



Power supply end					CNC end	
Wire color	Pin number	Input/Output	Signal name	Function	Input/Output	Notes
Orange	1	Input	Start +	The CNC initiates preflow, and if the hold input is not active, continues with the plasma arc. The system will stay in preflow if the hold input remains active.	Output	1
White	2	Input	Start –		Output	
Brown	3	Input	Hold +	The CNC delays plasma arc initiation. This signal is normally used in combination with the start signal to synchronize multiple torches.	Output	1 and 3
White	4	input	Hold –		Output	
Black	5	Output	Motion +	Notifies the CNC that an arc transfer has occurred and to begin machine motion once the CNC's pierce delay has timed out.	Input	2
White	6	Output	Motion –		Input	
Red	7	Output	Error +	Notifies the CNC that an error has occurred.	Input	2
White	8	Output	Error –		Input	

Notes to CNC interface cable run list

1. Inputs are optically isolated. They require 24 VDC at 12.5 mA, or dry-contact closure at 8 mA.
2. Outputs are optically isolated, open-collector, transistors. The maximum rating is 24 VDC at 10 mA.
3. Although the power supply has an output capability, it is normally used solely as an input.
4. There is no +24 VDC power available at the J6 CNC connector.
5. The wire clips on the center panel should be used to help route the CNC cable from the rear panel opening of the power supply to J6 on the control board. Open the clips by depressing the release tab, and add the CNC cable to the wires that are already present in the clip. See the figure on the next page.