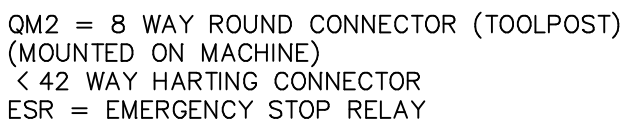


A= BLUE 0v  
+= RED 24v  
-= YELLOW  
SIGNAL

(A) 61 12v  
(B) 60 0v  
(C) 72 INPUT 1  
(D) 73 INPUT 2  
(E) 74 OUTPUT 1  
(F) 75 OUTPUT 2  
(G) 51A  
(H) EARTH



1K  
RESISTOR  
(RS 132-494)

SHEET 2  
STARTURN]  
[ GR2 ]

PIN	COLOUR	WIRE
1	BROWN	22
2	BLUE	21
3	EARTH	E
4	BLUE	61
5	RED	61
6	BLUE	40
7	WHITE	41
8	VOLET	42
9	GRN/YLW *	60
10	BROWN	38
11	BLACK	37
12	SCREEN	E
13	RED	52
14	BLUE	54
15	YELLOW	81
16	GREEN	82
17	RED	50
18	BLUE	51
19	YELLOW	61
20	GREEN	90
21	RED	83

SPINDLE MOTOR  
1.5mm SINGLES

12v FOR DATUMS  
0.5mm SINGLE

TOOLPOST WIRING  
8 CORE SCREEN

\*  
GREEN AND YELLOW WIRES COMMONED

E-STOP CONTACT 1  
4 CORE SCREEN

E-STOP CONTACT 2

GUARD CONTACT 1  
4 CORE SCREEN

GUARD CONTACT 2

GUARD INTERLOCK SOLENOID  
0.5mm SINGLE

2.5mm EARTH

PIN	COLOUR	WIRE
22	RED	
23	BLUE	
24	YELLOW	
25	GREEN	
26	SCREEN	E
27	BLACK	
28	ORANGE	
29	RED	
30	YELLOW	
31	BLACK	
32	ORANGE	
33	RED	
34	YELLOW	
35	WHITE	46
36	PINK	47
37	GREEN	60
38	BLACK	13
39	BLACK	N
40	BLUE	61
41	BLUE	60
42	BLUE	84

SPINDLE ENCODER  
4 CORE SCREEN

X AXIS MOTOR  
0.2mm SINGLES

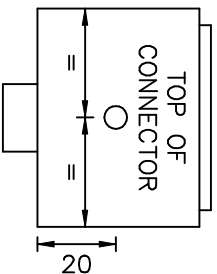
Z AXIS MOTOR  
0.2mm SINGLES

X DATUM  
Z DATUM  
0.2mm SINGLES

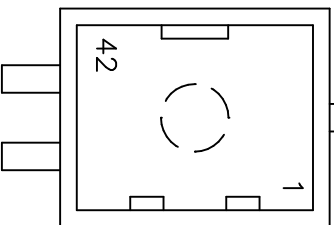
SPRAY MIST  
0.5mm SINGLES

WORKLIGHT  
0.5mm SINGLES

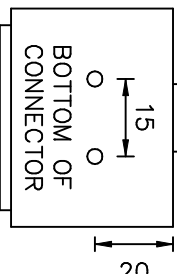
GUARD INTERLOCK SOLENOID  
0.5mm SINGLE

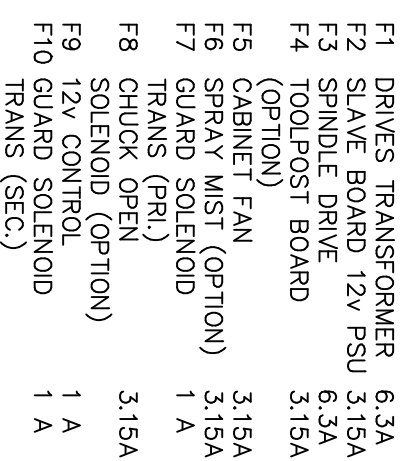


6mm AIR PIPE FOR CHUCK (OUT OF TOP)



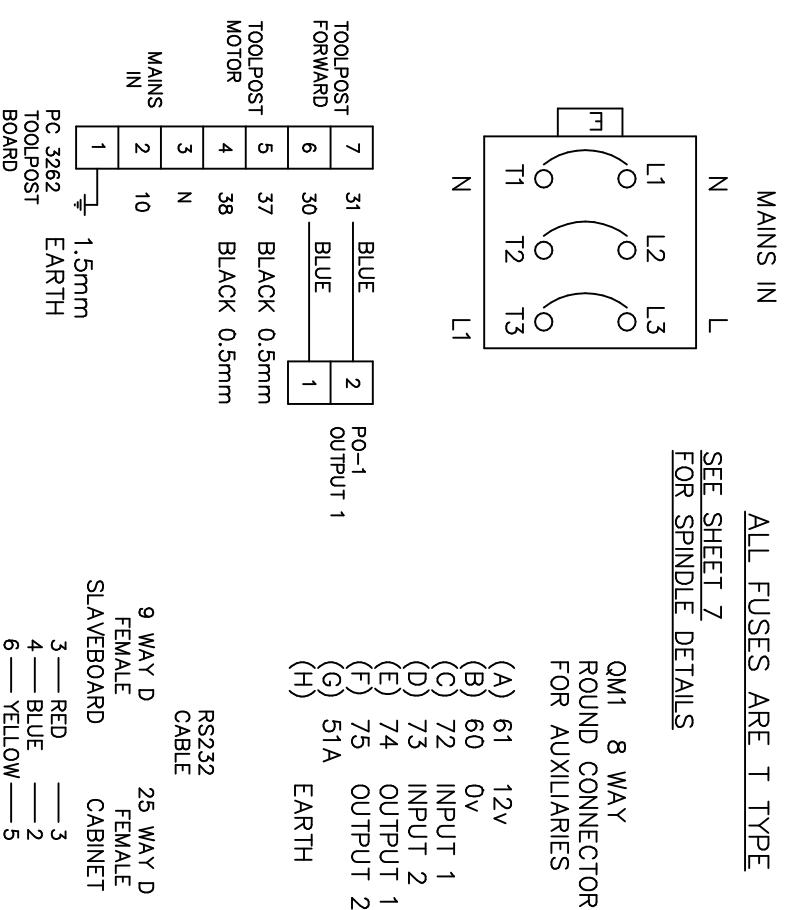
4mm AIR PIPES FOR POWER GUARD





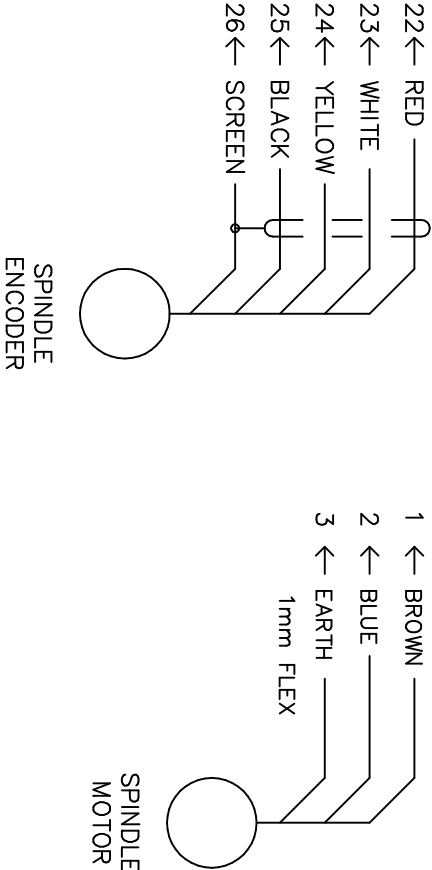
## MAINS IN

QM1 8 WAY  
ROUND CONNECTOR  
FOR AUXILIARIES

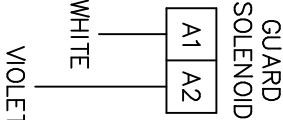
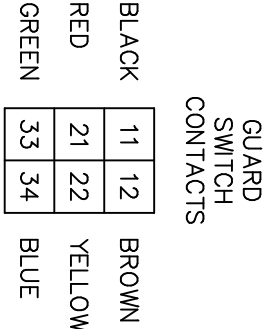
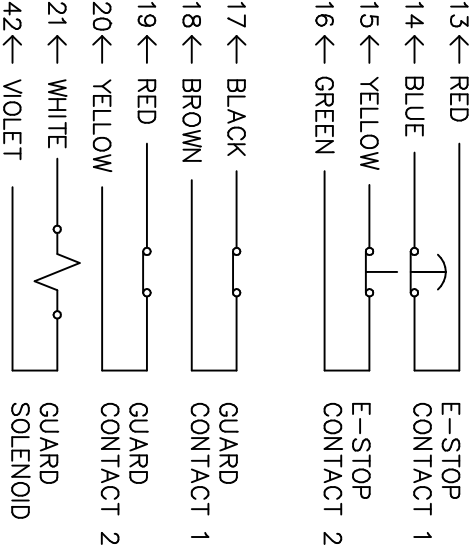


IF IN DOUBT    ASK

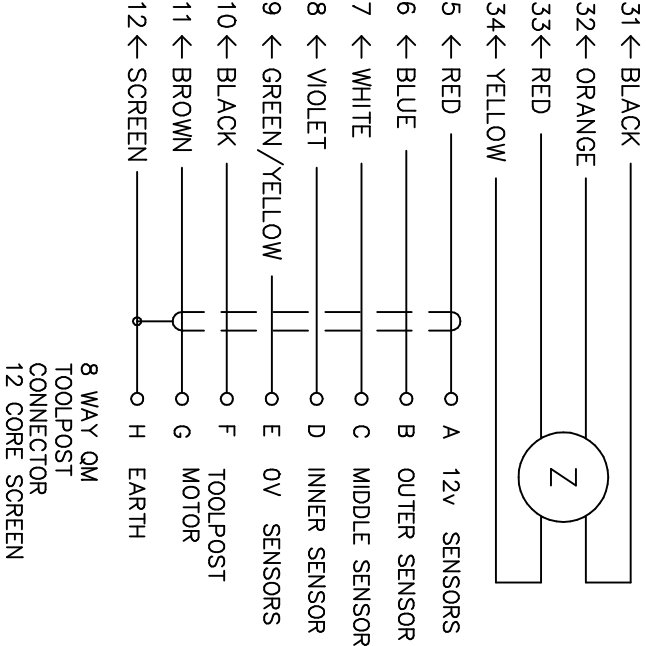
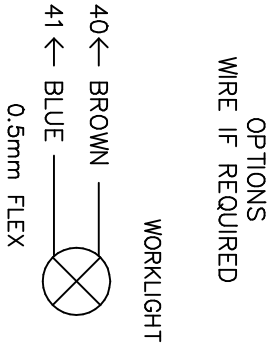
<    42 WAY HARTING CONNECTOR



STEPPER MOTORS  
LINK  
RED/WHITE + YELLOW/WHITE  
ORANGE/WHITE + BLACK/WHITE



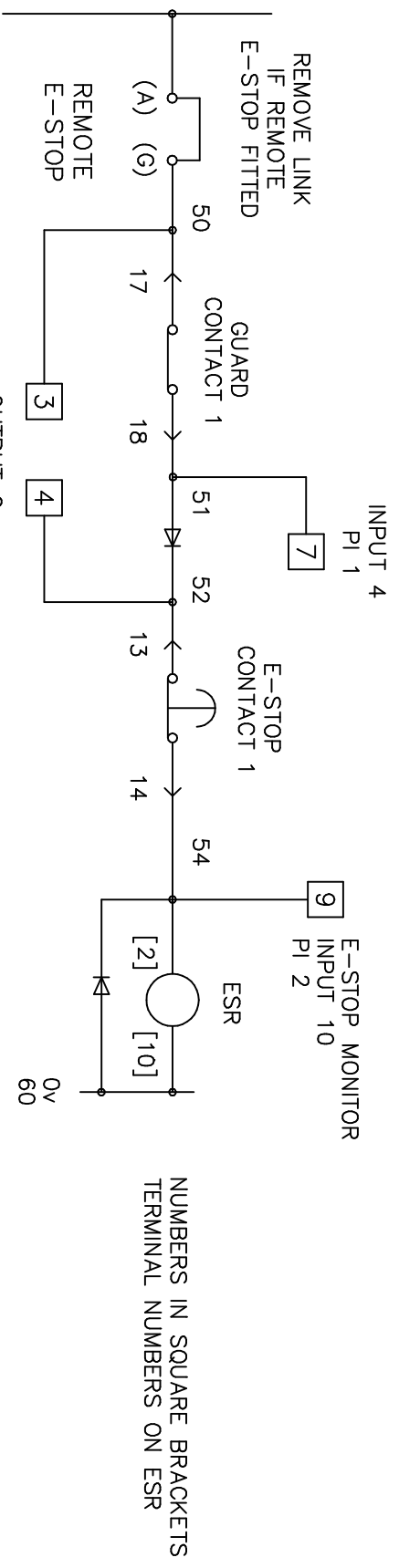
GUARD INTERLOCK  
(REMOVE LINK 12 – 41)



12 WAY QM  
IN SADDLE  
CONNECTION BOX  
0.2mm SINGLES

STARTURN 5  
MOTOR AND  
DATUM WIRING

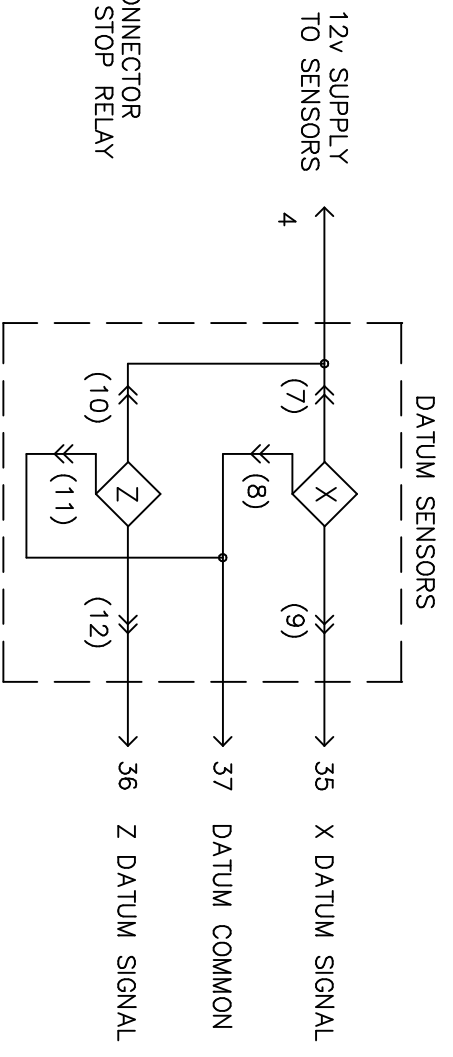
SHEET 5  
[STARTURN]  
[ GR5 ]



QM1 = 8 WAY ROUND QM CONNECTOR FOR AUXILIARIES

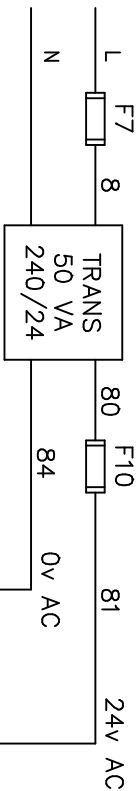
- (A) 61 (E) 74
  - (B) 60 (F) 75
  - (C) 72 (G) 51A
  - (D) 73 (H) EARTH
- 0.5mm BLUE  
0.5mm EARTH

< 42 WAY HARTING CONNECTOR  
ESR = EMERGENCY STOP RELAY

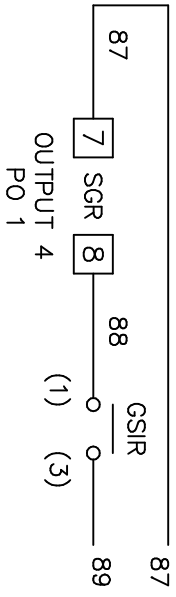
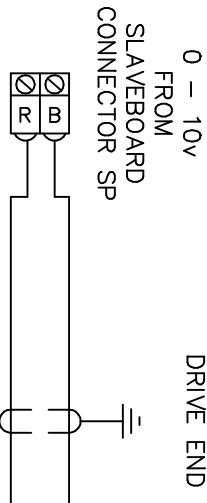


NUMBERS IN BRACKETS REFER TO 12 WAY QM CONNECTOR IN SADDLE CONNECTION BOX

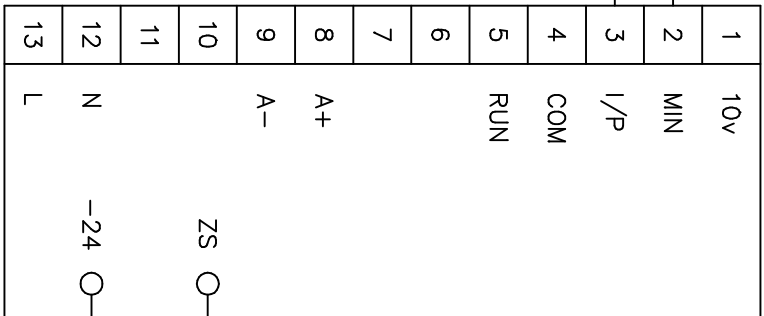
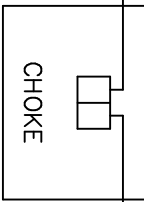
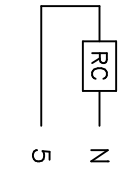
IF IN DOUBT ASK



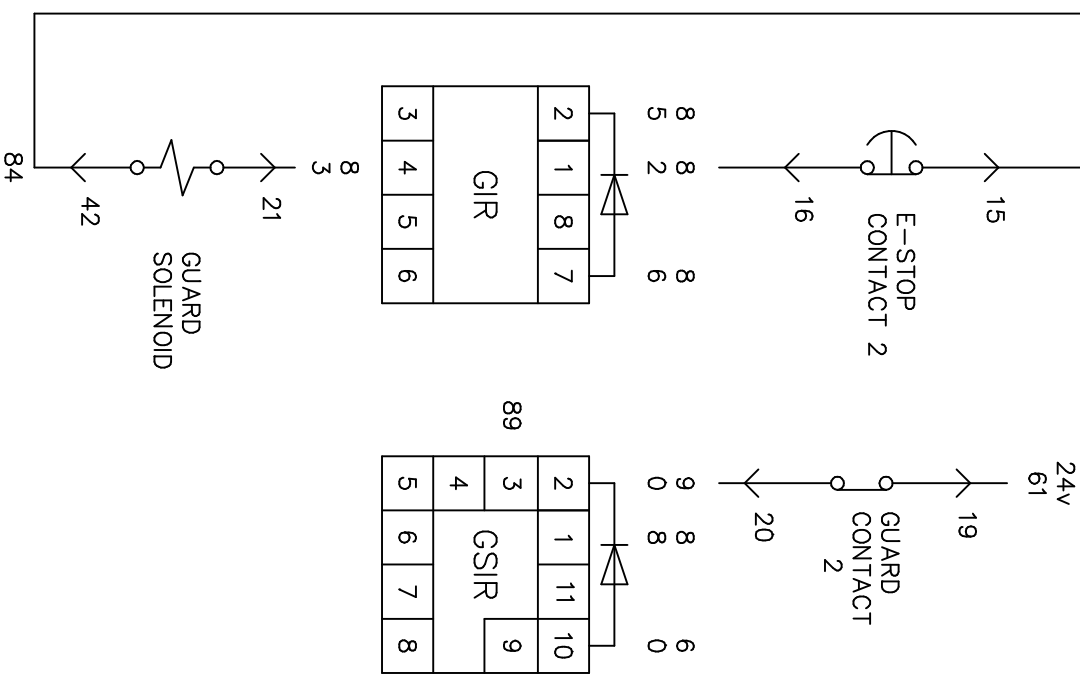
2 CORE SCREEN  
EARTH AT  
DRIVE END



SUPPRESSOR  
(RS 210-364)



0.2mm WIRES  
SOLDER TO  
SPINDLE DRIVE



< 42 WAY HARTING CONNECTOR  
SEE SHEET 3

IF IN DOUBT ASK