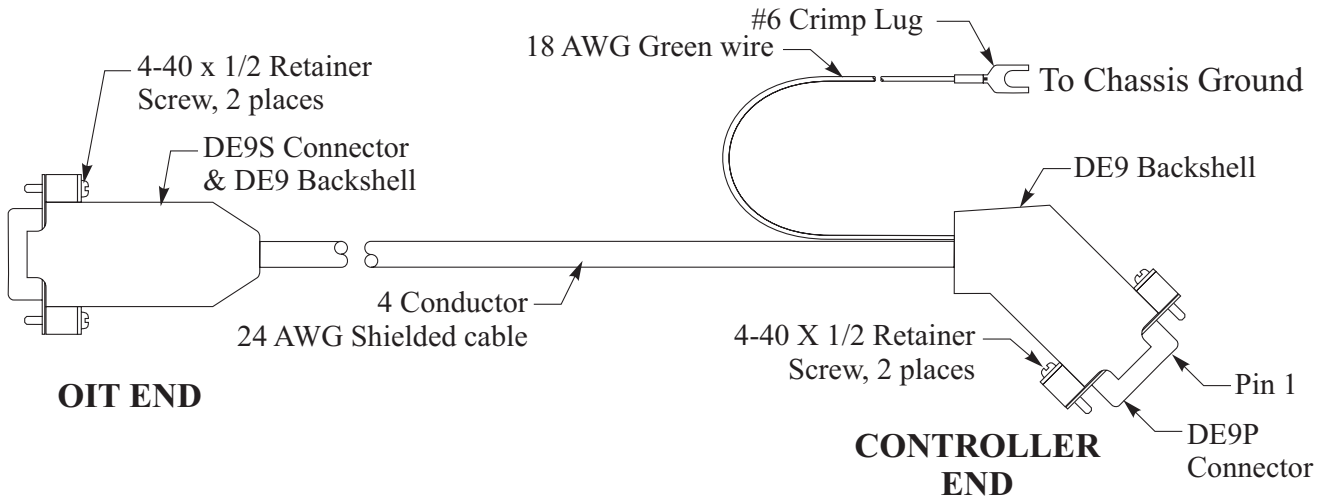


Controller Model: **International Parallel Machines IP3416**

Maple OIT Model: **Blue Series**

Communication Type: **RS-232 with DE9 connector at Controller**

Use the wiring diagram and illustration to assemble a communication cable for use with an International Parallel Machines IP3416 controller.



**NOTES:**

- 1) Twist together 18 AWG green wire and shield wire. Solder wires and insulate with heatshrink to avoid shorting.
- 2) Solder shield wire to the DE9S connector metal shell. Install heatshrink tubing over the shield wire to avoid shorting.

