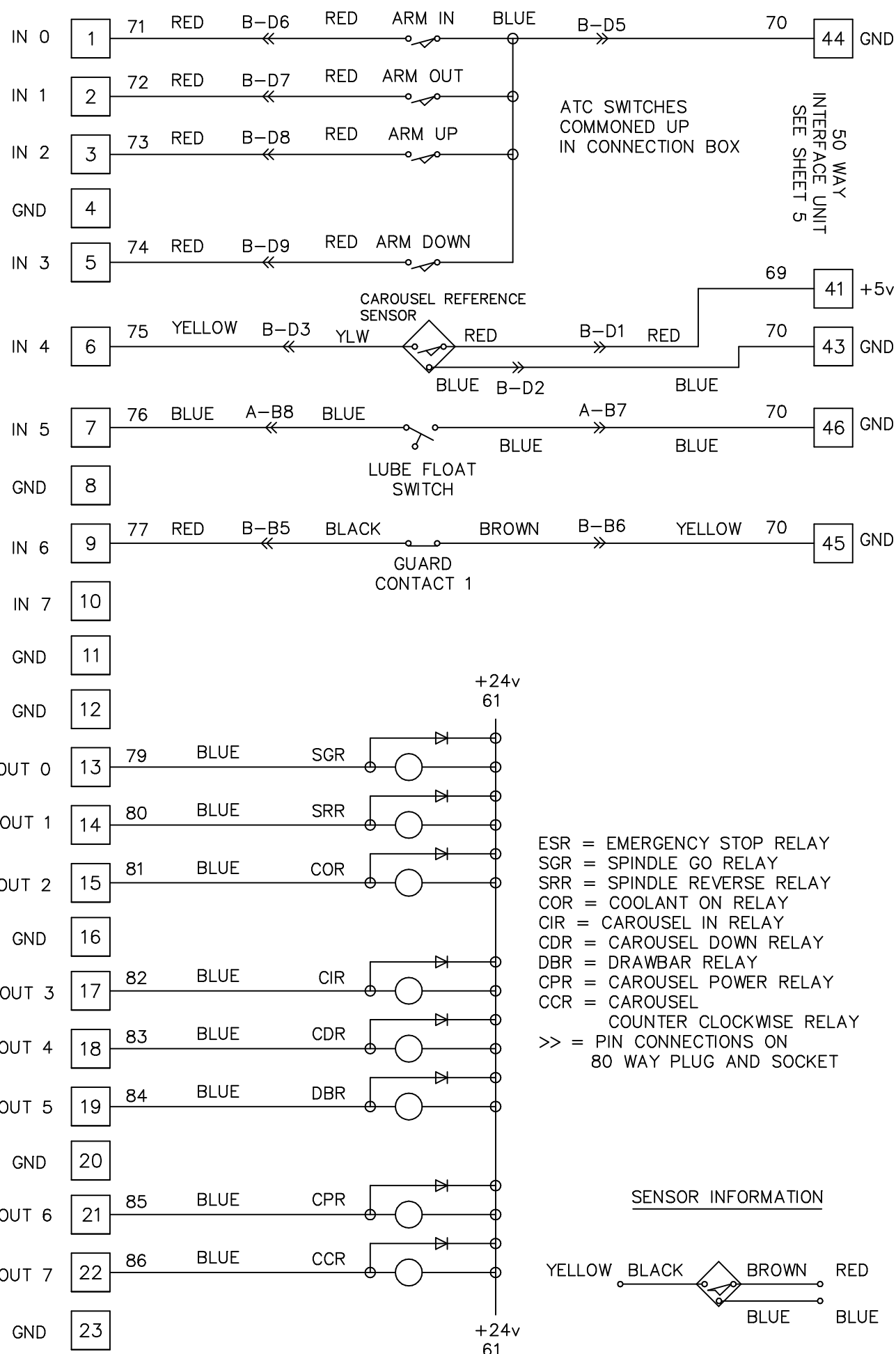


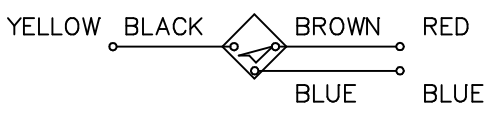
50 WAY
INTERFACE UNIT

BEAD CAPACITORS
(RS 126-590)
1K RESISTOR
(RS 132-494)

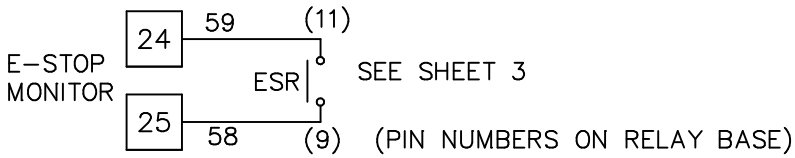


ESR = EMERGENCY STOP RELAY
SGR = SPINDLE GO RELAY
SRR = SPINDLE REVERSE RELAY
COR = COOLANT ON RELAY
CIR = CAROUSEL IN RELAY
CDR = CAROUSEL DOWN RELAY
DBR = DRAWBAR RELAY
CPR = CAROUSEL POWER RELAY
CCR = CAROUSEL COUNTER CLOCKWISE RELAY
>> = PIN CONNECTIONS ON 80 WAY PLUG AND SOCKET

SENSOR INFORMATION



BLACK	SIGNAL	75
BROWN	+5v	69
BLUE	0v	70



50 WAY
INTERFACE UNIT
SEE SHEET 5