



## IC/5 to MPI-16 Interface

**NOTE: Both the IC/5 and the MPI-16 must be programmed per their respective manuals.**

Interface cable for a turret with up to 16 positions using IC/5 outputs 5, 6, 7 and 8 for the position selections and IC/5 input 1 for the position feedback:

<b>MPI-16</b>		<b>IC/5 I/O Board #1</b>			
I/O PORT or TO CONTROLLER (MDC360) connector		INPUTS Connector 15 pin D		RELAYS Connector 25 pin D	
Function	Pin#	Function	Pin#	Function	Pin#
Pocket Select Input Bit 0	6			*RLY 5 NO	*4
Pocket Select Input Bit 1	7			*RLY 6 NO	*2
Pocket Select Input Bit 2	20			*RLY 7 NO	*1
Pocket Select Input Bit 3	18			*RLY 8 NO	*15
Inputs Common	1 or 13			*RLY 5 C	*5
Inputs Common	1 or 13			*RLY 6 C	*3
Inputs Common	1 or 13			*RLY 7 C	*14
Inputs Common	1 or 13			*RLY 8 C	*16
“In Position” Output	11	*Turret Input #1	*15		
Output Common	10	Input Ground	1		

### IC/5 Program Example

The items identified by \* in the table above depend on the IC/5 (Manual 074-237) parameter settings in the Source assigned to the MPI-16 (Manual 614800). The MPI-16 must be separately set up according to its manual.

In the IC/5 Source programming example shown below, output 5 is chosen as the first output of the four sequential outputs required for a turret with 16 crucibles. Likewise, three sequential outputs would be required for a turret with 8 crucibles (see also IC/5 manual Section 3, paragraph 3.6.2).

Input 1 is chosen to be the input which is activated (pulled low) by the MPI-16 “In-Position” output when the turret has reached the correct position.

Portion of IC/5 Source screen programmed to work with above cable:

```

Number of Crucibles      16      (1, 4, 8, 16, 32, 64)
Crucible Output         5       (0,1-37)
Crucible Output Type    0       (0=NO,1=NC)

Turret Feedback         YES     YES/NO
Turret Input           1       (0,1-28)
  
```