- Power System Off.
- Remove Power Supply Module access panel.
- Disconnect cable from the back of the Laser Source.
- Route Laser Cable down through the access panel of the PS Module.
- Ensure all doors are closed.
- Using a multi-meter set to DC Voltage, check 12vDC at Pins 12 & 13 (use a paperclip as probe extensions, if meter probes are too thick for pins):
    - **Black** Lead - 12 (ground)
    - **Red** Lead - 13 (interlock in)
- Power System On and let it home. The interlock circuit is not enabled until the system is connected and homed.
- When all doors (top, front and laser cover) are closed and the interlock indicator led on the control panel of the system is solid red, the voltage between the pins should read approx. 12 volts.
- When any of the doors is opened and the interlock indicator led on the control panel of the system is blinking red, the voltage between the pins should drop to 0 volts.
- Acceptable voltage is 12vDC +/-.05v. If it out of range, contact Support at 480-609-0297 or support@ulsinc.com