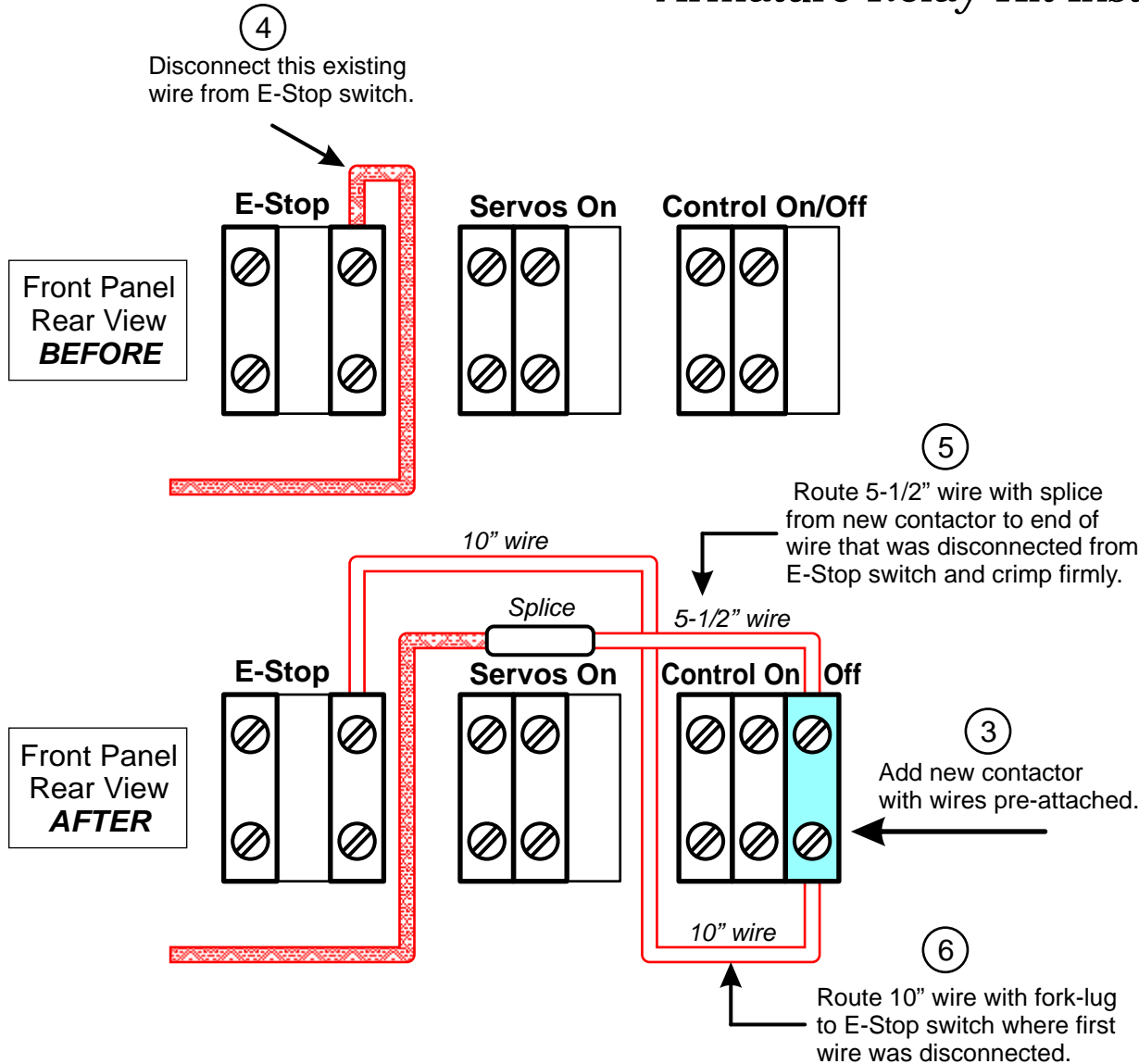


## Armature Relay Kit Installation: Front Panel

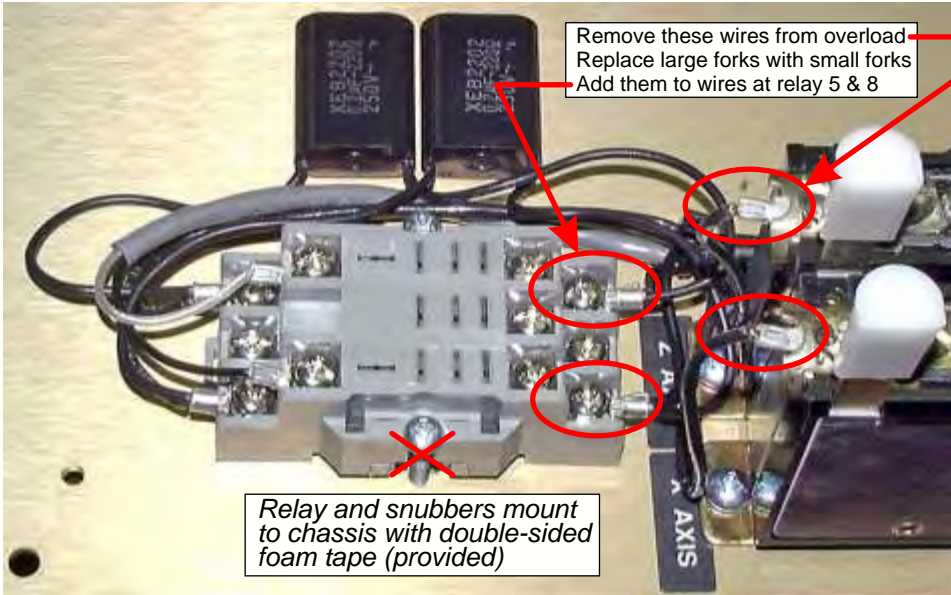


### Front Panel Modification:

1. Insure that power is off.
2. Remove cover from CNC.
3. Examine Control ON/OFF switch:
  - 3a. If there are contact blocks as shown on lower picture, *with wires on all 6 terminals*, no Front Panel Modification is necessary. Proceed to page 2 for relay installation.
  - 3b. If there is a contact block on the right side *with no wires attached*, put the 5-1/2" wire with splice on top terminal, and put 10" wire on bottom terminal as shown in lower picture. Go to step 4.
  - 3c. If there is *no contact block at right*, you must replace the switch assembly. Label the wires on the existing switch or take a picture with your phone before removing them. Replace the switch and reconnect the wires. Go to step 4.
4. Disconnect existing red wire from the E-stop switch as shown.
5. Insert this wire into splice on 5-1/2" wire coming from top of new contact block. Use crimper to secure splice.
6. Route 10" wire from new contact block to terminal on E-Stop switch.

This completes the Front Panel Modification. Proceed to page 2 for relay installation instructions.

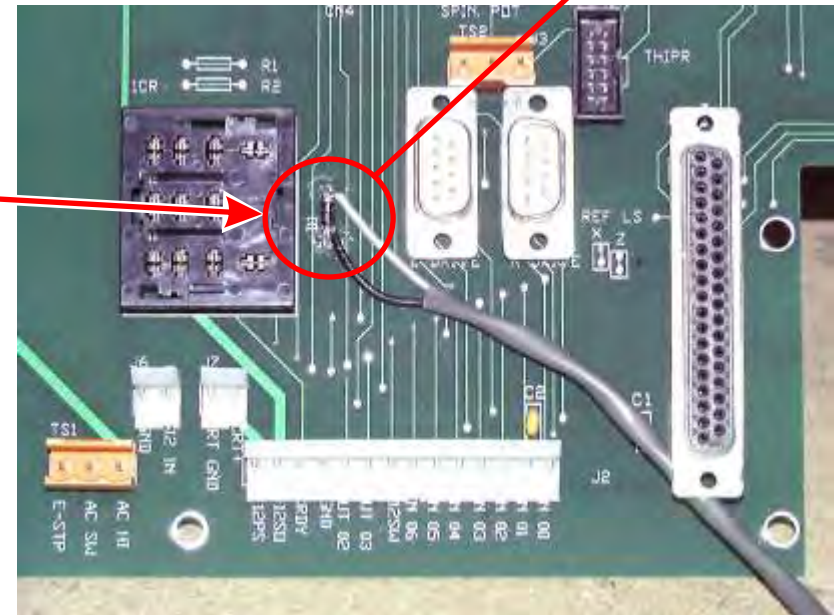
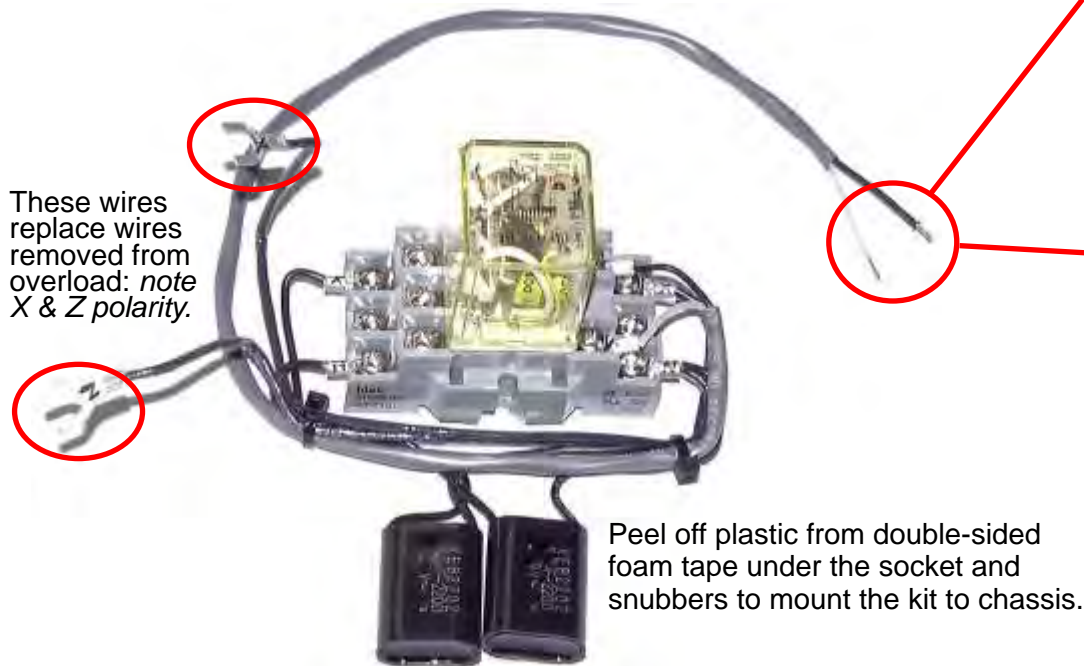
## Armature Relay Kit Installation: Chassis

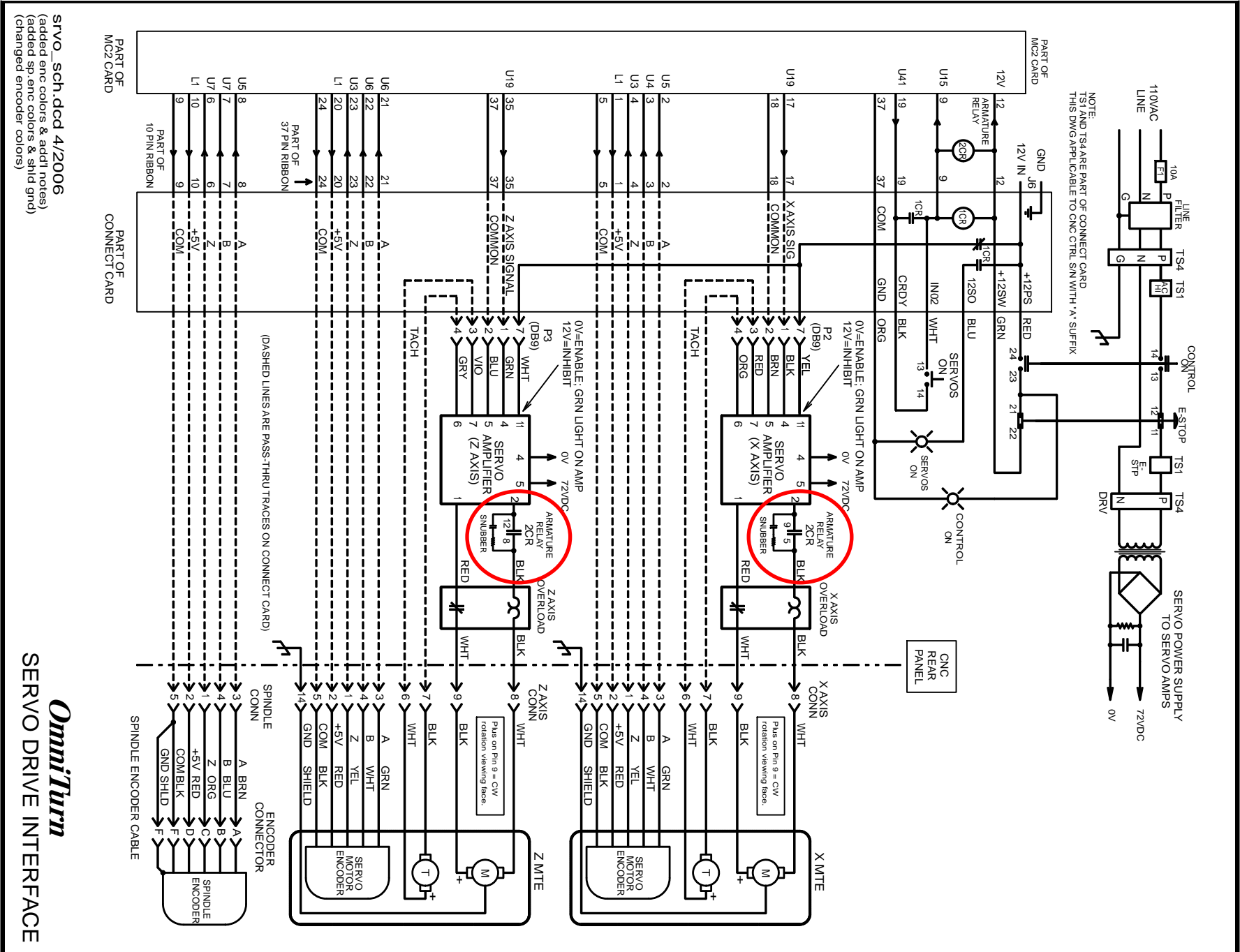


### Refer to photo at left:

Disconnect the original connections to the two overloads. Cut the large fork-terminals off, strip wires 1/4", install small fork-terminals (supplied), then **add** them to wires at relay at pins 5 & 8. **INSURE** that wire which was on X-Axis overload (outboard) goes to Pin 5 and wire which was on Z-Axis overload (inboard) goes to Pin 8. *Do not remove existing wires connected to Pins 5 & 8 of relay.*

Solder these two to D1 on connect card with clear wire to band, and black at opposite end, as shown here.





srvo\_sch.dcd 4/2006  
(added enc colors & addl notes)  
(added sp enc colors & shld gnd)  
(changed encoder colors)

**OmniTurn**  
SERVO DRIVE INTERFACE