



NOTES

1. PLC'S ARE NORMALLY SHIPPED WITH ALL OUTPUT COMMONS TIED TOGETHER. SEPARATE COM2 FROM THE OTHERS.
2. WIRE COLLET P/S SO CONTACT CLOSSES WHEN COLLET IS CLOSED. SET PARAMETER #0 TO 0 ON BARFEEDER.
3. CONNECT THESE WIRES TO INTERLOCK TERMINALS (REMOVE EXISTING JUMPER at TB1-26/TB1-27)
4. BREAK SPINDLE OFF/AUTO WIRE AND SPLICE THESE IN (BLU? wire at TB1-4).

**PLC to Barfeeder Interface 4/99
OmniTurn**