



Refer to the following table when connecting the Powermax system to a torch height controller or CNC controller with a machine interface cable.

Signal	Type	Notes	Connector sockets	Cable wires
Start (start plasma)	Input	Normally open. 18 VDC open circuit voltage at START terminals. Requires dry contact closure to activate.	3, 4	Green, black
Transfer (start machine motion)	Output	Normally open. Dry contact closure when the arc transfers. 120 VAC/1 A maximum at the machine interface relay or switching device (supplied by the customer).	12, 14	Red, black
Ground	Ground		13	
Voltage divider	Output	Powermax45: Divided arc signal of 50:1 (provides a maximum of 7 V) Powermax65/85: Divided arc signal of 20:1, 21.1:1, 30:1, 40:1, 50:1 (provides a maximum of 18 V).	5 (-), 6 (+)	Black (-), white (+)