

19X7	Inputs	Color			
19X7-1	Handwheel X	ws	white	278	
19X7-2	Handwheel Y	br	brown	279	
19X7-3	Handwheel Z	gn	green	280	
19X7-4	24V (αυτο είναι ένδειξη)	ge	yellow	200	
19X7-5	Spindle OFF	gr	gray	211	
19X7-6	/ (Spindle Feed Stop)	rs	orange	212	
19X7-7	Lubricant Pump Feedback	bl	blue	213	
19X7-8	No Function	rt	red		
19X7-34		sw	black		

19X6	Outputs	Color			Relay
19X6-1	X Axis Handwheel Clutch	ws	white	28A1-3	28A1-K2
19X6-2	Y Axis Handwheel Clutch	br	brown	28A1-4	28A1-K3
19X6-3	Z Axis Handwheel Clutch	gn	green	28A1-5	28A1-K4
19X6-4	Spindle CW	ge	yellow	28A1-14	28A1-K6
19X6-5	Spindle CCW	gr	gray	28A1-28	28A1-K7
19X6-6	Coolant Pump	rs	orange	28A1-29	28A1-K8
19X6-7	Tool Release	bl	blue	28A1-30	28A1-K9
19X6-8	Central Lubrication	rt	red	313	4V1 / 4K1
19X6-9	No Function				
19X6-34	/ ESTOP	sw	black	28A1-2	28A1-K1

19X4	Setpoint	Color		
19X4-1	X Axis	br	brown	E101
19X4-2	X Axis	bl	blue	E102
19X4-3	Y Axis	ws	white	E201
19X4-4	Y Axis	gr	green	E202
19X4-5	Z Axis	ge	yellow	E301
19X4-6				
19X4-7				
19X4-8				
19X4-9	Z Axis	rs	rs	E302

28A1	Relay Board
K1	Emergency Stop Switch
K2	X Axis Handwheel Clutch
K3	Y Axis Handwheel Clutch
K4	Z Axis Handwheel Clutch
<b>K5</b>	
K6	Main Drive Anti-Clockwise
K7	Main Drive Left Rotation
K8	Release Tool Clump
K9	Lubricant Pump
<b>K10</b>	