

TB2 PIN	I/O	System	28A1 relay board	Ribbon cable wire	Test Point	Relay	HAL Pin	connects to
1	INPUT16	NC-Start	28X2-2	3				
2	INPUT17	E-Stop	28X2-4	7		19K1	hm2_5i25.0.7i84.0.0.input-17-not	E-stop.EXT
3	INPUT18	Indramat Ready	28X2-6	11				
4	INPUT19	Machine spindle stopped	28X2-23	8				
5	INPUT20	Spindle and Feed stop	28X2-24	10				
6	INPUT21	Tool height probe						motion.probe-input
7	INPUT22							
8	INPUT23							
9	INPUT24	Select X Axis						
10	INPUT25	Select Y Axis						
11	INPUT26	Select Z Axis						
12	INPUT27							
13	INPUT28							
14	INPUT29							
15	INPUT30							
16	INPUT31							
17	OUTPUT8	Machine is on	28X1-2	3		19K1	hm2_5i25.0.7i84.0.2.output-08	machine-is-on
18	OUTPUT9	Tool Release	28X1-7	13		5K2		gmocccapy.toolchange-change
19	OUTPUT10	Coolant on M8	28X1-19	37	12	2K2	hm2_5i25.0.7i84.0.2.output-10	
20	OUTPUT11	Spindle CW M3	28X1-17	33	10	1K9		
21	OUTPUT12	Spindle CCW M4	28X1-18	35	11	1K10		
22	OUTPUT13	Main spindle on	28X1-16	31	9	1K8		
23	OUTPUT14							
24	OUTPUT15							