

<i>Pin Number J4 IDC connector</i>	<i>Pin Number DB25 Female</i>	<i>Printer Port Designation</i>	<i>Machine Function</i>	
J4-01	1	strobe	spindle speed	VFD speed (freq)
J4-03	2	data0	X axis direction	direction - motor 1
J4-05	3	data1	X axis step	step - motor 1
J4-07	4	data2	Y axis direction	direction - motor 2
J4-09	5	data3	Y axis step	step - motor 2
J4-11	6	data4	Z axis direction	direction - motor 3
J4-13	7	data5	Z axis step	step - motor 3
J4-15	8	data6	A axis direction	direction - motor 4
J4-17	9	data7	A axis step	step - motor 4
J4-19	10	ack	limit x	home and reference
J4-21	11	busy	limit y	home and reference
J4-23	12	paper end	limit z	home and reference
J4-25	13	select out	accessory input	probe, A limit, tool touch
J4-02	14	auto feed	coolant on	auto coolant on
J4-04	15	error	machine ready	Estop reset
J4-06	16	init	spindle direction	spindle direction
J4-08	17	select in	controller ready	watchdog / charge pump
J4-10	18	ground		
J4-12	19	ground		
J4-20	20	ground		
J4-14	21	ground		
J4-16	22	ground		
J4-18	23	ground		
J4-22	24	ground		
J4-24	25	ground		
J4-26		no connection		

Signals are active high
 X, Y, and Z are 10000 steps per inch
 A is 500 steps per degree
 spindle is frequency based, 10000 hz max (1750 or 4500 RPM)