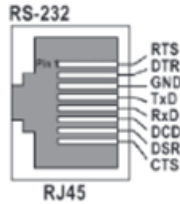


Full Handshaking wiring diagrams

Control HUB (RJ45)

- 1 Rts
- 2 Dtr
- 3 Gnd
- 4 Tx
- 5 Rx
- 6 Dsr
- 7 Dcd
- 8 Cts

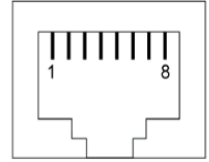


CNC Machine (DB25)

- 1 (shield)
- 5
- 6 & 8
- 7
- 3
- 2
- 20
- 20
- 4

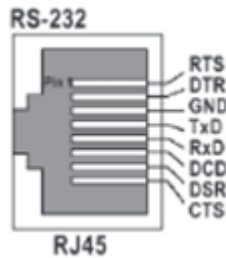
Moxa Pinout

- | Pin | RS-232 |
|-----|-----------|
| 1 | DSR (in) |
| 2 | RTS (out) |
| 3 | GND |
| 4 | TxD (out) |
| 5 | RxD (in) |
| 6 | DCD (in) |
| 7 | CTS (in) |
| 8 | DTR (out) |



Control HUB (RJ45)

- 1 Rts
- 2 Dtr
- 3 Gnd
- 4 Tx
- 5 Rx
- 6 Dsr
- 7 Dcd
- 8 Cts



CNC Machine (DB9)

- 8
- 6 & 1
- 5
- 2
- 3
- 4
- 4
- 7

Typical RJ45 adapter from Digikey color code:

RJ45	Color	Control DB25	Moxa DB25
1	Blue	5	20
2	Orange	6&8	5
3	Black	7	7
4	Red	3	3
5	Green	2	2
6	Yellow	20	20
7	Brown	20	4
8	White	4	6&8

Digikey part numbers:

- RJADK25P7080831-ND RJ45 to DB25 Male
- RJADK09S7080831-ND RJ45 to DB9 Female
- RJADK25S7080811-ND RJ45 to DB25 Female