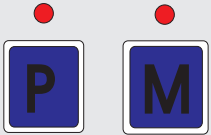




Z axis cutoff::

To prepare the machine for the Z axis cutoff move the X axis and the Y axis to the required position.Touch the workpiece with the electrode and set the Z axis to zero.



Press the M key on the keyboard and the LED above the M key and the LED above the P key will light up.
Enter the value for the cutoff size.(a negative value has to be entered).
The LED above the P key will extinguish.
When the programmed size has been reached the LED above the M key will extinguish and a relay contact will open.The relay contact will stay open until the Z axis is retracted..

15 pin SUB D high density

- < 11 ----- +24VDC
- < 12 ----- N/C R1 out
- < 13 ----- N/O R1 out
- < 14 ----- N/C R2 out
- < 15 ----- N/O R2 out