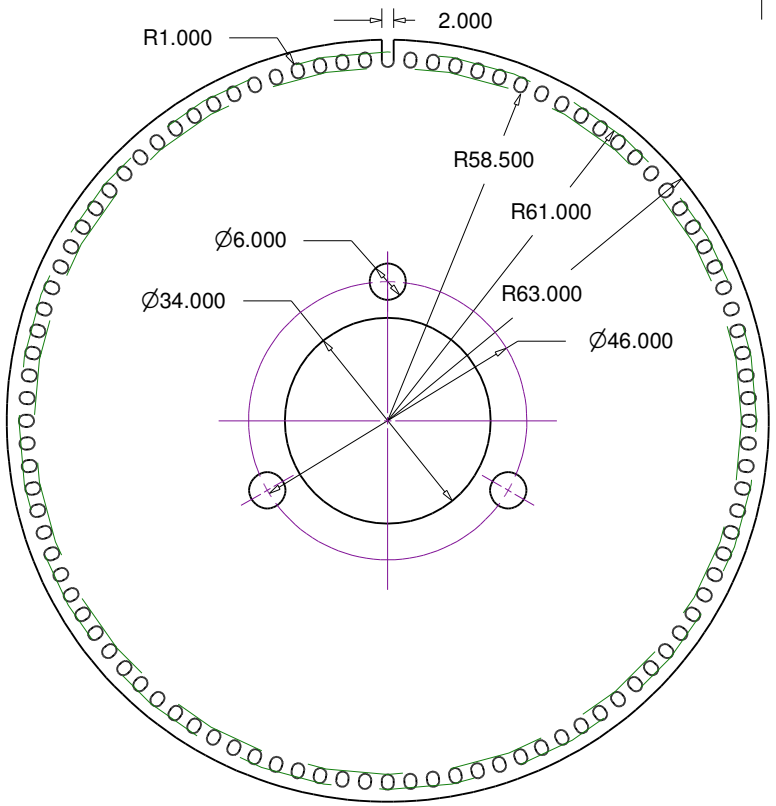
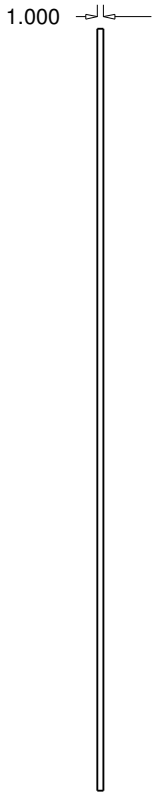
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



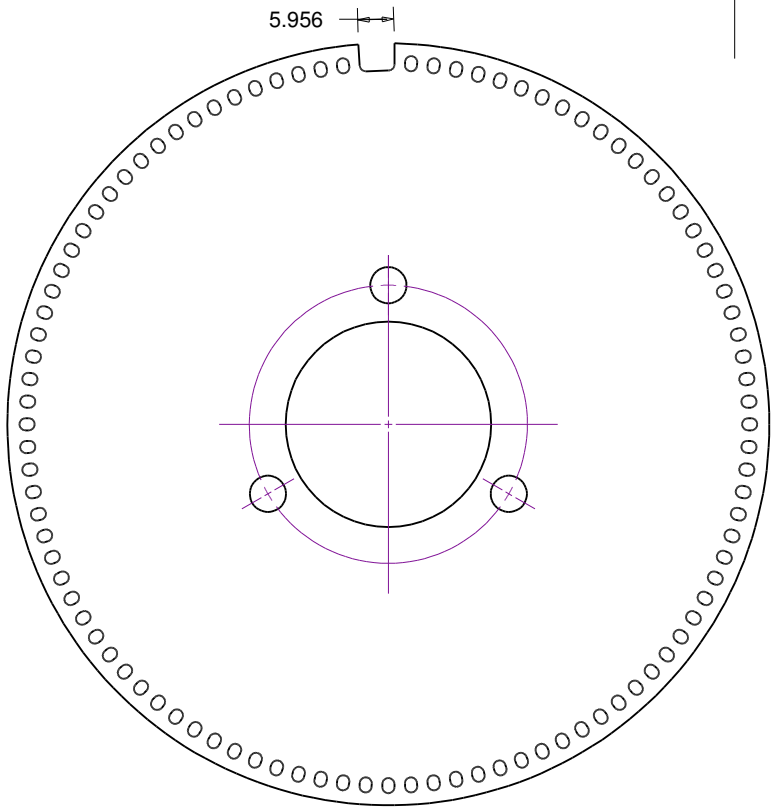


	DRAWN OBH	DATE 6 Oct 2016	EMCO Compact 5 PC Update
	CHECKED		**EMCO** **A6A 000 100 Timing Disk**
	QA		
	MFG		
	APPROVED		

SIZE	FSCM NO.	DWG NO.	REV
A		DWG NO.	

SCALE		SHEET
1:1.25		1 of 3

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



Excerpt from MACH3 Turn manual regarding Index slot width:

Suppose the maximum speed of your spindle is *N* (rpm).
The slot angle required *alpha* (degrees) is given by
alpha = 0.0012 x *N*
If the diameter of the disc is *D* (inches or mm) then the slot width *W* (in same units) will be approximately
W = 0.0088 x *alpha* x *D*

So for example if maximum spindle speed is 3000 RPM and disc diameter is 110 mm then:
Alpha = 0.0012 x 3000 = 3.6o
Slot width = 0.0088 x 3.6 x 110 = 3.48 mm
Big slot needs to be 50% wider = 3.48 x 1.5 = 5.22 mm

Slot with needed for Compact 5 - Modification to timing disk

Max RPM (N) = 2,800
Disk diameter (D) 126mm

Alpha = 0.0012 x N (2800) = 3.36 degrees
Slot Width (W) = 0.0088 x 3.36 x 110 = 3.25mm

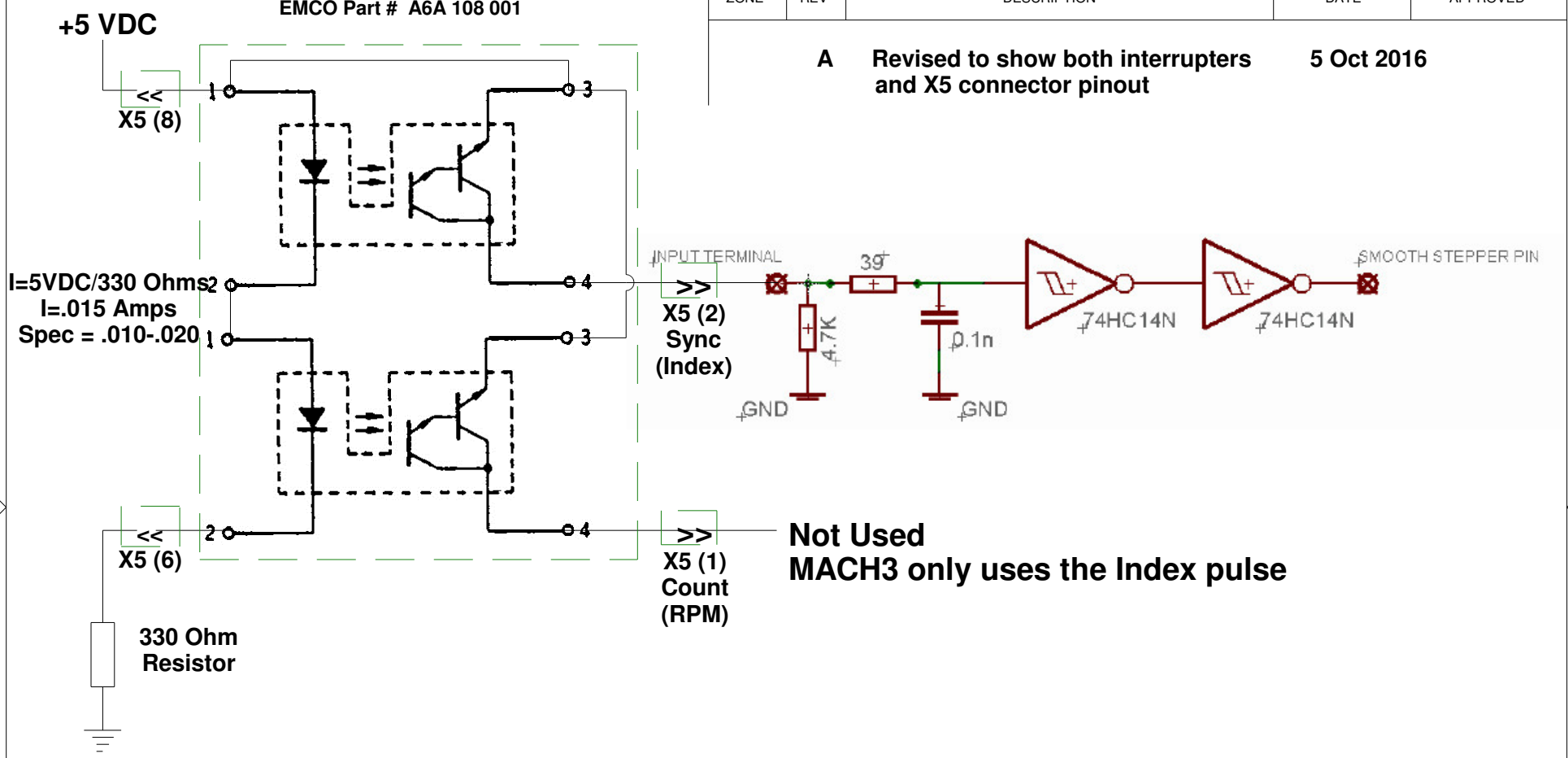
Slot needs to be 50% wider or 3.25mm x 1.5 = 4.875mm

Removing the area shown will give a slot width of about 6mm

	DRAWN OBH	DATE 6 Oct 2016	EMCO Compact 5 PC Update
	CHECKED		**Modified EMCO A6A 000 100 Timing Disk**
	QA		
	MFG		SIZE A / FSCM NO. / DWG NO. DWG NO. / REV
	APPROVED		SCALE 1:1.25 / SHEET 2 of 3

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	Revised to show both interrupters and X5 connector pinout	5 Oct 2016	

NEC PS4001 Photo Interrupters
EMCO Part # A6A 108 001



Not Used
MACH3 only uses the Index pulse

	DRAWN: OBH	DATE: 6 Oct 2016	EMCO Compact 5 PC Update
	CHECKED		**Photo Interrupter Wiring**
	QA		
	MFG		SIZE: A; FSCM NO.; DWG NO.: DWG NO.; REV
	APPROVED		SCALE: None; SHEET: 3 of 3