

N003 G01 X100 Y100 F1500 Linear Interpolation
 N004 M04 S200 Spindle spin counter clockwise at 200r/min
 N005 G04 K5 Delay 5s
 N006 G01 X50 F1500 Linear Interpolation
 N007 M05 Spindle stop
 N008 M51 Output port 1 is connected
 N009 M02 Program End
 (3) After finishing edition, press **Save**, then press **AUTO** and **Start** to run.

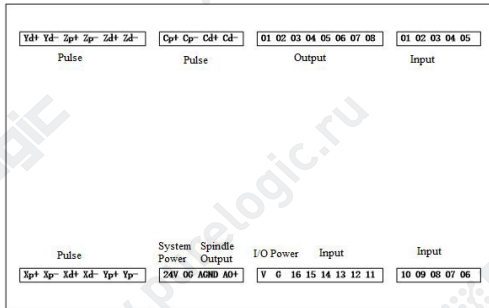
Spindle

S code is used to control the speed of the spindle, this controller use analog voltage controlling method to control spindle speed.
 Note: S code can not support power off memory.
 EX: N001 M03 S1000 Spindle spin clockwise at 1000r/min.

05

Wiring Diagram

TC55H Back View



Wiring Instruction

Xp+ — X axis pulse positive output
 Xp- — X axis pulse negative output
 Xd+ — X axis direction positive output
 Xd- — X axis direction negative output
 Yp+ — Y axis pulse positive output
 Yp- — Y axis pulse negative output
 Yd+ — Y axis direction positive output
 Yd- — Y axis direction negative output
 Zp+ — Z axis pulse positive output
 Zp- — Z axis pulse negative output
 Zd+ — Z axis direction positive output
 Zd- — Z axis direction negative output
 Cp+ — C axis pulse positive output
 Cp- — C axis pulse negative output

Cd+ — C axis direction positive output
 Cd- — C axis direction negative output
 01-08 (Output) — Output 01-08, Connect to power 24V+ through Relay or solenoid valve
 01-16 (Input) — Connect to power 24V-through machine or switch
 AGND — Analog Spindle Output 0-10V Positive
 AO+ — Analog Spindle Output 0-10V Negative
 24V — System Power Positive
 24G — System Power Negative
 V — I/O Power Positive
 G — I/O Power Negative