Moxa to Fanuc CNC cable (with pigtail power leads)

Fanuc side (25-pin male)   Moxa side (9-pin female)

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gnd pin 1  -------------------- green -------------------------- V- pigtail

tx   pin 2  ------------------- orange ------------------- pin 2  rx

rx   pin 3  ------------------ white/orange ---------------- pin 3  tx

rts  pin 4  ------------------ white/green----------------- pin 6  dsr

cts  pin 5  ------------------ white/brown----------------- pin 7  rts

gnd pin 7  ------------------- blue----------------------- pin 5  gnd

dsr  pin 6  -------------------white/blue------------------- pin 4  dtr

dtr  pin 8  -------

+24 pin 25 -------------------- brown -------------------------- V+ pigtail
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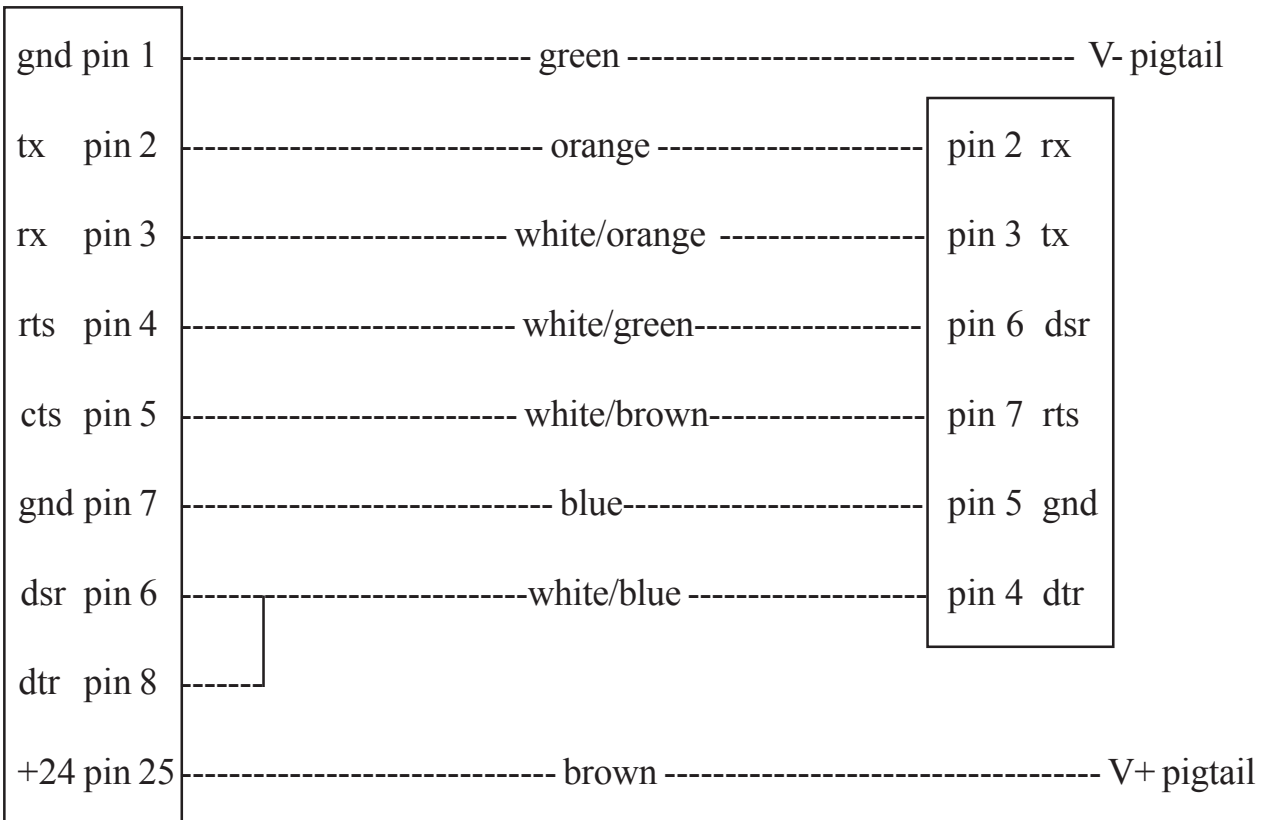
Important:

When connecting this cable to a Fanuc CNC control, you will find that the two screws on the 25-pin end are 4-40 and the holes on the Fanuc connector are tapped with a METRIC thread. It helps to have a 4-40 bottoming tap handy to "chase" the threads so the screws will thread in easily.

Also, run the two pigtail wires up UNDER the Moxa unit so they are protected, and attach them to the V+ (Brown) and V- (Green) terminal screws on the top of the Moxa.