touch. This will damage the circuit board.**
- **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)

