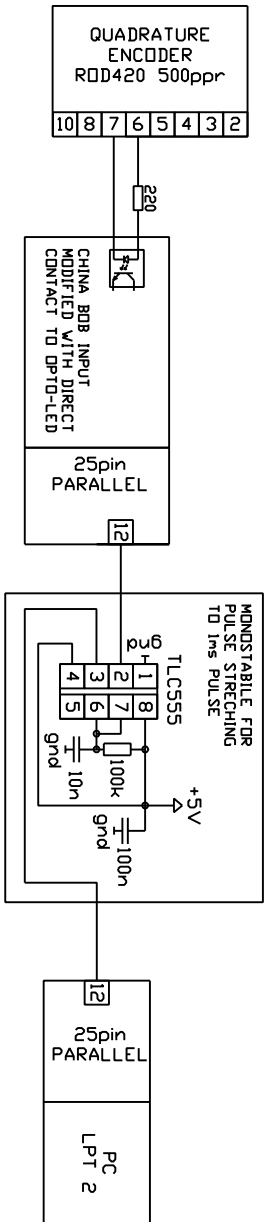


NOTE! ALL PIN NUMBERS ARE DEVICE PIN NUMBERS, NOT CABLE CONDUCTOR NUMBERS.

RPM INPUT FROM SERVOD
SPINDLE ENCODER INDEX PULSE.
PULSE IS TOO SHORT FOR
DIRECT USE, LESS THAN 1µs AT
HIGH SPEEDS, SO NEEDS TO BE
STRETCHED.
555 NEEDS TO BE CMOS
VERSION FOR TTL
COMPATIBILITY.
INDEX PULSE USED ALSO AS
SPINDLE HOME SWITCH.

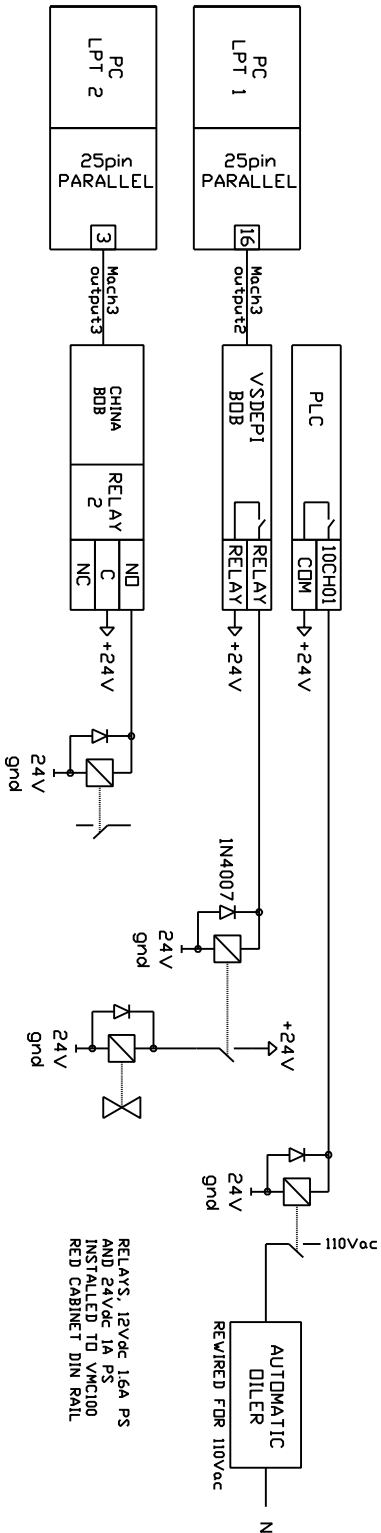


OUTPUT FOR DILER.
PLC DILS MACHINE.
DME PER HOUR

OUTPUT FOR AIR,
ATC CLEANS SPINDLE
WITH AIR BURST

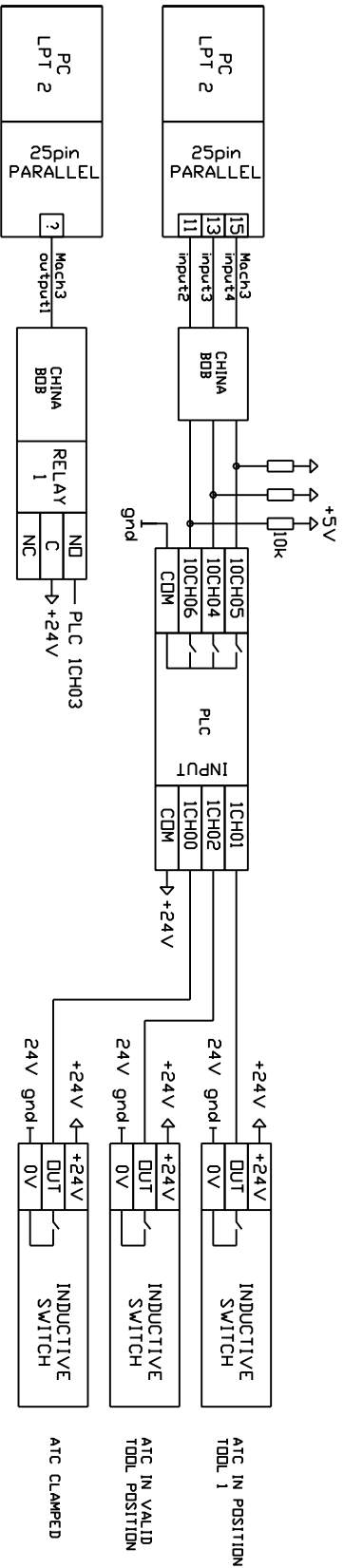
OUTPUT FOR DISABLING
Z LIMIT WHEN ATC IS
CHANGING TOOL

OUTPUT FOR
FUTURE USE



RELAYS, 12Vdc 16A PS
AND 24Vdc 1A PS
INSTALLED TO VMCI00
RED CABINET DIN RAIL

INPUTS FOR ATC
INDUCTIVE SWITCHES
PLC TRANSLATES 24V
SIGNAL TO TTL FOR BOB



OUTPUT DISABLES
Z LIMIT DURING ATC
MOVEMENT