

4

3

2

1


REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROV
RE-DRAWN & UPDATED				

LATHES ONLY		
CHART OF JUMPERS		CONNECTOR NUMBER
PARITY	EVEN PARITY	10 NO JUMPER
	NO PARITY	10 JUMPER TO + 24 VOLTS
SPINDLE INTERLOCK	HARDINGE D 5 M	31 (M03) TO 11 EXTERNAL SPINDLE "ON" TO 12
SPINDLE INTERLOCK DISABLED	HARDINGE D 5 M	11 TO 1 OR 36 (24 VOLTS)

MILLS ONLY		
CHART OF JUMPERS		CONNECTOR NUMBER
PARITY	EVEN PARITY	10 NO JUMPER
	NO PARITY	10 JUMPER TO + 24 VOLTS
RESOLUTION	.0001	11 JUMPER TO + 24 VOLTS
	.0005	11 NO JUMPER
MILL TYPE	MINI MILL	12 & 13 NO JUMPER
	LAGUN	12 NO JUMPER 13 JUMPER TO + 24 VOLTS
	BRIDGEPORT	12 JUMPER TO + 24 VOLTS 13 NO JUMPER

RPM ON 35
 COOL FLOOD 33
 SPINDLE CW 31
 PROCESSOR STOP 103 29
 LSB 27
 BCD PARALLEL 25
 M FUNCTION OUTPUT 23
 GND 19
 M FUNCTION ENABLE 17
 POWER ON STATUS 101 15
 SEE CHART 13
 SEE CHART 11
 JOG {
 -X 9
 -Y 7
 -Z 5
 -C 3
 + 24 1
 }
 36 + 24
 34 RPM UP
 32 MIST COOL 2
 30 SPINDLE CCW
 28 M STROBE
 26
 24 M FUNCTION OUTPUT
 22 BCD PARALLEL
 20 MSB
 18 GND
 16 10 OVERLOAD STATUS
 14 105 LIMIT SWITCH INPUT
 12 SEE CHART
 10 SEE CHART
 8 + X
 6 + Y
 4 + Z
 2 + C
 JOG

CONNECT TO + 24 V.D.C.
 WHEN NO AUXILIARY
 M FUNCTIONS ARE USED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 2. - .XX ± - ± - XXX ± -		CONTRACT NO.		 SERVO PRODUCTS COMPANY 433 NORTH FAIR OAKS AVENUE, PASADENA, CALIFORNIA 91101
MATERIAL		APPROVALS	DATE	
D-3635		DRAWN <i>Shirley Seim</i> 1-16-80 CHECKED <i>John Roush</i> 30 Jan 80	CONNECTION-MACH. INTERFACE CNC	
NEXT ASSY USED ON		FINISH	SIZE B	CODE IDENT NO. 3899
APPLICATION		DO NOT SCALE DRAWING	SCALE 2	SHEET 1 OF 1