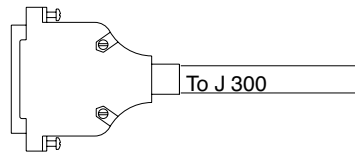
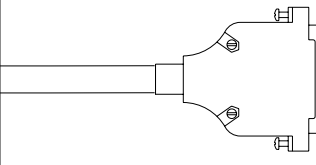


8 Power supply to CNC interface cable



Part no.	Length	Part no.	Length
123210	3 m (10 ft)	123741	25 m (82 ft)
123211	4.5 m (15 ft)	123742	35 m (115 ft)
123022	7.5 m (25 ft)	123220	45 m (150 ft)
123314	10 m (35 ft)	123852	60 m (200 ft)
123023	15 m (50 ft)	123853	75 m (250 ft)
123851	20 m (65 ft)		



9 Optional multi-system CNC interface cable (see schematics for installation information)

Power supply

CNC

Wire color	Pin #	Input/Output	Signal name	Function	Input/Output	Notes
Black Red	1 20	Input Input	Rx - Rx +	RS-422 serial receiver RS-422 serial receiver	Output Output	
Black Green	2 21	Output Output	Tx - Tx +	RS-422 serial transmitter RS-422 serial transmitter	Input Input	
Black Blue	3 22		RS-422 ground None	RS-422 serial ground Not used		
Black Yellow	4 23	Output Output	Motion 1 E (-) Motion 1 C (+)	Notifies the CNC that an arc transfer has occurred and to begin machine motion once the CNC's pierce delay has timed out.	Input Input	2 & 3
Black Brown	5 24	Output Output	Error E (-) Error C (+)	Notifies the CNC that an error has occurred.	Input Input	2
Black Orange	6 25	Output Output	Rampdown error E (-) Rampdown error C (+)	Notifies the CNC that a rampdown error has occurred	Input	2
Red White	7 26	Output Output	Not ready E (-) Not ready C (+)	Notified the CNC that the plasma system is not ready to fire an arc	Input	2
Red Green	8 27	Output Output	Motion 2 E (-) Motion 2 C (+)	Notifies the CNC that an arc transfer has occurred and to begin machine motion once the CNC's pierce delay has timed out.	Input Input	2 & 3
Red Blue	9 28	Output Output	Motion 3 E (-) Motion 3 C (+)	Notifies the CNC that an arc transfer has occurred and to begin machine motion once the CNC's pierce delay has timed out.	Input Input	2 & 3
Red Yellow	10 29	Output Output	Motion 4 E (-) Motion 4 C (+)	Notifies the CNC that an arc transfer has occurred and to begin machine motion once the CNC's pierce delay has timed out.	Input Input	2 & 3
Red Brown	11 30		None None	Not used Not used		
Red Orange	12 31	Input Input	Corner - Corner +	CNC Notifies the plasma system that a corner is approaching and to reduce cut current (Cut current is CNC selectable or defaults to 50% of cut current)	Output Output	1
Green White	13 32	Input Input	Pierce - Pierce +	CNC Notifies the plasma system to maintain the shield preflow until the CNC releases the signal.	Output	1
Green Blue	14 33	Input Input	Hold - Hold +	Not required without Command THC. Command THC requires signal to preflow gases during IHS.	Output	1
Green Yellow	15 34	Input Input	Start - Start +	CNC initiates the plasma arc.	Output Output	1
Green Brown	16 35		None None	Not used Not used		
Green Orange	17 36		None Power ground	Not used Ground		
White Black	18 37		Power ground CNC +24 VDC	Ground Available 24 VDC (200 milliamps maximum) See notes		4
	19		CNC + 24 VDC	Not connected		