

Indexer Electrical Connections

M-Function

The circular din on the back of the Servo Control box that is labeled as the M-function is the input and output for the CNC and Servo Control completion relays.

Pin definitions on the circular DIN connector:

(Touch Black +24 volts only 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)

