

| I/O Pin | Connected Switch/Control | I/O Pin | Connected Switch/Control |
|---------|---------------------------------------|---------|---------------------------------|
| 1 | Pendant Encoder (Green - Only Moving) | 55 | |
| 2 | Pendant Encoder (Green - Not Moving) | 54 | |
| 3 | Y, Z, 6 on Top Pendant Switch | 53 | |
| 4 | X, Z, 5 on Top Pendant Switch | 52 | - Jog on Panel |
| 5 | | 51 | + Jog on Panel |
| 6 | | 50 | |
| 7 | 4, 5, 6 on Top Pendant Switch | 49 | Axis Selector 6 on Panel |
| 8 | | 48 | Axis Selector 5 on Panel |
| 9 | .001 on Bottom Pendant Switch | 47 | Axis Selector 4 on Panel |
| 10 | V on Bottom Pendant Switch | 46 | Axis Selector Z on Panel |
| 11 | | 45 | Axis Selector Y on Panel |
| 12 | Pendant Enable Key | 44 | Axis Selector X on Panel |
| 13 | | 43 | Axis Selector Off on Panel |
| 14 | Feed Hold on Panel | 42 | Feedrate Override 130% on Panel |
| 15 | | 41 | Feedrate Override 115% on Panel |
| 16 | | 40 | Feedrate Override 100% on Panel |
| 17 | Cycle Start on Panel | 39 | Feedrate Override 85% on Panel |
| 18 | E-Stop on Panel (Green when go) | 38 | Feedrate Override 70% on Panel |
| 19 | Step Jog X1 on Panel | 37 | Feedrate Override 55% on Panel |
| 20 | Step Jog X.1 on Panel | 36 | Feedrate Override 40% on Panel |
| 21 | Step Jog X.01 on Panel | 35 | Feedrate Override 25% on Panel |
| 22 | Step Jog X.001 on Panel | 34 | Feedrate Override 15% on Panel |
| 23 | Step Jog X.0001 on Panel | 33 | Feedrate Override 8% on Panel |
| 24 | Continuos Jog 2% on Panel | 32 | Feedrate Override 4% on Panel |
| 25 | Continuos Jog 5% on Panel | 31 | Feedrate Override 0% on Panel |
| 26 | Continuos Jog 10% on Panel | 30 | Continuos Jog 100% on Panel |
| 27 | Continuos Jog 25% on Panel | 29 | Continuos Jog 75% on Panel |
| 28 | Continuos Jog 50% on Panel | | |

Off on top pendant switch does not light up any inputs

.0001 on bottom pendant switch does not light up any inputs

| | Pin 7 | Pin 3 | Pin 4 |
|-----|-------|-------|-------|
| Off | 0 | 0 | 0 |
| X | 0 | 0 | 1 |
| Y | 0 | 1 | 0 |
| Z | 0 | 1 | 1 |
| 4 | 1 | 0 | 0 |
| 5 | 1 | 0 | 1 |
| 6 | 1 | 1 | 0 |
| | 1 | 1 | 1 |