

# Indexer Electrical Connections

## M-Function

We use industry standard M-function relay, wiring and signal protocols.

The indexer finish relay is normally open by default. This can be changed in the menu setup.

Pin definitions on the circular DIN connector:

- **DO NOT allow Red and Green wires to touch.**
- **Only touch Black +24 volts to White to test cycle start.**

Pin 1	Red	Servo Control Finished relay
Pin 2	Green	Servo Control Finished relay
Pin 3	Black	CNC Start Relay (+24 Volts out from Servo Control)
Pin 4	White	CNC Start Relay (Cycle Start on Servo Control)

The CNC M-function start signal will be wired to the N/O relay coil.

Use a voltage meter to measure across the Black and White relay terminals:

24VDC when the relay is open.

0VDC when the relay is closed (Indexer will start).

