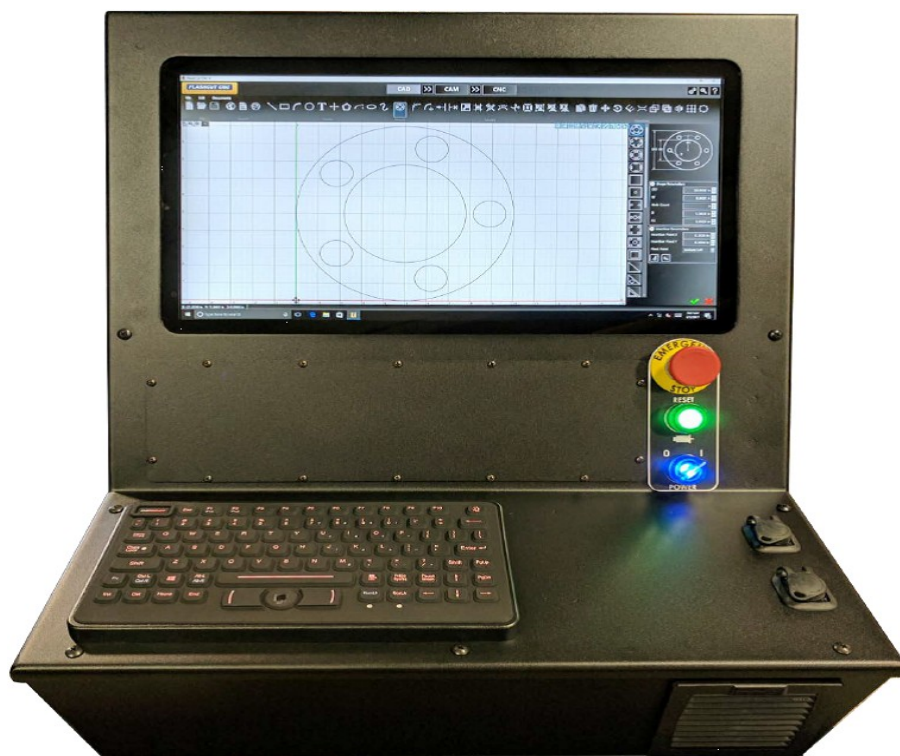


# **FLASHCUT CNC**

CONTROL MADE SIMPLE

## **8 Amp Micro Stepping Titanium Series CNC Controller Hardware Guide**



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<b>Getting Started.....</b>	<b>1</b>
About This Manual.....	1
Turning Off the Controller.....	1
Safety and Usage Guidelines.....	2
<b>Micro Stepping CNC Controller.....</b>	<b>3</b>
Front Panel.....	3
<i>Touch Screen.....</i>	3
<i>Pendant Panel.....</i>	4
<i>Emergency Stop.....</i>	4
<i>Reset Button.....</i>	4
<i>Power Switch.....</i>	4
<i>Fan.....</i>	4
Top of Controller.....	5
<i>Keyboard.....</i>	5
<i>USB.....</i>	5
Bottom View.....	6
<i>Mounting.....</i>	6
Controller Interior.....	7
<i>USB Hub.....</i>	8
<i>USB Interface Board.....</i>	8
<i>Support Strut.....</i>	8
<i>Controller and Power Sub Panels.....</i>	8
Controller Sub Panel.....	9
<i>Motor Drives.....</i>	9
<i>Computer.....</i>	9
<i>Signal Generator.....</i>	10
<i>Motor Connection Panel.....</i>	10
<i>Motor Power Connectors.....</i>	11
Power Sub Panel.....	12
<i>Circuit Breaker.....</i>	12
<i>12VDC Power Supply.....</i>	12
<i>AC Power Relay.....</i>	12
<i>DC Power Relay.....</i>	12
<i>Power Board.....</i>	12
<i>Line Filter.....</i>	13
<i>Transformer.....</i>	13
<i>Regeneration Resistor.....</i>	13
<i>Relay.....</i>	13
<i>Voltage Selector Switch.....</i>	13
<i>Accessory Connector.....</i>	14
<b>Connection Diagram.....</b>	<b>15</b>
<b>Stepper Motor Cabling.....</b>	<b>16</b>
Cable and Wiring.....	16
Motor Wiring for Third-Party Stepper Motors.....	17
<b>Motor Drive Settings.....</b>	<b>18</b>
Configuring the Drives.....	18
<i>Motor Selection.....</i>	18
<i>Current Factor Setting.....</i>	19

<i>Load Inertia</i> .....	20
<i>Idle Current</i> .....	20
<i>Step Mode</i> .....	21
<i>Self-Test</i> .....	22
<i>Indicator LEDs</i> .....	22
Software Configuration.....	23
<i>Motor Signal Setup</i> .....	23
<i>Input Line Setup</i> .....	23
<b>Signal Generator</b> .....	<b>24</b>
LEDs.....	24
<i>Power-On Sequence</i> .....	24
<i>During Operation</i> .....	24
Inputs.....	25
<i>Internal Power</i> .....	25
<i>External Isolated Power</i> .....	25
Outputs.....	27
Motor Signals.....	28
Jumper Settings.....	29
<i>JP83 – DB to USB Ground</i> .....	29
<i>JP84/JP85 – Input Power Select</i> .....	30
<i>JP86 – USB to Chassis Ground</i> .....	30
<i>JP87 – Internal Signal to Chassis Ground</i> .....	30
Internal Connections.....	31
<i>JP30 – Auxiliary Input</i> .....	31
<i>JP31 – Status LEDs</i> .....	32
<i>JP32 – Bus Expansion</i> .....	33
<i>JP33 – Step and Direction</i> .....	34
<i>JP40 – Input Aux</i> .....	35
<i>JP50 – Output Aux</i> .....	36
<i>JP53 – Low-Side Relay</i> .....	36
<i>JP71-75 – Axis Plug-In Interfaces</i> .....	37
<i>JP80 – Rear Panel Power</i> .....	38
<i>JP81 – Rear Panel Fuse</i> .....	38
<i>JP82 – Front Panel Switch</i> .....	38
<b>Advanced Power Board</b> .....	<b>39</b>
Internal Connections.....	40
<i>P101 – Transformer Connector</i> .....	40
<i>P102 – AUX Motor Power Connector</i> .....	40
<i>P103 – Fan Connector</i> .....	41
<i>P107 - Motor Power Connector (x3)</i> .....	41
<i>P110 &amp; P111 – Motor Power Connectors</i> .....	42
<i>P202 – Signal Generator Power Connector</i> .....	42
<i>P204 – LED Connector</i> .....	43
<i>P301 – Accessory Connector</i> .....	43
<i>P405 – Internal Emergency Stop Connector</i> .....	44
<i>P501 – Relay Control Connector</i> .....	44
<i>P600 – Motor Power Resistor Connector</i> .....	44
<i>P601 – Emergency Stop Output Connector</i> .....	45
<i>P701 – Brake 1 Input Connector</i> .....	45

<i>P702 – Brake 2 Input Connector</i> .....	45
Switch Settings.....	46
<i>SW502 – DIP Switches</i> .....	46
Fuses.....	47
<i>F101 – Motor AC Fuse</i> .....	47
<i>F201 – 18.8VAC Fuse</i> .....	47
LED Indicators.....	47
<b>Controller Maintenance</b> .....	<b>48</b>
External Maintenance.....	48
<i>Fan Filter</i> .....	48
Internal Maintenance.....	49
<i>Opening The Lid</i> .....	49
<i>Disconnecting Power</i> .....	49
<i>Replacing Fuses</i> .....	50
<i>Adding/Replacing a Drive</i> .....	51
<b>Pin Location Index</b> .....	<b>54</b>
Signal Locations.....	54
Voltage/GND Locations.....	57
<i>+5VDC</i> .....	57
<i>GND</i> .....	57
<i>OPT-VCC</i> .....	58
<i>OPT-GND</i> .....	58
<i>Analog GND</i> .....	58
<i>5-24VDC Clamp Voltage</i> .....	58
<b>Wiring Appendix</b> .....	<b>59</b>
Example Wiring.....	59
<i>Typical Output Line Circuit</i> .....	59
<i>Typical Input Line Circuit – Internal Power</i> .....	60
<i>Typical Input Line Circuit – External Power</i> .....	61
<i>Proximity Sensors</i> .....	62
Internal Schematic.....	63
<b>Revision History</b> .....	<b>65</b>

# Getting Started

## *About This Manual*

CNC is a unique application involving hardware and software. We recommend that you read all of these instructions before using the product.



**Since automated machining is potentially dangerous, please take the time to completely read through this manual and the software User's Guide to understand the operation of the electronics, software and machine before cutting a part.**

## *Turning Off the Controller*



**Always turn off the CNC Controller when it is not in use.**

## ***Safety and Usage Guidelines***



**When running an automated machine tool, safety is of the utmost importance. For proper and safe use of the CNC program and your CNC machine, the following safety guidelines must be followed:**

- 1. Never let the machine tool run unattended.**
- 2. Require any person in the same room as a running machine tool to wear safety goggles and to stay a safe distance from the machine.**
- 3. Allow only trained operators to run the machine tool. Any operator must have:**
  - Knowledge of machine tool operation.
  - Knowledge of personal computer operation.
  - Knowledge of Microsoft Windows.
  - Good common sense.
- 4. Place safety guards around the machine to prevent injury from flying objects. It is highly recommended that you build a safety shield around the entire tool envelope.**
- 5. Never place any part of your body within the tool envelope while the machine is online, since unexpected machine movement can occur at any time.**
- 6. Always keep the tool envelope tidy and free of any loose objects.**
- 7. Be on alert for computer crashes at all times.**

**WPI, Inc. is not responsible for the safe installation and use of this product. You and only you are responsible for the safety of yourself and others during the operation of your CNC machine tool. We supply this product but have no control over how it is installed or used. Always be careful!**

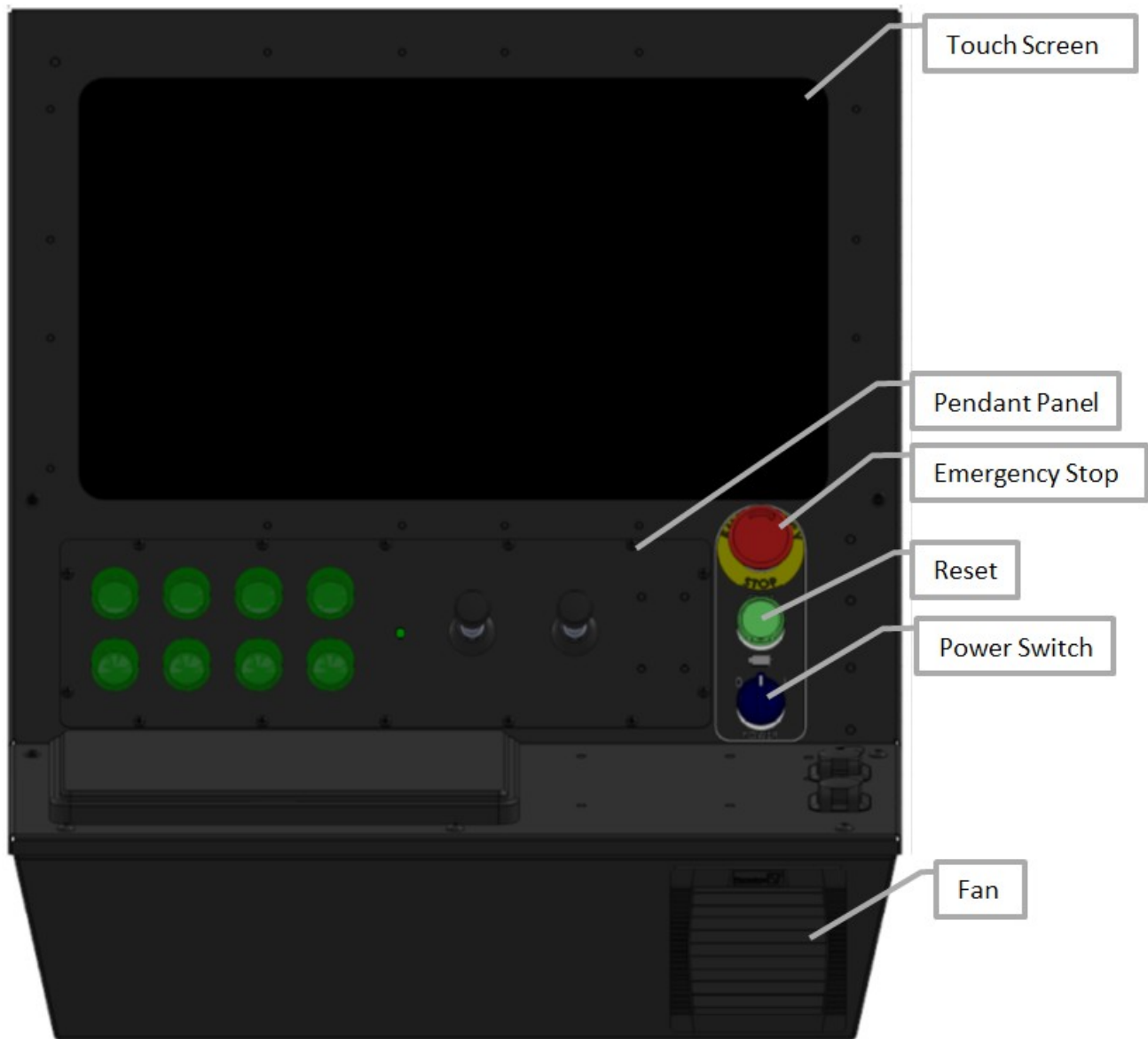
**WPI, Inc. or its affiliates are not responsible for damage to any equipment or workpiece resulting from use of this product.**

**If you do not understand and agree with all of the above safety guidelines, do not use this product.**

# Micro Stepping CNC Controller

## Front Panel

The front panel provides a the main power switch, emergency stop button, reset button, pendant panel, keyboard, USB ports and the main cooling system input.



## Touch Screen

The Titanium Series controller utilizes a 19.5" capacitive touch screen for ease of use. Thin gloves will work with this screen. The touch surface is made of glass, so precaution should be taken to avoid scratching.

## **Pendant Panel**

The pendant panel is used to mount extra physical buttons and controls such as joysticks for jogging, cycle start and feedhold buttons that are connected to the internal USB Interface Board. The pendant panel also supplies a mounting location for physical buttons used to control external devices outside of the software. The pendant panel is shown with optional equipment and these controls are not present in the basic configuration.

## **Emergency Stop**

The emergency stop (E-stop) is used to immediately stop the machine and the software in the case of an emergency. When the E-stop is pressed, power is disconnected from the drives and motors. Once released, the reset button must be pressed to reapply power to the drives and motors. Keep in mind, if the machine is stopped in this way, the DRO may no longer accurately reflect the machine's position until re-homed.

## **Reset Button**

The reset button must be pressed upon initial power-up and after an E-stop event to apply power to the drives and motors. When this occurs, the button will illuminate green. If this does not happen, the E-stop may still be applied.

## **Power Switch**

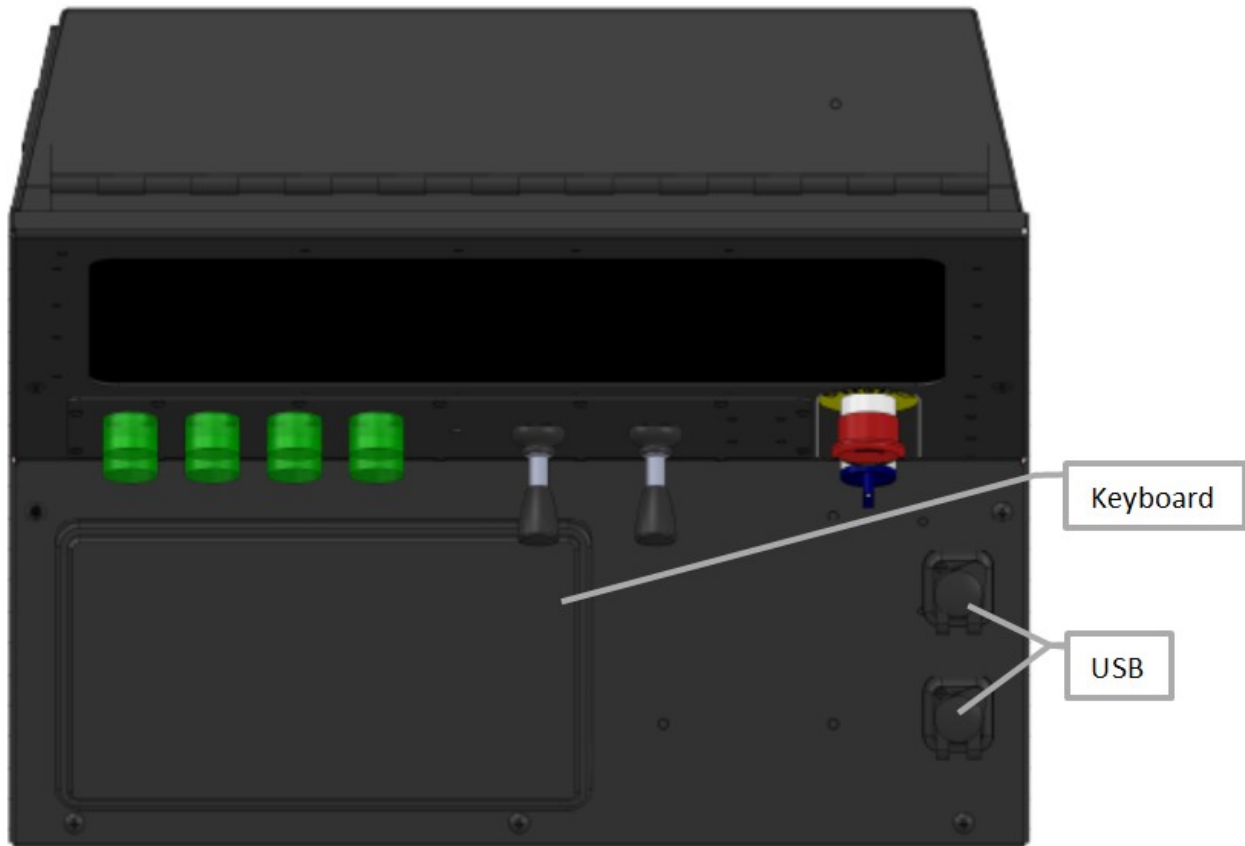
The power switch turns the unit on and off. If there is ever a communications error while running CNC, it may be necessary to power the system down, wait 10 seconds and turn it back on to reset the internal microprocessor. The power button is an extension to the internal computer. The computer drives a relay that switches power to the entire system.

## **Fan**

The fan is the input of the cooling system and has a filter used to catch large, harmful debris. Do not block air flow by placing the fan in front of objects or objects in front of the fan. The filter should be cleaned or replaced based on the environment it is kept in. The exhaust for the cooling system is the vented slots and filter on the left side of the controller. Please see the Maintenance section for more information on changing the filter.



## Top of Controller



### Keyboard

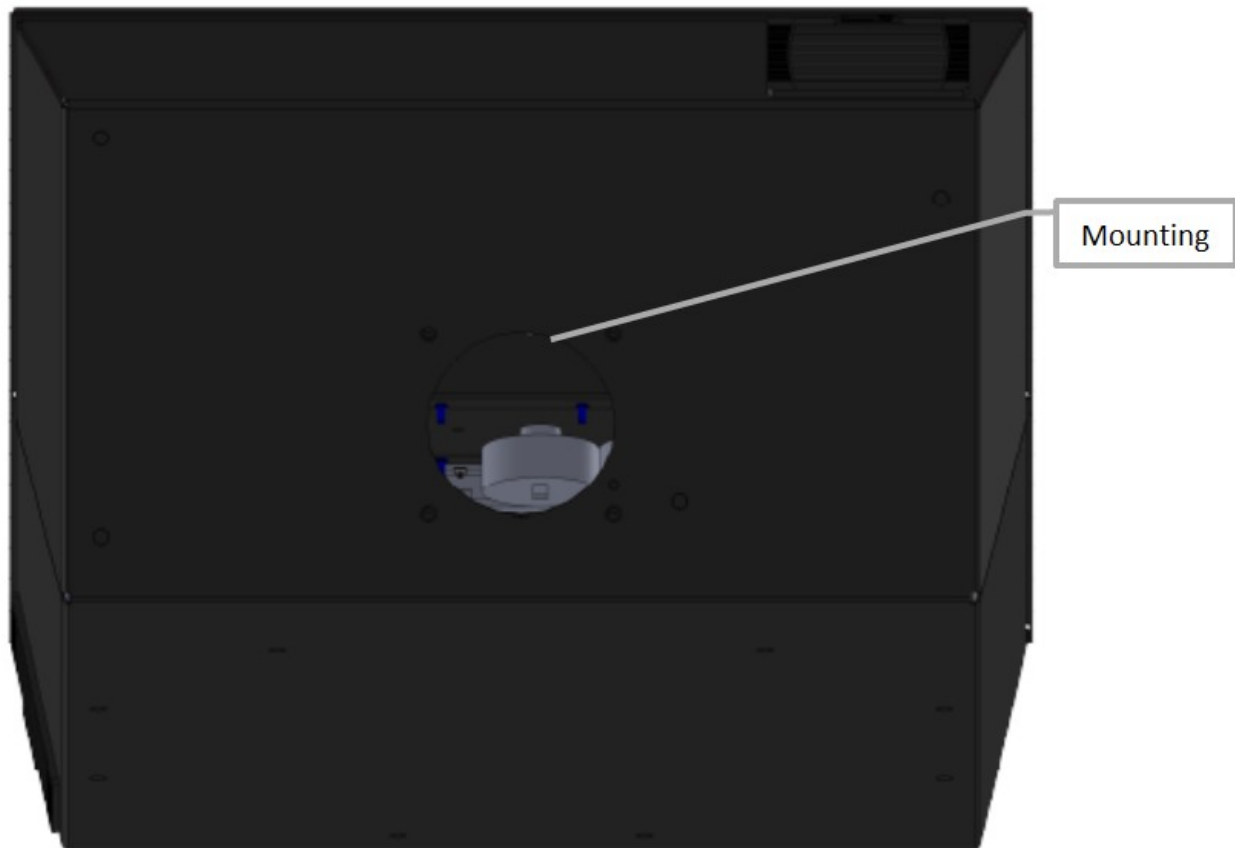
The keyboard is a sealed, ruggedized human interface device. It comes with an integrated touch mouse that may be used in addition to the touchscreen. The keyboard has variable back-light levels to aid in low-light installations.

### USB

There are two external USB ports to interface other devices with the integrated computer. These devices include USB memory modules, other human interface devices, USB-to-serial adapters, etc.

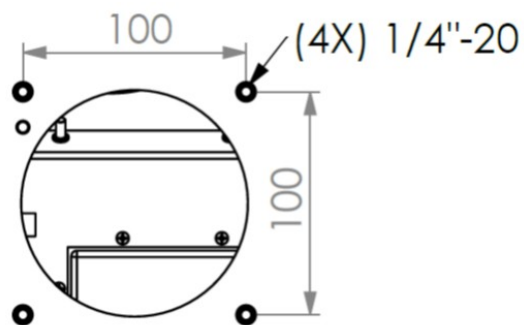
## Bottom View

The bottom panel of the CNC controller provides enclosure mounting and a cabling feed-through to the CNC system.



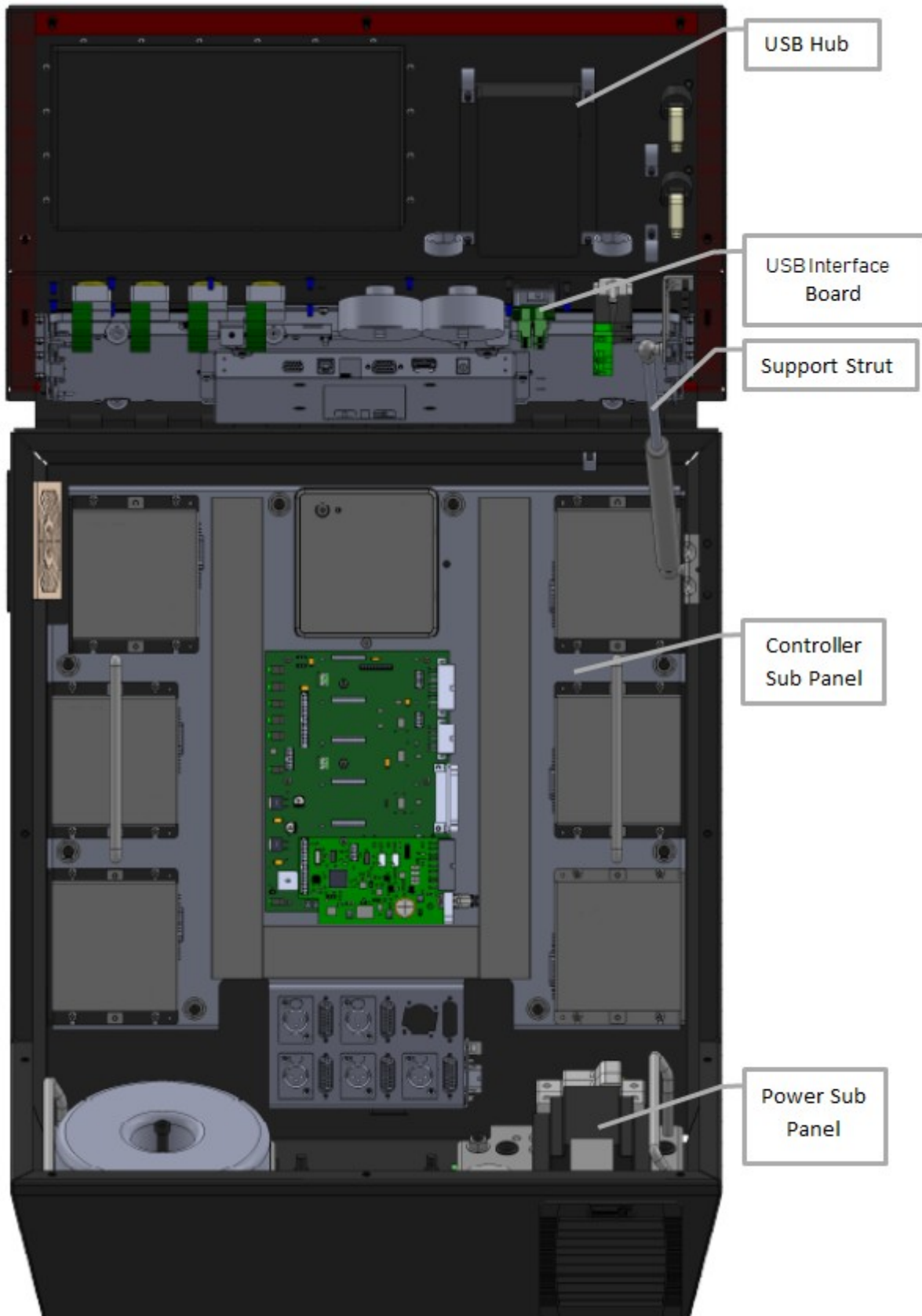
## Mounting

The mounting point for the Titanium Series controller is located on the bottom of the system. A VESA-100 bolt pattern is used. Use four 1/4"-20 bolts in these through-holes. Connections between the controller and machine should be made through the 4" diameter feed-through hole.



## Controller Interior

The interior of the lid has several components mounted to it, as seen below.



**USB Hub**

The USB hub is used to connect all internal USB devices on the lid and condense the connection into a single USB cable down to the computer. The USB hub is the connection point for the two external USB ports, the keyboard, the optional USB interface board and the touch screen.

**USB Interface Board**

The USB interface board gives the user a means of interfacing up to 254 additional physical buttons to the CNC software to increase efficiency of the operator. This feature is optional and may not be included on basic models of the Titanium Series controller. For further information on the interface board, please refer to the USB Interface Board Hardware Guide.

**Support Strut**

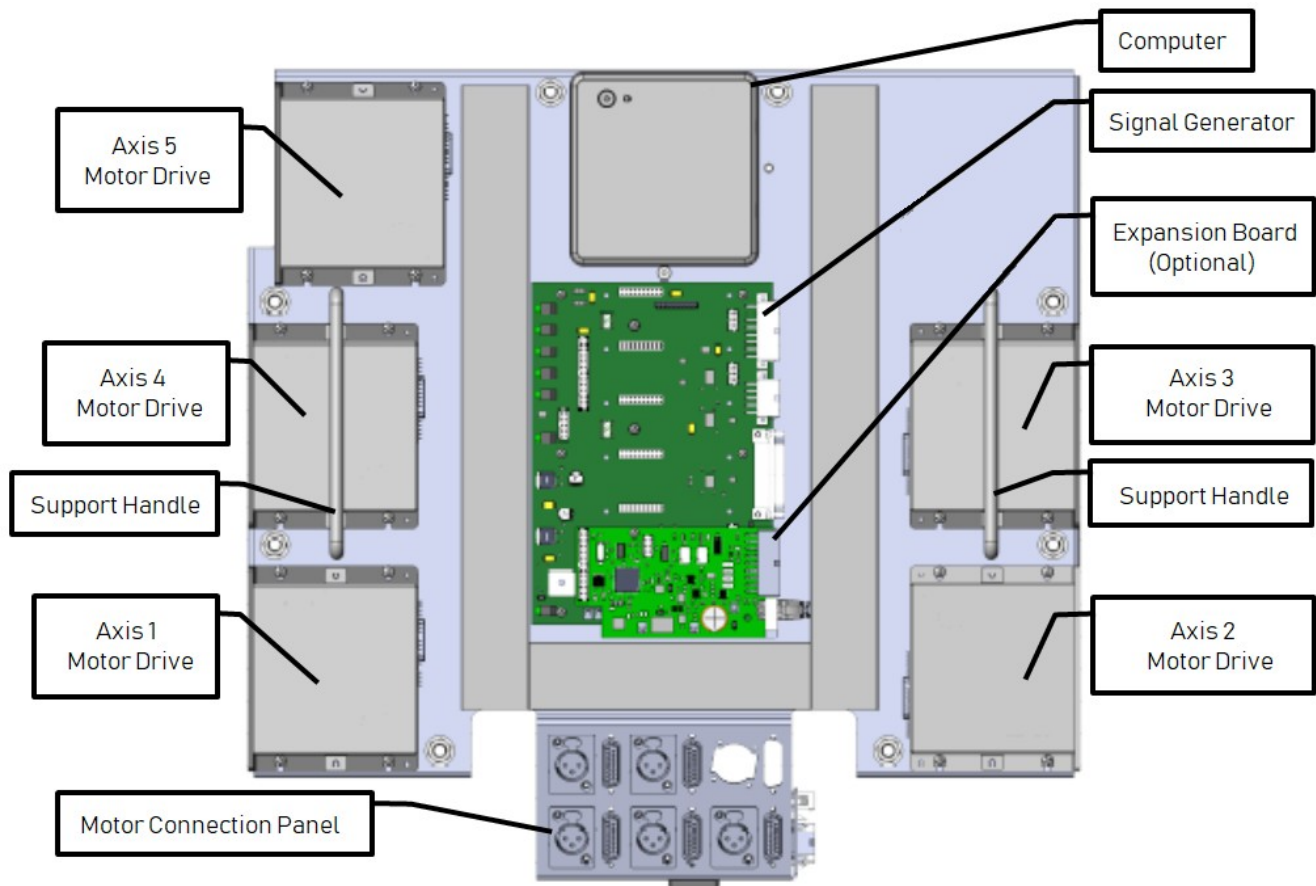
The support strut is designed to hold the load of the lid for easy-open maintenance and to dampen lid closing to reduce the potential of pinching.

**Controller and Power Sub Panels**

These two panels provide mounting points for control and power distribution components, respectively. The panels are not intended to be removed in-field and should only be dismounted if instructed to do so by a member of the Support Team. Please see the Controller and Power Sub Panel sections in this manual for more information.

## Controller Sub Panel

The Signal Generator, internal computer, motor drives and any I/O expansions are mounted to the controller sub panel. This panel also provides connection points for the motors.



### Motor Drives

The Titanium Series controller can support up to six axes of motion, with six drive mounting locations. Five of these six can move independently and in a typical 6-axis system, one drive is “slaved” to another and will move in lock-step with each other.

### Computer

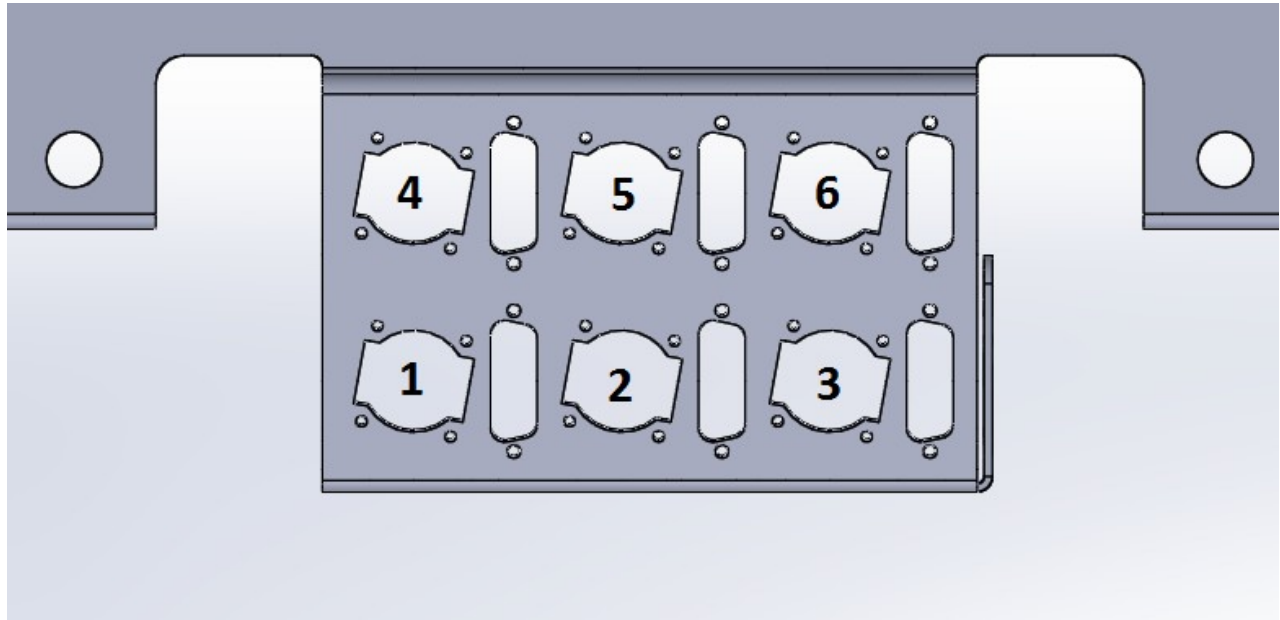
The Titanium Series controller comes integrated with a small-footprint Windows-based PC. The PC is equipped with either an i3 or i5 processor, 8GB of DDR3 RAM and a solid-state drive.

## Signal Generator

The Signal Generator is the primary controller for motion. The Signal Generator sends data to and receives data from the computer using USB communication. Each of the motor drives receive position information from the Signal Generator. Any drive status lines are routed to the inputs of the Signal Generator. For further information on connections and interfaces, refer to the Signal Generator section of this manual.

## Motor Connection Panel

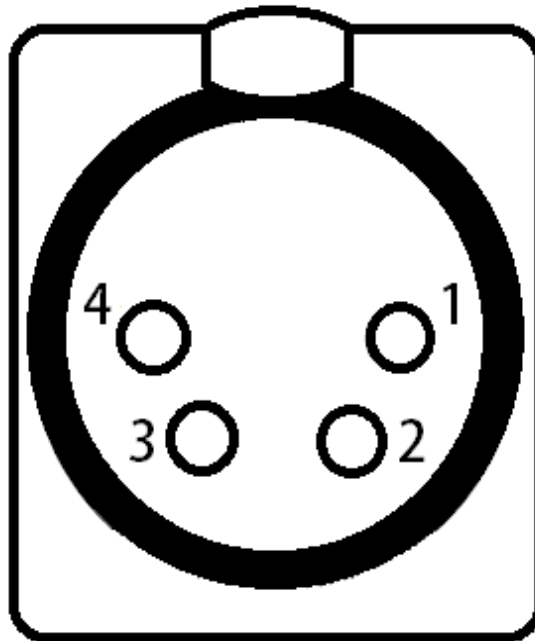
There are positions to mount up to six motor connectors. The axis numbers are labeled on the panel and follows the pattern shown below.



## Motor Power Connectors

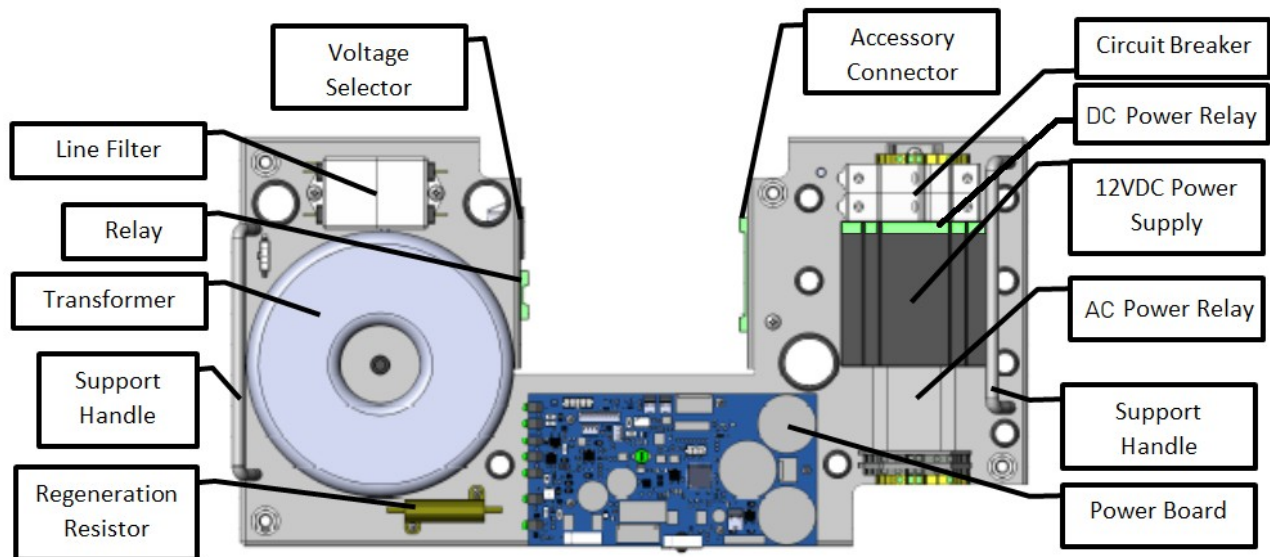
The motor power cables plug into these connectors. The numerical motor lines are correlated to any combination of the X, Y, Z, A and/or B axes in the Axes menu in the CNC software. Each motor connector is a female XLR4 Receptacle (see the section on Motor Cabling for mating connector information). The pin assignments for the motor power connector are as follows:

XLR4 Connector for Motor Power	
<i>Pin No.</i>	<i>Signal</i>
1	B-
2	B+
3	A+
4	A-



## Power Sub Panel

The power sub panel is the mounting location for the transformer, circuit breaker, 12VDC power supply, line filter, voltage selector, mains relay, regeneration resistor and power board.



### Circuit Breaker

The circuit breaker protects the system from over-current events and will trip at 20A. This is the connection point for AC mains to the controller. Connect the line and neutral leads to the terminals marked “L” and “N”, respectively. The protective earth ground should be connected to the ground terminal block adjacent to the breaker.

### 12VDC Power Supply

This power supply provides power for the monitor, computer and USB hub. The 12VDC power is always live while the circuit breaker is closed and the AC mains is connected.

### AC Power Relay

This relay switches the AC mains to the transformer and any optional, AC-driven components on the controller sub panel.

### DC Power Relay

This relay is driven by the power state of the computer and switches power to the touch screen and USB hub.

### Power Board

The power board takes the stepped-down VAC from the transformer and rectifies it to VDC for motor and logic power. The power board handles the emergency stop circuitry to disconnect motor power in an emergency event. For further explanation of the power board, refer to the Servo Power Board section of this manual.



**Line Filter**

This is an AC mains line filter to suppress transients on the mains supply voltage, which can damage sensitive electronics.

**Transformer**

The transformer steps down the AC mains to a lower voltage, which is used as the motor power and system logic voltage on the Signal Generator. The Titanium Series controller is available with two sizes of transformer: 500W or 1000W. When the system is configured for several large motors, a 1000W transformer is likely necessary.

**Regeneration Resistor**

The regeneration resistor is used to absorb energy created by the motors when decelerating large inertial loads. The resistor is used to bleed down over-voltage conditions on the motor power bus and to protect against transients generated during motor power on, motor power off and emergency stop.

**Relay**

The relay connector provides a switch closure for controlling both AC and DC devices. This connection is not polarity-sensitive and has a 0.5 Amp maximum current load. If the controller comes equipped with a Mini I/O Expansion Board, this connector is not wired as a relay because the same signal is available on the Mini I/O Expansion Board. This connector may be used for a constant 24VDC source and will be marked as such. This power source can be used for proximity sensors and other low-current devices.

**Voltage Selector Switch**

The voltage selector switch allows the controller to use an external power source of 115 or 230 VAC. If the input power is wired for 230VAC, then simply flip the switch with a flat-head screwdriver so that “230V” is clearly visible. If the input power is wired for 115 VAC, then flip the switch until “115V” is clearly visible.

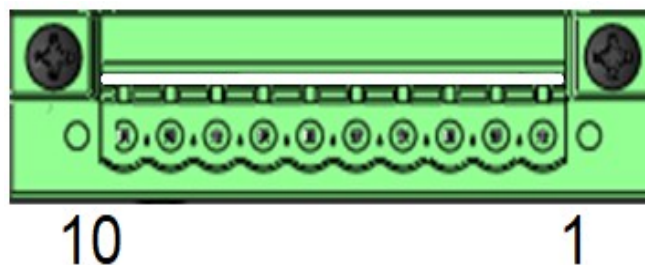


**Severe damage can occur if 115V is selected and your source is wired for 230VAC.**

## Accessory Connector

The accessory connector is an interface to the emergency stop circuit, 24 VDC out, the reset circuit and two motor brakes. It is designed to connect external switches or circuits wired to the connector's screw terminals (Molex-Waldom part number 39530-0010). The pin-out can be seen below:

10-Pin Phoenix Connector for Accessory Signals			
Pin No.	Signal	Pin No.	Signal
1	ESTOP +	6	BRAKE1-
2	ESTOP-	7	BRAKE2+
3	+24V	8	BRAKE2-
4	GND	9	RESET+
5	BRAKE1+	10	RESET-



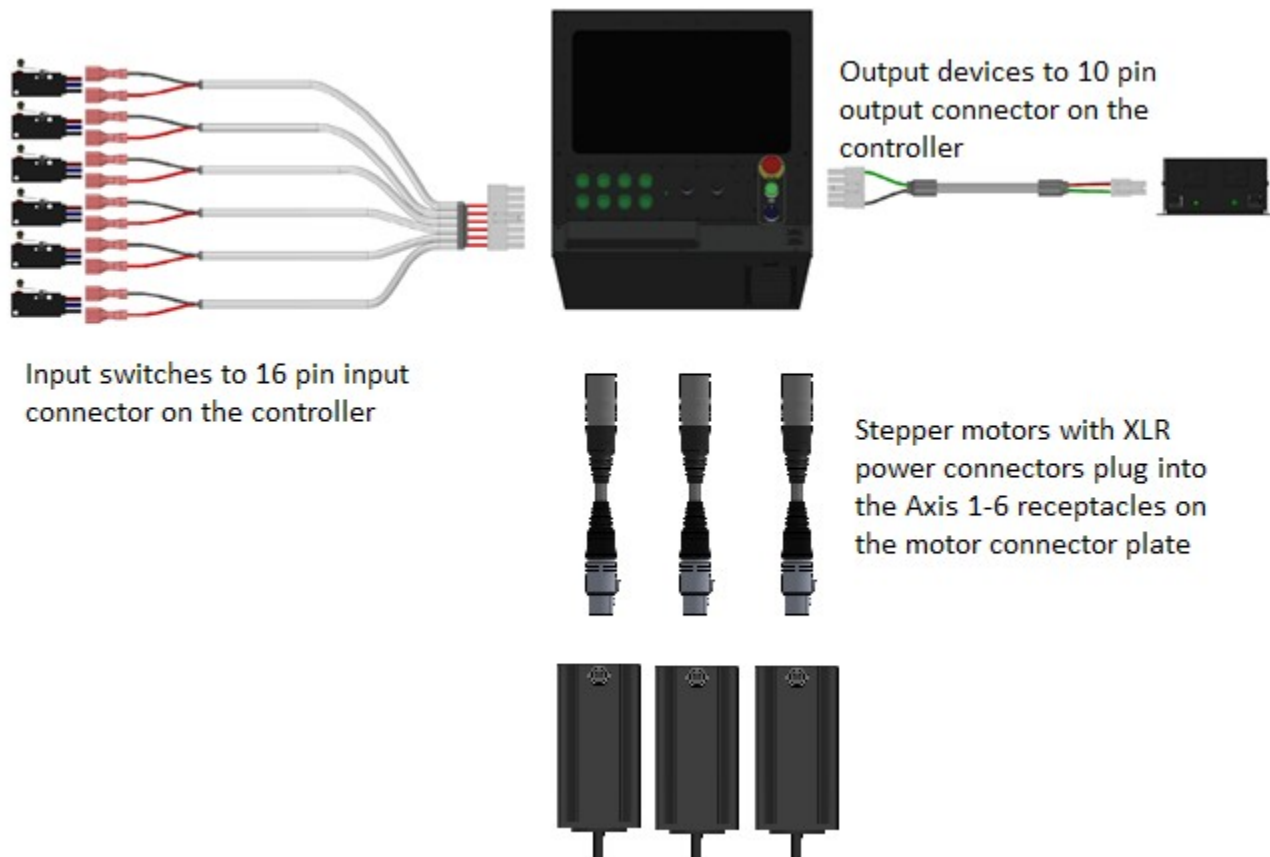
**Emergency Stop (Pins 1 & 2):** The emergency stop input can be used to disconnect power to the motor drivers in the event of an emergency using a normally closed switch. Make sure switch 6 on the power board is enabled. For further information on the power board, please see the section on the power board later in this guide.

**Switched 24V Supply (Pins 3 & 4):** The switched 24VDC supply can be used to indicate when the motor drivers are powered and ready to run. The supply will not output voltage until the emergency stop and reset circuits have been cleared.

**Brake Outputs (Pins 5 & 6; 7 & 8):** There are two 24VDC brake outputs to control motor brakes. When a brake output is active and supplying power, the brake rotates freely. For further information on triggering the brake output, please see the power board section of this guide.

**Reset (Pins 9 & 10):** The reset input can be used to clear an emergency stop condition. This requires the emergency stop button to be returned to a normal state. Power will then be restored to the motors when the reset input is tripped. To use the reset input, connect a normally open switch to pins 9 & 10 and turn on switch 1 on the power board. For further information, please see the section on the power board later in this guide.

## Connection Diagram

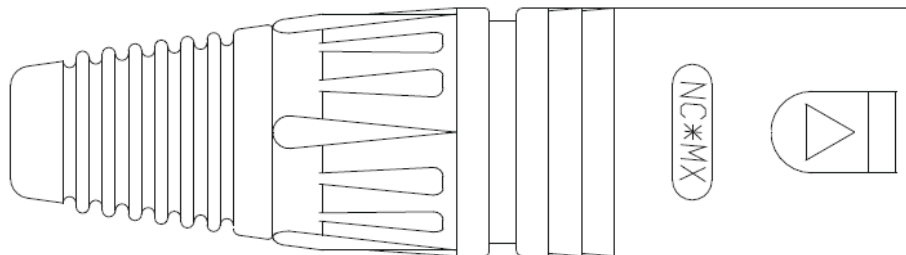
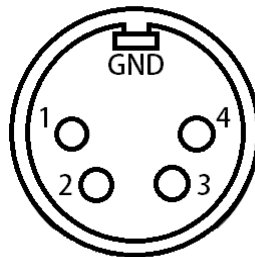


## Stepper Motor Cabling

### *Cable and Wiring*

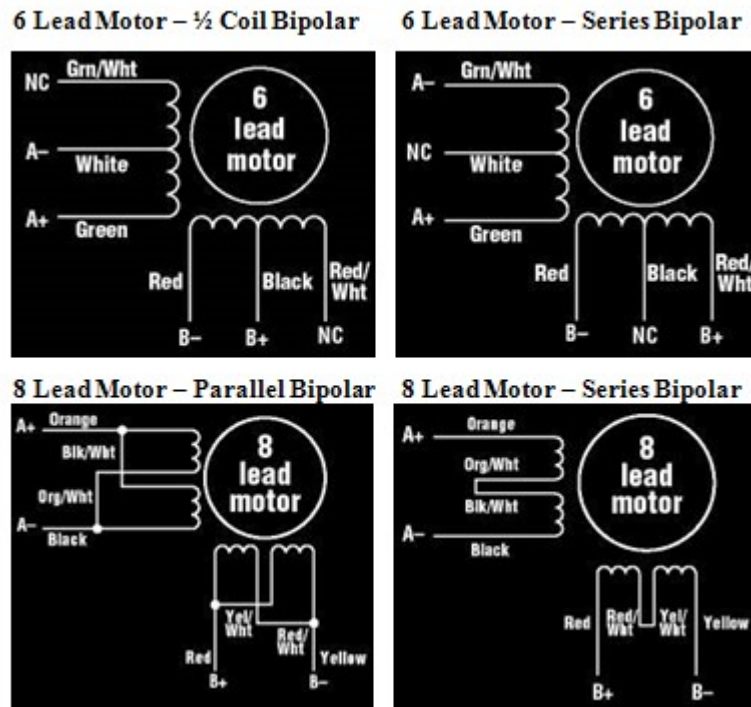
The cable used for stepper motor wiring should be two 18 AWG twisted pairs (four conductors) with a foil shield and shield wire. Each twisted pair connects one coil in the motor to the stepper drive. An example of appropriate cable is Alpha Wire P/N 2242C. If the cable is an extension (between the controller and existing cabling), the shield wire should be terminated on both ends. If the cable is directly connected to the motor, the shield should only be terminated on the controller side. The mating connector is a male XLR4 (such as Neutrik part number NC4MX).

XLR4 Connector for Motor Power	
<i>Pin No.</i>	<i>Signal</i>
1	B-
2	B+
3	A+
4	A-



## Motor Wiring for Third-Party Stepper Motors

If you have your own stepper motors, you can use the following charts for wiring. Please note that the motor colors will vary. To determine the wiring of a six- or eight-wire motor—when unknown—take resistance reading between several leads and refer to the following table.

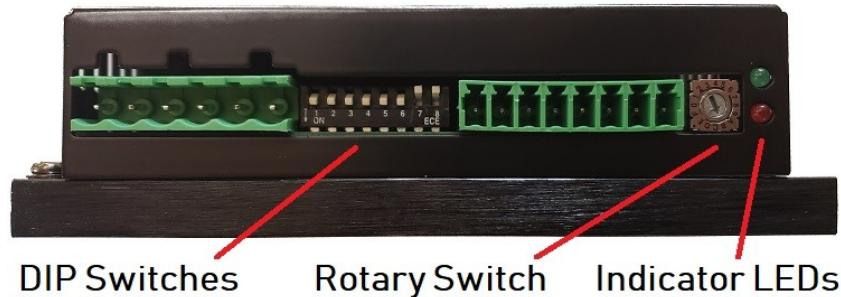


Lead Pair	Resistance
A+ & A-	1-10 $\Omega$
B+ & B-	1-10 $\Omega$
A+/- & B+/-	No continuity
A(center) & A+/-	½ of A+ & A-
B(center) & B+/-	½ of B+ & B-
A(center) & B+/-	No continuity
B(center) & A+/-	No continuity

If the A+ & A- , B+ & B- or A & B coils are reversed, the motor will spin in the opposite direction. This can be corrected in the software configuration on the “Machine....Axes” page. Changing the Direction for the motor in question should correct the problem.

## Motor Drive Settings

Each drive module has logic connector for the Step, Direction, Fault and Enable signals coming from the Axis Plug-in connector on the Signal Generator, a motor connector for the A, B and C coils of the motor, a power connector and a group of dip switches for configuring the drive for your specific requirements. The configuration of the dip switches may vary depending on your application. The acceptable voltage input range is 24-75VDC.



### Configuring the Drives

#### Motor Selection

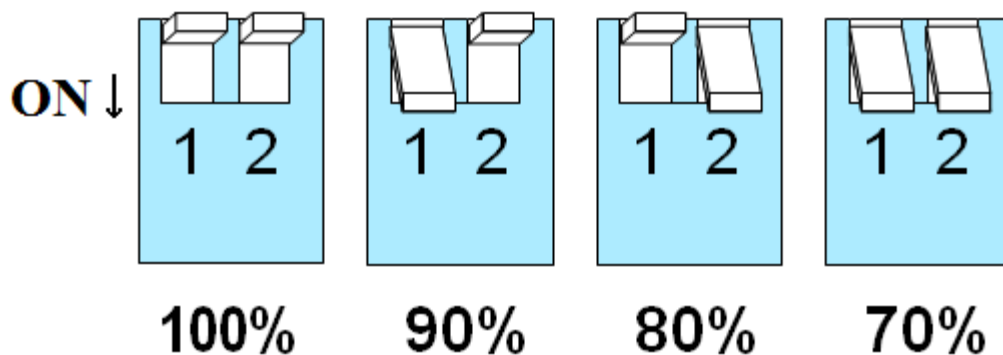
The rotary switch is used to select the motor connected to each drive for tuning and max current settings. The drives are optimized for use with our stepper motors but can also drive third-party motors. Each setting matches the current and inertia of a given motor to provide the most power with minimum resonance. To select a motor, simply move the rotary switch to the letter of number that corresponds to the driven motor in the table above. Make sure the power is off before changing this setting or damage could occur to your motor, drive or cabling. If your motor is not on the list, please select a setting which matches the properties of your motor within 10%.



<b>Rotary</b>	<b>Motor</b>	<b>Current</b>	<b>Rotary</b>	<b>Motor</b>	<b>Current</b>
0	MP2301	1.4A	8	MP1702/3	2.0A
1	MP2302	1.4A	9	MP2301	2.4A
2	MP2303	3.6A	A	MP2302	2.4A
3	MP3402-P	4.3A	B	MP2303	6.0A
4	MP3402-S	2.2A	C	MP3402-P	7.2A
5	MP3403-P	4.3A	D	MP3402-S	3.6A
6	MP4201	4.7A	E	MP3403-P	7.2A
7	MP1701	1.6A	F	MP4201	7.8A

## Current Factor Setting

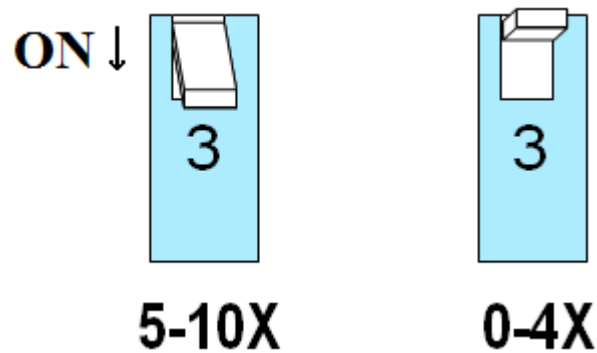
The maximum current for the motor being driven is set automatically by the rotary switch. You may want to reduce the current to save power or lower motor temperature. This can be set using switches 1&2. This is important if the motor mounting method will not help dissipate heat or if the ambient temperature is expected to be high. Stepper motors produce torque in direct proportion to current but the heat generated is roughly proportional to the square of the current. For example, if the motor is operating at 90% of rated current, it will produce 90% of the rated torque. In this case, the motor will produce approximately 81% as much heat at maximum current. At 70% current, the torque is limited to 70% of maximum while the heat is reduced to about 50%. Switches 1 & 2 on the front of the drive set the percent of rated current that will be applied to the motor. Please set them according to the illustration below. The factory default setting is 70% (SW1 and SW2 on).



**Make sure that the result of the rotary and switch current settings don't exceed the rating of your motor.**

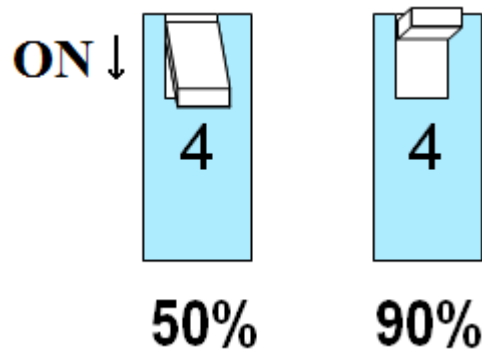
## Load Inertia

The drives include anti-resonance and electronic damping features which greatly improve motor performance. For optimal results, the drive must be set to the electro-mechanical characteristics of the motor and load. Most of this is handled automatically by the rotary switch's setting but, to further enhance performance, you must set switch 3 to indicate the appropriate inertia ratio of the load and motor. The ranges are 0x to 4x and 5x to 10x. Simply divide the load inertia by the rotor inertia to determine the ratio, then set switch 3 accordingly, as shown:



## Idle Current

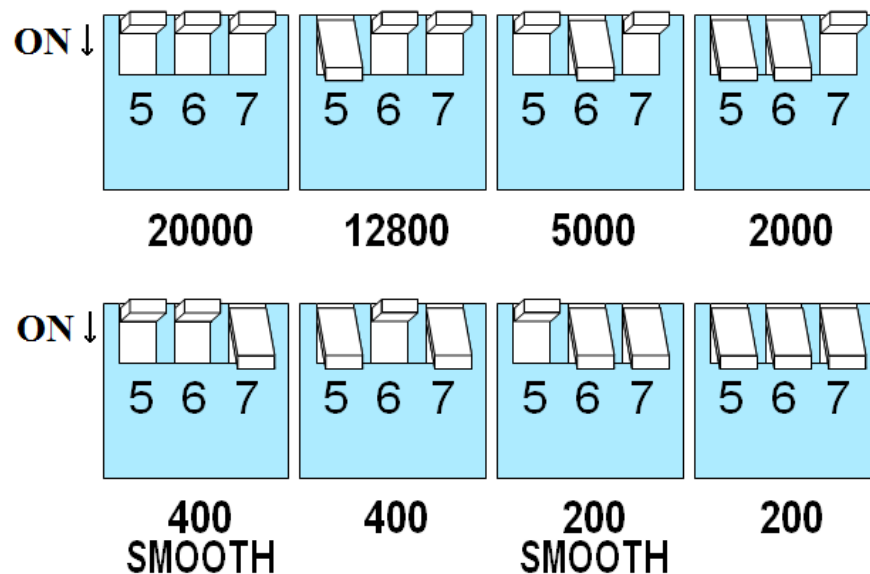
Motor heating and power consumption can also be reduced by lowering the motor current when it is not moving. This setting is controlled by switch 4. The drive will automatically reduce the motor current when idle to either 50% or 90% of the running current. The 50% idle current setting will lower the holding torque to 50% of the set current, which is enough to prevent the load from moving in most applications. This reduces motor heating to 25% while idle. In some applications, such as supporting a vertical load, it is necessary to provide a high holding torque. In such cases, the idle current can be set to 90% as shown below. The default idle current setting is for 50%:





## Step Mode

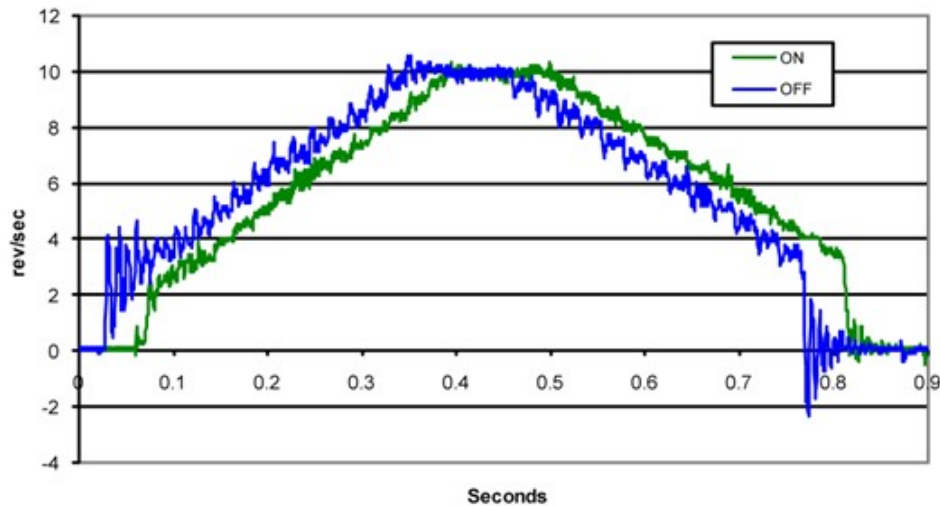
Smaller step sizes result in smoother motion and more precise speed but also require a higher step pulse frequency to achieve maximum speed. These step sizes are configured using switches 5-7. The smallest step size of the drives is 1/1000 of a single, discrete step and the maximum step rate of the Signal Generator is 100,000 microsteps/sec. Six settings are provided in the drive module, as shown below. Choose the one that best matches the capabilities for your system. The numbers below each setting refer to the number of microsteps in one rotation of a 200-step motor, such as those available from us.



At lower step resolutions such as 200 steps/revolution (full step) and 400 steps/revolution (half step), motors may produce more audible noise than when they are microstepped (2000 steps/revolution and beyond). The drives include a feature called “Microstep Emulation” (also called “step smoothing”) that can generate smooth motion from coarse command signals. If you select “200 SMOOTH or 400 SMOOTH”, this feature is employed to provide the smoothest possible motion from a low-frequency signal source.

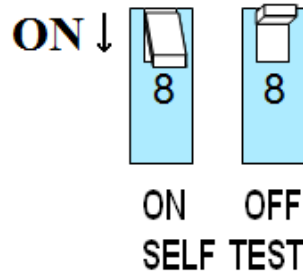
Because a command filter is used as part of the step smoothing process, there will be a slight delay in the motion. If this delay is objectionable for your application, please choose a non-filtered “200” or “400” setting. The chart on the next page shows an example of the delay. If you are using the smoothing feature, you must have all axis in the same smoothing mode. Otherwise, there will be a timing problem with multi-axis interpolation.

Motion Profile with Step Smoothing Filter



## Self-Test

If you are having trouble with motor behavior, you may want to try the built-in self-test. Anytime switch 8 is moved to the ON position, the drive will automatically rotate the motor back and forth 400 steps in each direction. This feature can be used to confirm that the motor and cabling are correctly wired, configured and otherwise operational.



## Indicator LEDs

In the event of a drive fault or alarm, the green and red LEDs will flash an alarm code corresponding to the error encountered. The pattern repeats until the alarm is cleared.

Code	Error
● solid green	no alarm, motor disabled
●● flashing green	no alarm, motor enabled
●●● flashing red	configuration or memory error
●●●● 1 green, 4 red	power supply voltage too high
●●●●● 1 green, 5 red	over current / short circuit
●●●●●● 1 green, 6 red	open motor winding
●●●●●●● 2 green, 3 red	internal voltage out of range
●●●●●●●● 2 green, 4 red	power supply voltage too low

## Software Configuration

### Motor Signal Setup

In a Titanium Series controller, these values should come already configured. In the software, go to “System...Controller” in the configuration and make sure the 8A Titanium Series Micro Stepper controller is selected.

### Input Line Setup

If the drive encounters an electrical problem that prevents it from functioning, it will enter a fault state. If this occurs, a fault signal will be sent from the microstepper motor drive to the Signal Generator through one of the input lines.



**If you are using input lines, do not occupy inputs 8, 9, 11, 13, 15 or 17 as a conflict will occur and the input connected to these lines will malfunction and may damage the controller.**

To configure these faults to stop the software in the case of a stepper drive fault go to “I/O...Input Lines” and define Function of the lines you are using for faults as Safety and Wiring as N.O. This signal is automatically routed to the Signal Generator via the internal control cables. An internal signal line on input 8 also indicates when the emergency stop is active

<i><b>Line #</b></i>	<i><b>Description</b></i>	<i><b>Function</b></i>	<i><b>Wiring</b></i>
8	Emergency Stop	Safety	N.C.
9	Axis 1 Fault	Safety	N.O.
11	Axis 2 Fault	Safety	N.O.
13	Axis 3 Fault	Safety	N.O.
15	Axis 4 Fault	Safety	N.O.
17	Axis 5 Fault	Safety	N.O.

# Signal Generator

## LEDs

The Signal Generator has seven LED indicators on-board to show different states of the system.

### Power-On Sequence

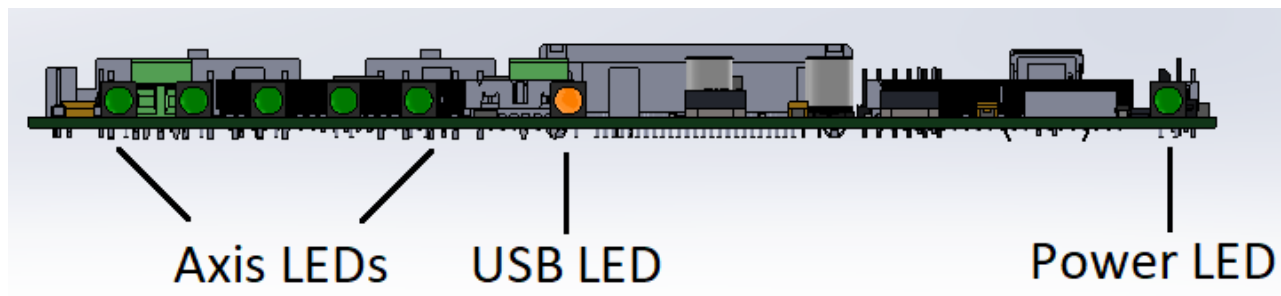
When power is first applied to the Signal Generator, the seven LED indicators go through a start-up sequence to indicate that the firmware is in a healthy state. First, all LEDs blink once. Then, each LED blinks once in order from Axis 1 to Power.

After the light sequence is complete, Axis 1-5 LEDs will remain off and the Power LED will be on. The USB LED will be on if a USB cable is connected between the controller and PC, otherwise the USB LED will be off.

If the LEDs do not sequence on power-up as described, either there is no power to the Signal Generator or the firmware on the controller has become corrupted and the controller will need to be repaired.

### During Operation

Each Axis LED will pulse when its corresponding axis is commanded to move. This causes the LED to appear to increase in brightness as the commanded motion becomes faster.



## **Inputs**

Inputs 1-8 are all optically isolated to provide a measure of protection from overvoltage and transient voltages. The inputs' reference voltage can be supplied by the Signal Generator's internal logic power or by an external voltage wired to the Signal Generator's TB40.

### **Internal Power**

This option works well for most applications but negates some of the signal isolation. When JP84 shorts pins 1 and 2, OPT VCC gets its power from the internal 5V power source. When JP85 shorts pins 1 and 2, OPT GND is directly connected to the internal GND.

### **External Isolated Power**

For the best noise immunity, connect an external 5V-24V power supply using one of the following methods. This is the default configuration. Ensure that all of your input devices are compatible with the supplied voltage. When JP84 shorts pins 2 and 3, OPT VCC gets its power from the TB-VCC. When JP85 shorts pins 2 and 3, OPT GND is directly connected to the TB-GND.

Choose only one of the following methods to supply power:

- Connect a power source to the TB-40 screw terminal.
- Connect a power source through pins 23 & 25 of the DB-25 connector.

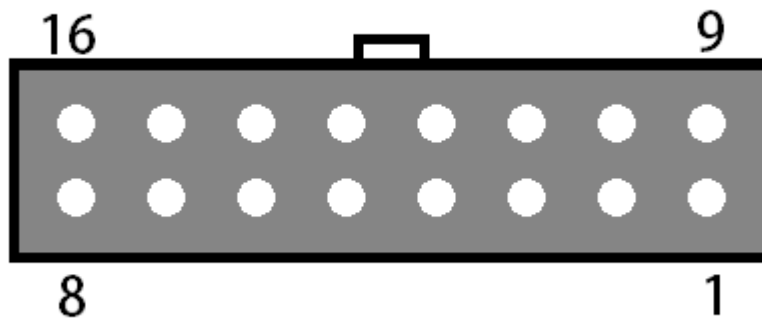


**If you are providing an external voltage through pins 23 & 25 of the DB-25 Motor Signals connector or via TB-40, then you must have both JP84 & JP85 jumpers on pins 2 & 3. OTHERWISE, SEVERE DAMAGE COULD RESULT.**

The input line settings can be individually changed between normally closed (N.C.) or normally open (N.O.) input lines using the software config. Please refer to the software User's Guide under "Input Line Settings" for further information. In the software, the Input Line Status dialog displays "OPEN" for a high-level input voltage, or open switch, and "CLOSED" for a low-level input voltage or closed switch. Each of these inputs are also accessible on the Motor Signals connector. These are the same—electrically—between this location and the Motor Signals connector.

The receptacle that plugs into this connector is a Mini-Fit Jr. Series 16 pin receptacle (Molex part number 39-01-2160), with female pins (Molex part number 39-00-0039 or 39-00-0047 for 22 gauge or thinner wires). The Molex 63819-0901 crimp tool is recommended for installing the pins. Kits containing connectors and pins are available through us or at an electronics distributor.

16-Pin Mini-Fit Jr. Connector for Inputs			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	OPT. GND	9	INPUT 1
2	OPT. GND	10	INPUT 2
3	OPT. GND	11	INPUT 3
4	OPT. GND	12	INPUT 4
5	OPT. GND	13	INPUT 5
6	OPT. GND	14	INPUT 6
7	OPT. GND	15	INPUT 7
8	OPT. GND	16	INPUT 8



## Outputs

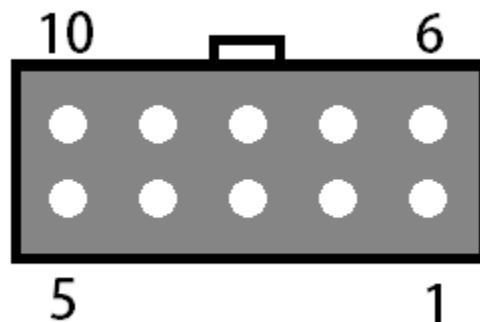
This connector is for up to eight output lines. These lines are all compatible with TTL/CMOS level outputs. The Output ports cannot drive a 24V external system unless it accepts TTL/CMOS levels. They are all driven by HCT family logic. Output logic high is normally 5V and can be as low as 3.9V at full load. Output logic low is normally 0V and can be as high as 0.3V at full load. Each of these signals can provide up to 20mA of current.

Two additional pins on this connector are provided for your output lines: ground and +5V. These are connected to GND and +5V and are not optically isolated. This 5V circuit can source up to 100 mA. Any larger current demand requires a larger power source.

The output lines are all initialized to low (0V) when you turn on the Signal Generator. Output lines 1 and 2 are also connected through pins 1 and 2, respectively, of the Motor Signal connector. These are the same—electrically—between this location and the Motor Signals connector.

The receptacle that plugs into this connector is a Mini-Fit Jr. Series 10 pin receptacle (Molex part number 39-01-2100), with female pins (Molex part number 39-00-0039 or 39-00-0047 for 22 gauge or thinner wires). The Molex 63819-0901 crimp tool is recommended for installing the pins. Kits containing connectors and pins are available through us or at an electronics distributor.

10-Pin Mini-Fit Jr. Connector for Outputs			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	OUTPUT 1	6	OUTPUT 2
2	OUTPUT 3	7	OUTPUT 4
3	OUTPUT 5	8	OUTPUT 6
4	OUTPUT 7	9	OUTPUT 8
5	+5V	10	GND



## Motor Signals

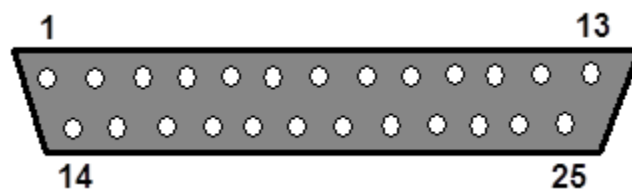
The Motor Signals connector uses a DB-25 connector to send step and direction signals from the Signal Generator to an external drive box.

The Motor Signals connector also provides a connection point to inputs 1-8 and outputs 1 & 2. Inputs 1-8 are the same signals found on the Input connector. Output 1 & 2 are the same outputs found on the output connector.

The Motor Signals connector can be used to tap into the internal VCC +5V power supply on the signal generator as well as provide an externally isolated power supply for the inputs. Refer to the signal generator section of this hardware guide for further information on input voltage compatibility.

The voltage levels for each Output, Step, Direction and Enable signals are all 5V logic.

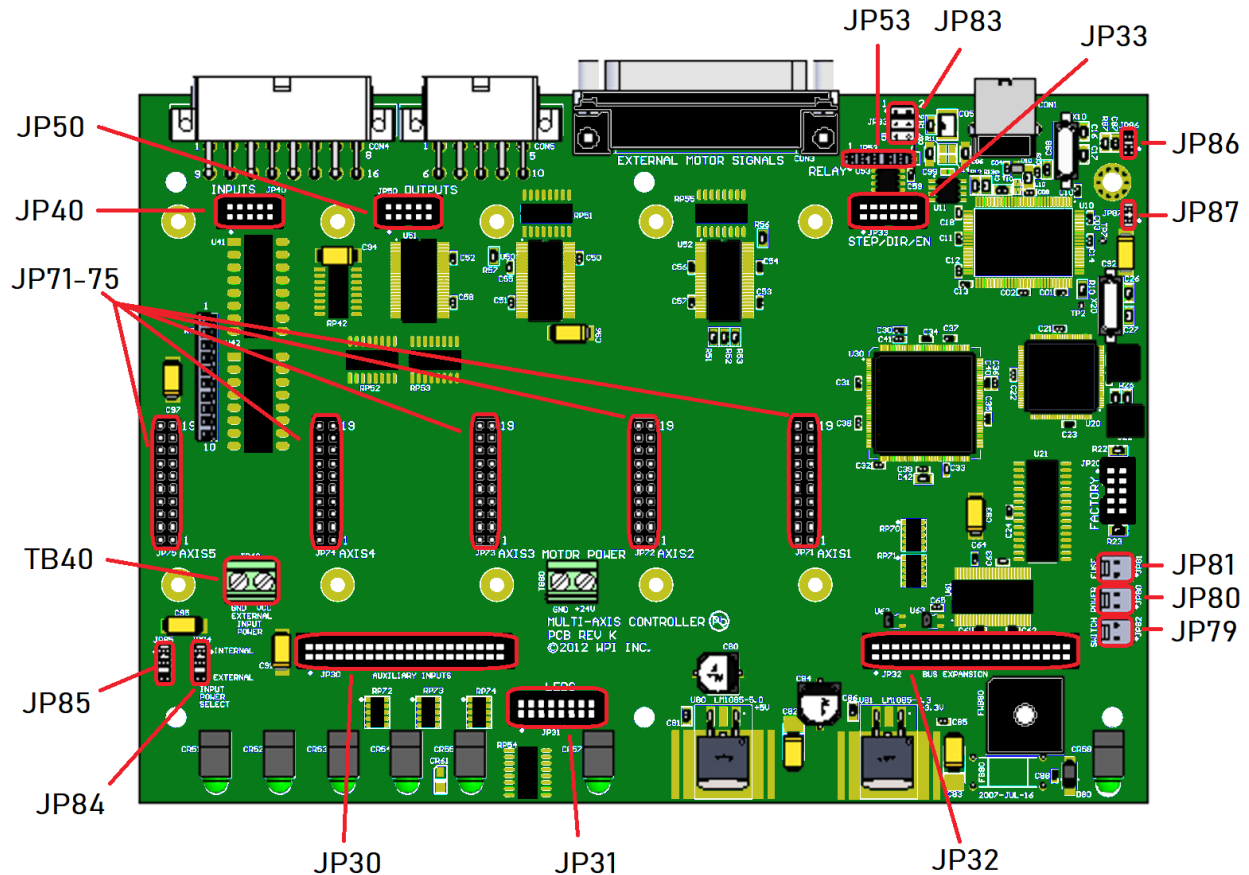
DB-25 Connector for Motor Signals			
Pin No.	Signal	Pin No.	Signal
1	OUTPUT 1	14	ENABLE ALL
2	OUTPUT 2	15	INPUT 1
3	STEP AXIS 5	16	INPUT 2
4	DIRECTION AXIS 5	17	INPUT 3
5	INPUT 5	18	INPUT 4
6	INPUT 6	19	DIRECTION AXIS 4
7	INPUT 7	20	DIRECTION AXIS 3
8	INPUT 8	21	DIRECTION AXIS 2
9	DIRECTION AXIS 1	22	INTERNAL VCC +5V
10	STEP AXIS 4	23	OPT. VCC (INPUT)
11	STEP AXIS 3	24	INTERNAL GND
12	STEP AXIS 2	25	OPT. GND (INPUT)
13	STEP AXIS 1		





## Jumper Settings

Pin 1 of each jumper can be identified by a small, white dot printed on the PCB. A complete description of all jumpers and pin assignments can be found in the Wiring Appendix.



### JP83 – DB to USB Ground

This connects the DB-25 ground to the USB ground. By default pins 1 & 2, 3 & 4, and 5 & 6 are jumped as pairs. In order to isolate only the USB shield, only jump pins 3 and 5 and remove JP86. To isolate only the chassis, jump pins 1 & 2, 3 & 5 and 4 & 6 and remove JP86 and JP87. For further information, please see the USB Communications Troubleshooting Guide.

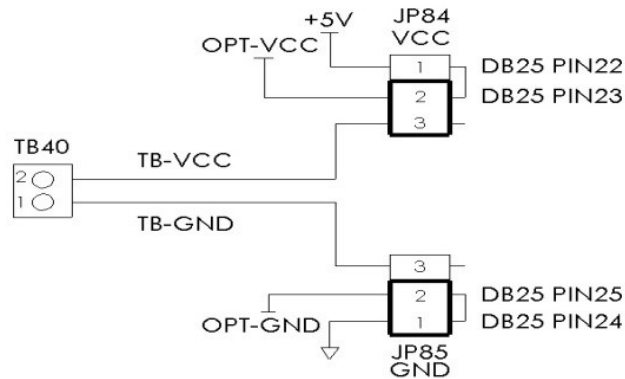
1	2
---	---

3	4
---	---

5	6
---	---

### JP84/JP85 – Input Power Select

These two jumpers enable you to choose between the internal power of the Signal Generator and isolated power from an external source. Both jumpers must be set on the same pair of pins (either both must be on pins 1 & 2 or both must be on pins 2 & 3). See the Input section of this guide for further details.



### JP86 – USB to Chassis Ground

This jumper connects the USB shield to the chassis ground of the Signal Generator when jumped. In order to isolate the USB shield remove this jumper and make sure only pins 3 and 5 are jumped on JP83. In order to isolate the DB-25 the USB shields, remove this jumper. In order to isolate the DB-25 shield, the USB shield and the chassis remove this jumper as well as JP87.

### JP87 – Internal Signal to Chassis Ground

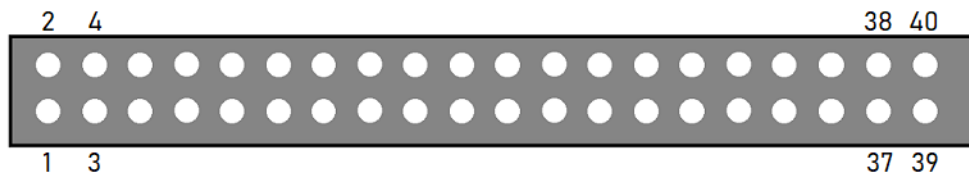
This jumper connects the internal signal ground to the chassis ground of the Signal Generator when jumped. In order to isolate the chassis ground, remove this jumper in addition to JP86 and jump pin 3 and 5, and 4 and 6 on JP83. In order to isolate the DB-25 shield, the USB shield and the chassis, remove this jumper as well as JP86.

## Internal Connections

### JP30 – Auxiliary Input

This header contains the input signals from the Signal Generator for optional I/O Expansion. Connections should be made with approved peripherals, otherwise damage may occur.

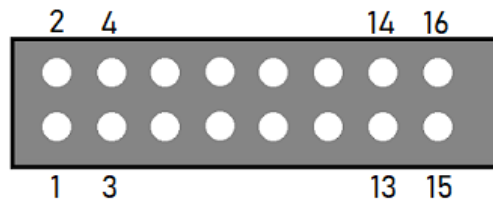
JP30 – Auxiliary Input			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	+3.3V	21	GPI-24
2	+3.3V	22	GPI-9
3	GPI-32	23	GPI-23
4	GPI-1	24	GPI-10
5	GPI-31	25	GPI-22
6	GPI-2	26	GPI-11
7	GPI-30	27	GPI-21
8	GPI-3	28	GPI-12
9	GPI-29	29	GPI-20
10	GPI-4	30	GPI-13
11	GPI-28	31	GPI-19
12	GPI-5	32	GPI-14
13	GPI-27	33	GPI-18
14	GPI-6	34	GPI-15
15	GPI-26	35	GPI-17
16	GPI-7	36	GPI-16
17	GPI-25	37	+3.3V
18	GPI-8	38	+3.3V
19	GND	39	GND
20	GND	40	GND



**JP31 – Status LEDs**

This is for connecting wired LEDs from a custom chassis to the 501A LED signals.

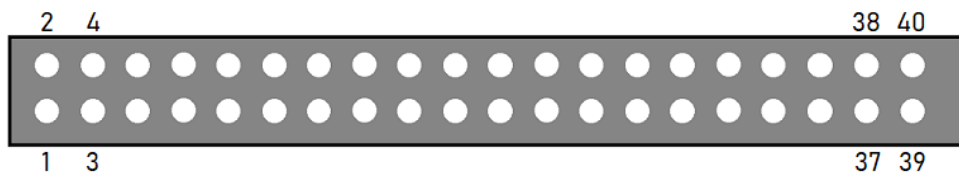
<b>JP31 – Status LEDs</b>			
<i><b>Pin No.</b></i>	<i><b>Signal</b></i>	<i><b>Pin No.</b></i>	<i><b>Signal</b></i>
1	+5V	9	LED-DIR4
2	N/C	10	LED-STEP4
3	LED-DIR1	11	LED-DIR5
4	LED-STEP1	12	LED-STEP5
5	LED-DIR2	13	LED-AUX
6	LED-STEP2	14	LED-USB
7	LED-DIR3	15	GND
8	LED-STEP3	16	LED-PWR



**JP32 – Bus Expansion**

This header contains signal and address lines for an optional I/O Expansion board. Connections should be made with approved peripherals, otherwise damage may occur.

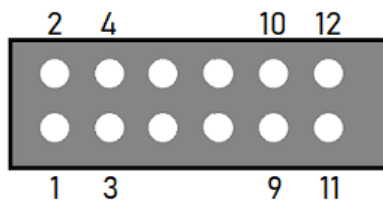
<b>JP32 – Bus Expansion</b>			
<b><i>Pin No.</i></b>	<b><i>Signal</i></b>	<b><i>Pin No.</i></b>	<b><i>Signal</i></b>
1	+3.3V	21	DATA1
2	GND	22	DATA2
3	CS6	23	DATA3
4	STATUS6	24	DATA4
5	TXD2	25	DATA8
6	FAULT6	26	DATA7
7	RXD2	27	DATA6
8	AUX1-STB	28	DATA5
9	OUT-ENA	29	+7V
10	AUX2-STB	30	+7V
11	OUT2-STB	31	SPHOME
12	OUT1-STB	32	ENC CLK
13	OUT4-STB	33	+3.3V
14	OUT3-STB	34	ENC DIR
15	+5V	35	AGND
16	+5V	36	AV+
17	GND	37	DAC2
18	GND	38	DAC1
19	A0	39	ADC1
20	A1	40	AGND



### JP33 – Step and Direction

This header contains each step and direction signal for all five axes of motion as well as the global enable signal and the common ground reference.

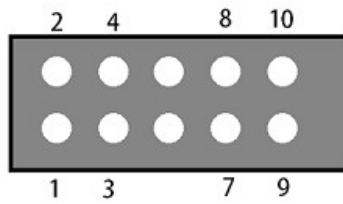
JP33 – Step and Direction			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	STEP5	7	STEP2
2	ENA	8	DIR3
3	STEP4	9	STEP1
4	DIR5	10	DIR2
5	STEP3	11	GND
6	DIR4	12	DIR1



### JP40 – Input Aux

This header contains the same signals as the Mini-Fit Jr. Input Connector. It is provided to use an internal input connector or an external input connector on a custom chassis.

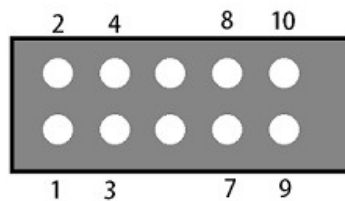
JP40 – Input Aux			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	GPI-2	6	GPI-5
2	GPI-1	7	GPI-8
3	GPI-4	8	GPI-7
4	GPI-3	9	OPT-GND
5	GPI-6	10	OPT-GND



**JP50 – Output Aux**

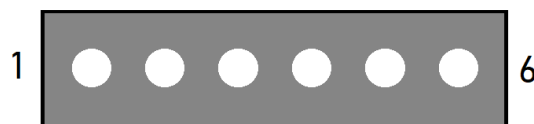
This contains the same signals as the Mini-Fit Jr. Output Connector. It is provided to use an internal output connector or an external output connector on a custom chassis.

<b>JP50 – Output Aux</b>			
<i><b>Pin No.</b></i>	<i><b>Signal</b></i>	<i><b>Pin No.</b></i>	<i><b>Signal</b></i>
1	GPO-2	6	GPO-5
2	GPO-1	7	GPO-8
3	GPO-4	8	GPO-7
4	GPO-3	9	GND
5	GPO-6	10	VCC

**JP53 – Low-Side Relay**

This header contains duplicate signals for Outputs 1&2 in order to drive an internal relay. (Either mounted here or on the power board, depending on configuration.) The clamps provide a reference voltage for use in signal isolation. The output low pins will sink current to drive devices.

<b>JP53 – Low-SideRelay</b>			
<i><b>Pin No.</b></i>	<i><b>Signal</b></i>	<i><b>Pin No.</b></i>	<i><b>Signal</b></i>
1	+5V	4	GPO-1 LOW
2	GPO-2 CLAMP	5	GPO-1 CLAMP
3	GPO-2 LOW	6	GND

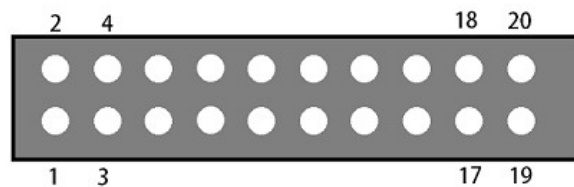




**JP71-75 – Axis Plug-In Interfaces**

There are five plug-in interfaces—one for each axis. They are used to add additional functions to the main signal generator board. Most typically, these provide signals to motor drives.

<b>JP71-75 – Axis Plug-In Interfaces</b>						
<b>Pin No.</b>	<b>Function</b>	<b>JP71</b>	<b>JP72</b>	<b>JP73</b>	<b>JP74</b>	<b>JP75</b>
1	HV-PWR	HV-PWR	HV-PWR	HV-PWR	HV-PWR	HV-PWR
2	HV-PWR	HV-PWR	HV-PWR	HV-PWR	HV-PWR	HV-PWR
3	Ground	GND	GND	GND	GND	GND
4	Ground	GND	GND	GND	GND	GND
5	RxD2	RxD2	RxD2	RxD2	RxD2	RxD2
6	Status	STATUS1	STATUS2	STATUS3	STATUS4	STATUS5
7	TxD2	TxD2	TxD2	TxD2	TxD2	TxD2
8	Fault Input	FAULT1	FAULT2	FAULT3	FAULT4	FAULT5
9	Input A	IN8	IN10	IN12	IN14	IN16
10	Direction	DR1	DR2	DR3	DR4	DR5
11	Input B	IN9	IN11	IN13	IN15	IN17
12	Step	ST1	ST2	ST3	ST4	ST5
13	SM0	SM0	SM0	SM0	SM0	SM0
14	SCOM	SCOM1	SCOM2	SCOM3	SCOM4	SCOM5
15	SM1	SM1	SM1	SM1	SM1	SM1
16	CS	CS1	CS2	CS3	CS4	CS5
17	Enable (Global)	ENA	ENA	ENA	ENA	ENA
18	+5V	+5V	+5V	+5V	+5V	+5V
19	Ground	GND	GND	GND	GND	GND
20	Ground	GND	GND	GND	GND	GND



**JP80 – Rear Panel Power**

Connect the main power here. It can be 8.5V – 16V DC.

**JP81 – Rear Panel Fuse**

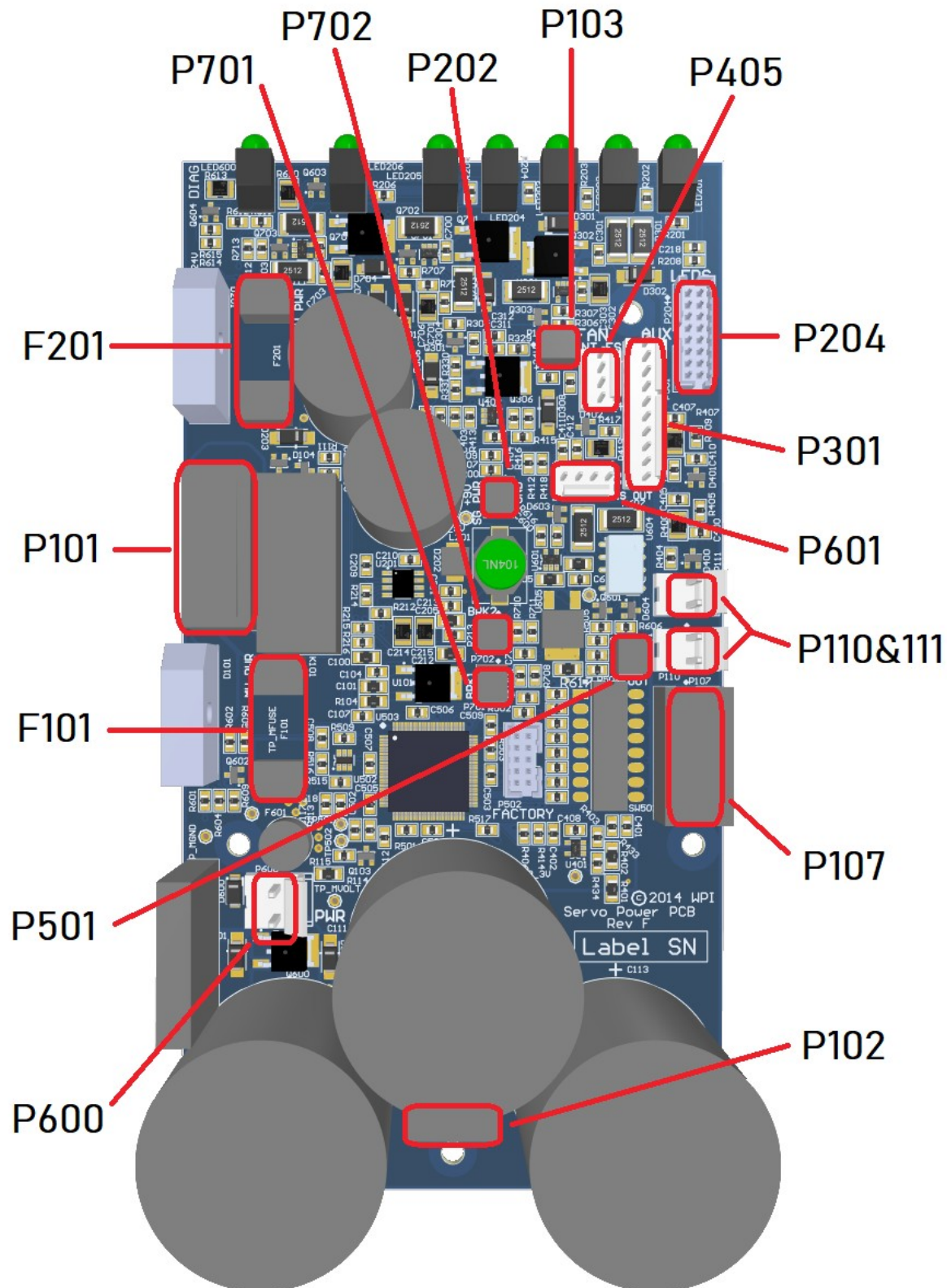
This is for an optional power fuse. The unit is shipped with a shunt instead of a fuse. If you replace the shunt with a fuse, it should be rated to 1A slow-blow or time-delay.

**JP82 – Front Panel Switch**

If the power supplied to JP80 is not switched, you can connect the main power switch here.

## Advanced Power Board

The Advanced Power Board supplies logic and motor power, indicates system status and contains circuitry for emergency stop (ESTOP), motor reset and brake functionality.

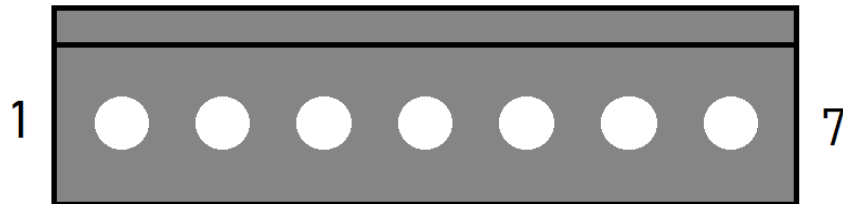


## Internal Connections

### P101 – Transformer Connector

This header is the AC power input for motor and logic power. Pins 4 & 6 are typically wired to unused leads from the transformer but make no connection on the board.

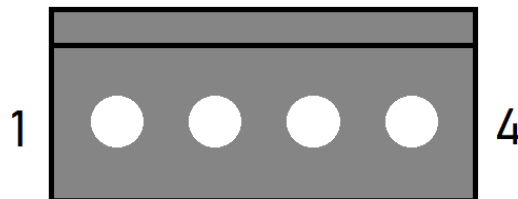
P101 – Transformer Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	24VAC Line	5	MPWR AC Line
2	24VAC Neutral	6	N/C
3	N/C	7	MPWR AC Neutral
4	N/C		



### P102 – AUX Motor Power Connector

This header provides additional access to the DC motor power bus. This bus is shared between P102, P107, P110 and P111.

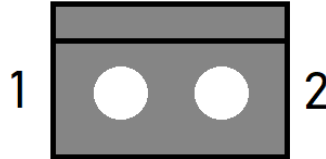
P102 – AUX Motor Power Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	MPWR DC+	3	MPWR DC-
2	MPWR DC+	4	MPWR DC-



### P103 – Fan Connector

This header is the power source for the system fan.

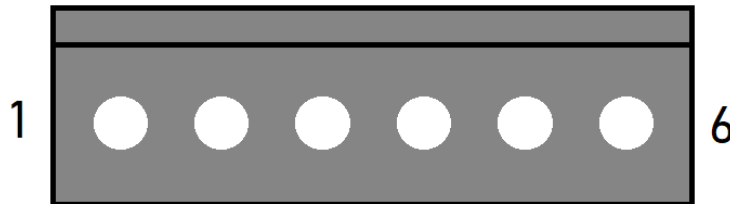
P103 – Fan Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	GND	2	+24VDC



### P107 - Motor Power Connector (x3)

This header provides three pairs of motor power voltage and ground. This bus is shared between P102, P107, P110 and P111.

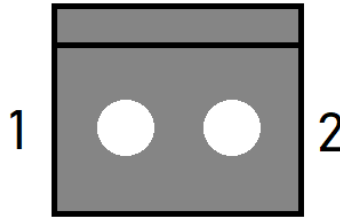
P107 – Motor Power Connector (3x)			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	MPWR DC-	4	MPWR DC+
2	MPWR DC+	5	MPWR DC-
3	MPWR DC-	6	MPWR DC+



### P110 & P111 – Motor Power Connectors

These headers each provide a pair of motor power voltage and ground. This bus is shared between P102, P107, P110 and P111.

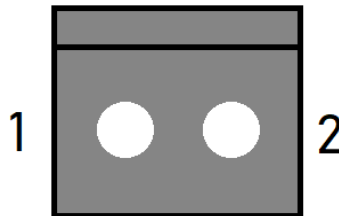
P110 & P111 – Motor Power Connectors			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	MPWR DC-	2	MPWR DC+



### P202 – Signal Generator Power Connector

This header provides 9V logic power to the Signal Generator.

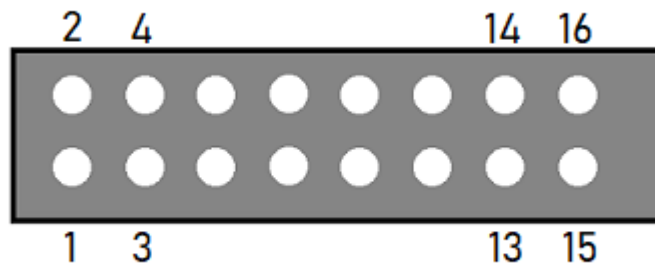
P202 – Signal Generator Power Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	GND	2	+9VDC



### P204 – LED Connector

This header receives system status information from the Signal Generator.

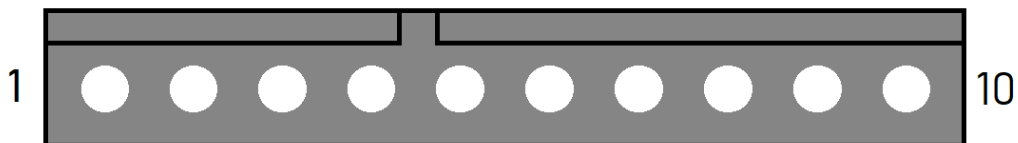
P204 – LED Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	+5V	9	N/C
2	N/C	10	LED-STEP4
3	N/C	11	N/C
4	LED-STEP1	12	LED-STEP5
5	N/C	13	N/C
6	LED-STEP2	14	LED-USB
7	N/C	15	GND
8	LED-STEP3	16	N/C



### P301 – Accessory Connector

This header contains the signals of the rear Accessory port. See that section for more details.

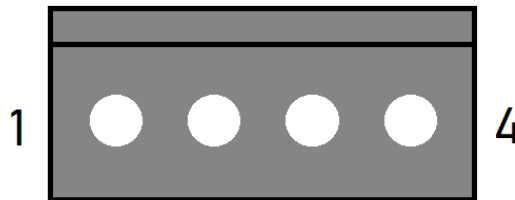
P301 – Accessory Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	+24V	6	GND
2	GND	7	ESTOP_EXT+
3	BRAKE1	8	ESTOP_EXT-
4	GND	9	RESET+
5	BRAKE2	10	RESET-



### P405 – Internal Emergency Stop Connector

This header contains internal emergency stop and reset control inputs.

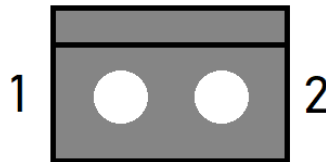
P405 – Internal Emergency Stop Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	ESTOP_INT+	3	RESET_INT+
2	ESTOP_INT-	4	RESET_INT-



### P501 – Relay Control Connector

This header controls the state of the on-board relay.

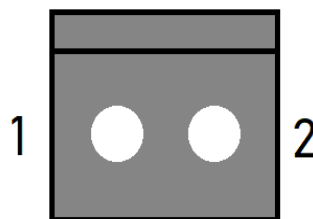
P501 – Relay Control Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	GND	2	RELAY_IN



### P600 – Motor Power Resistor Connector

This header connects to the regenerative clamp resistor.

P600 – Motor Power Resistor Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	REGEN_DRIVE	2	MPWR DC+ (Fused)

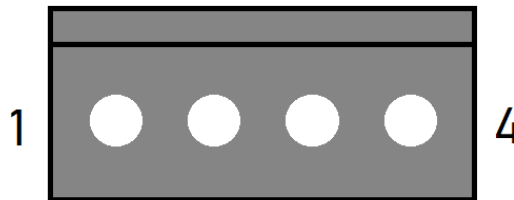




### P601 – Emergency Stop Output Connector

This header outputs emergency stop state and on-board relay contacts.

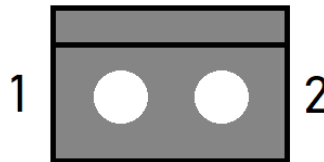
P601 – Emergency Stop Output Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	RELAY+	3	ES_OUT_LOGIC+
2	RELAY-	4	GND



### P701 – Brake 1 Input Connector

This header accepts a signal to activate or disengage brake 1. Typically, this is sourced from a motor drive's output.

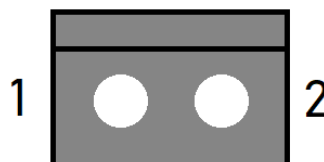
P701 – Brake 1 Input Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	GND	2	BRAKE1_IN



### P702 – Brake 2 Input Connector

This header accepts a signal to activate or disengage brake 2. Typically, this is sourced from a motor drive's output.

P702 – Brake 2 Input Connector			
<i>Pin No.</i>	<i>Signal</i>	<i>Pin No.</i>	<i>Signal</i>
1	GND	2	BRAKE2_IN



## Switch Settings

### SW502 – DIP Switches

This switch bank controls the settings for various on-board functions.

SW502 – DIP Switches			
SW No.	Function	On State	Off State
1	Reset Configuration	Reset clears ESTOP	No reset function
2	Brake Input Polarity	Active high	Active low
3	Logic Out Config	Logic uses ESTOP	False
4	Relay Out Config	Relay uses ESTOP	False
5	Internal ESTOP	Used	Not used
6	External ESTOP	Used	Not used
7	Under V Monitor	Used	Not used
8	N/A	N/A	N/A

**Reset Configuration:** When enabled, pins 3&4 on P405 must be jumped momentarily to activate motor power when all ESTOPs are cleared.

**Brake Input Polarity:** This setting determines whether a high or low signal across P701 and P702 will cause the respective brake outputs on P301 to be active.

**Logic Out Config:** When enabled, pin 3 on P601 will reflect the state of motor power.

**Relay Out Config:** When enabled, the relay output on pins 1&2 on P601 will be open if an ESTOP event is active.

**Internal ESTOP:** When enabled, pins 1&2 on P405 must be jumped to clear an ESTOP event.

**External ESTOP:** When enabled, pins 7&8 on P301 must be jumped to clear an ESTOP event.

**Under V Monitor:** When enabled, the power board will report under-voltage states.

## ***Fuses***

### **F101 – Motor AC Fuse**







This fuse protects the drive power supply circuitry. It should be replaced with a 250 VAC, 8-16A Time Lag (Slow Blow) 5x20mm.

### **F201 – 18.8VAC Fuse**

This fuse protects the circuitry that provides power to the logic of the Signal Generator and its subsystems. It should be replaced with a 250 VAC, 4A Time Lag (Slow Blow) 5x20mm fuse.

## ***LED Indicators***

The Power / Status LED provides visual indication of power board status and operation through blink codes and color codes, shown below:

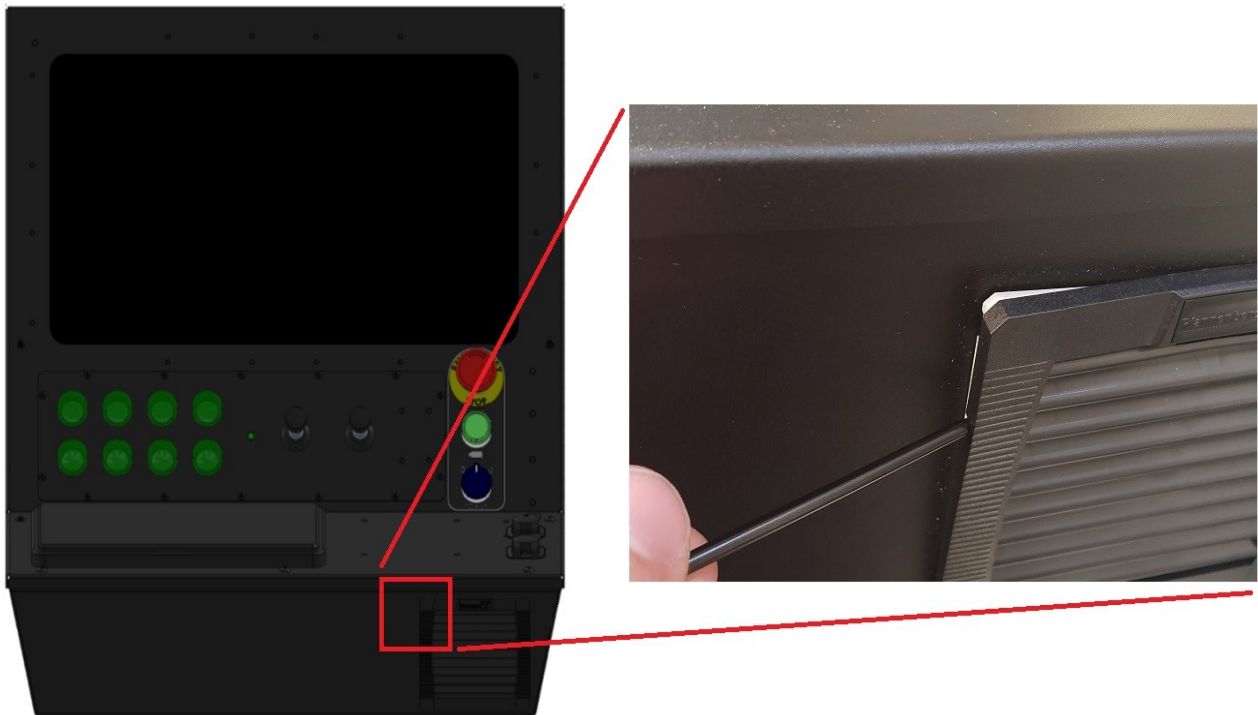
Code	Error
 solid green	no error
 flashing green	ESTOP closed, waiting for RESET
 solid red	low motor power
 2 green, 2 red	low 24V
 1 green, 3 red	regen resistor locked
 alternating	ESTOP open

## Controller Maintenance

### *External Maintenance*

#### **Fan Filter**

The intake fan filter should be cleaned periodically. The time between cleanings is dependent on the controller's environment and should be performed whenever debris buildup is noticeable. First, remove the filter cover by pulling directly away from the controller. You may need to use a small flathead screwdriver or similar tool to pry one or more of the corners away from the fan mount, as shown below.



Next, remove the foam filter and use a vacuum or compressed air to remove debris. Do not use water or cleaning products to clean the filter. Once cleaned, replace the filter in the filter cover and reattach it to the controller. The filter is Pfannenberg part number 18611600029.

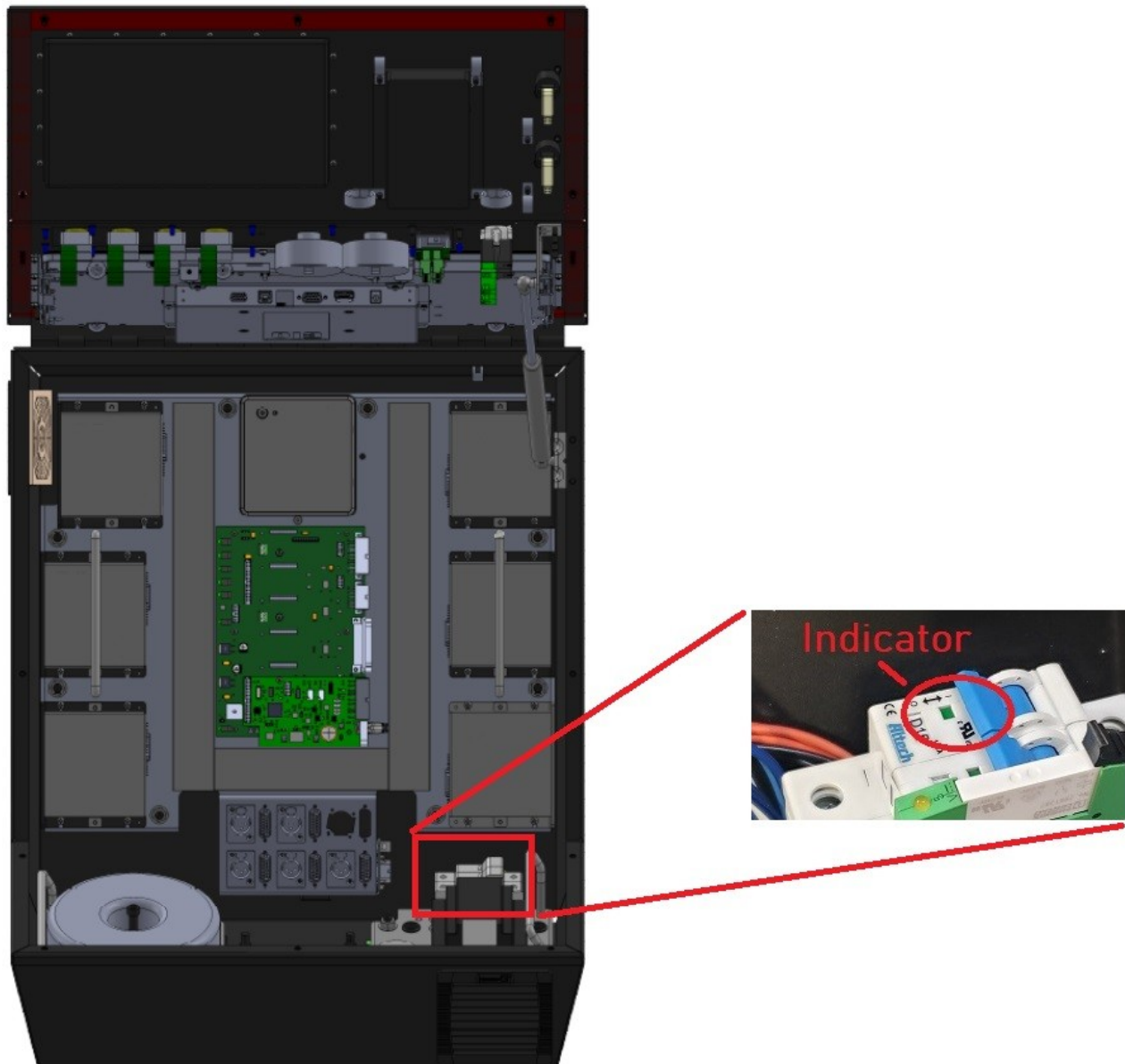
## Internal Maintenance

### Opening The Lid

Before installing or replacing internal components, open the lid. The lid is secured by seven 10-32 screws on the edges of the lid. Remove these using a P2 Phillips screwdriver and lift the lid off of the controls. Take care to gently guide the lid to its open position, as the support strut will provide extra opening force.

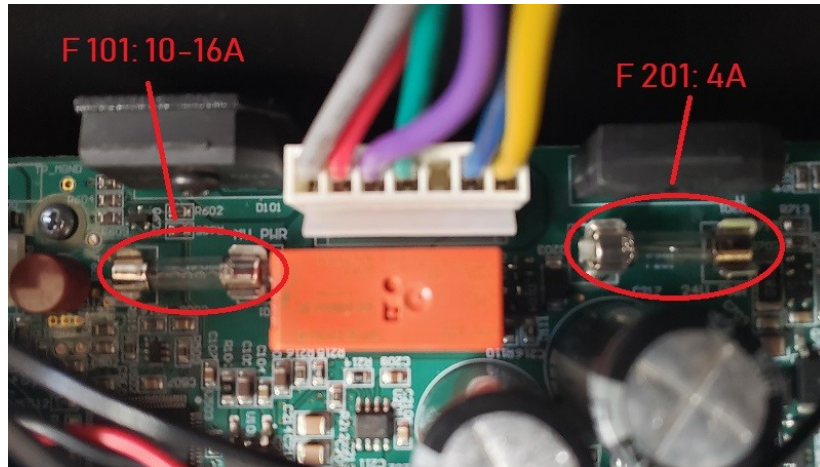
### Disconnecting Power

Immediately after opening the lid, open the AC mains circuit breaker to ensure that the system is safe to work on. When power is disconnected, the breaker will show a green indicator.



## Replacing Fuses

If your system demands more power than can be safely output, you might blow a fuse on the system's power board. Fortunately, these fuses are replaceable. See the following picture for their location. They are both 20x5mm form factor. F 101 is rated from 10–16A and F 201 is rated to 4A.

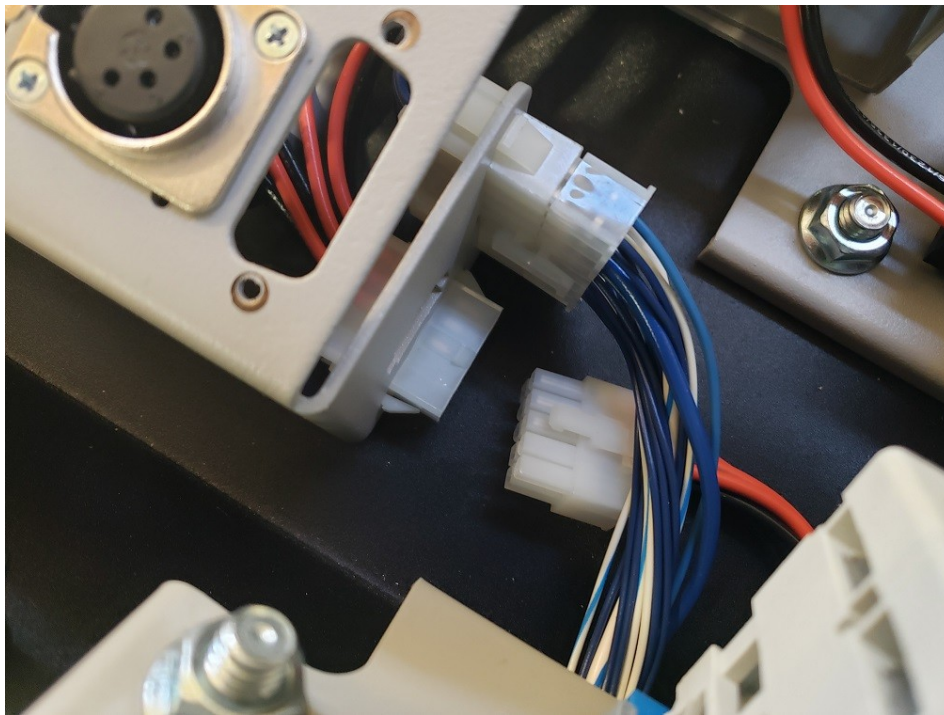


## Adding/Replacing a Drive

To upgrade your CNC controller—such as adding a 4th or 5th axis—you should install the new drive module(s) using the following instructions.

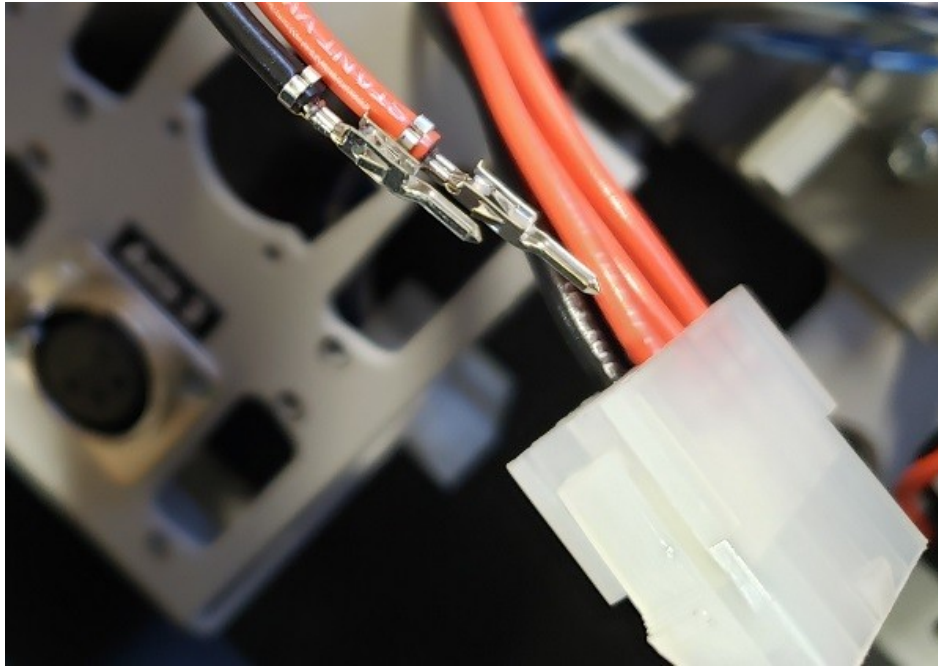
Improper wiring can cause damage to your controller or motors. Please take care in following these instructions properly. Please refer to the pictures below for the correct connectors.

1. Set the dip switches and rotary switch of the new drive to the appropriate settings for your application. See the Motor Drive Settings section of this manual for more information.
2. If replacing a drive, remove the four mounting screws and unplug all connectors.
3. Add or replace the drive and mount to the bottom of the chassis using four 6-32x1.25" socket head screws. If replacing the drive, skip to step 8.
4. Add an additional pair to the motor power harness. Disconnect and then dismount the connector from the panel as shown.

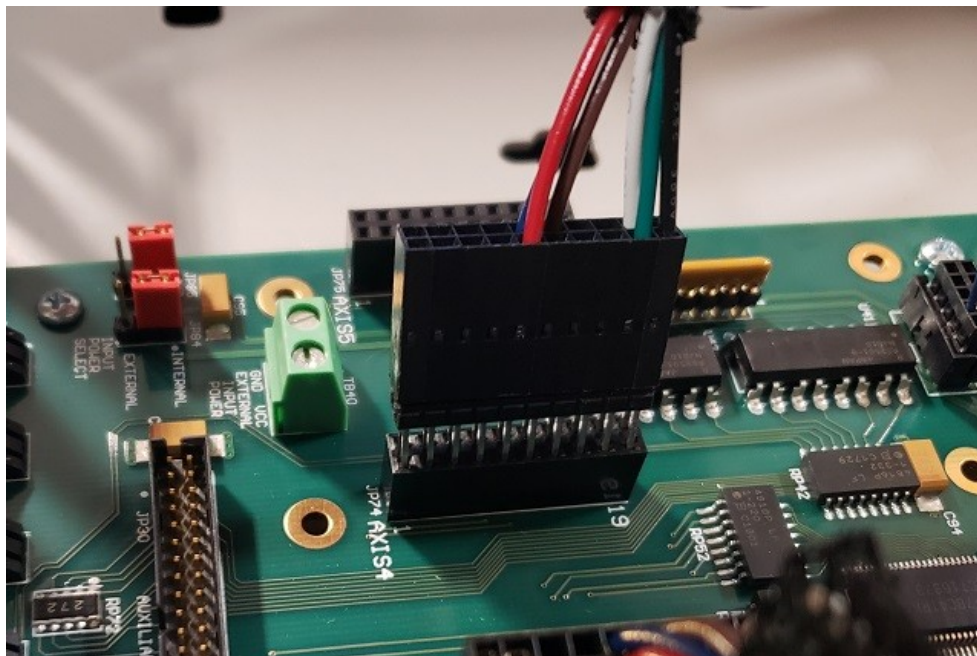




5. Seat the loose pins in the next pair of open connections in the harness's housing and re-mount it in the motor connection panel.

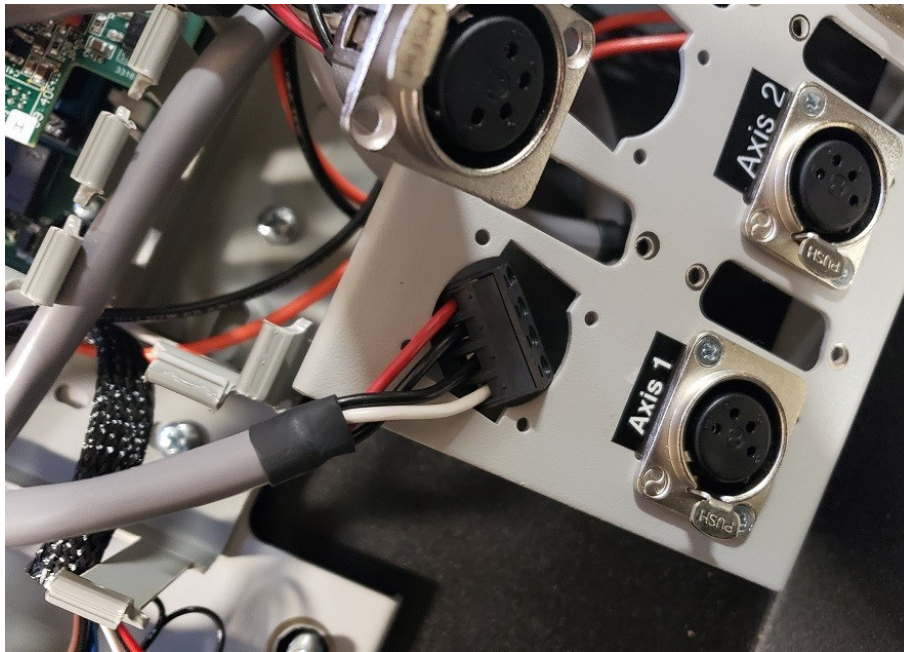


6. Add a step/direction cable to the signal generator in the next available axis control header.





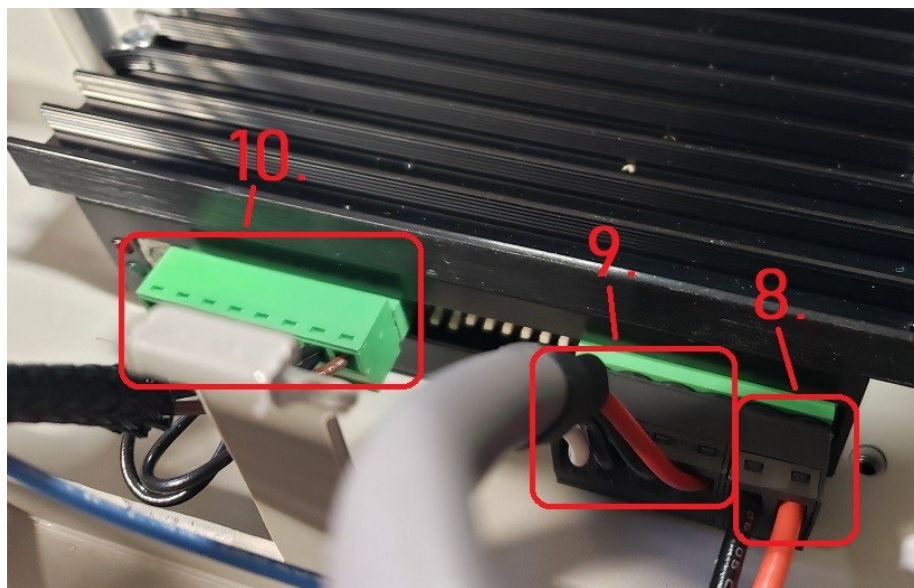
7. Mount an additional motor power connector to the sub panel using 4-40x $\frac{1}{4}$ " thread-cutting screws.



8. Connect the input motor power cable from the power harness to V+ & V- on the drive.

9. Connect the output motor power cable from the motor connector panel to the drive's B-, B+, A- & A+ output.

10. Connect the motion signals of the drive to an axis interface connector on the Signal Generator with a step/direction cable.



# Pin Location Index

## Signal Locations

This table contains every instance of each signal in the system.

<i>Signal Locations</i>																		
	Signal Generator									Mini I/O	Ultra I/O							
Signal	CON5	CON4	CON3	JP30	JP40	JP50	JP53	JP33	JP71–JP75	P103	CON 1301	CON 1302	P1301 P1302	JP 1301	JP 1302	JP 301	JP 302	JP 303
Input 1		9	15	4	2													49
Input 2		10	16	6	1													48
Input 3		11	17	8	4													47
Input 4		12	18	10	3													46
Input 5		13	5	12	6													45
Input 6		14	6	14	5													44
Input 7		15	7	16	8													43
Input 8		16	8	18	7													42
Input 9				22					JP71.9							47		
Input 10				24					JP71.11							46		
Input 11				26					JP72.9							45		
Input 12				28					JP72.11							44		
Input 13				30					JP73.9							43		
Input 14				32					JP73.11							42		
Input 15				34					JP74.9							41		
Input 16				36					JP74.11							40		
Input 17				35					JP75.9									41
Input 18				33					JP75.11									40
Input 19				31						10			P1.10					39
Input 20				29						12			P1.12					38
Input 21				27									P2.10				49	
Input 22				25									P2.12				48	
Input 23				23													47	
Input 24				21													46	
Input 25				17								9		2			45	
Input 26				15								10		1			44	
Input 27				13								11		4			43	
Input 28				11								12		3			42	
Input 29				9								13		6			41	
Input 30				7								14		5			40	
Input 31				5								15		8			39	
Input 32				3								16		7			38	

<b>Signal Locations</b>																		
	<b>Signal Generator</b>									<b>Mini I/O</b>	<b>Ultra I/O</b>							
<b>Signal</b>	<b>CON5</b>	<b>CON4</b>	<b>CON3</b>	<b>JP30</b>	<b>JP40</b>	<b>JP50</b>	<b>JP53</b>	<b>JP33</b>	<b>JP71–JP75</b>	<b>P103</b>	<b>CON 1301</b>	<b>CON 1302</b>	<b>P1301 P1302</b>	<b>JP 1301</b>	<b>JP 1302</b>	<b>JP 301</b>	<b>JP 302</b>	<b>JP 303</b>
Output 1	1		1			2	4			6&15			P1.6&15					37
Output 2	6		2			1	3			7&16			P1.7&16					36
Output 3	2					4							P2.6&15					35
Output 4	7					3							P2.7&16					34
Output 5	3					6												33
Output 6	8					5												32
Output 7	4					8												31
Output 8	9					7												30
Output 9																39		
Output 10																38		
Output 11																37		
Output 12																36		
Output 13																35		
Output 14																34		
Output 15																33		
Output 16																32		
Output 17																		29
Output 18																		28
Output 19																		27
Output 20																		26
Output 21																	37	
Output 22																	36	
Output 23																	35	
Output 24																	34	
Output 25													1		2		33	
Output 26													2		1		32	
Output 27													3		4		31	
Output 28													4		3		30	
Output 29													5		6		29	
Output 30													6		5		28	
Output 31													7		8		27	
Output 32													8		7		26	
Analog Input 1										18				P1.18		30		
Analog Input 2														P2.18		29		
Analog Output 1										17				P1.17		27		
Analog Output 2														P2.17		26		
PWM Output 1										14				P1.14		1		
PWM Output 2														P2.14		7		



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## ***Voltage/GND Locations***

### **+5VDC**

- Signal Generator
  - CON5.5
  - CON3.22
  - JP50.9
  - JP53.1
  - JP33.11
  - JP71-75.20
- Mini I/O
  - P103.13
- Ultra I/O
  - CON1302.9
  - P1301.13
  - P1302.13
  - JP1302.10

### **GND**

- Signal Generator
  - CON5.10
  - CON3.24
  - JP30.19, 20, 39, 40
  - JP50.9
  - JP53.6
  - JP33.11
  - JP71-75.20
- Mini I/O
  - P103.4, 5, 8, 9
- Ultra I/O
  - CON1302.10
  - P1301.4, 5
  - P1302.1, 3, 4, 5
  - JP301.1, 2, 3, 4, 5, 6

**OPT-VCC**

- Signal Generator
  - CON3.23
- Ultra I/O
  - JP301.24, 48
  - JP302.25, 50
  - JP303.25, 50

**OPT-GND**

- Signal Generator
  - CON4.1, 2, 3, 4, 5, 6, 7, 8
  - CON3.25
  - JP40.9, 10
- Ultra I/O
  - CON1301.1, 2, 3, 4, 5, 6, 7, 8
  - JP301.16, 17, 18, 19, 20, 21, 22, 23, 24
  - JP302.13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24
  - JP303.13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24
  - JP1301.9, 10

**Analog GND**

- Ultra I/O
  - P1301.8, 9
  - P1302.8, 9
  - JP301.25, 28, 31

**5-24VDC Clamp Voltage**

- Signal Generator
  - JP53.2, 5
- Ultra I/O
  - JP301.8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24
  - JP302.1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25
  - JP303.1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12

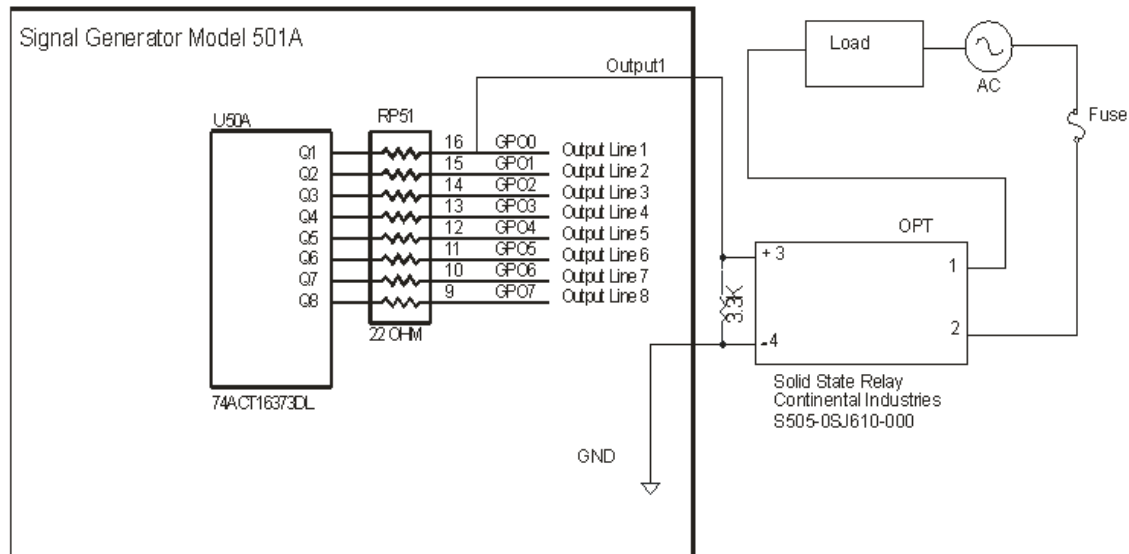
## Wiring Appendix

### Example Wiring

#### Typical Output Line Circuit

The schematic below shows a typical connection of one solid state relay controlled by output line 1 of the Signal Generator. A typical load could be a spindle, a vacuum, a laser, etc. In this example, the solid-state relay used is a Continental Industries model S505-0SJ610-000.

Each of the output signals has a 22-ohm resistor in series with their outputs. This is to reduce any “ringing” at the transient switching points. Ground and 5V are provided on this connector for your convenience. Our Spindle On/Off Relay Box is wired as shown in the below schematic.







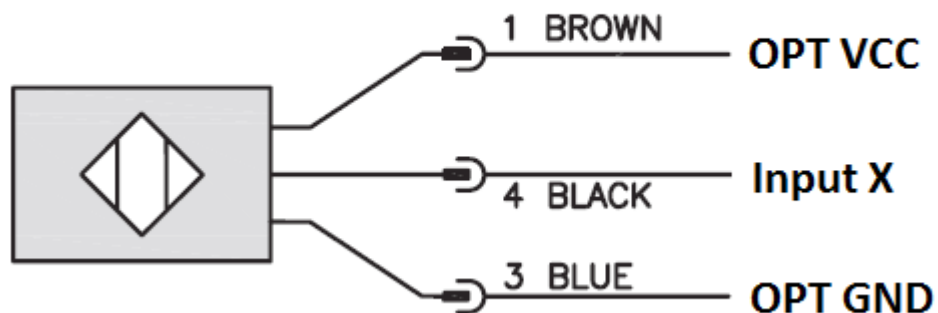


## Proximity Sensors

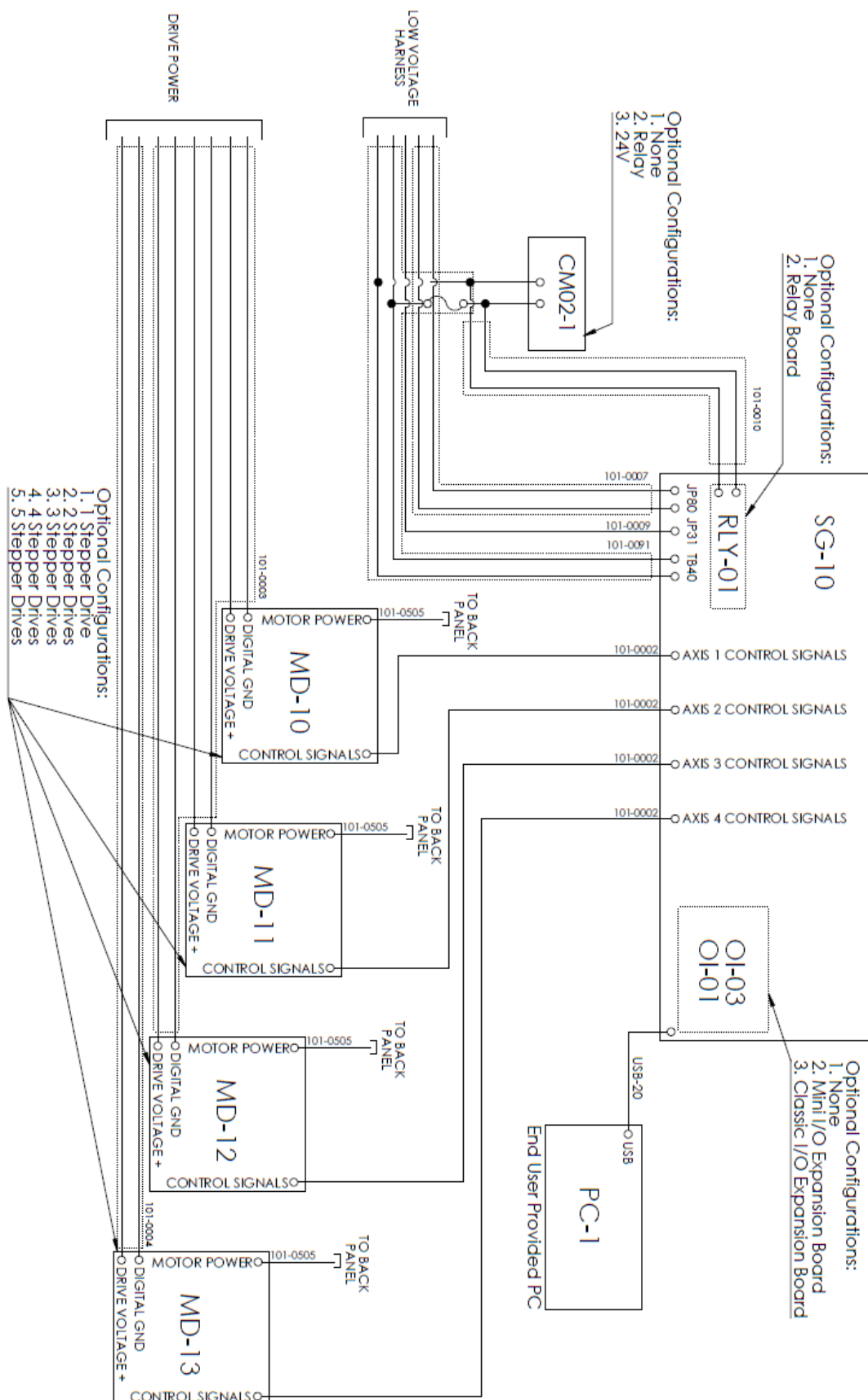
When connecting a proximity type sensor, connect to the controller using the following diagram.

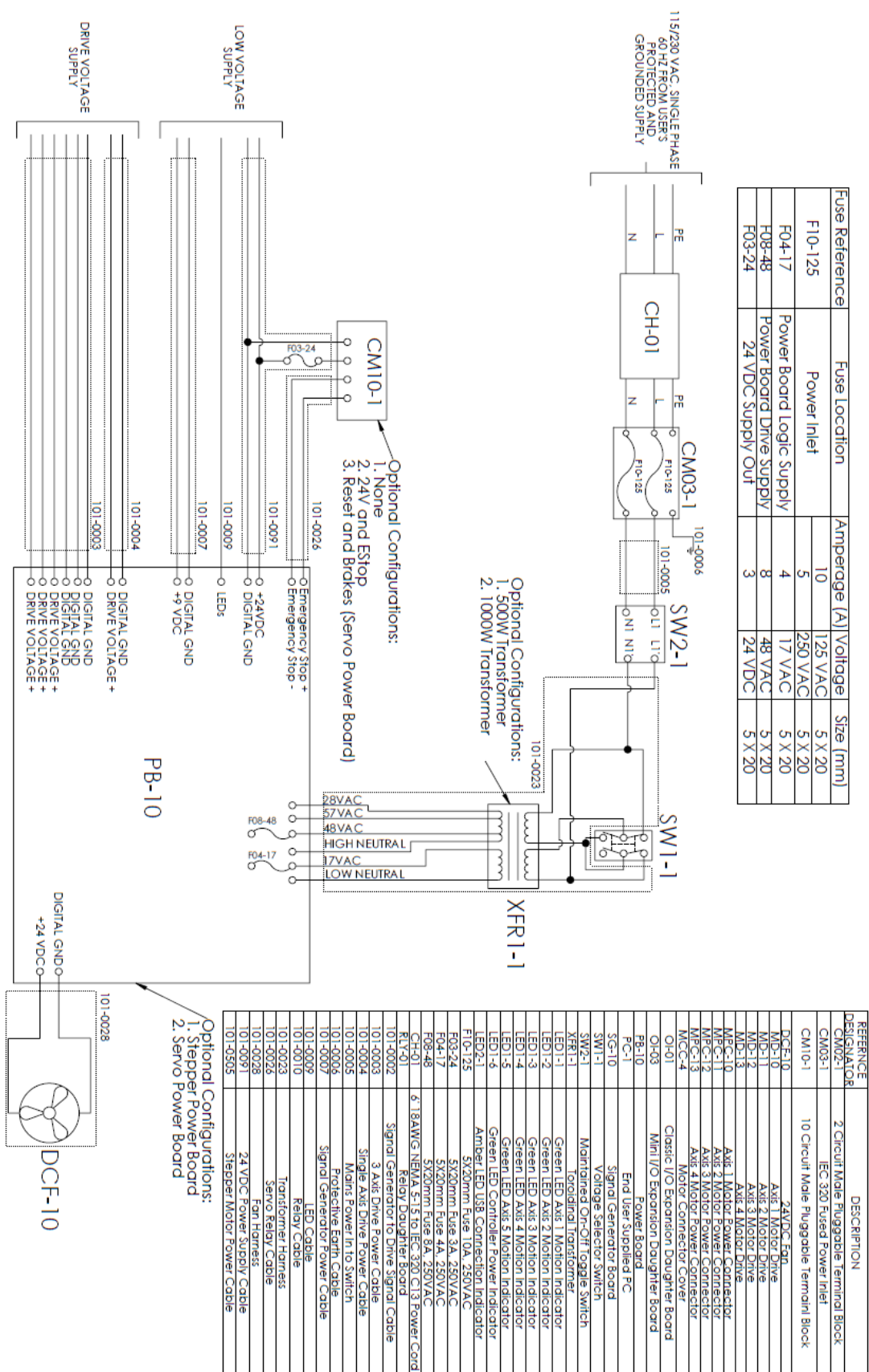
Please note only NPN type proximity sensors are compatible with the controller. Most sensors require the use of a higher, external voltage supply than the standard 5V to operate. Please see the information on Inputs in the Signal Generator section for more information on wiring OPT VCC.

### NPN Proximity Sensor



## Internal Schematic





## Revision History

## Revision B

[illegible]