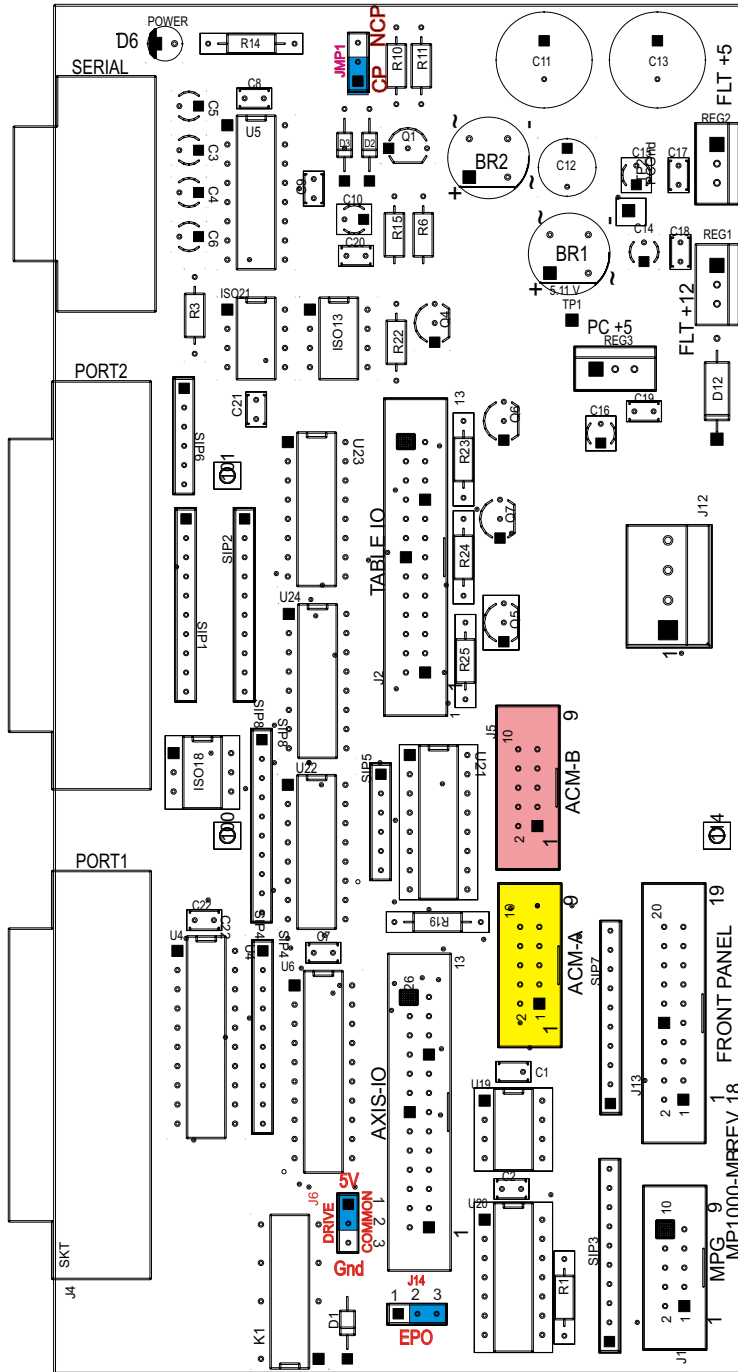


JUMPER DETAILS FOR MP1000 "B SERIES" cards

Jumpers shown in their default settings for operation with
CandCNC Power Control Units



For NON CandCNC power
Control Units jumper J14
to pins 1-2

All other jumpers stay in default condition

Move ACM cable from ACM-A to ACM-B
for NON-CandCNC Power Controllers

New Pin Assignments for MP1000B Series

MP1000B PinOuts

Port	Pin	Function	Notes	FOR
1	1	FP-DB9-8	PendOut	
1	2	Xstep	AxisIO-2	
1	3	Xdir	AxisIO-3	
1	4	Ystep	AxisIO-4	
1	5	Ydir	AxisIO-5	
1	6	Zstep	AxisIO-6	
1	7	Zdir	AxisIO-7	
1	8	Astep	AxisIO-8	
1	9	Adir	AxisIO-9	
1	10	E-Stop	input	
1	11	Xhome	TableIO-14	
1	12	Yhome	TableIO-15	
1	13	Zhome	TableIO-16	
1	14	IO-2	TableIO-12	K2
1	15	Ahome	TableIO-17	
1	16	IO-3	TableIO-11	K3
1	17	IO-4	TableIO-10	K4
1	18	Gnd		
1	19	Gnd		

2	1	T-Relay	THCSensor-	
2	2	Limits	TableIO-1	
2	3	Feedhold	TableIO-2	
2	4	FP-SW-RUN	FP/MACH	ACM-A/B
2	5	FP-SW-STOP	FP/MACH	ACM-A/B
2	6	UP	Out	
2	7	DOWN	Out	
2	8	ARC Good	Out	
2	9	FP-DB9-7	MPGsw	
2	10	FP-DB9-5	MPGsw2	
2	11	FP-DB9-6	MPGa	
2	12	FP-DB9-2	MPGb	
2	13	FP-DB9-4	MPG2A	
2	14	IO-5	TableIO-9	K5
2	15	FP-DB9-9	MPG2B	
2	16	SpinDir		
2	17	CP		