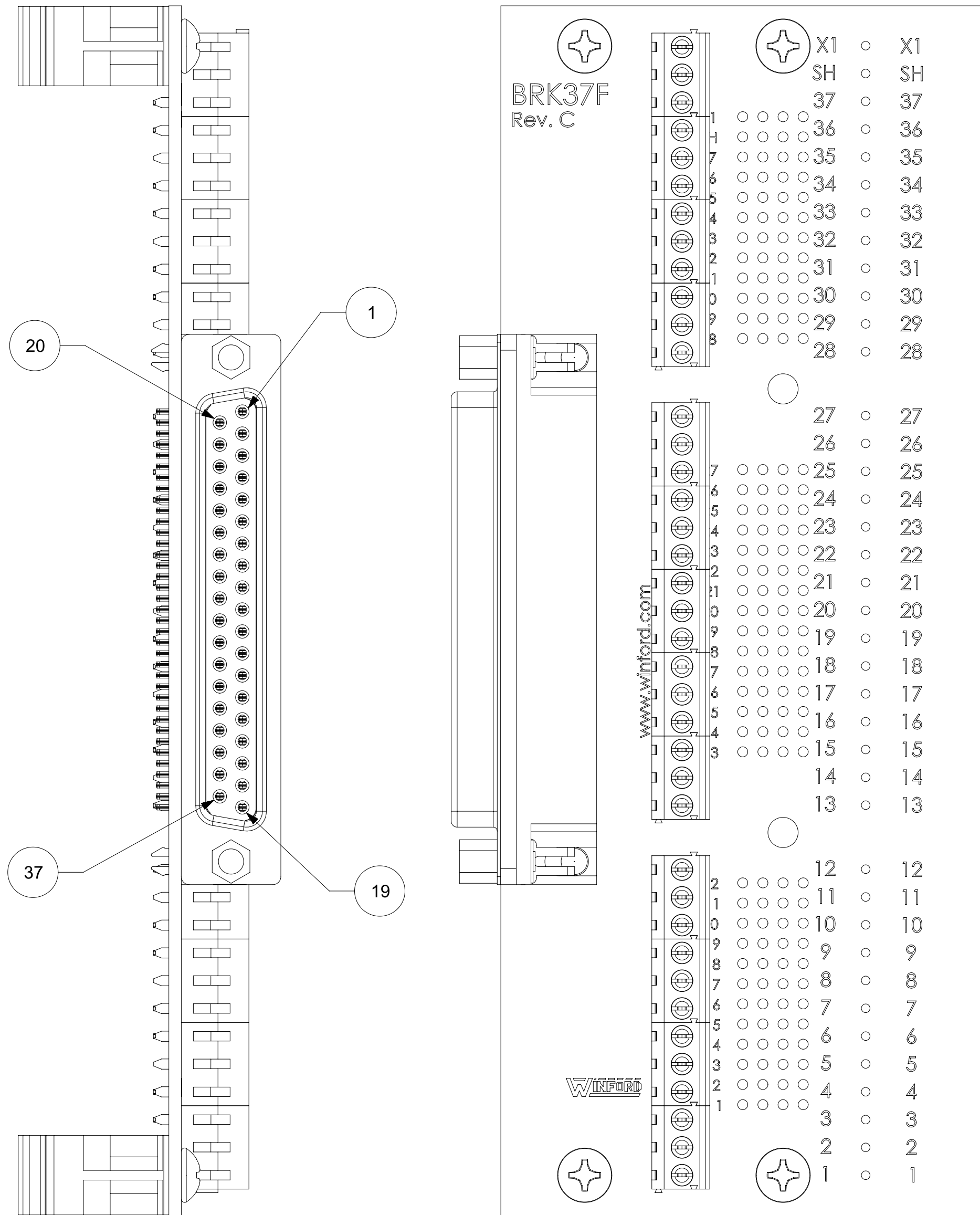




Pin#	J325 Wire#	Description	Status of wires with Old Controller On and Disconnected for Old Controller
1	#200	+24 VDC	Red Wire
2			
3			
4	#216	Wayoil - Lube Level	+24 VDC
5	#258	Spindle Drawing -Air Pressure OK	+24 VDC (When Air Pressure is Connect and On)
6			
7			
8			
9	#201	E-Stop (Z-Axis OT)	+24 VDC
10			
11			
12			
13	#235	Drawbar Unclamp	0 VDC
14	#234	Drawbar Clamp	+24 VDC
15	#239	Spindle Zero Speed	+24 VDC
16	#237	Spindle - Up to Speed	+24 VDC
17	#200	+24 VDC (X-Home)	Green Wire
18	#200	+24 VDC (Y-Home)	White Wite
19	#200	+24 VDC (Z-Home)	Black Wire
20			
21			
22			
23	#238	Spindle - High Speed	+24 VDC
24	#255	E-Stop / Limit (Push Button on Front)	+24 VDC
25	#207	X/Y Axis Limit Switch Over-Travel Switches)	+24 VDC
26	#208	Spindle - Motor OverLoad	+24 VDC
27			
28			
29			
30			
31			
32			
33			
34			
35			
36			
37			

NOTE:

Wire #235 has +24 VDC when the Tool changer switch at the right side of the machine spindle is rotated clockwise.

