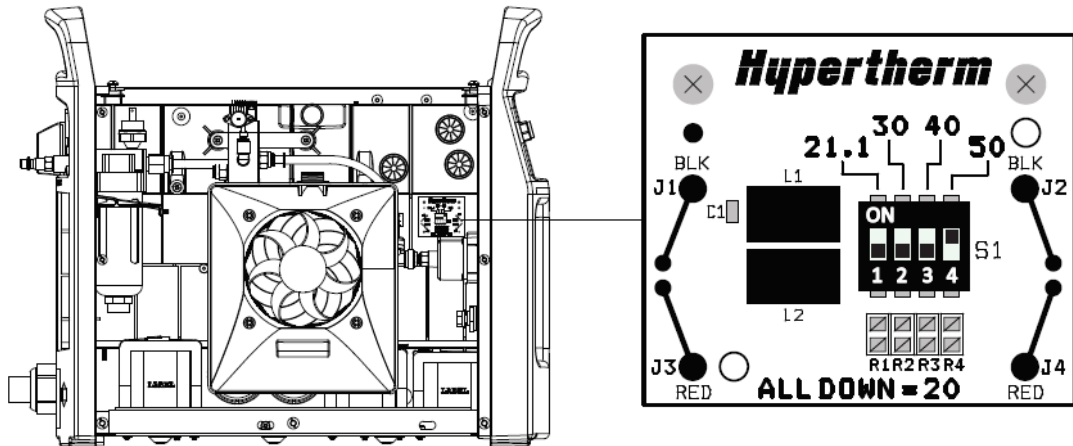




- **Connect wires;**

Signal	Type	Notes	Connector sockets	cable wires
Start (start plasma)	Input	Normally open. 18 VDC open circuit voltage at START terminals. Requires dry contact closure to activate.	3	Yellow
			4	Brown
Transfer (start machine motion)	Output	Normally open. Dry contact closure when the arc transfers. 120 VAC/1 A maximum at the machine interface relay or switching device (supplied by the customer).	12	
			14	
Voltage divider	Output	Divided arc signal of 20:1, 21.1:1, 30:1, 40:1, 50:1 (provides a maximum of 18 V).	5 (-)	White
			6 (+)	Green
Ground	Ground		13	

- Set S1 in right position. Most used is 50:1;



Set the DIP switches to one of the following settings and replace the power supply cover.

