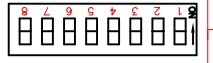


DESCRIPTION	SWITCH NUMBER
STOP	1
START	2
REVERSE	3
FORWARD	4
STOP	5
STOP	6
STOP	7
STOP	8
STOP	9
STOP	10
STOP	11
STOP	12
STOP	13
STOP	14
STOP	15
STOP	16
STOP	17
STOP	18
STOP	19
STOP	20
STOP	21
STOP	22
STOP	23
STOP	24
STOP	25
STOP	26
STOP	27
STOP	28
STOP	29
STOP	30
STOP	31

SPDL #	4	5	6	7	8
1	X	X	X	X	X
2	X	X	X	X	X
3	X	X	X	X	X
4	X	X	X	X	X
5	X	X	X	X	X
6	X	X	X	X	X
7	X	X	X	X	X
8	X	X	X	X	X
9	X	X	X	X	X
10	X	X	X	X	X
11	X	X	X	X	X
12	X	X	X	X	X
13	X	X	X	X	X
14	X	X	X	X	X
15	X	X	X	X	X
16	X	X	X	X	X
17	X	X	X	X	X
18	X	X	X	X	X
19	X	X	X	X	X
20	X	X	X	X	X
21	X	X	X	X	X
22	X	X	X	X	X
23	X	X	X	X	X
24	X	X	X	X	X
25	X	X	X	X	X
26	X	X	X	X	X
27	X	X	X	X	X
28	X	X	X	X	X
29	X	X	X	X	X
30	X	X	X	X	X
31	X	X	X	X	X

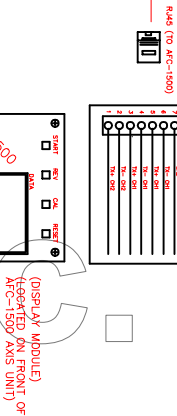
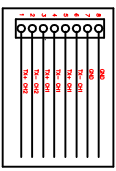


X: ON
O: OFF

AFC-1500 AXIS UNIT

CONNECTION REFERENCE ONLY
(FOR REFERENCE ONLY)

PLC SIGNALS FOR SERIAL COMMUNICATION



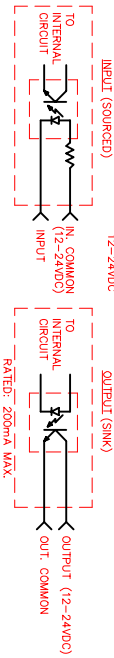
(DISPLAY MODULE)
(MOUNTED ON FRONT OF
AFC-1500 AXIS UNIT)

AXIS I/O CONNECTOR

INPUTS (1-5&9-16)	OUTPUTS (17-25)
1 STOP	17 SELF CHECK DISABLE
2 START	18 WORK SELECT 2
3 REVERSE	19 OUT DATA 4
4 FORWARD	20 OUT DATA 2
5 BYPASS	21 OUT DATA 1
	22 OUT DATA 3
	23 OUT DATA 5
	24 OUT DATA 6
	25 OUT DATA 0

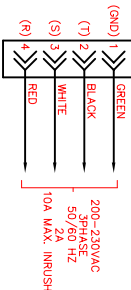
CONNECTOR (CABLE SIDE)
MR-25M

(HONDA)



PLC SIGNAL NAME	COMMENT
1 TORQUE MOTOR	SV TO 4.5V
2 ANGLE PULSE	TTL, IOL = 30mA
3 ANGLE CUV/COV	TTL, IOL = 30mA
4 CURRENT VOLTAGE	1.2A PEAK / V
5 SPEED VOLTAGE	1000GREEN / V (MOTOR SPEED)
6 SIGNAL GROUND	COMMON FOR ALL OUTPUT SIGNALS

ADAPTER PLUG DESCRIPTION
MFG. - MOLEX
MODEL - M16-01-2066
TERMINAL PIN - 3P-00-0039 (6 PIECES)



PLC SIGNAL	PLC SIGNAL	PLC SIGNAL	PLC SIGNAL
1 BANK SELECT	13	12	12
2 LOGIC LEVEL	0	0	0
3 BANK #	1	2	2
4 PIN SIGNAL	SIGNAL	SIGNAL	SIGNAL
5 REJECT	REJECT	NOT USED	NOT USED
6 ABNORMAL	ABNORMAL	ANGLE HI REJECT	ANGLE HI REJECT
7 TIME 1 REJECT	TIME 1 REJECT	ANGLE LO REJECT	ANGLE LO REJECT
8 TIME 2 REJECT	TIME 2 REJECT	RATE 1 HI REJECT	RATE 1 HI REJECT
9 ABNORMAL	ABNORMAL	RATE 1 LO REJECT	RATE 1 LO REJECT
10 WORK SELECT 0	WORK SELECT 0	RATE 2 HI REJECT	RATE 2 HI REJECT
11 WORK SELECT 1	WORK SELECT 1	RATE 2 LO REJECT	RATE 2 LO REJECT
12 WORK SELECT 2	WORK SELECT 2	SPINDLE ERROR 0	SPINDLE ERROR 0
13 WORK SELECT 3	WORK SELECT 3	SPINDLE ERROR 1	SPINDLE ERROR 1
14 NOT USED	NOT USED	SPINDLE ERROR 2	SPINDLE ERROR 2
15 NOT USED	NOT USED		
16 NOT USED	NOT USED		
17 NOT USED	NOT USED		
18 NOT USED	NOT USED		
19 NOT USED	NOT USED		
20 NOT USED	NOT USED		
21 NOT USED	NOT USED		
22 NOT USED	NOT USED		
23 NOT USED	NOT USED		
24 NOT USED	NOT USED		
25 NOT USED	NOT USED		

O: OPEN
S: SHORT TO COMMON

NOTICE OF PROPRIETARY RIGHTS
The design concepts and engineering data contained in this drawing are the property of FCI, Inc. and are not to be disclosed, copied, or used in any manner without the prior written permission of FCI, Inc.

DATE	BY	DESCRIPTION
10/19/00	MC	REVISION 1
10/19/00	MC	REVISION 2
10/19/00	MC	REVISION 3
10/19/00	MC	REVISION 4
10/19/00	MC	REVISION 5