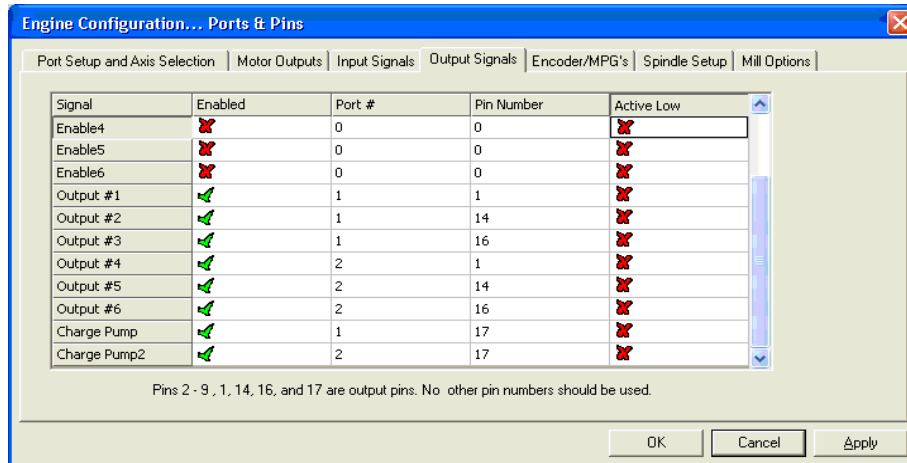


Output Signals:

Output signals are depicted below. Note which are enabled and which pins are selected and their respective ports. These will control auxiliary devices such as spindle, coolant, pumps, etc. The encoder interface has 4 relays on board rated at 125 vac and 15 amps. The Sound Logic Breakout board requires a solid state relay to be used with each of its outputs. Note on Charge pump J-9 mode, See page 5 to free up one of the outputs for other uses.



Encoder MPG's:

In the screen below, Port 2, proper pin number and steps per unit must be entered. The steps per unit will be the same as in “motor tuning” menu. Or simply the CPR in quadrature of the encoder device times the pitch lead of the ballscrew. Again, depending on your particular configuration. If the DRO reads in opposite, simply swap encoder A&B pins. If encoder data is displayed on an incorrect DRO simply swap with the correct encoder entry. Example: If Encoder 3 is displayed on Encoder 2, and 2 on 3, swap with one another.

