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Safety notice

Please carefully read the manual before using the product. Here list some safety operation items, but they can't replace some safety operation rules from the country and the company.

Safety operation

Users must follow safety operation rules made by the country and the company.

Mechanical dangerousness

Operation and repair of automation equipment are a little dangerous and are careful. Please be far away from the working equipment. Please control the equipment by correctly using the panel's buttons. Don't wear so loose clothes when using and repairing the equipment.

High-voltage dangerousness

Be careful of electric shock during operation. Please install the equipment according to its manual. Don't touch cables or wires after power on. Only professional maintenance personal can open the controller. When the equipment has problems, power should be off and then repair.

Power isolation

Please check whether power is right ($AC220V \pm 15\%$).

You must need an AC stabilized-voltage power if power is beyond the above range.

In some places there is no normal power, such as zero line and ground line are together or no zero line, an isolation transformer must be used from 2-phase/3-phase AC380V to 2-phase AC220V.

A lightning rod is also a must.

Working environment

The controller's working temperature is 0-40 °C . If out of its working temperature, the controller probably works worse. If the temperature is below 0°C, the screen will not display normally.

Relative humidity is 0-85%.

Special protection is a must when working in high-temperature, high-humidity, and corrosive-gas environment. Don't ask dusts, metal chips and others to go into the controller.

Controller connection

The controller's input/output uses DC24V power (3A or over 3A) and the power can't be used for other electrical equipment. When the power is not connected and emergent stop and limit position are both valid, the controller will in the state of emergent stop and limit position.

The connection line between the controller and the driver should be shielding wire.

Don't plug in and plug out when power on.

Controller's input/output line should connect well.

Good ground-connection

All parts of the cutting machine and the controller should connect ground.

The most effective method of reducing plasma interference is to use shielding wire and good ground-connection.

Controller's ground wire diameter should be over 4 mm² , and try to keep a shorter distance to the ground.

DC24V ground (-) must break with ground.

Controller protection

Don't ask dusts, metal chips and other materials to go into the controller so that it can't normally work.

The controller's LCD screen should be protected.

Others

The controller can use U disk and its format is FAT or FAT32

The controller has a manual.

If the controller damages because of abnormal operation, we are not responsible for maintenance.

Controller operation and maintenance

Only professional operators can use the controller.

Controller operation

Please use fingers to press buttons.

Please don't change functions and parameters at random if you are not familiar with them.

Please feel free to let us know problems during operation.

Controller maintenance

When the controller can't work normally, you need to check relative hardware or wire connection after power off.

Don't open the controller to repair without professional personnel.

Please feel free to let us know when the controller has problems.

Declaration

Controller guarantee instruction

Guarantee period: within 12 month after leaving our company.

Guarantee terms: during guarantee period any problems under normal operations.

During guarantee period, we charge for out of guarantee terms.

We charge for all problems out of guarantee period.

Following situations are beyond guarantee:

Any damage under abnormal operation or accident damage;

Damaged by plug in and out of the controller when power on;

Natural disasters;

Repair, disassemble, retrofit, etc. at random without our allowance.

Chapter 1 controller general introduction

Basic parameters

Processor: industrial ARM chip

Display: 15" true color LCD

Input/output: 32 optoelectronic isolation input, 24 optoelectronic isolation output

Communication: RS232 X 2, USB X 1, 485 X 1

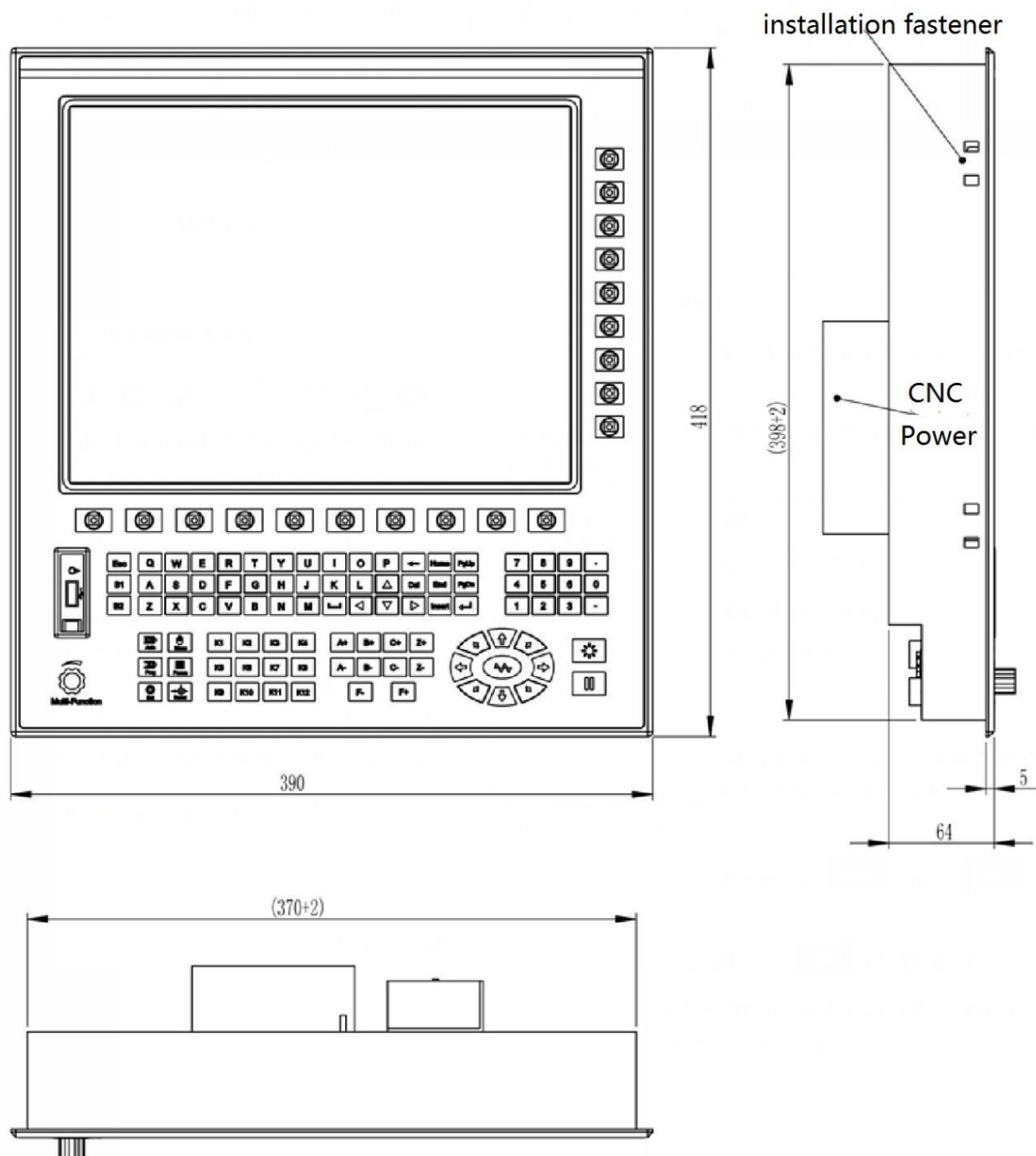
Pulse equivalence: electronic gear numerator, denominator set range: 1 ~ 65535

Store space: 4G

Working temperature: 0°C ~ +40°C

Store temperature: -40°C ~ +60°C

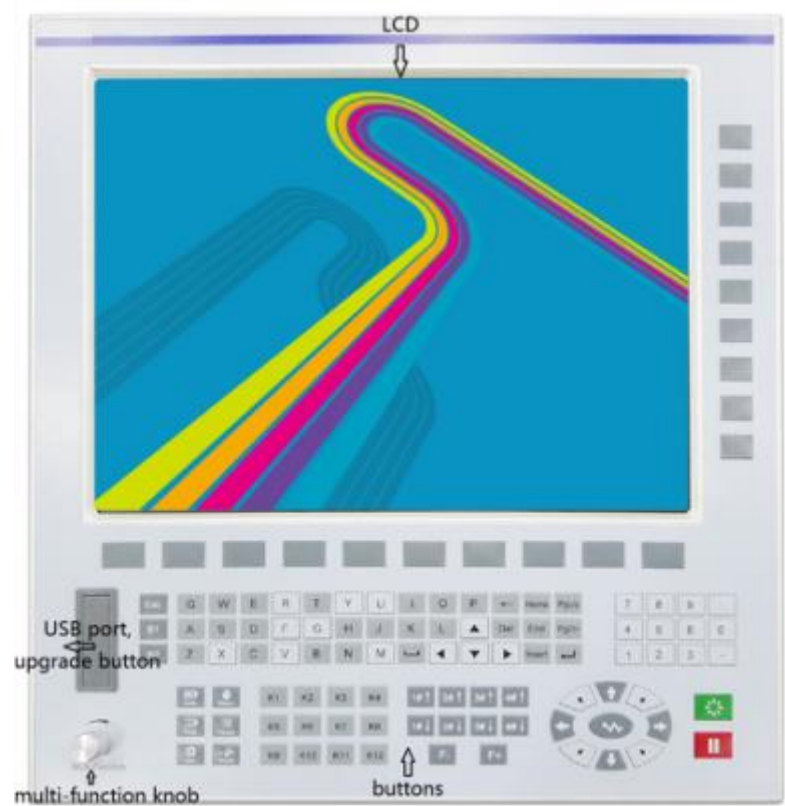
1-1 installation dimension



1-2 display

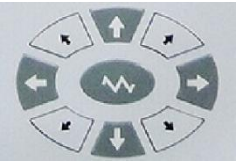
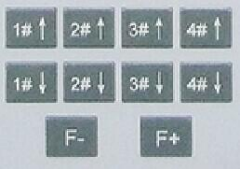
15" true color LCD, resolution 1024*768.

CNC front panel



1-3 keys

	Function keys The specific function is up to the interface display.
	Cursor movement keys
	Edit keys Fast operation: 1, when revise values, press , press  again, can clear back numbers 2,  to confirm and line feed 3, when preview figure, [X] zoom out, [Y] zoom in, [G] restore, move figure by edit direction keys

	4, [Del] delete, [Ins] insert, [Home] line head, [End] line end, [PgUp] pageup, [PgDn] pagedown
	Manually open or closed external switches
	Direction keys Manually move torch  change manual multiplying power, 10% or 80%
	Speed adjustment, torch up/down keys Up/down keys separately control 4 torches [F+]: speed up, [F-]: speed down
	Start/Pause keys When preheat delay,  prolong delay,  skip delay

Press the same key, multi-choice display in cycle

Section	Display “pierce point” and “line number” in cycle, automatically tip input range
Breaking point	Display three breaking points in cycle, start with the latest breaking point
Mirror	“X mirror”, “Y mirror” and “XY mirror” display in cycle
Return	“parts reference point” and “laser location point” (if set the parameter)

1-4 USB port



U disk is FAT or FAT32 format without several partitions, and small storage is better.

It's better to save parts program in U disk to CNC to cut and cover the port when cut in order to avoid dust.

“A” key is CNC upgrade button, turn on CNC after press it.

1-5 back panel

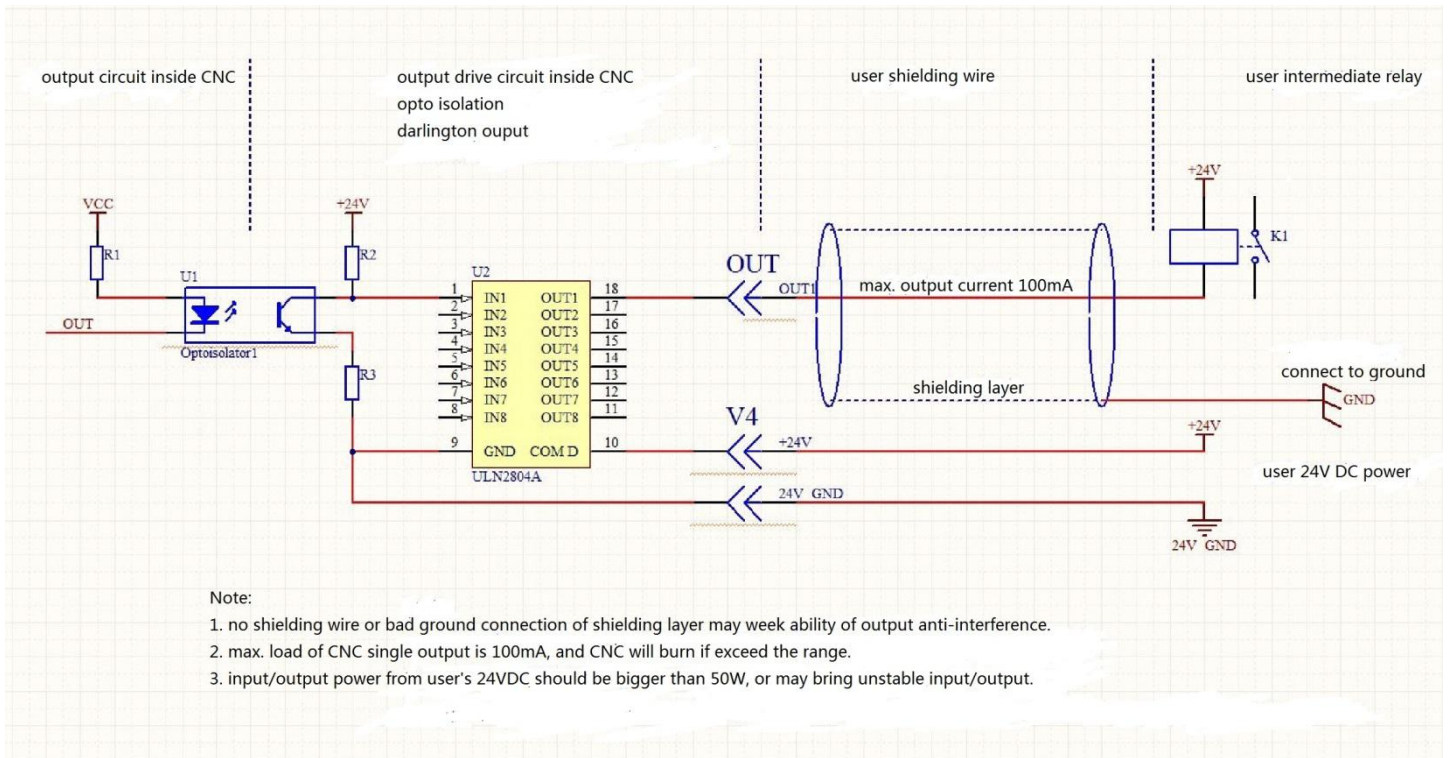
Input signal port X 4; Output signal port X 4; Communication signal port RS232 X 2

RJ4 net port X 1; Motor signal port X 3; Power supply port X 2;

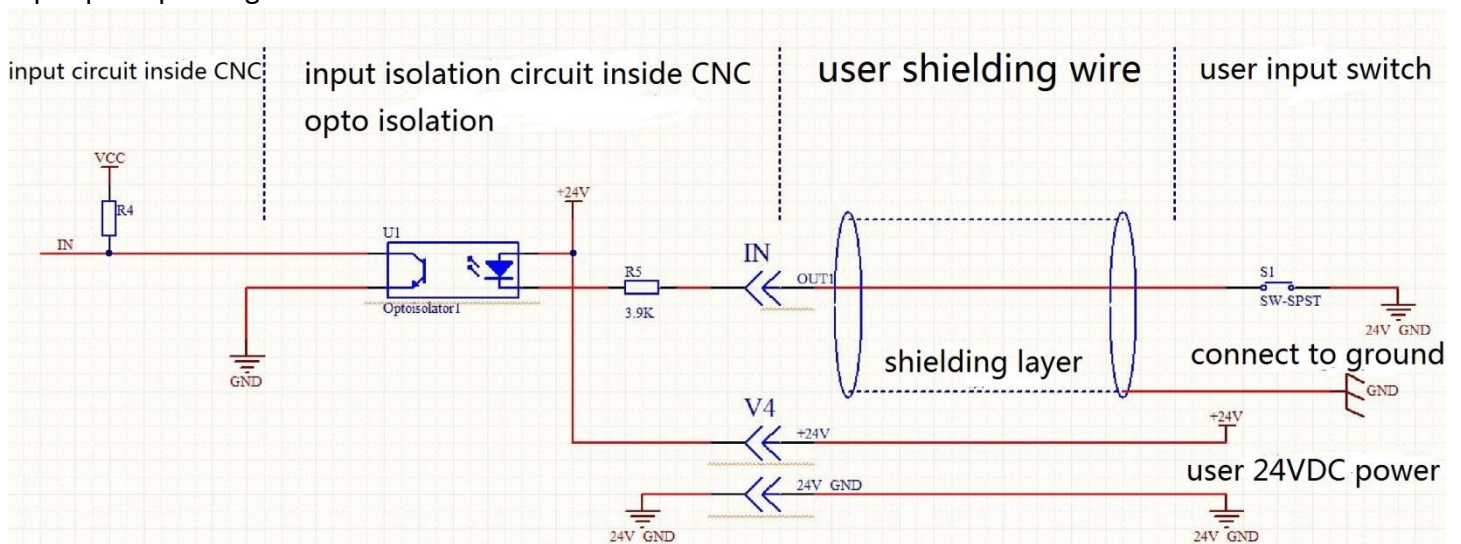
Note: 220V AC power for CNC connects the AC input port of the switch power supply.

1-6 signal port

Output principle diagram



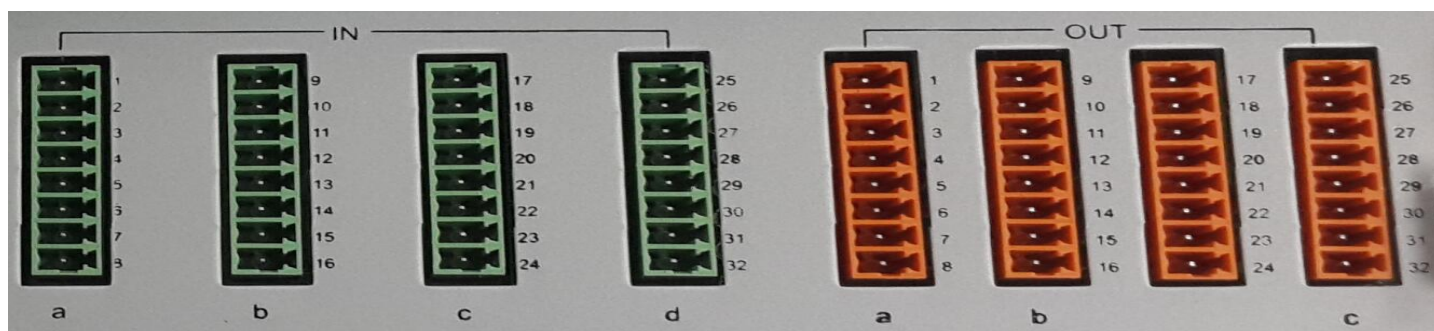
Input principle diagram



Note:

1. no shielding wire or bad ground connection of shielding layer may seriously reduce input anti-interference ability.
2. suggest to use normally-closed contact connecting to 24V ground to improve anti-interference ability.
3. whatever normally-open or normally-closed, must set normal state in parameter.
4. set unused input port to be invalid in paramter to improve anti-inteferece ability. Input/output power of 24VDC is bigger than 50W, or unstable.

Note: offer 24V DC power to CNC because itself needs at least 50W power.



Input signal port definition

Diagnose interface can check input port and change input port position and set input signal logic.

IN terminal	Signal definition	Instruction
1	Start	Connect external start switch
2	Pause	Connect external pause switch
3	Close	Connect external close switch
4	Alarm	Connect external alarm input signal
5	Torch Collision	Torch collision check
6	E-stop	Connect external e-stop switch
7	Arc strike success feedback	Connect plasma arc strike success signal
8		
9	X + limit	Connect X + limit switch
10	X – limit	Connect X - limit switch
11	X 0 point	Connect X 0 point switch
12	Y + limit	Connect Y + limit switch
13	Y - limit	Connect X - limit switch
14	Y 0 point	Connect Y 0 point switch
15		
16		
17	Z + limit	Connect Z + limit switch
18	Z - limit	Connect Z - limit switch
19	Z 0 point	Connect Z 0 point switch
20	Torch 1 in-position	Connect torch 1 in-position signal
21	Torch 2 in-position	Connect torch 2 in-position signal
22	Torch 3 in-position	Connect torch 3 in-position signal
23	Torch 4 in-position	Connect torch 4 in-position signal

Output signal port definition

Diagnose interface can check output port and change input port position and set input signal logic.

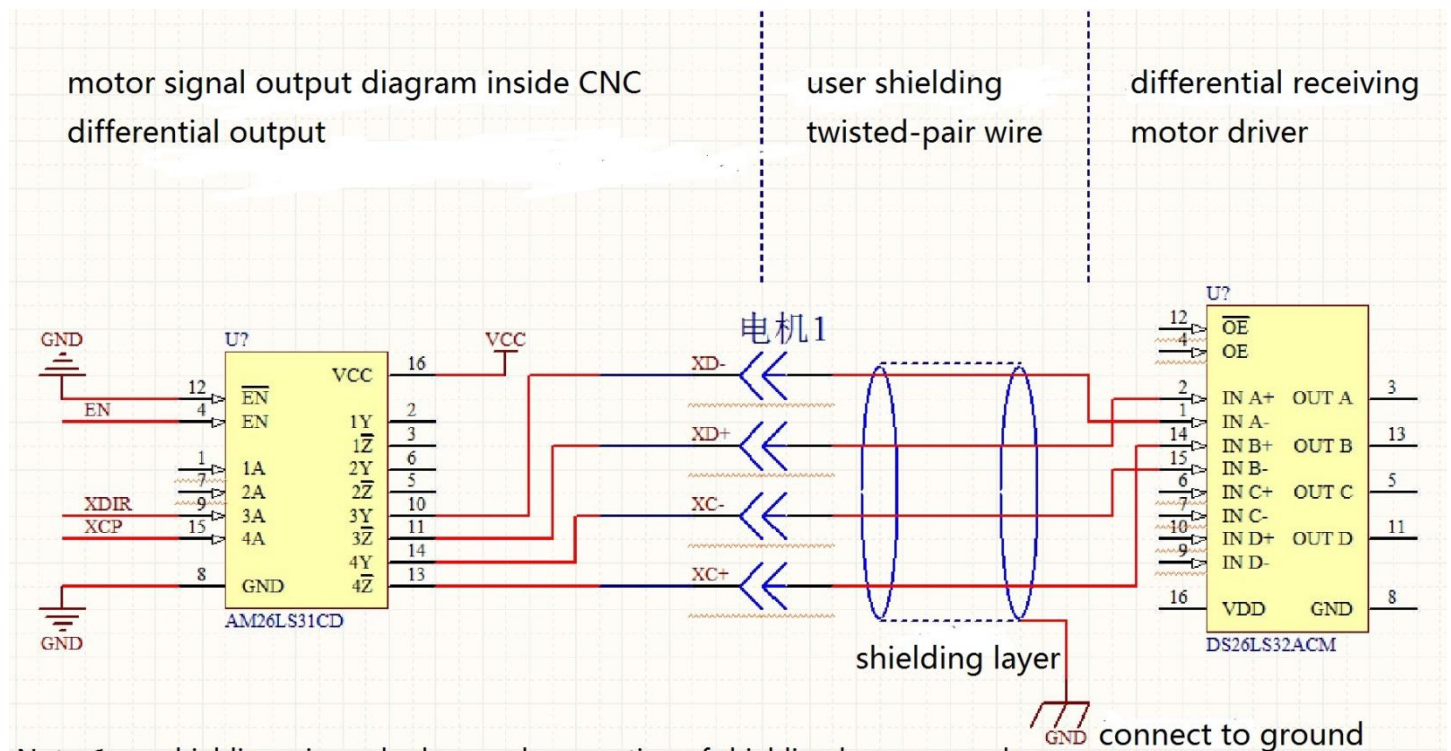
OUT terminal	Signal definition	Instruction
1	M10	Gas/preheat
2	M12	Cut oxygen/arc strike
3	M14	Torch 1 up
4	M16	Torch 2 down
5	M18	Low preheat
6	M20	ignition
7	M22	High preheat
8	M24	preheat
9	M36	Torch 2 up
10	M40	Torch 2 down
11	M32	Low oxygen

12	M34	Powder
13		Stir
14	M38	Height control
16	M42	Drill up
17	M44	Drill down
18	M46	Drill on
19		Torch 3 up
20		Torch 3 down
21		Torch 4 up
22		Torch 4 down
23		Arc strike
24		
25		Torch 1 enable
26		Torch 2 enable
27		Torch 3 enable
28		Torch 4 enable

CN2 port for remote control

Motor signal port

Differential signal driver connection principle diagram



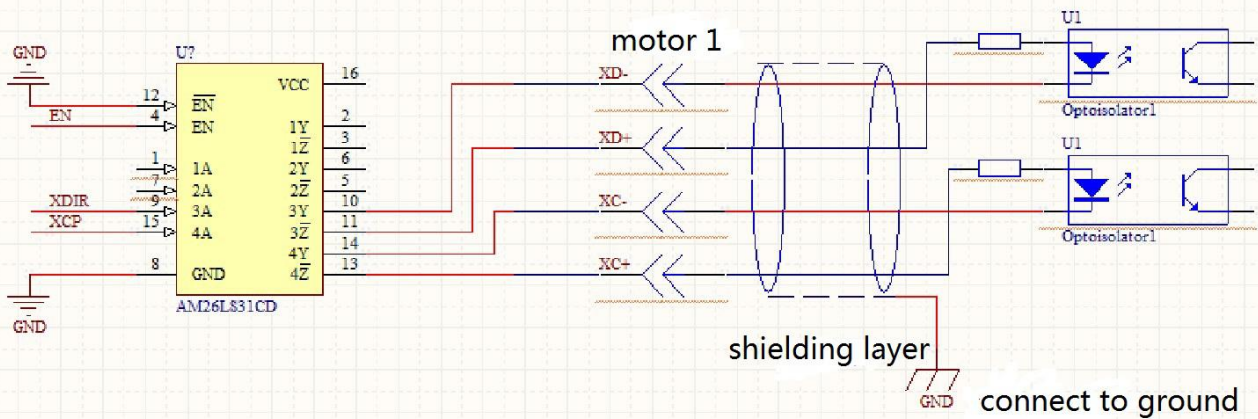
- Note: 1. no shielding wire or bad ground connection of shielding layer may reduce output anti-interference ability, please use shielding twisted-pair wire.
2. CNC motor signal is 5V, max. load of single output is 20mA, it will burn if exceed the range.
3. almost all servo and stepper drivers have differential receiving port and there is current-limiting diagram.

Optical coupler driver connection principle diagram

motor signal output diagram inside CNC
differential output

user shielding wire

optocoupler motor
driver

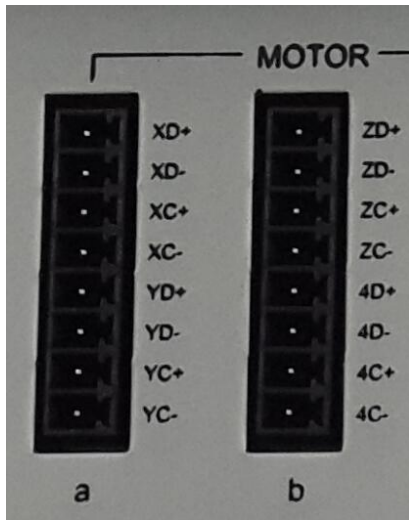


Note: 1. no shielding wire or bad ground connection of shielding layer may reduce output anti-interference ability.

2. CNC motor signal is 5V, max. load of single output is 20mA, it will burn if exceed range.

3. optocoupler driver usually has current-limiting diagram.

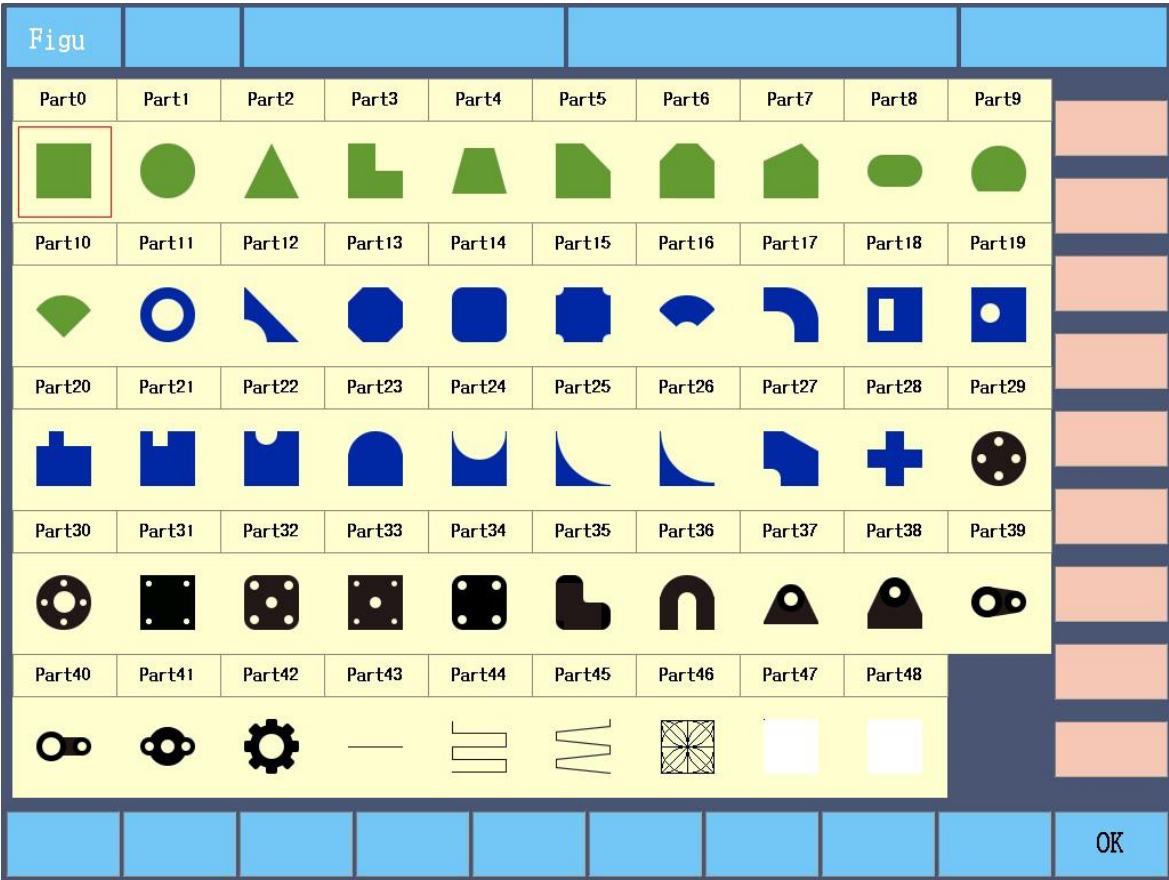
Motor signal port definition



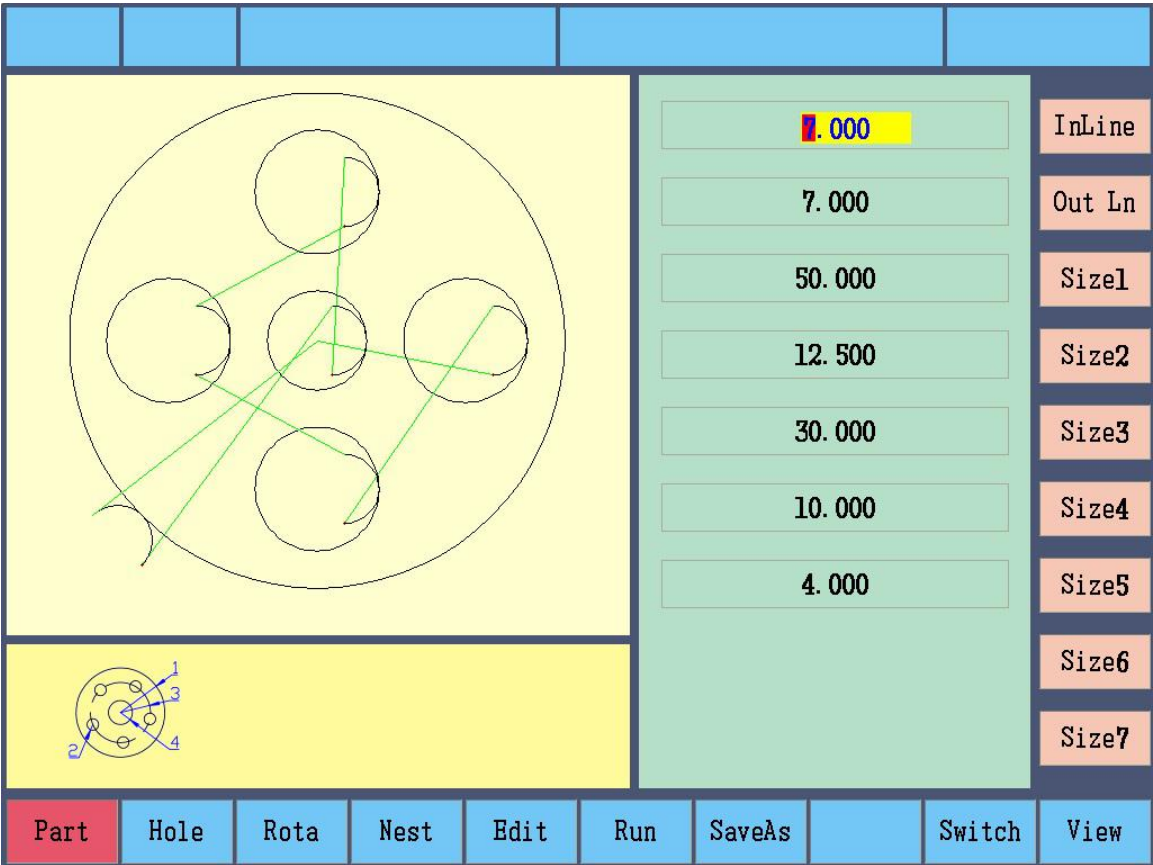
Signal definition	Instruction		Signal definition	Instruction	
XD+	1 st motor of X axis	Direction +	ZD+	2 nd motor of X axis	Direction +
XD-		Direction -	ZD-		Direction -
XC+		Pulse +	ZC+		Pulse +
XC-		Pulse -	ZC-		Pulse -
YD+	1 st motor of Y axis	Direction +	4D+	2 nd motor of Y axis	Direction +
YD-		Direction -	4D-		Direction -
YC+		Pulse +	4C+		Pulse +
YC-		Pulse -	4C-		Pulse -

Chapter 2 load parts

2-1 load from figure
Turn on CNC, press Figure



There are 47 common parts, choose by direction keys and then to confirm.



Press direction keys to choose parameters of parts, input values by number keys, then preview.

Part: set the figure as parts.

Hole: set the parts as hole type, some parts can't change inner/outer outline (can't change lead-in/out line direction).

Rota (rotate): input angle, positive number is anticlockwise, negative number is clockwise.

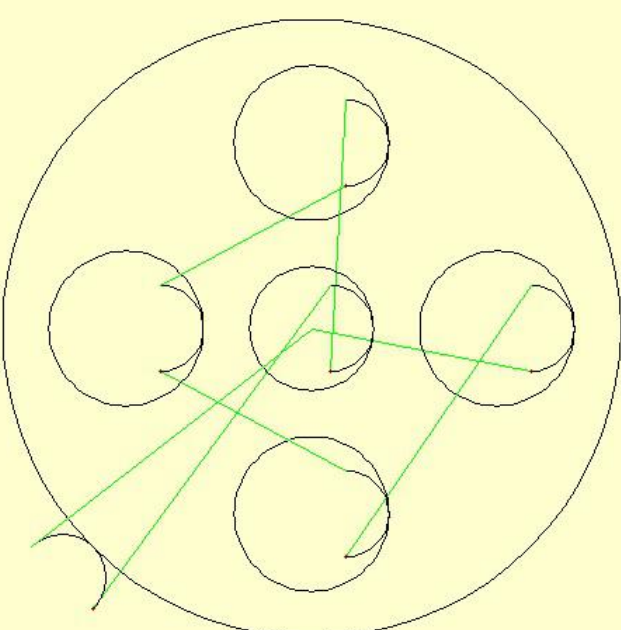
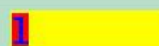
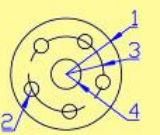
Nest: align parts.

Edit: load the parts program in the edit area.

Run: load the parts and enter auto cutting interface.

SaveAs: save current parts program.

F4 Nest: after set parts size, align the parts

							LnNo		
					1		CoNo		
					99.999		Ln Gap		
					99.999		Co Gap		
					0.000		Offset		
					5.000		Gap		
							Accept		
Part	Hole	Rota	Nest	Edit	Run	SaveAs		Switch	View

LnNo, line number

CoNo, column number

Ln Gap, line gap

Co Gap, column gap

Offset, line offset

Gap (safe distance), between two parts to avoid wrong cutting

2-2 load from Disk

Two methods:

1. press shortcut key "Prog" in Auto interface.

File	Open						
Name		Info					
0. bmp		1572936					
TK30. TXT		947					
1. bmp		1572936					
2. bmp		1572936					
Space 0.945 G						PageUp	
Used: 0.004 G						PageDn	
Obec 4							
LoDisk	UDisk	Save	View	Search	Save	Proces	Figure
		Save			OK		

LoDisk (local disk): files in CNC disk.

U Disk: files in U disk.

View (preview): preview the current file.

Search: input file name and search it.

OK: load the file.

Note: CNC only supports 1-level folder, don't set folder in the folder.

2. Press Load in Edit interface

Edit	Prog TK30.TXT		Tot Ln 000052			
00001 G92 X0.000 Y0.000 00002 G90 00003 G00 X35.500 Y-7.000 00004 M07 00005 G41 00006 G03 X42.500 Y0.000 I0.000 J7.000 00007 G03 X42.500 Y0.000 I-12.500 J0.000 00008 G03 X35.500 Y7.000 I-7.000 J0.000 00009 M08 00010 G40 00011 G00 X5.500 Y-37.000 00012 M07 00013 G41 00014 G03 X12.500 Y-30.000 I0.000 J7.000 00015 G03 X12.500 Y-30.000 I-12.500 J0.000 00016 G03 X5.500 Y-23.000 I-7.000 J0.000 00017 M08 00018 G40 00019 G00 X-24.500 Y-7.000 00020 M07 00021 G41 00022 G03 X-17.500 Y-0.000 I0.000 J7.000 00023 G03 X-17.500 Y-0.000 I-12.500 J0.000 00024 G03 X-24.500 Y7.000 I-7.000 J0.000					DelLn InsLn lstLn EndLn PageUp PageDn	
New	Load	View	Save	SaveAS	Manage	Skip
		Line	Copy	Paste		

The difference of two methods is that if cut the part program from the Edit interface, it needs to go to Auto interface.

2-3 load from Edit

In the Edit interface edit G code program and save and go to auto cutting interface.

Edit	Prog TK30.TXT	Tot Ln 000052
<pre>00001 G92 X0.000 Y0.000 00002 G90 00003 G00 X35.500 Y-7.000 00004 M07 00005 G41 00006 G03 X42.500 Y0.000 I0.000 J7.000 00007 G03 X42.500 Y0.000 I-12.500 J0.000 00008 G03 X35.500 Y7.000 I-7.000 J0.000 00009 M08 00010 G40 00011 G00 X5.500 Y-37.000 00012 M07 00013 G41 00014 G03 X12.500 Y-30.000 I0.000 J7.000 00015 G03 X12.500 Y-30.000 I-12.500 J0.000 00016 G03 X5.500 Y-23.000 I-7.000 J0.000 00017 M08 00018 G40 00019 G00 X-24.500 Y-7.000 00020 M07 00021 G41 00022 G03 X-17.500 Y-0.000 I0.000 J7.000 00023 G03 X-17.500 Y-0.000 I-12.500 J0.000 00024 G03 X-24.500 Y7.000 I-7.000 J0.000</pre>		
New	Load	View
Save	SaveAS	Manage
Skip	Line	Copy
Paste		

New: clear parts program area, then manually input G code, edit cutting program

View (preview): preview program cutting path.

Save: input file name and save to the local disk.

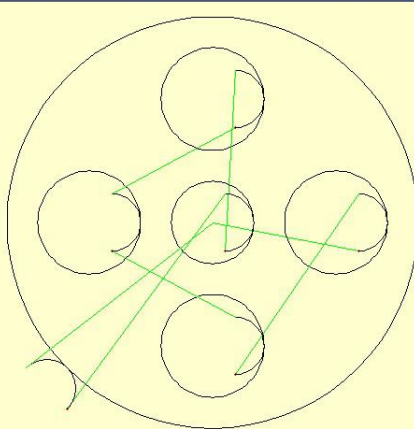
SaveAs: choose save path and then save

2-4 restore part cutting

Cutting break, pause or power off

If there is a more urgent part to cut, then you can press Pause to stop the current cutting. Then continue the previous cutting by "break point".

If power off when cut, the controller can automatically record the current position and save break point, when power on, continue the previous cutting by "break point".

Auto	Pending	Prog: TK30.TXT	Current Spd: 04000 F*100 %
			
Figure RelCoord Program			
1000#		TotT: Left:	
TK00.TXT (515)			
Man	Section	BreakPoint	View
Nest	Mirror	Torch	Bridge
Line	Return		

BreakP (break point): display the file name of the latest breakpoint, (serial number).

Controller can record 3 latest break points of 2 files, press F3 again to display last break point till the first break point. The controller automatically loads the file and preview figure and display the break point position.

Record rule:

- Record two latest break points in the same file, when over two points, then the first point is covered.
- cut a new file and have 2 break points, then the last point of last file is recorded.

Note:

- If the program is not saved, then can't restore cutting by "break point".
- Restore cutting by "break point" is useful when no machine coordination clearance and troch movement and other operations, or torch position may be wrong.

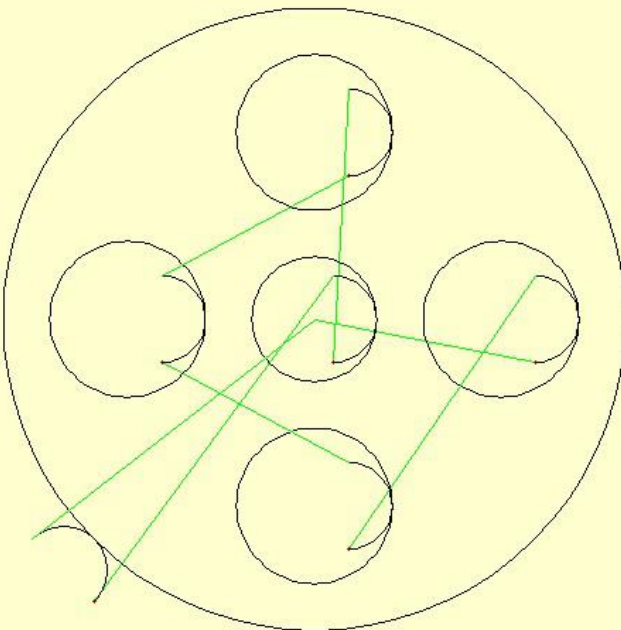
Chapter 3 array parts

After loading the parts, it can be rotated, mirrored, zoomed or arrayed.

Note: the parts loaded by "break point" can't be rotated, mirrored, scaled and arrayed.

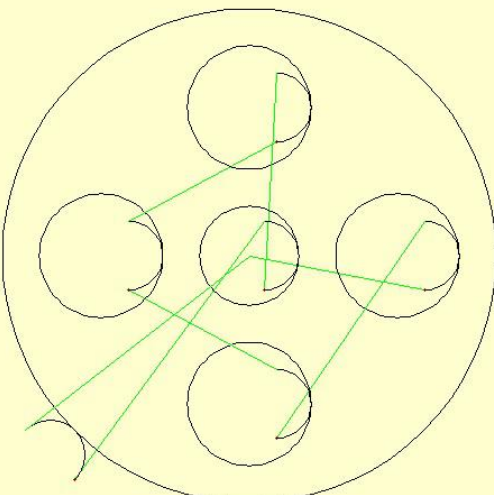
3-1 rotate

In Auto interface, press Rotate

Auto			Pending			Prog: TK30.TXT			Current Spc04000 F*100 %																	
 Figure RelCoord Program									04000			SpdLim														
									5.00			Kerf														
									0.00			Rotate														
									1.00			Scale														
									Outline			Outline														
									Simulate			Simulate														
									Set			StartP														
1000# Rotate												MainLCD														
									TotT: Left:			SubLCD														
Man			SectionBreakPoint			View			Nest			Mirror			Torch			Bridge			Line			Return		

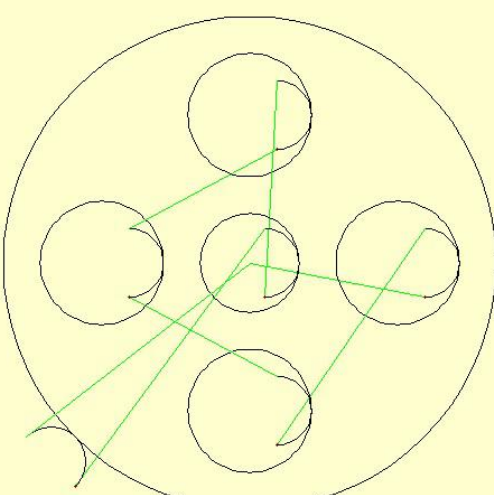
After input angle, press Enter, the parts is rotated, positive value is anticlockwise, negative value is clockwise. Press the key again to cancel.

3-2 mirror
Press Mirror

Auto		Pending		Prog: TK30.TXT		Current Spc00730		F=073 %	
						00730		SpdLim	
						0.00		Kerf	
						0.00		Rotate	
						1.00		Scale	
						Outline		Outline	
Simulate		Simulate							
Figure RelCoord Program						Set Mach Oper In Out Info		StartP	
1000# Mirror								MainLCD	
XMirror								SubLCD	
Man		SectionBreakPoint		View		Nest		Mirror	
Torch		Bridge		Line		Return			

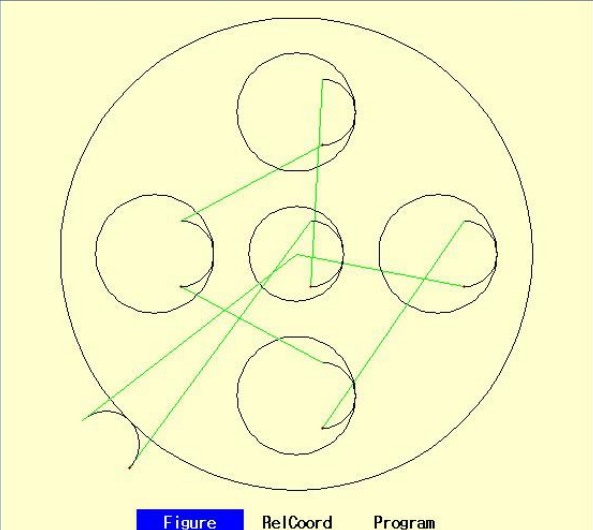
X mirror, Y mirror and XY mirror display in cycle, press Enter to confirm. Press again to cancel.

3-3 scale
Press Scale

Auto		Pending		Prog: TK30.TXT		Current Spc00730		F=073 %	
						00730		SpdLim	
						0.00		Kerf	
						0.00		Rotate	
						1.00		Scale	
						Outline		Outline	
Simulate		Simulate							
Figure RelCoord Program						Set Mach Oper In Out Info		StartP	
1000# Scale								MainLCD	
								SubLCD	
Man		SectionBreakPoint		View		Nest		Mirror	
Torch		Bridge		Line		Return			

After input scale value, press Enter to confirm.

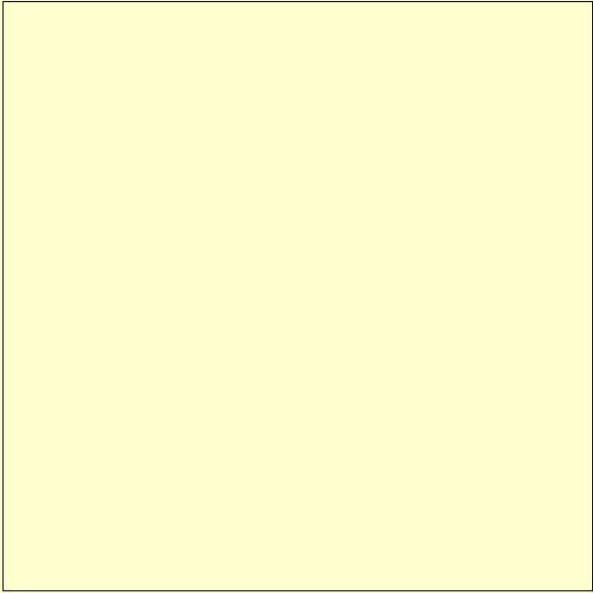
3-4 nest
Press Nest

Auto		Pending		Prog: TK30.TXT		Current Spd04000		F*100 %			
						1.000		Ln No.			
						1		Co No.			
						99.999		Ln Gap			
						99.999		Co Gap			
						0.000		Offset			
						5.000		Gap			
						Auto		Accept			
1000# Nest						TotT: Left:		MainLCD			
				SubLCD							
Man		SectionBreakPoint		View		Nest		Mirror		Torch	
Bridge		Line		Return							

Ln No. (line number), Co No. (column number), Ln Gap (line gap), Co Gap (column gap), Offset (line offset), press Accept to submit and refresh.
Note: after set line offset, controller automatically limits the width, actual quantity is fewer than input quantity.

3-5 Nest

Press F7 to Nest

						1000		Length			
						1000		Width			
						10		Gap			
						5		Step			
								Angle			
Add		Del		Front		Back		Move		Refresh	
Save											

Add: add parts.

Del (delete): delete parts.

Front: change cutting sequence, a place in advance.

Back: change cutting sequence, a place back.

Move: move the part by direction keys.

Refresh: display cutting sequence.

Save: save parts program.

Length: plate length

Width: Plate width

Gap: distance of parts

Step: movement distance

Angle: rotation angle

X: zoom in, Y: zoom out, G: restore

Note: suggest to set plate size and distance of parts before add the parts.

Add parts

Press Add

										1000	Length			
										1000	Width			
										10	Gap			
										5	Step			
											Angle			
Figure	File													

Add parts from Figure

										0.000	InLine			
										10.000	Out Ln			
										100.000	Size1			
										100.000	Size2			
											Size3			
											Size4			
											Size5			
											Size6			
											Size7			
Part	Hole	Rota				No.		Switch	View					

Choose the parts and set parameters, press View (preview) to display parts, press confirm key, input the number of parts, press Enter.

Note: after revise the number of part, must preview.

Press F2 File, dd parts from disk.

File		Open							
Name	Info								
0. bmp	1572936								
TK30. TXT	947								
1. bmp	1572936								
2. bmp	1572936								
5. bmp	1572936								
6. bmp	1572936								
7. bmp	1572936								
8. bmp	1572936								
TK11. TXT	355								
1126	355								
Space 0.945 G						PageUp			
Used: 0.004 G						PageDn			
Obsec 10									
LoDisk	UDisk	Save	View	Search	Save	Proces	Figure	Save	OK

Choose parts and press OK to confirm and input the number of parts, press Enter.

Delete parts

After adding parts, choose them by direction keys, press Del to delete.

		1000		Length					
		1000		Width					
		10		Gap					
		5		Step					
		0.0		Angle					
		TL00. TXT							
TL00. TXT									
TL00. TXT									
TL00. TXT									
TL00. TXT									
Add	Del	Front	Back	Move	Refresh	Save			

Change parts sequence
After adding parts, change cutting sequence by “Front” and “Back”, press F7 to refresh.

Move parts
After adding parts, choose them by direction keys, press Move key or Step key distance.

					1000		Length		
					1000		Width		
					10		Gap		
					5		Step		
					0.0		Angle		
					TL00. TXT TL00. TXT TL00. TXT TL00. TXT TL00. TXT				
Add	Del	Front	Back	Move		Refresh	Save		

Rotate parts
After choosing parts, press Angle key to input rotation angle

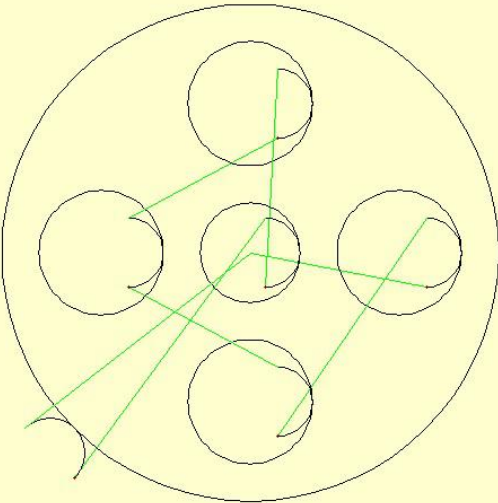
					1000		Length		
					1000		Width		
					10		Gap		
					5		Step		
					60.0		Angle		
					TL00. TXT TL00. TXT TL00. TXT TL00. TXT TL00. TXT				
Add	Del	Front	Back	Move		Refresh	Save		

Save nesting parts program
Press Save key

File		Save							
Name		Info							
0. bmp		1572936							
TK30. TXT		947							
1. bmp		1572936							
2. bmp		1572936							
5. bmp		1572936							
6. bmp		1572936							
7. bmp		1572936							
8. bmp		1572936							
TK11. TXT		355							
1126		355							
Space 0.945 G									
Used: 0.004 G									
Obec 10									
LoDisk		UDisk		Save		View		Search	
Save		Proces		Replace		SaveAs		OK	

Chapter 4 cut parts

4-1 Auto interface

Auto		Pending		Prog: TK30.TXT		Current Spc00730		F=073 %	
						00730		SpdLim	
						0.00		Kerf	
						0.00		Rotate	
						1.00		Scale	
						Outline		Outline	
						Simulate		Simulate	
								StartP	
1000#						TotT:		MainLCD	
						Left:		SubLCD	
Man		SectionBreakPoin		View		Nest		Mirror	
Torch		Bridge		Line		Return			

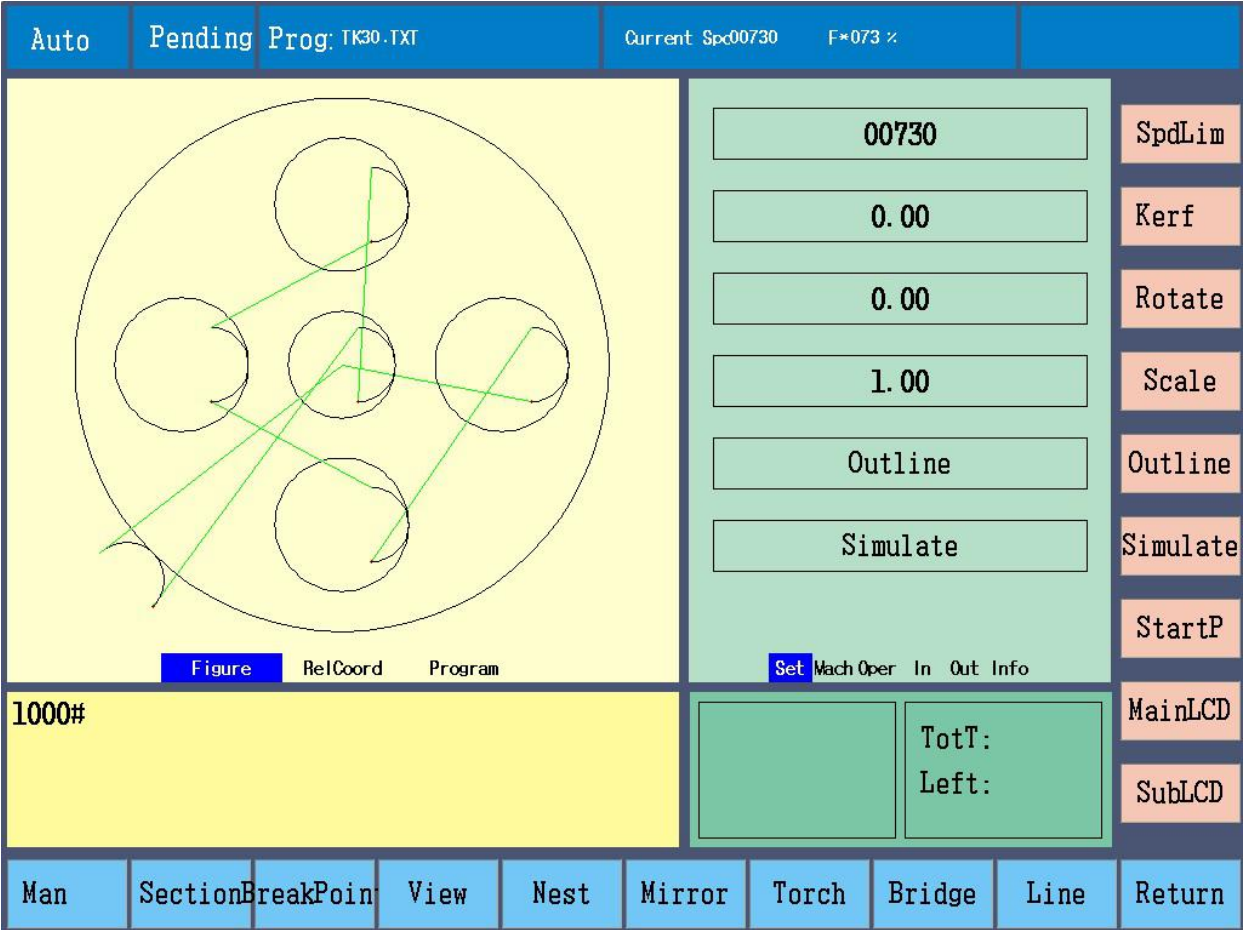
Press MainLCD key to display in cycle following interfaces as below,
Relative coordinate:

Auto	Pending	Prog: TK30.TXT	Current Spc04000	F*100 %	
X: 00000.000			04000	SpdLim	
Y: 00000.000			5.00	Kerf	
Z:			0.00	Rotate	
A:			1.00	Scale	
B:			Outline	Outline	
C:			Simulate	Simulate	
Figure RelCoord Program			Set	StartP	
1000#			TotT:	MainLCD	
			Left:	SubLCD	
Man	SectionBreakPoin	View	Nest	Mirror	Torch
Bridge	Line	Return			

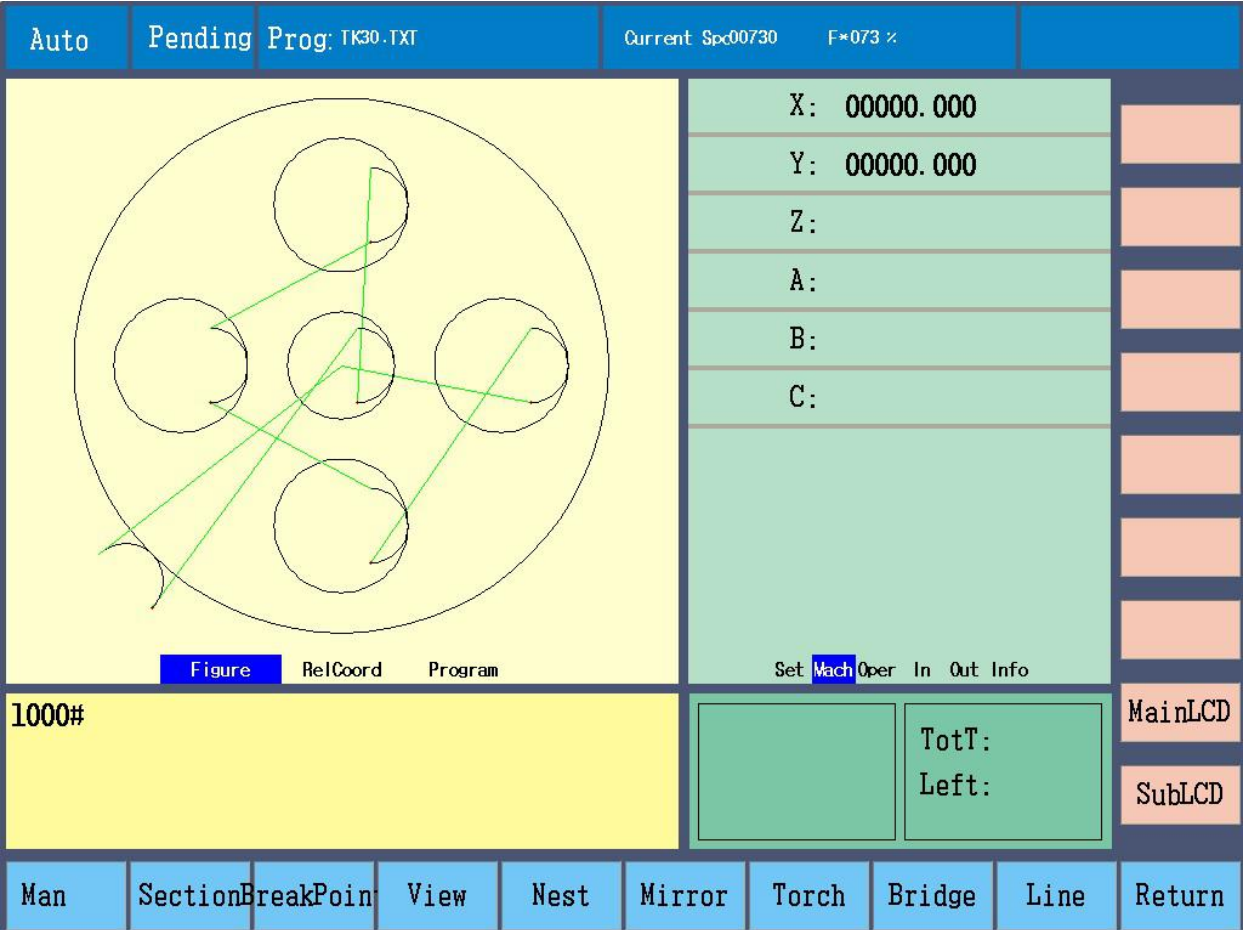
Program codes:

Auto	Pending	Prog: TK30.TXT	Current Spc04000	F*100 %	
00001 G92 X0.000 Y0.000			04000	SpdLim	
00002 G90			5.00	Kerf	
00003 G00 X35.500 Y-7.000			0.00	Rotate	
00004 M07			1.00	Scale	
00005 G41			Outline	Outline	
00006 G03 X42.500 Y0.000 I0.000 J7.000			Simulate	Simulate	
00007 G03 X42.500 Y0.000 I-12.500 J0.000				StartP	
00008 G03 X35.500 Y7.000 I-7.000 J0.000				MainLCD	
00009 M08				SubLCD	
00010 G40					
00011 G00 X5.500 Y-37.000					
00012 M07					
00013 G41					
00014 G03 X12.500 Y-30.000 I0.000 J7.000					
00015 G03 X12.500 Y-30.000 I-12.500 J0.000					
00016 G03 X5.500 Y-23.000 I-7.000 J0.000					
00017 M08					
00018 G40					
Figure RelCoord Program			Set		
1000#			TotT:		
			Left:		
Man	SectionBreakPoin	View	Nest	Mirror	Torch
Bridge	Line	Return			

Press SubLCD key to display in cycle following interfaces as below,
Current auto cutting settings:



Machine coordinate:



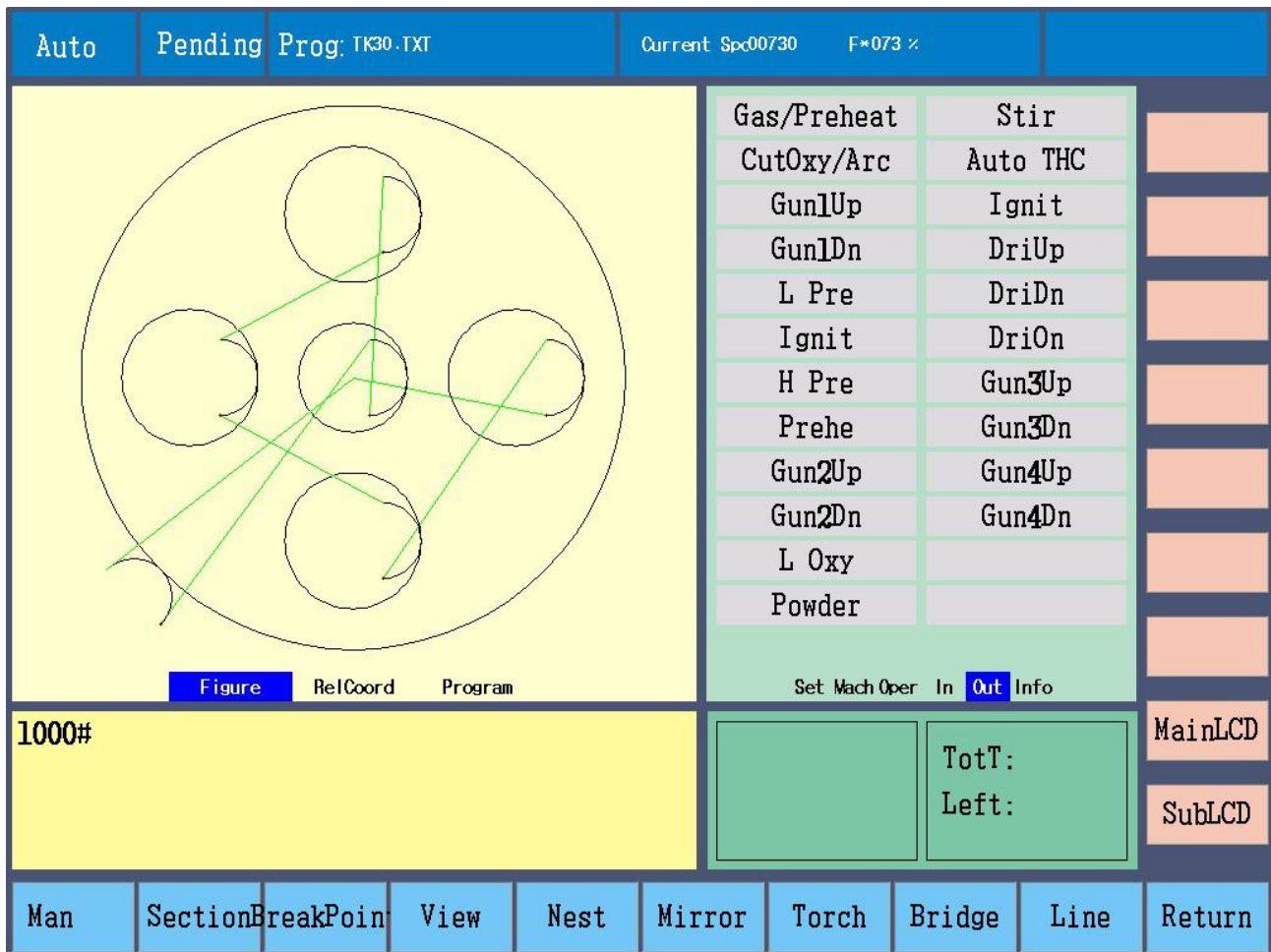
Operation tips and states

Auto			Pending			Prog: TK30.TXT			Current Spc00730			F*073 %		
						K1 Ignite			1# GunUp			MainLCD SubLCD		
						K2 Gas			1# GunDn					
						K3 Prehe			2# GunUp					
						K4 H Oxy			2# GunDn					
						K5 Pierce			3# GunUp					
						K6 THC			3# GunDn					
						K7			4# GunUp					
						K8 Close			4# GunDn					
						K9								
						K10								
						K11								
						K12								
Figure RelCoord Program						Set Mach Oper			In	Out	Info			
1000#									TotT:			MainLCD		
									Left:				SubLCD	
Man	Section	BreakPoint	View	Nest	Mirror	Torch	Bridge	Line	Return					

Input states:

Auto			Pending			Prog: TK30.TXT			Current Spc00730			F*073 %		
						Start			Z + Limit			MainLCD SubLCD		
						Pause			Z - Limit					
						Close			Z 0 Point					
						Alarm			1# Locate					
						GunCrash			2# Locate					
						E Stop			3# Locate					
						ArcSuccess			4# Locate					
						X + Limit			Spare					
						X - Limit			Spare					
						X 0 Point			Spare					
						Y + Limit			Spare					
Y - Limit			Spare											
Y 0 Point			Spare											
			Spare											
			Spare											
Figure RelCoord Program						Set Mach Oper			In	Out	Info			
1000#									TotT:			MainLCD		
									Left:				SubLCD	
Man	Section	BreakPoint	View	Nest	Mirror	Torch	Bridge	Line	Return					

Output states:



Current parts program information:

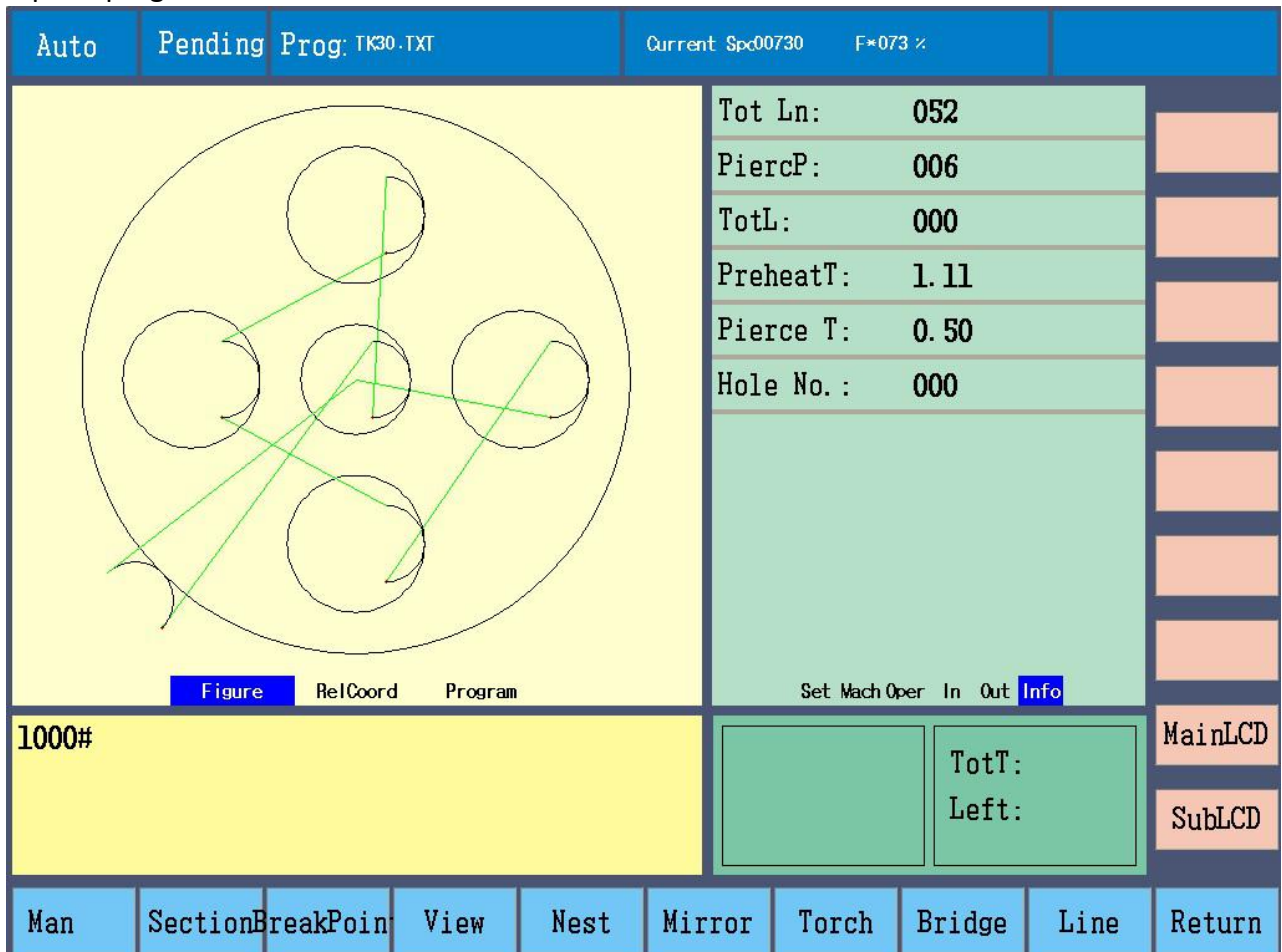
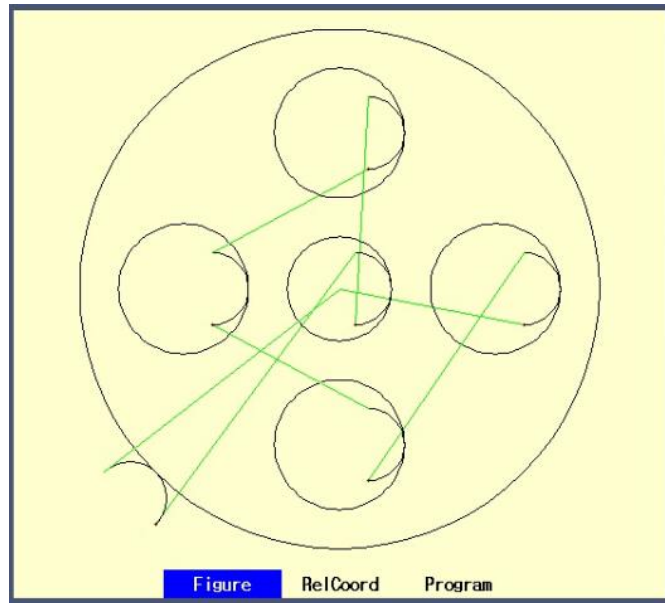


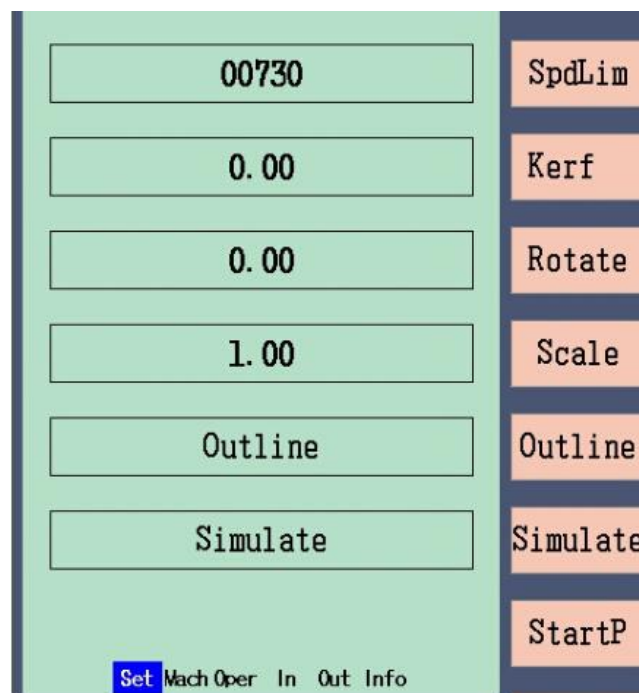
Figure display in the main LCD



X: zoom in the figure
 Y: zoom out the figure
 G: restore the figure
 Move and preview the figure by direction keys.

Figure display setting
 In Parameter and Figure interfaces, figure can be set.

Sub LCD setting display



SpdLim (speed limitation): set auto cutting speed limitation
 Kerf: set kerf compensation value
 Rotate: rotate the parts
 Scale: zoom in/out the parts
 Outline: outline mode, press Start, torch will move along the outline to check whether the plate is big enough.
 Simulate: simulation run mode, press Start, torch will move along the cutting path till program ends without output.
 StartP (start point): change start point, choose torch start point (initial position), change 5 different positions.
 Operation display area

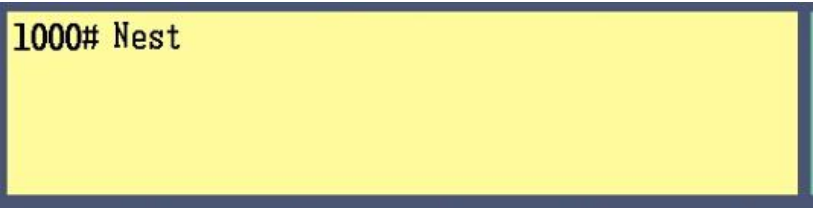
Man	Section	BreakPoint	View	Nest	Mirror	Torch	Bridge	Line	Return
-----	---------	------------	------	------	--------	-------	--------	------	--------

- Man: go to manual interface
- Section: section operation
- BreakPoint: break point operation
- View: preview parts
- Nest: array parts
- Mirror: mirror parts
- Torch: choose 4 torches
- Bridge: bridge mode
- Line: draw line mode
- Return: back to parts reference point, when laser location, press again, tip to laser location point.

State display area



Setting tip & state tip



4-2 manual interface

Man

Program

Current Spc04000

F*100 %

1000#

TotT:

Left:

04000

00100

Continue

H Spd

Set

Mach Oper

In

Out

SpdLim

P Move

Continue

H Spd

Point 1

Point 2

Origin

MainLCD

SubLCD

Auto

MoveTo

StartP

EndPoint

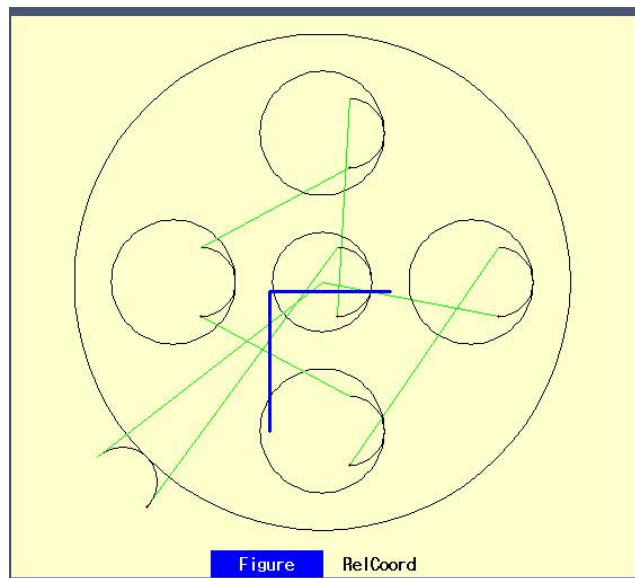
Coordinate

ClearC

Reset

Return

Manual path display



Manual settings

00200	SpdLim
00100	P Move
Continue	Continue
H Spd	H Spd
	Point 1
	Point 2
	Origin
Set Mach Oper In Out	

SpdLim (speed limitation): speed limitation of manual movement and idle run.

P Move (point movement): set point movement increment.

Continue: continuously move

H Spd (high speed): fast change moving speed, 10% or 80% of manual speed limitation.

Point 1/2: set the current point as the fixed point, machine coordinate.

Origin: machine origin.

Note:

1. If don't choose "Continue", then press the direction keys to move, release keys to stop.
2. During continuously movement, press keys of the same or reverse directions to pause, press other direction keys to slantly move, press direction keys again, stop to move in one direction.

Operation display area

Auto		MoveTo	StartP	EndPoint	Coordinate	ClearC	Reset	Return
------	--	--------	--------	----------	------------	--------	-------	--------

Auto: go to auto interface

MoveTo: input X/Y axis point movement increment, move to the target point.

StartP (start point): set the current point as the deflection start point.

EndPoint: set the current point as the deflection end point.

Coordinate: set reference coordinate.

ClearC (clear coordinate)

Reset: machine reset

Return: back to parts reference point, if has laser location, press again, tip back to laser location point.

4-3 preparation before cut

1. Cutting situation is safe, gas and plasma power source are ready, intermediate relay and solenoid valve DC24V power on.

2. Cutting machine precision is set (CNC parameters), motor and drivers are ready.

After load the part program, check cutting mode, speed and kerf, then press Start button.

Cutting mode

Plasma & flame. Main menu ---> Para (parameter) ---> Switch

Speed limitation

1. Set cutting speed limitation, the maximum values is not bigger than "Cut Speed Limit" value in Speed parameter.

2. Multi-functional knob, turn it to adjust speed rate.

3. F+/F- to adjust.

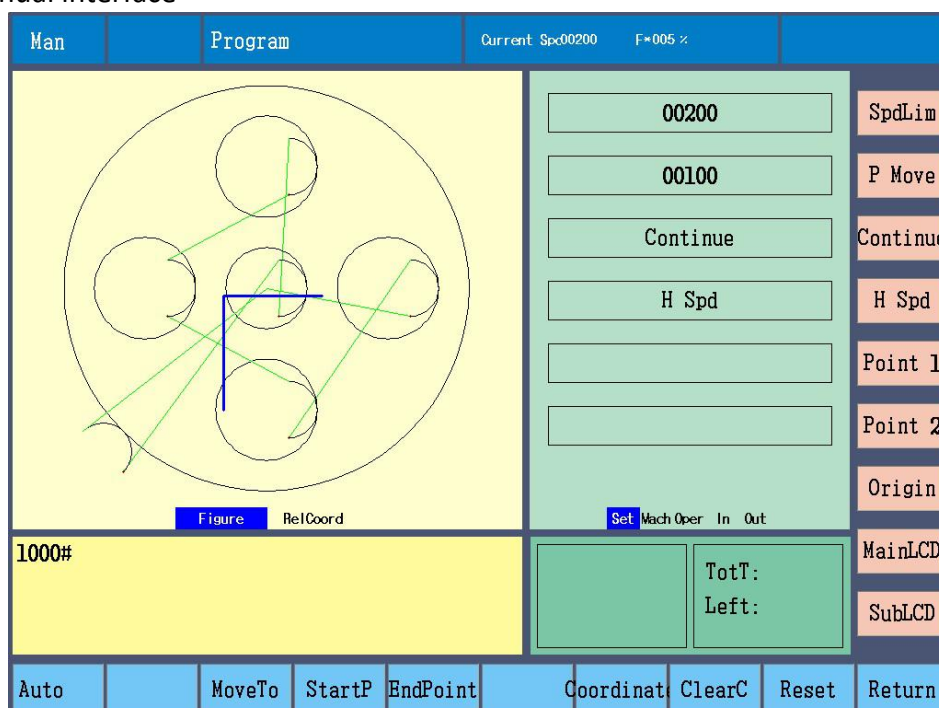
Note: during cutting, idle run, go forward and backward, speed adjustment is to change the current speed rate, the adjusted speed rate will be recorded till adjust next time.

Kerf

In auto interface, under pending state, press Kerf to revise, set value is a half of the actual kerf width, unit:mm.

4-4 other operations before cut

Move torch, in manual interface

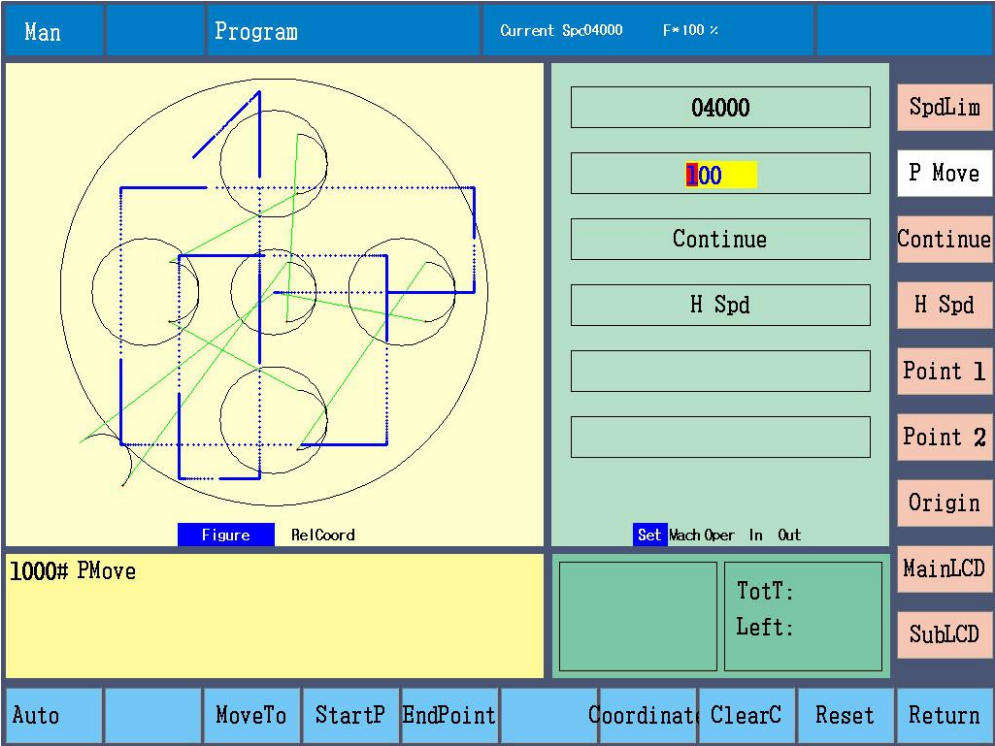


1. Manually move the torch to any position

The initial setting is that press direction keys to move the torch, release keys and the torch stops.
 Choose “Continue”: press direction keys to move the torch, it stops till press Pause, or the same or reverse direction keys.
 In continue mode, press the direction key of another axis, and torch obliquely moves, press direction keys again to cancel another axis movement.

2. Manually adjust torch to specified position

Press “P Move”, input “point movement increment” value, after Enter, press direction keys to move torch at specified distance.



MoveTo, single or dual axis to move, input “point movement increment” value of X axis and Y axis, after Enter, press Start key, the torch moves in two axes at the same time.

Manual

Prog

Speed = 04000 F*100 %

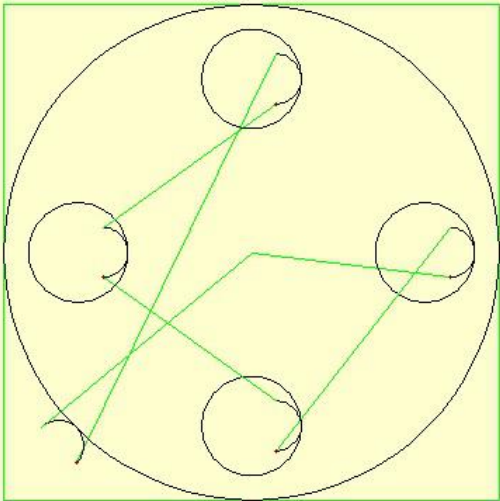


Figure RelativeCoor

004000

100.00

Continue

High Spd

Set MachOper In Out

SpdLimit

Jog

Continue

High Spd

Point 1

Point 2

Origin

Main LCD

Sub LCD

0011# Incremen

X: 100.000 Y: 100.000

Total T:
Left T:

Auto

MoveDist

Start Po

EndPoint

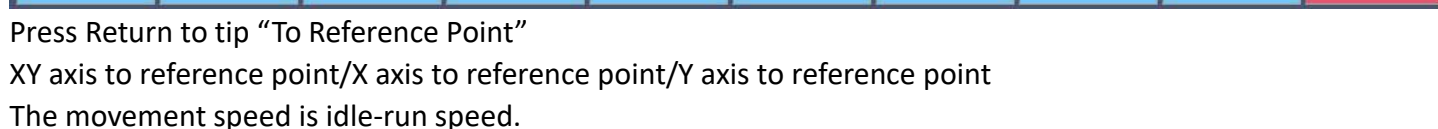
Set Co

Clear Co

Reset

Return

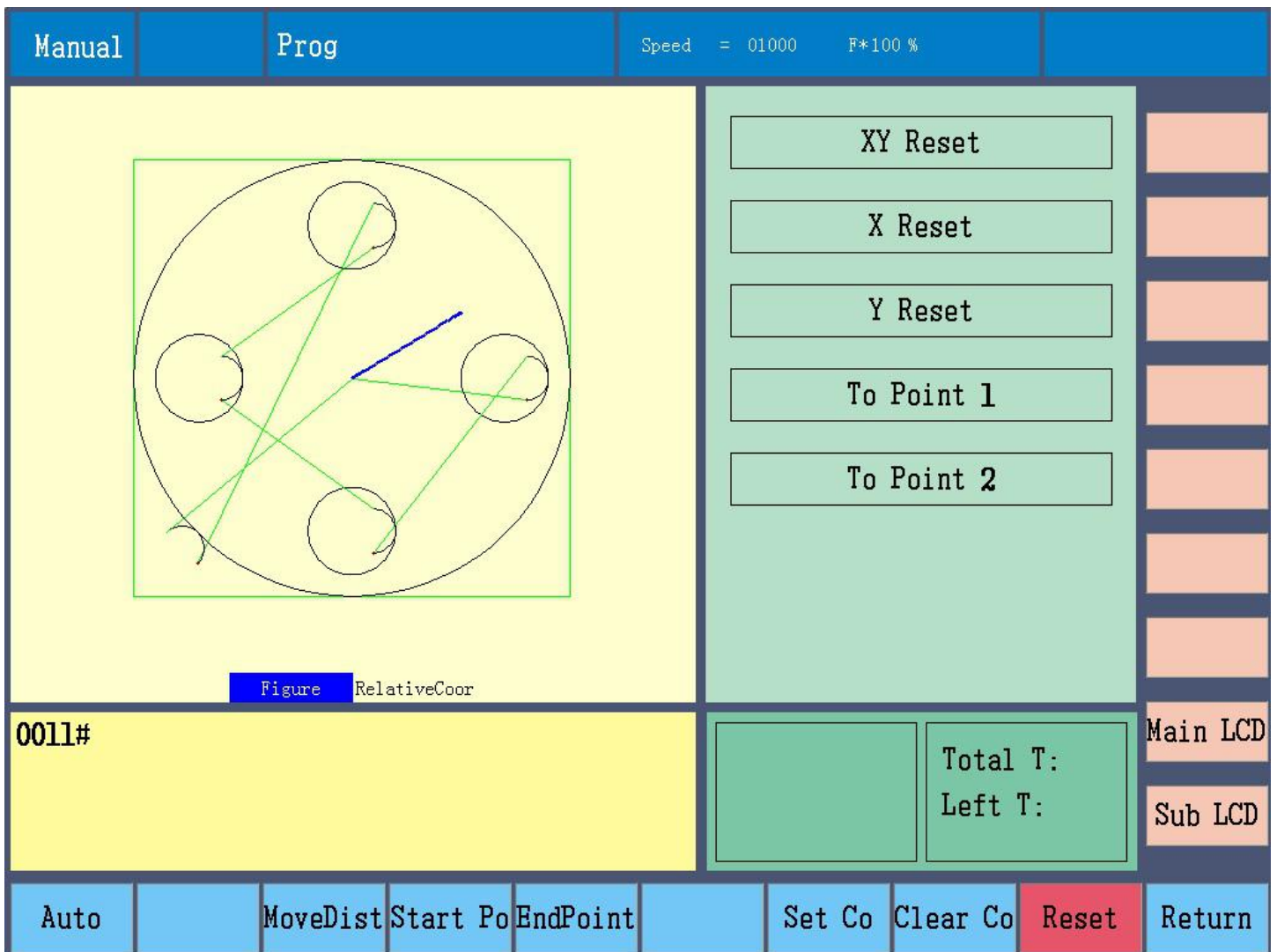
Return
Move the torch to the parts reference point, default is G92 X0 Y0.



“Zero
along
coord

“Zero
along
“Zero
machi

“Zero
machi



Note:

1. When Zero Point Switch is 0, and continue off-line to move torch, the machine coordinate will accumulate, clear by reset.
2. Two axis reset at the same time, one axis meets 0 point switch, two axis stop, after one axis reset, another axis continue.

Align parts (plate calibration)

If plate doesn't align with machine axis, then manually align parts, in manual interface,

Manual	Prog	Speed = 04000	F*100 %
--------	------	---------------	---------

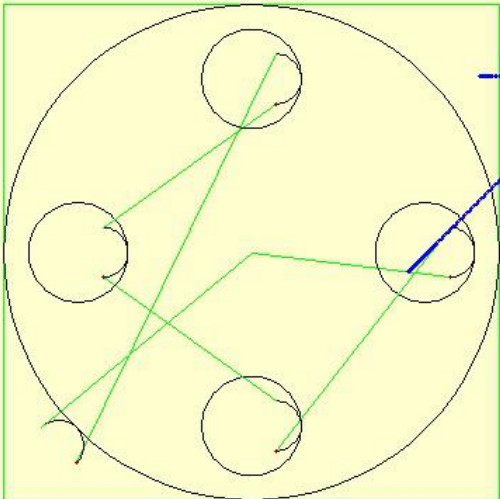


Figure RelativeCoor

004000	SpdLimit
100.00	Jog
Continue	Continue
High Spd	High Spd
	Point 1
	Point 2
	Origin

Set MachOper In Out

	Total T:
	Left T:

0011#

Angle 45.00

Main LCD

Sub LCD

Auto	MoveDist	Start Po	EndPoint	Set Co	Clear Co	Reset	Return
------	----------	----------	----------	--------	----------	-------	--------

Press direction keys to move torch, align one side of plate, press start point.

Press direction keys to move torch, align another point of the same side of plate, press end point.

Controller tips rotation angle, after confirm, back to Auto, preview, display the figure after rotation.

Man	Program	Current Spd04000	F*100 %
-----	---------	------------------	---------

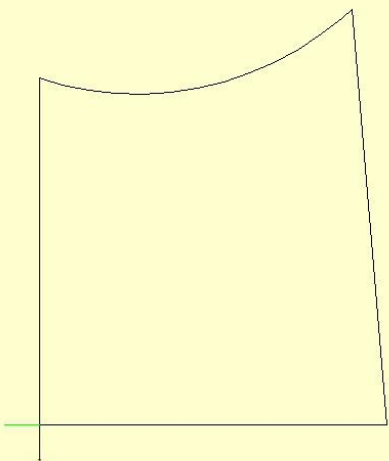


Figure RelCoord

04000	SpdLim
00100	P Move
Continue	Continue
H Spd	H Spd
	Point 1
	Point 2
	Origin

Set MachOper In Out

	TotT:
	Left:

1000# Rotate

StarOrCanc

MainLCD

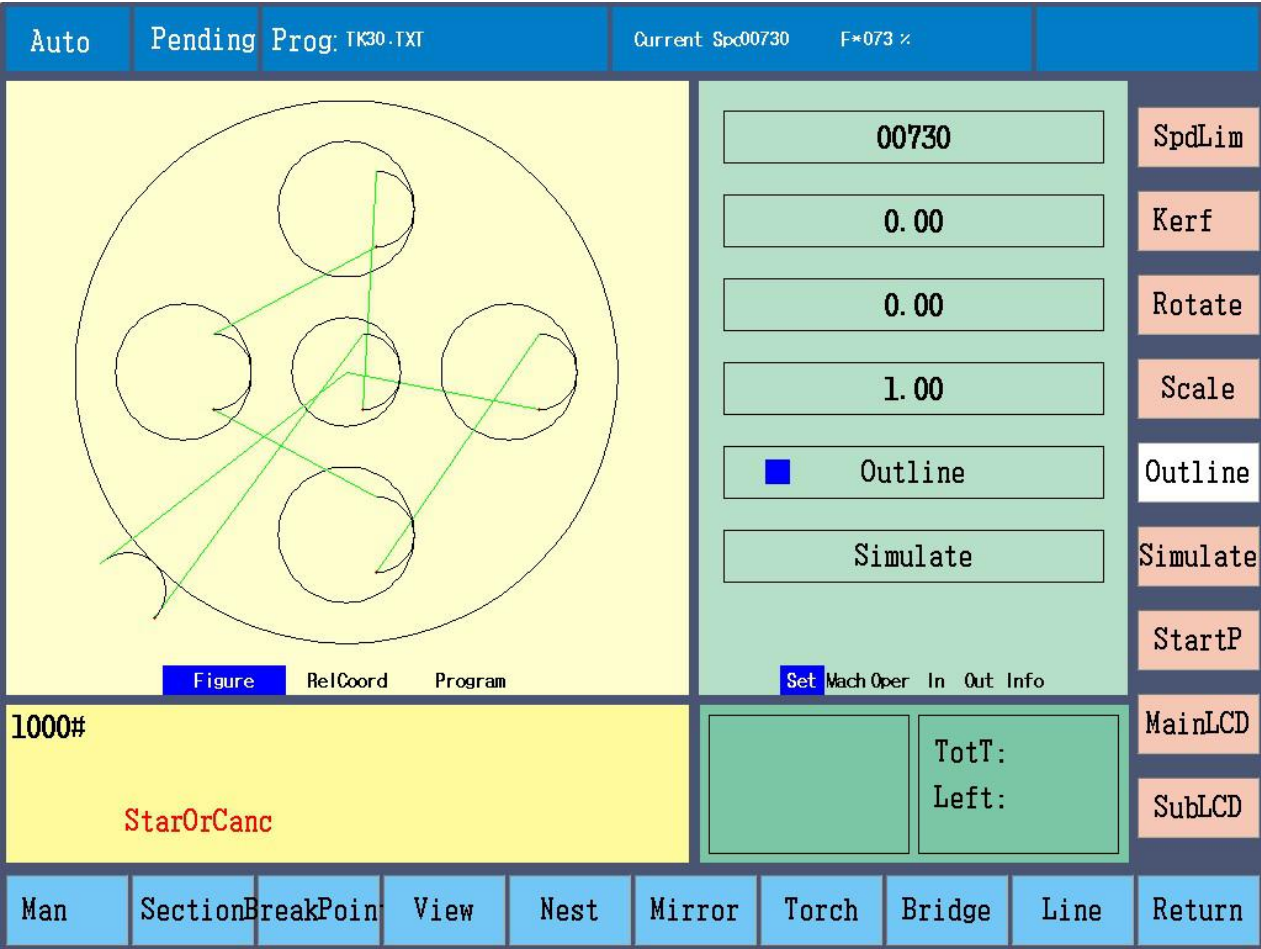
SubLCD

Auto	MoveTo	StartP	EndPoint	ToStart	Coordinat	ClearC	Reset	Return
------	--------	--------	----------	---------	-----------	--------	-------	--------

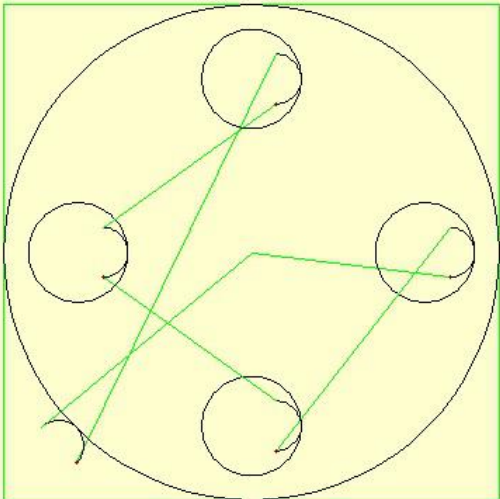
Note: after set end point, can press StartP(point), back to the start point.

Outline

If want to check whether the plate is big enough for parts, can choose Outline before cutting.



Outline, choose it, press start key, torch moves along outer outline to check whether torch is beyond plate.

Auto		Pending Prog TK29.TXT		Speed = 01000 F*100 %			
				001000		SpdLimit	
				0.00		Kerf	
				0.00		Rotate	
				1.00		Scale	
				☒ Outline		Outline	
Figure RelativeCoor Program				Simulate		Simulate	
				Set MachOper In Out Info		StartPoi	
0011# Start Or Cancel				M93 Exhaust Off		Total T: Left T:	
						Main LCD	
						Sub LCD	
Manual	Section	Break P	Preview	Nest	Mirror	Torch	BrBridge Draw Ln Mode

If the current point relative coordinate is not the parts reference point, after pressing Start key to tip "Current Point Locate" or "Reference Point Locate"

Auto		Pending		Prog TK29.TXT		Speed = 01000 F*100 %			
						001000		SpdLimit	
						0.00		Kerf	
						0.00		Rotate	
						1.00		Scale	
						☒ Outline		Outline	
						Simulate		Simulate	
								StartPoi	
Figure RelativeCoor Program						Set MachOper In Out Info		Main LCD	
0011#						M93 Exhaust Off		Sub LCD	
						Total T: Left T:			
Manual	Section	Break P	Preview	Nest	Mirror	Torch	BrBridge	Draw Ln	Mode

“Current Point Locate”, the current point is the parts reference point, relative coordinate is reference coordinate, start to over to the bottom left corner of the outline, run along the parts edge at clockwise.

“Reference Point Locate”, don’t change current relative coordinate, move to the parts reference point from the current point, then move to the bottom left corner of the outline, run along the parts edge at clockwise.

Simulation run

Before cutting, choose Simulate to check cutting path is right or not.

Simulate, choose it and press start button, torch moves along program path at cutting speed.

During the operation, output is invalid. E-stop, pause, limit and other input are valid.

Auto		Pending		Prog: TK30.TXT		Current Spd04000		F*100 %	
						04000 2.00 0.00 1.00 Outline Simulate		SpdLim Kerf Rotate Scale Outline Simulate StartP	
Figure RelCoord Program						Set Mach Oper In Out Info			
1000#						M89 Gun4Dn Off		TotT: 001.0 Left: 000.0	
Man		SectionBreakPoint		View		Nest		Mirror	
						Torch		Bridge	
						Line		Return	

Change start point

For some irregular parts or plate, in order to get cutting start point, can change that point.

StartP (start point), current start point displays at left bottom corner in preview area. Press it several times to change that point. Press start key, torch moves to the first pierce point from selected start point and then cut. Moving sequence: left bottom --- left top --- right top --- right bottom --- center

Auto		Pending		Prog: TK30.TXT		Current Spd00800		F*080 %	
						00800 2.00 0.00 1.00 Outline Simulate		SpdLim Kerf Rotate Scale Outline Simulate StartP	
Figure RelCoord Program						Set Mach Oper In Out Info			
1000#								TotT: Left:	
Man		SectionBreakPoint		View		Nest		Mirror	
						Torch		Bridge	
						Line		Return	

Section

Before cutting, choose a certain position of the parts to cut by Section function.

Press Section to input PierceP (point) number, press again to input line number.

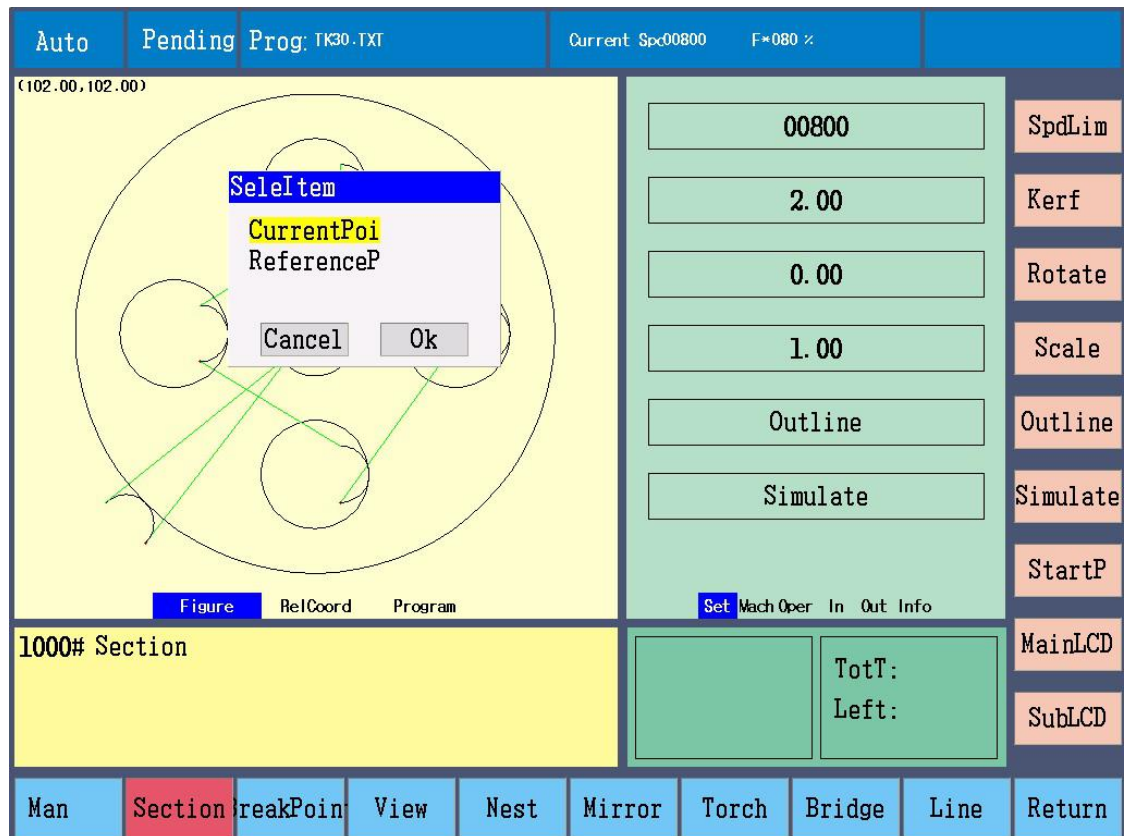
After input pierce point number, and confirm to preview selected pierce point position.

Auto		Pending		Prog: TK30.TXT		Current Spd00800		F*080 %	
						00800		SpdLim	
						2.00		Kerf	
						0.00		Rotate	
						1.00		Scale	
						Outline		Outline	
Simulate		Simulate							
Figure RelCoord Program						Set Mach Oper In Out Info		StartP	
1000#								MainLCD	
PierceP: <6						TotT: Left:		SubLCD	
Man	Section	reakPoin	View	Nest	Mirror	Torch	Bridge	Line	Return

Display the target point after Section.

Auto		Pending		Prog: TK30.TXT		Current Spd00800		F*080 %	
(102.00,102.00)						00800		SpdLim	
						2.00		Kerf	
						0.00		Rotate	
						1.00		Scale	
						Outline		Outline	
Simulate		Simulate							
Figure RelCoord Program						Set Mach Oper In Out Info		StartP	
1000# Section								MainLCD	
						TotT: Left:		SubLCD	
Man	Section	reakPoin	View	Nest	Mirror	Torch	Bridge	Line	Return

Option dialog displays after start.



CurrentPoi (current point location): after confirm, torch makes the current position as pierce point, after pressing start key, start to cut.

RefrenceP (reference point location): after confirm, torch locates as reference coordinate and moves to the pierce point in idle-run speed, press start key, and then cut.

Choose as program line number: press Section twice, input line number, after confirm, and preview the start position of selected line.

Manual output: Before cutting, according to cutting mode, manually open some output.

Flame mode

- 1, press K1 for ignition cycle (M52), press K8 to close.
- 2, press K2 to open gas output (M10), press K2 again or K8 to close (M11).
- 3, press K3 to open preheat oxygen output (M24), press K3 again or K8 to close (M25).
- 4, press K4 to open cutting oxygen output (M12), press K4 again or K8 to close (M13).
- 5, press K5 for pierce cycle (M07), press K8 to close.
- 6, press K6 to open torch height control auto output (M38), press K6 again or K8 to close (M39).
- 6, press SU for torch up, release button to stop.
- 7, press SD for torch down, release button to stop.

Plasma mode

- 1, press K4 to open plasma arc strike output (M12), press K4 again or K8 to close (M13).
- 2, press K5 for pierce cycle (M07), press K8 to close.
- 3, press K6 to open torch height control auto output (M38), press K6 again or K8 to close (M39).
- 4, press SU for torch up, release button to stop.
- 5, press SD for torch down, release button to stop.

Note: when cut and torch moves, torch up/down are valid.

4-5 auto cutting

After cutting preparation, in auto mode, press start key to cut according to current cutting mode and

parameter settings.

After start, controller will work as below,

- 1, deal with parts cutting program, draw parts preview figure.
- 2, output and delay time and other movements.
- 3, control torch up/down.
- 4, port input signal.
- 5, speed adjustment.
- 6, refresh figure and state.

Dynamic figure display: During cutting, controller dynamically displays current torch position, can zoom preview figure.

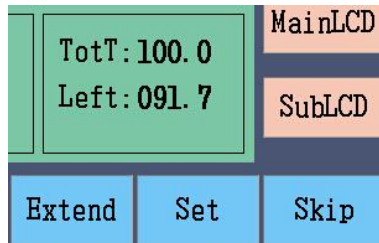
X zoom in

Y zoom out

G restore

Note: after zoom in preview figure, controller can automatically move the figure and follow the torch position, if moves too fast, maybe refresh figures frequently.

Delay timer: During cutting, delay has timer, can operate “extend”, “set” and “skip”.



Extend time, add 100s.

Set current time as operation time of the same movement. Time setting in parameter also changes.

Skip left time, can't change time setting of same operation and parameter.

Note:

- 1, in flame mode, load new file, the initial preheat time is 100s.
- 2, when delay, start key is like skip function, pause key is like extend function.
- 3, flame: ignition and pierce time; plasma: arc strike and pierce time. Set before cutting.

Pause during auto cutting

After cutting, not delay, can press Pause to stop cutting, close output, slow speed and stop torch movement, after pause, controller records current position as break point.

When pause, can operate output control at left side, torch up/down and speed adjustment, and can operate items at right side, also can move torch at 10% of manual speed, press F to change between 10% and 80%.

Start: After pause, press start button, controller pierce at current position, then continue to cut.

Flame cutting, if close preheat, controller finishes pierce; if preheat goes on, then skip preheat, then pierce, so discover preheat state, after enough preheat, then start.

Forward and backward: After pause, can move forward and backward along program path, press F6 and F7, initial speed is back speed in parameter settings, only move torch, don't change output state.

Move forward and backward to a position, can press start button to continue cutting.

When don't cut through the plate, can use forward and backward.

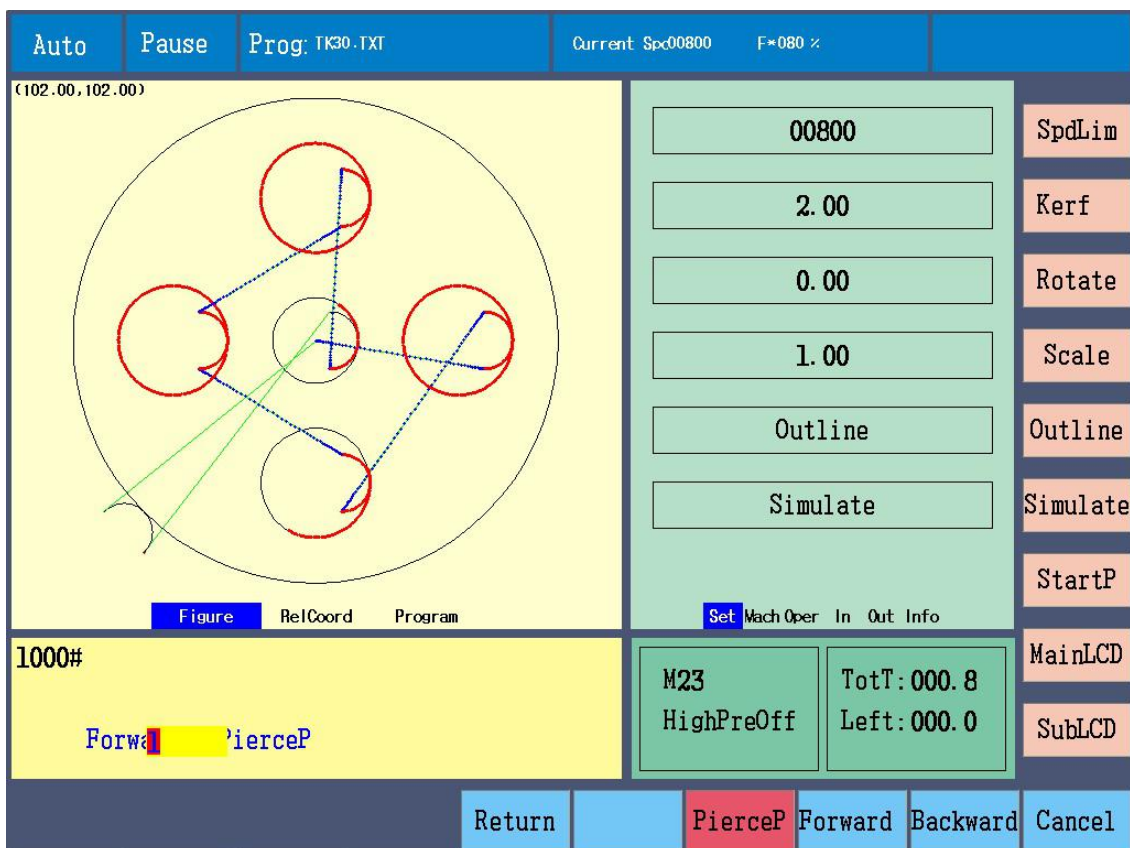
After forward start, no pause to stop movement, then automatically start preheat, pierce, cutting at the next

pierce point.

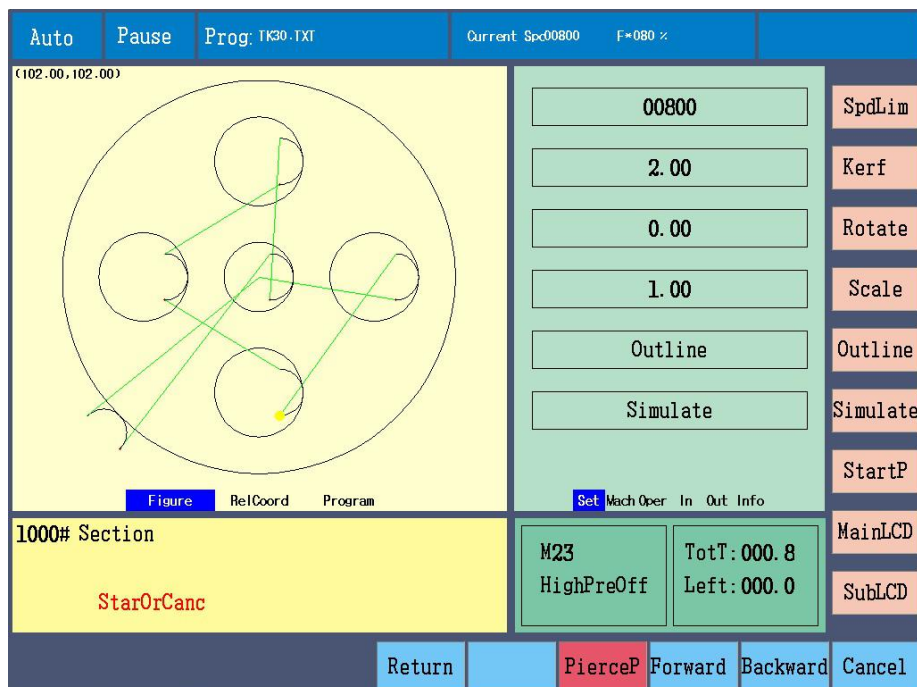
After backward start, no pause to stop movement, then automatically pause at the next pierce point, can continue backward or forward.

Pierce point: After pause, choose pierce point and cut.

Press PierceP(point) to display pierce point number of “forward” and “backward”.



Press Enter to confirm, controller displays selected pierce point position.



Press start button, torch moves to selected pierce point position from current position. But still in the state of Pause, following operations are available.

Return: torch returns to the start point at idle run speed.

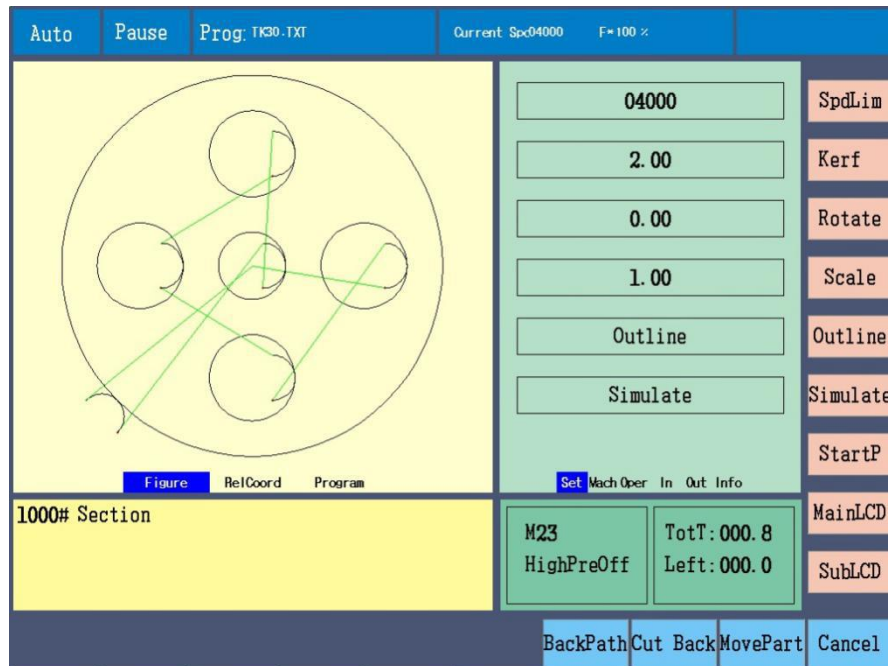
Press L3 after pause, torch moves back to start point in idle-run speed.

Simulate: choose Simulate, press Start key, then simulatively run the left parts program

Cancel: exit pause state, back to auto pending state, can continue to cut by “break point”.

Start after path deviate

After pause, use direction buttons to move torch, to make torch to deviate path, there are 3 methods to continue cutting.



BackPath: keep current output state, torch moves to pause position from current position by shortest path.

Cut Back: pierce at current position, then cut to pause position by shortest path, choose the operation, please carefully choose path to avoid wrong cutting.

Move Part: pierce at current position then cut the left parts.

When plate and parts have enough space, or near plate edge, choose “Cut Back” , better smoothness of break point.

Note: pierce in flame mode, controller finishes different tasks according current output state.

1, gas, preheat oxygen, cutting oxygen all close, execute complete M07, then cut left parts program.

2, gas and preheat oxygen open, cutting oxygen close, execute “pierce torch up” (delay) --- “open cutting oxygen” (delay) --- “pierce torch down” (delay), then cut left parts program, just like manually finish preheat.

3, not above two situations, then firstly close output, and execute complete M07, cut left parts program.

Input port: Controller has 13 input signals, when cut in auto or manual mode, check input port state and deal with accordingly.

Input port

1, correctly connect external input switches.

2, correctly set port logic state in diagnose interface.

3, connect external 24VDC power and start.

Note: port logic state setting is available in “diagnose”.

When have e-stop or alarm signal input, controller immediately stop torch movement, close all output, save the current position as break point, display e-stop or alarm in tip place, before e-stop and alarm input state change, can't move torch and open output.

When limit signal input, controller will operate the same as e-stop or alarm signal input, but can manually move torch in reverse direction to leave limit.

Note: when e-stop, alarm and limit input, torch urgently stops movement, maybe there is overshoot, so the actual stay position may be a little different from break point position, when restart or break point restore, maybe need to manually calibrate.

Chapter 6 Setup

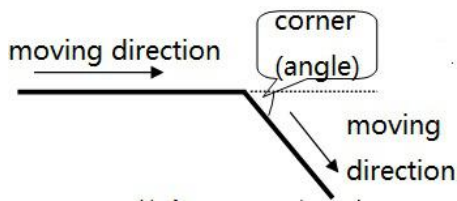
Speed

Para	Speed			
Parameter	Value	Unit	Range	
Start Speed	77	mm/min	20~8000	Calculate
Increased Acceleration T	200	ms	0~10000	Circle
Uniform Acceleration T	200	ms	0~10000	
Decreased Acceleration T	200	ms	0~10000	
Speed Limit	4000	mm/min	20~900000	
Flame Cutting Spd Limit	1000	mm/min	20~900000	
Plasma Cutting Spd Limit	1000	mm/min	20~900000	
Backward/Forward Speed	500	mm/min	20~6000	
Reset Speed	1000	mm/min	20~6000	
Speed Angle	30	degree	0~90	
Corner Speed Limit	1000	mm/min	20~900000	
Climb Speed Ratio	10		0~100	
X Axis Increased Acce T	200	ms	0~10000	
X Axis Uniform Acce T	200	ms	0~10000	
X Axis Decreased Acce T	200	ms	0~10000	
Info:				
System	Speed	Control	Mode	Switch
Figure	Machine	Offset	Advanced	Save

Y Axis Increased Acce T	200	ms	0~10000	
Y Axis Uniform Acce T	200	ms	0~10000	
Y Axis Decreased Acce T	000	ms	0~10000	

1	Start Speed	Start and stop speed of every axis
2	Increased Acceleration Time	Increased acceleration time
3	Uniform Acceleration Time	Uniform acceleration time
4	Decreased Acceleration Time	Decreased acceleration time
5	Speed Limit	Max. speed, dry run speed
6	Flame Cutting Speed Limit	Max. cutting speed in the flame mode
7	Plasma Cutting Speed Limit	Max. cutting speed in the plasma mode
8	Backward/Forward Speed	After pause, speed of moving forward/backward
9	Reset Speed	Reset speed
10	Speed Angle	Speed down in advance when direction changes over the angle
11	Corner Speed Limit	Max. speed at the corner between two directions
12	Climb Speed Ratio	Relative to the ratio of cutting speed, after pierce, torch movement speed within climb time
13	X Axis Increased Acce Time	X Axis Increased Acceleration Time
14	X Axis Uniform Acce Time	X Axis Uniform Acceleration Time

15	X Axis Decreased Acce Time	X Axis Decreased Acceleration Time
16	Y Axis Increased Acce Time	Y Axis Increased Acceleration Time
17	Y Axis Uniform Acce Time	Y Axis Uniform Acceleration Time
18	Y Axis Decreased Acce Time	Y Axis Decreased Acceleration Time



Note: when change direction during torch movement, controller will lower speed in advance to avoid torch shake.

In fact, torch shake is caused by different factors, such as inertia, machine rigidity and so on, users can set the corner speed to improve steadiness.

System

Para	System								
Parameter	X Direction	Y Direction	Range	Calculate Circle					
Gear Numerator		2	1~65535						
Gear Denominator	1	1	1~65535						
Machine Origin	0.000	0.000	-300.000~3000.000						
Fixed Point 1	0.000	0.000	-31000.000~31000.000						
Fixed Point 2	0.000	0.000	-31000.000~31000.000						
Reset Direction	0	0	-1~1						
Backlash	0.000	0.000	0.000~10.000						
Soft +Limit	9000	9000	0~31000						
Soft -Limit	-9000	-9000	-31000~0						
Plate Size	8000	8000	0~15000						
Info:									
System	Speed	Control	Mode	Switch	Figure	Machine	Offset	Advanced	Save
1	Gear Numerator	Numberator/denominator is pulse equivalent, for machine accuracy, unit: μm							
2	Gear Denominator	Numberator/denominator is pulse equivalent, for machine accuracy, unit: μm							
3	Machine Origin	Machine origin coordinate, a certain position coordinate for machine 0 point							
4	Fixed Point 1	Fixed position 1 for machine 0 point							
5	Fixed Point 2	Fixed position 2 for machine 0 point							

6	Reset Direction	-1 negative direction, 0 don't move, 1 positive direction
7	Backlash	Mechanical gap when compensation direction change
8	Soft + Limit	Positive direction max. value of machine coordinate
9	Soft - Limit	Negative direction max. value of machine coordinate
10	Plate Size	Steel plate size

Gear Numerator and Denominator: Numerator/denominator is pulse equivalent; controller sends a pulse, the torch movement distance,

Example: numerator is "2", denominator is "1", and pulse equivalent is 0.002mm.

Formula: $\text{numerator/denominator} = \text{lead screw pitch} \times 1000 / (360 \times \text{subdivision number/step angle} \times \text{drive ratio})$

Adjustment method:

1) set a ratio, such as 8/1, manually move a standard distance, such as 2000, measure actual moving distance, use formula, $8 \times \text{actual distance} / 1 \times 2000$, if the actual distance is 2651, then the simplified fraction is 2651/250.

2) set a ratio, such as 8/1, manually move a standard distance, such as 2000, measure actual moving distance, press F key, input the value, press Enter, there is result, press F8 to confirm.

Note: automatic calculation is better.

Machine Origin: Set a coordinate point as machine reference point, or in manual interface to move the torch to a certain position, confirm the origin position by F6 Test Origin.

Test origin: machine has mechanical zero point, and when reset direction is right, move the torch to the selected position, set current coordinate, then press F7 Test Origin, execute "XY axis reset at the same time", then display XY axis current coordinate, press Enter to confirm, current coordinate is machine origin coordinate.

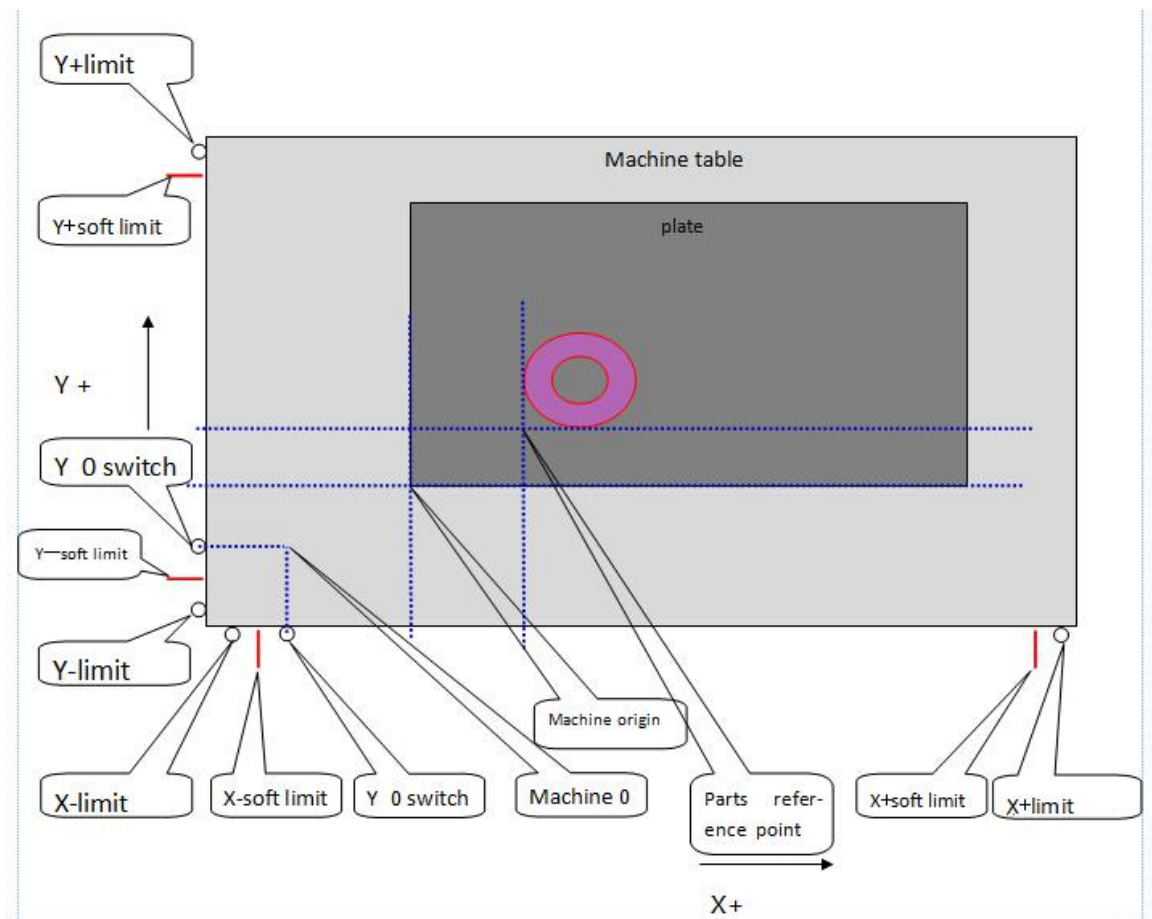
Backlash: eliminate mechanical backlash, usually check mechanical structure, it's better not to use backlash, or easy to damage the machine.

Soft Limit: set a machine coordinate range, when torch moves beyond the range, reduce speed and stop, only move torch in reverse direction to limit torch movement range to avoid torch collision, if don't use soft limit, can set soft limit invalid in Machine parameter.

Note: when automatically run, then stop after soft limit, automatically record break point.

Reset Direction: when set reset, torch movement direction is 1, torch positive movement direction is -1, torch negative movement direction is 0, torch doesn't move, when machine coordinate become X0, Y0, current position is equal to machine zero point position.

Coordinate setting reference diagram



Note: machine origin can set to any point of value range.

Control

Para	Control									
Parameter	Value	Unit	Range	Calculate Circle 						

14	Speed Limit Diameter	Speed limit diameter
15	Speed Limit Angle	Speed limit angle
16	Small Circle Speed Limit	0: ineffective, 1: effective
17	Stir Time	Stir time for spraying the powder and drawing lines
18	Drill On Time	Drill on time
19	Drill Lift Time	Drill lift time
20	Interpolation Period	Interpolation period
21	Chord Height Tolerance	Chord height tolerance

Torch Up after Pause: Choose 1, press “torch up delay” after pause, torch moves up after the time, after start again, press “torch down delay”, torch moves down after the time, choose 0, after pause, torch keeps the current cutting height.

Edge Pierce: Valid: torch moves the pierce point, options column appear, choose “edge pierce”, “continue locally”, “no pierce”.

Edge Pierce, this moment can manually move torch, away from original path, choose plate edge pierce, then cut back to the previous point in shortest path, continue the left cutting, equal to cutting return after pause, can reduce preheat time for thick plate and improve cutting efficiency.

Local Pierce, pierce at local point and continue left cutting.

No Pierce, idle run the path till next pierce point, new tip appears.

Note: when several pierce points, there is tip for every pierce point.

Smooth Precision: When use parts drawings not made by CAD, such as art word, with lots of small sections, use smoothness precision to improve cutting efficiency.

Craft

Flame

Para	Mode			
Parameter	Value	Unit	Range	
Ignition Time	1.5	s	0.0~20.0	Calculate
Preheat Time	100.0	s	0.0~999.0	Circle
Low Preheat Time	0.0	s	0.0~100.0	
High Preheat Time	0.0	s	0.0~100.0	
Multi Pierce Time 1	0.0	s	0.0~100.0	
Multi Pierce Time 2	0.0	s	0.0~100.0	
Pierce Time	0.5	s	0.0~30.0	
Move Pierce Time	0.0	s	0.0~10.0	
Climb Time	0.0	s	0.0~10.0	
Torch Up Time	1.0	s	0.0~100.0	
Torch Down Time	0.8	s	0.0~100.0	
Pierce Up Time	1.0	s	0.0~100.0	
Pierce Down Time	0.8	s	0.0~100.0	
Cutting Off Time	0.0	s	0.0~10.0	
Stop Time	0.0	s	0.0~100.0	
Info:				
System	Speed	Control	Mode	Switch
Ignitor	0	0~1	0~1	
High Preheat Oxygen	0	0~1	0~1	
Low Preheat When Cut	0	0~1	0~1	
High Preheat When Cut	0	0~1	0~1	
Pierce Level No.	0	0~2	0~3	
Torch Up Then Cut Oxy	0	0~1	0~1	
Keep Output After Cut	0	0~1	0~1	
(flame)the out			0~1	
1	Ignition Time	Ignition time		
2	Preheat Time	Preheat time, default is 100s for new program		
3	Low Preheat Time	Low preheat time		
4	High Preheat Time	High preheat time		
5	Multi Pierce Time 1	Multi pierce time 1		
6	Multi Pierce Time 2	Multi Pierce time 2		
7	Pierce Time	Pierce time at pierce height		
8	Move Pierce Time	Keep output when pierce and XY axis start to move		
9	Climb Time	Moving time of XY axis starting to move at climbing speed		
10	Torch Up Time	Torch up time after cutting		
11	Torch Down Time	Torch down time after ignition		
12	Pierce Up Time	Torch up time to pierce height after preheat		
13	Pierce Down Time	Torch down time to cutting height after pierce		
14	Cutting Off Time	Input positive value, after torch stops, cutting output close after a		

		period of time for eliminate cutting lag angle, then torch move up; input negative value, close cutting output before torch stops.
15	Stop Time	Stop time
16	Ignitor	Set whether use ignitor, when don't use, keep preheat between two cuttings, when use, ignite again for every pierce
17	High Preheat Oxygen	Set whether use high-pressure preheat oxygen to assist preheat
18	Low Preheat When Cut	Whether keep low preheat oxygen on after preheat and start to cut
19	High Preheat When Cut	Whether keep high preheat oxygen on after preheat and start to cut
20	Pierce Level No.	Pierce level number
21	Torch Up Then Cut Oxy	Torch moves up, then turn on cut oxygen
22	Keep Output After Cut	Keep output after cut
23	Flame THC Out	Flame THC out

Ignition Time: time of torch ignition

Preheat Time: before pierce turn on low preheat and high preheat oxygen

Note: when use auto ignitor

1, when ignite, firstly turn on gas output, then turn on low preheat output, then turn on ignitor output, after ignition time, turn off ignitor output, keep gas and low preheat output.

2, when pierce (output off), according to setting of "high preheat" to judge whether turn on high preheat. If choose high preheat, firstly turn on gas output, then turn on low preheat output, then turn on ignitor output, after ignition, turn off ignitor output, keep gas and low preheat output, turn on high preheat, preheat starts, after preheat delay, pierce starts; if don't use high preheat, firstly turn on gas output, then turn on low preheat output, then turn on ignitor output, after ignition, turn off ignitor output, keep gas and low preheat output, preheat starts, after preheat, pierce starts.

Don't use auto ignitor

1, when ignite, ignition time set 0, firstly press K1 to open gas and low preheat output, manually ignite gas

2, when pierce, controller doesn't open ignitor output, ignition time skip, directly preheat starts

Pierce Time: after preheat, torch moves up to pierce position, open cutting oxygen (high oxygen) output, the time of pierce starts

Move Pierce Time: after start pierce, before torch moving down to cutting height, X and Y start moving time, the time is to avoid steel slag

Climb Time: after pierce, torch moving time at climbing speed, climbing speed is set in speed parameters, percentage of cutting speed

Torch Up Time: after cut, torch move up time

Torch Down Time: after ignition, torch move down time

Note: 1, torch up time and torch down time decide torch idle-run and preheat height, usually up time is longer than down time

2, before start cutting every time, firstly move torch to align plate start point, and adjust torch to proper cutting height, then start, controller firstly executes torch up, then idle-run to pierce position and ignite, after ignition, move down to cutting height (torch down time), after cutting, execute torch up, idle-run to start position, don't execute torch down, so before next start, firstly need to adjust torch to proper cutting height.

Pierce up time: after preheat, torch move up time

Pierce down time: after pierce, torch down time

Note: 1, pierce up time and pierce down time decide torch cutting height, usually up time is longer than down time.

2, move up before pierce to avoid steel slag

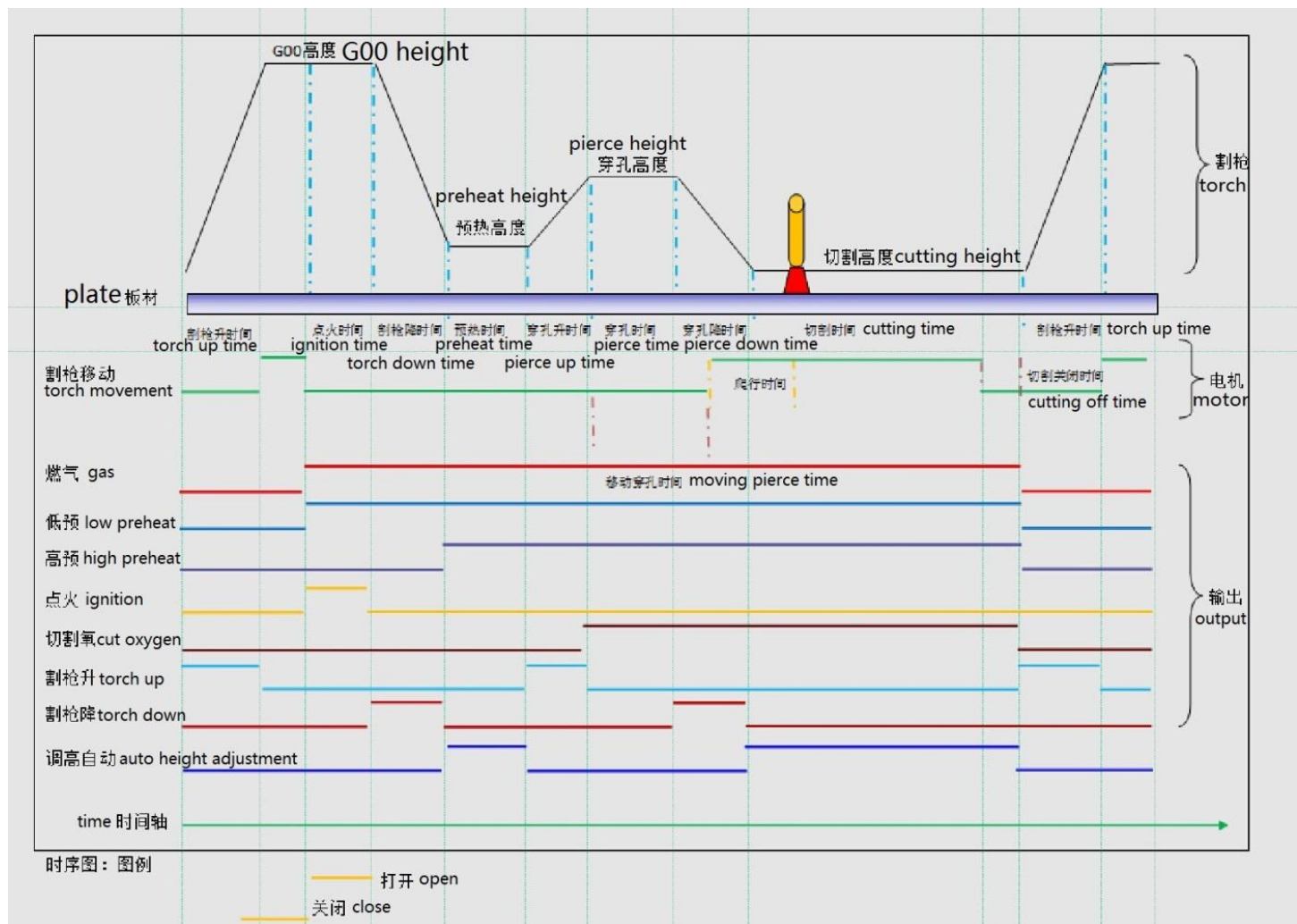
Cutting Off Time: after cutting, keep cutting output time, to avoid lag angle, after the time, torch starts to move up

Ignitor: when set 0, before move to the next pierce point, keep gas and low preheat output (with fire), set 1, close gas and low preheat output after cutting current part, ignite again at the next pierce point

High Preheat Oxygen: when set 0, don't use high preheat, when set 1, use high preheat to assist preheat

Low Preheat: 0 to close low preheat during cutting, 1 to keep low preheat during cutting
High Preheat: 0 to close high preheat during cutting, 1 to keep high preheat during cutting
 Note: can't set 0 at the same time of keep low preheat and keep high preheat

Flame cutting procedure



Plasma

Para	Mode			
Parameter	Value	Unit	Range	
Torch Up Time	0.0	s	0.0~100.0	Calculate
Torch Down Time	0.8	s	0.0~100.0	Circle
Location Up Time	0.500	s	0.000~3.000	
Arc Strike Time	2.0	s	0.1~20.0	
Arc Success Check Delay	0.0	s	0.0~20.0	
Times Of Retry	5		0~20	
Pierce Up Time	0.0	s	0.0~100.0	
Pierce Time	0.3	s	0.0~20.0	
First Pierce Time	0.5	s	0.0~30.0	
Pierce Down Time	0.0	s	0.0~100.0	
Move Pierce Time	0.0	s	0.0~10.0	
Climb Time	0.0	s	0.0~10.0	
THC Delay	0.0	s	0.0~10.0	
Stop Time	0.0	s	0.0~10.0	
Stop Exhaust Time	0.0	s	0.0~100.0	
Info:				
System	Speed	Control	Mode	Switch
Figure	Machine	Offset	Advanced	Save
THC Off Spd Dn Ratio	90	%	0~100	
THC Off Distance	0.000	mm	0.000~90.000	
Arc Off Delay	0.0	s	0.0~100.0	
Arc Break Time	0.0	s	0.0~10.0	
Location Check	0	0~1	0~1	
Locate After Pause	0	0~1	0~1	
Arc Strike Success Check	0	0~1	0~1	
Arc Output Used Alone	1	0~1	0~1	
THC For Small Circle			0~1	
1	Torch Up Time	Time of torch moving up after cutting		
2	Torch Down Time	Torch lifter has no location switch (zero point switch), location feedback set 0, torch down time, torch height is arc strike height; when check location feedback, down all the time till zero point		
3	Location Up Time	When location feedback valid, check location switch signal input, close torch down output, open torch up output, keep location up time and then close, torch height is location height (arc strike height)		
4	Arc Strike Time	Time of opening arc strike switch, end till check arc strike success feedback signal		
5	Arc Success Check Delay	Arc success check relay		
6	Times of Retry	After arc strike fails, times of try		
7	Pierce Up Time	After finish arc strike, time of torch up to pierce height, when don't check arc strike success feedback signal, time from arc		

		strike time ends
8	Pierce Time	Time of torch at pierce height, to pierce though plate
9	Pierce Down Time	After finish pierce, time of torch down to cutting height
10	Move Pierce Time	Keep output during pierce, XY axis start to move
11	Climb Time	After finish cutting, time of torch moving at climbing speed
12	THC Delay	After torch starts to move, open height adjustment auto signal output
13	Stop time	After finish cutting, time of torch stopping movement
14	Stop Exhaust Time	Stop exhaust time
15	THC Off Speed Down Ratio	During cutting, speed down to setting range, close THC auto signal output, reduce arc voltage THC wrong action
16	THC Off Distance	Turn off THC at a position away from the end point
17	Arc Off Delay	Turn off arc time
18	Arc Break Time	When arc strike success feedback valid, set time, continue cutting after arc break
19	Location Check	Torch lifter has location switch (zero point switch), set 1
20	Arc strike Success Check	After arc strike, whether check arc strike success feedback signal input, plasma power or arc voltage auto THC has the signal, can connect to the controller, set 1
21	Arc Output Used Alone	Arc strike output pin is used alone
22	THC For Small Circle	Whether THC works when cut small circles

Torch Up Time: after cutting, time of torch moving up

Torch Down Time: torch lifter has no location switch (zero point switch), location feedback set 0, torch down time end, torch height is arc strike height

Note: when check location feedback, torch down time invalid

Location Up Time: when check location feedback valid, check location switch signal input, close torch down output, open torch up output, keep location feedback and close, torch height is location height (arc strike height)

Note: when don't check location feedback, location up time invalid

Arc Strike Time: time of arc transfer

Times of Retry: after arc strike fails, times of restart arc strike

Note: 1, if choose check arc strike success feedback valid, check arc strike success feedback signal input, end arc strike time, or firstly close arc strike output, restart arc strike, try arc strike according to times setting, if can't arc strike, "arc strike fails" wait for next command

2, if choose check arc strike success feedback invalid, end arc strike time and start next movement, times of retry invalid

Pierce Up Time: after arc strike, time of torch moving to pierce height

Note: choose check arc strike success feedback valid, controller checks arc strike success feedback signal input, timing, or start after arc strike time

Pierce Time: torch up to pierce position, start to pierce

Pierce Down Time: after pierce, torch down to cutting height

Move Pierce Time: after torch starts pierce, before torch down to cutting height, XY start to move, this period of time to avoid steel slag

Climb Time: after pierce, torch moving time at climbing speed, climbing speed is set in parameters, percentage of cutting speed

THC Delay: after pierce, open the time

Note: set the time, help THC to avoid unsteady arc voltage time and reduce torch shake

THC Off Speed Down Ratio: during cutting, speed change is in the range, close auto height adjustment, reduce arc voltage auto THC wrong action caused by speed change, set 99, cutting speed is 99% of set speed, don't

close THC auto output caused by speed change

Arc Break Time: check arc strike success feedback valid, set time, so that torch continues to move after arc break

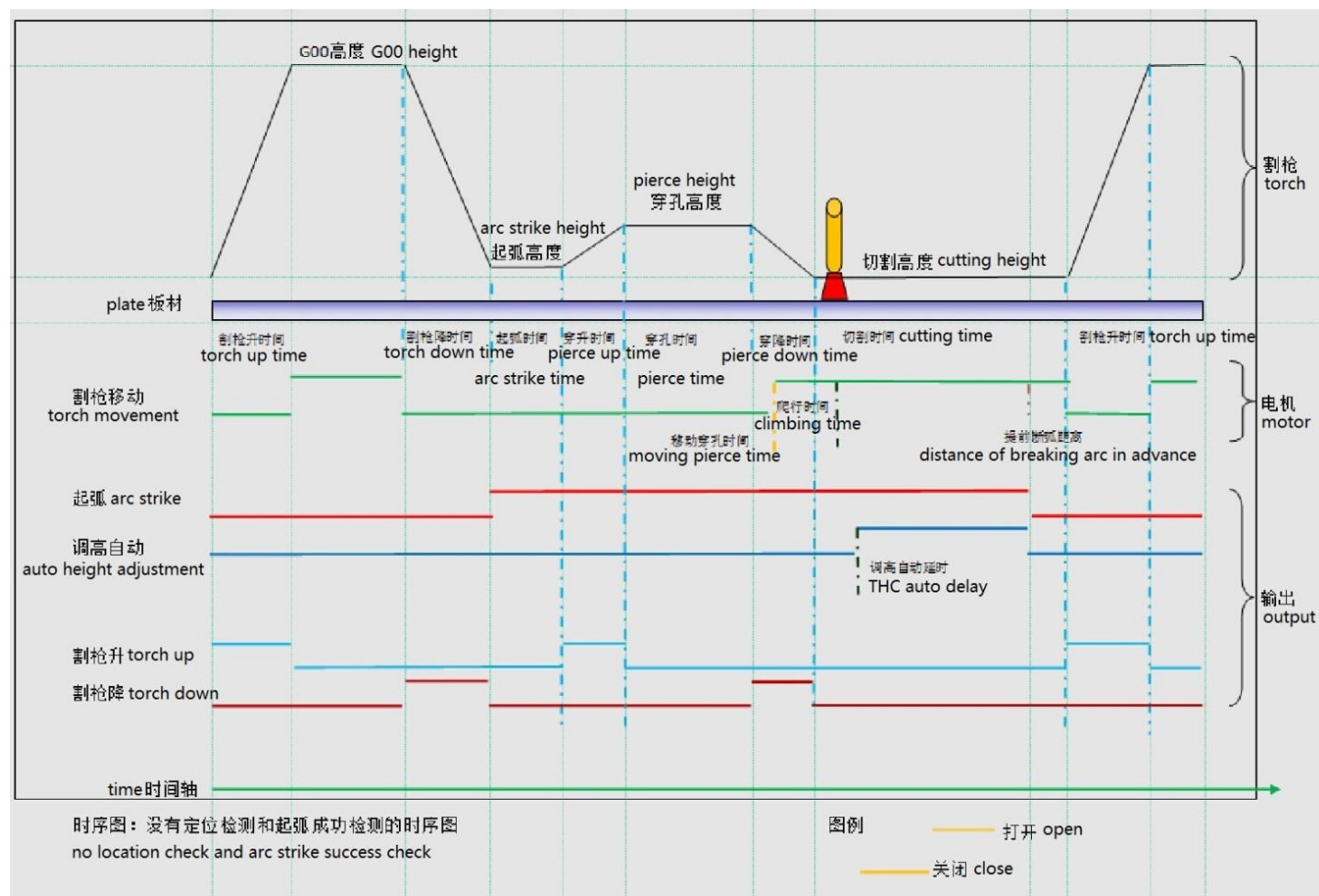
Note: don't check arc strike success feedback, time of arc break invalid

Location Check: torch lifter has location switch (zero point switch), can set 1, choose check location feedback, or set 0

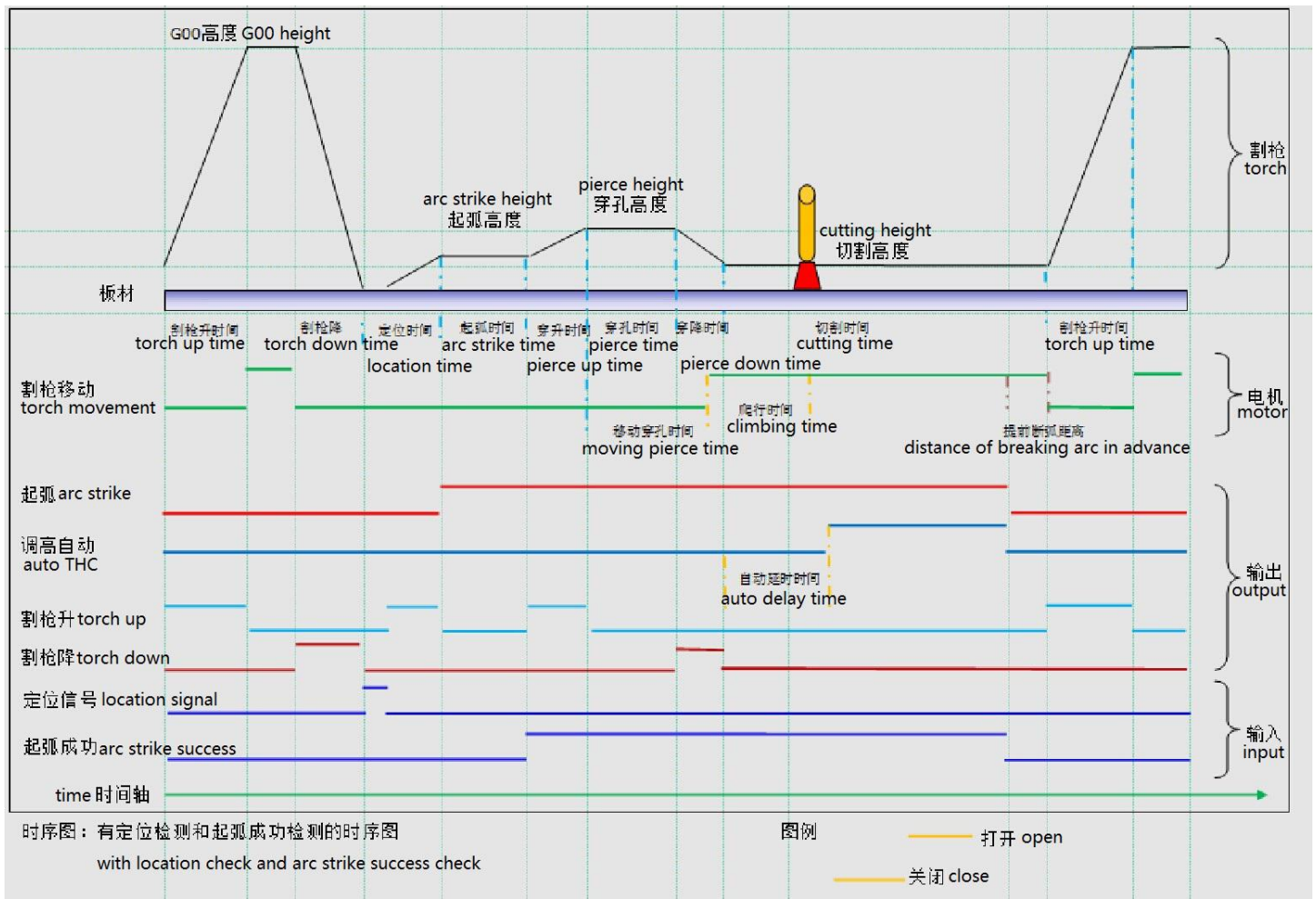
Note: set 1, torch location, keep torch down output, till check location switch signal input close

Arc Strike Success Check: open arc strike output, whether check arc strike success feedback signal input, plasma power or arc voltage auto THC has the signal output, can connect to controller input, set 1

Plasma cutting procedure (no location check and arc strike success check)



Plasma cutting procedure (with location check and arc strike success check)



Figure

Para	Figure								
Parameter		Value	Unit	Range	Calculate Circle				
Pretreat Figure			0~1	0~1					
Kerf Display		1	0~1	0~1					
Outline Display		0	0~1	0~1					
Pierce No. Display		0	0~1	0~1					
Info:									
System	Speed	Control	Mode	Switch	Figure	Machine	Offset	Advanced	Save
1	Pretreat Figure		You'd better not choose figure pretreatment for oversized file						
2	Kerf Display		Cancel kerf line display to simplify figure display						
3	Outline Display		Cancel outline display to simplify figure display						
4	Pierce No. Display		Cancel pierce number display to simplify figure display						

Machine

Para	Machine		
Parameter	Value	Unit	Range
External Limit		0~1	0~1
Soft Limit	0	0~1	0~1
Torch Collision Check	0	0~1	0~1
Pneumatic Lift	0	0~1	0~1
Laser Location	0	0~1	0~1
Zero Point Switch	0	0~1	0~1
To Start Point	0	0~1	0~1
Alarm Stop Mode	0	0~1	0~1
Torch 1 Mode	0	-1~1	-1~1
Torch 2 Mode	0	-1~1	-1~1
Torch 3 Mode	1	-1~1	-1~1
Torch 4 Mode	1	-1~1	-1~1
Command Pulse Output Mod	0	0~1	0~1
Info: 1 use, 0 not			

System	Speed	Control	Mode	Switch	Figure	Machine	Offset	Advanced	Save
1	External Limit		1 effective, 0 ineffective						
2	Soft Limit		1 effective, 0 ineffective						
3	Torch Collision Check		1 effective, 0 ineffective						
4	Pneumatic Lift		1 effective, 0 ineffective						
5	Laser Location		1 effective, 0 ineffective						
6	Zero Point Switch		1 effective, 0 ineffective						
7	To Start Point		1 effective, 0 ineffective						
8	Alarm Stop Mode								
9	Torch 1 Mode								
10	Torch 2 Mode								
11	Torch 3 Mode								
12	Torch 4 Mode								
13	Command Pulse Output Mode								

Offset

Para	Offset			
Parameter	X Direction	Y Direction	Range	
Drill Torch Offset	0.000	0.000	-800.000~800.000	Calculate Circle
Line Drawing Offset	0.000	0.000	-800.000~800.000	
Flame:Laser Locate Offse	0.000	0.000	-800.000~800.000	
Plasma:Laser Locate Offs	0.000	0.000	-800.000~800.000	
Info:				
System	Speed	Control	Mode	Switch
Figure	Machine	Offset	Advanced	Save
1	Drill Torch Offset		Offset distance between the drill torch and cutting torch	
2	Line drawing Offset		Offset distance between the line-draw torch and cutting torch	
3	Flame: Laser Location Offset		Offset distance between the laser assist location device and flame cutting torch	
4	Plasma: Laser Location Offset		Offset distance between the laser assist location device and plasma cutting torch	

Advanced

Para	Advanced		
		Restore Default	Restore
		Save As Default	Save As
		Export Parameter	Export
		Import Parameter	Import
		Manage Parameter	Manage

System	Speed	Control	Mode	Switch	Figure	Machine	Offset	Advanced	Save
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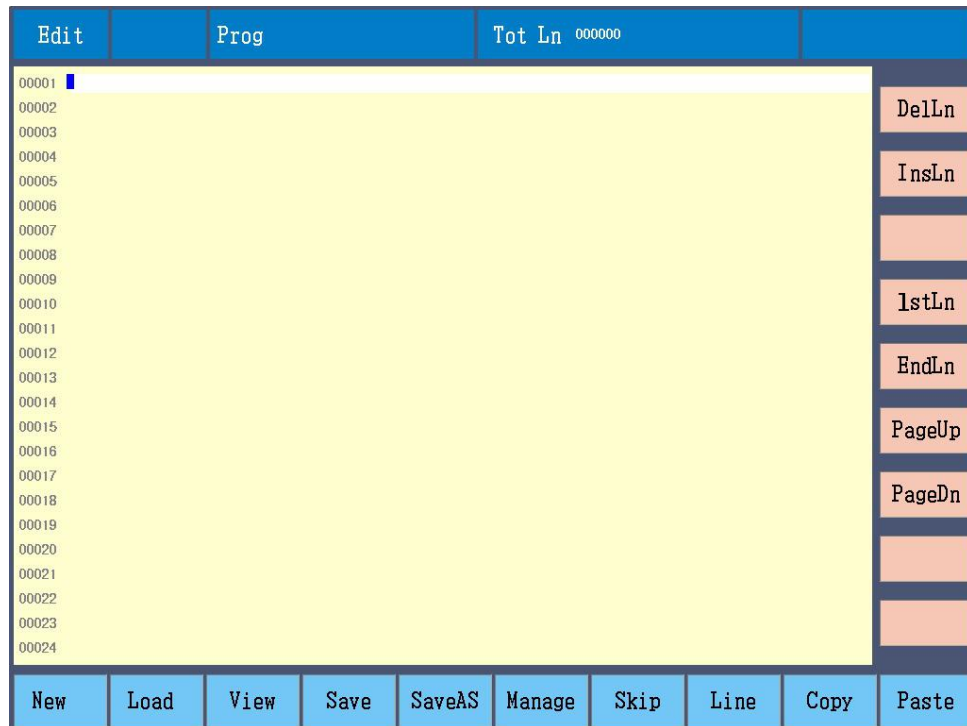
1	Restore Default	All parameters become default
2	Save As Default	Save all parameters as default
3	Export Parameter	Create parameter file in SD card, expanded name "PAG", existed parameter file will be replaced, please backup
4	Import Parameter	Lead in parameter file in SD card to replace all parameters, if from U disk, firstly by manager, save all parameter file in SD card
5	Manage Parameter	Set parameter revise permission

Note: 1, restore and save default, need to input password 999, after testing machine, the machine supplier should save parameter default before sales.

2, machine users can save as default, but cover machine maker's parameters, if cover and want to restore machine maker's default, can use lead-in parameter file.

Chapter 6 Edit

Main menu press Edit



6-1 edit function

New, clear edit area, create a new parts program

Open, open a parts program

View (preview), preview current parts program

Save, save current parts program

SaveAs: save current parts program as a new file

Manage: open file manager

Del Ln (delete line): delete current line

Line: input program line number and go to that line

6-2 codes instruction

Every action of CNC machine running according to regulate program, every machine program be composed of some instruction segment, and every instruction segment be composed of some function word, each function word must start by letter, parameter follow.

Definition of function word:

N: The No. of instruction segment

G: Prepare function

M: Assistant function

T: Knife function (it's kerf width in this controller)

L: Cycle times or delay time

X: X axis absolute coordinate

Y: Y axis absolute coordinate

U: distance of X axis relative points

V: distance of Y axis relative points

I: When cutting arc, the value of the coordinate of the circle centre subtract X axis start point value

J: When cutting arc, the value of the coordinate of the circle centre subtract Y axis start point value

R: Specified arc radius

H: Chord height of the arc

A: assistant variable

F: Specified moving speed, used for G01, G02 and G03

Attention 1: There are some appointments:

X [U]n -- It can be X or U, n express a value, but only appear once.

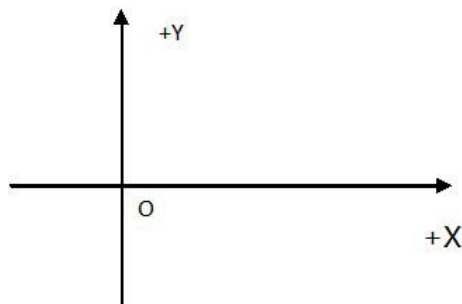
Y [V]n -- It can be Y or V, n express a value, but only appear once also.

PPn -- It can be assembled random axis, at least include one axis, also can include two axes.

Attention 2: The instruction executes order is sequence (except transfer and call sub program instruction); In same program the M,S and T will be executed before G instruction.

6-3 Coordinate System

This controller uses standard right angle coordinate system, as below



6-4 G command (Basic Prepare Command)

1) G92 reference point setup

When set up a program, coordinate value of fabricating starting point (reference point) must put in 22

front of program and set up with absolute coordinate.

Format: G92 Xn Yn

If behind G92, there is no X, Y, then make current X, Y coordinate as reference point. Generally to locate with machine origin, there is no X, Z behind G92.

2) G90/G91

Absolute coordinate G90 (default) / relative coordinate G91;

Using G90, X, Y are coordinate values, U, V are relative values for current point; using G91, X, Y and U, V all are relative values for current point.

Format: G90

Format: G91

e.g. 1: G92 X0 Y0

G91 // relative coordinate

G00 X100 Y100 // rapidly locate to (100, 100), equal to G00 U100 V100

G01 X500 Y100 // straight line to the position (600, 200), equal to G01 U500 V100

e.g. 2: G92 X0 Y0

G90 // absolute coordinate, default

G00 X100 Y100 // rapidly locate to (100, 100)

G01 X600 Y200 // straight line to (600, 200)

3) G20/G21 British system/ metric system instruction

G20 British system, X, Y, I, J, R, U, V, H, F, behind G20, all are British system unit

G21 Metric system (default), X, Y, I, J, R, U, V, H, F, behind G21, all is metric system unit

Format: G20

Format: G21

4) G00 point movement

This command is to go to specified position rapidly. When two axes have displacement, the controller uses max. limit speed by multiplying power, from starting point to finishing point move straightly. G00 moves, affected by speed multiplying power.

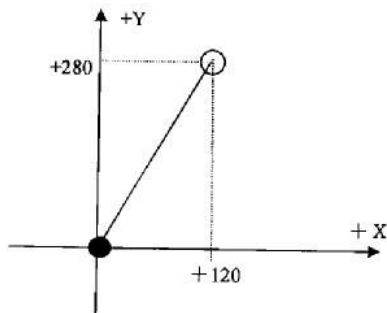
Format: G00 X [U]n Y[V]n

Or G00 PPn

e.g.: G92 X0 Y0

G00 X120 Y280

(or G000 U120 V280)



- current torch position
- torch expectant position

5) G01 straight line cut

This command is to make cutting tool to straightly go to specified location, as cutting movement command, one axis or two axes straight-line interpolation movement. Movement speed can be specified by F.

Format: G01 X[U]n Z[W]n [Fn]

Or G01 PPn [Fn]

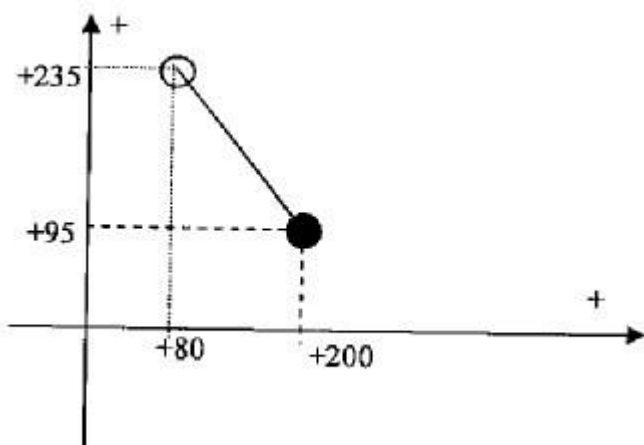
e.g.: G92 X0 Y00

G00 X200 Y95

G01 X80 Y235

(or G01 U-120 V145)

M02



- current torch position
- torch expectant position

6) G02/G03 arc cut

This command is for arc interpolation, clockwise arc G02, anticlockwise arc G03,

Format: G02[03] X[U]n Y[V]n In Jn [Fn] or G02[03] X[U]n Y[V]n In Rn [Fn]

G02[03] PPn In Kn [Fn] or G02[03] PPn Rn [Fn]

e.g. (G02)

G92 X0 Y0

G00 X40 Y50

G02 X160 V0 I60 J20

G28

M02

e.g. (G03)

G92 X0 Y0

G00 X40 Y50

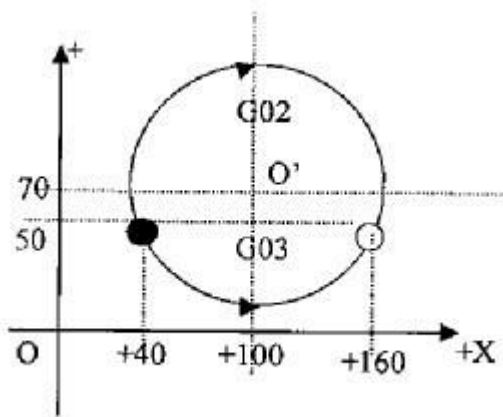
G03 X160 V0 I60 J20

(or G03 X160 V0 R63.25)

G28

24

M02



- current torch position

- torch expectant position

Instruction:

I、 J are X axis, the center of the circle in Y axis has a increment for starting point

R is the radius of the circle (R is positive value, when arc ≤ 180 degree, R is radius)

If I、 J are specified, don't use R; vice versa

7) G04 pause / delay command

This command is to set up delay, when program run to this command, program will be delayed as L specified time, unit is second

Format: G04 Ln

e.g.: G04 L2.4 (delay 2.4 s)

When run G04, press [start] to stop delay, to continue the program after G04, press [esc] to stop current program

8) G26, G27, G28 back to reference point

This command is to make cutting tool back to the reference point

Format: G26 X axis back to reference point

G27 Y axis back to reference point

G28 X, Y axis back to reference point at the same time

e.g.: G28 (X, Y axis back to reference point at the same time, equal to G00)

9) G22/G80 loop statement

This command is for program loop, G22 is the start of loop, and the number of loops, G80 is the end of the loop, can nest loop, not over 5 levels, G22 and closest G80 is a loop.

Format: G22 Ln_ (L is the number of loop)

Loop

G80

e.g.: N000 G92 X100 Y100

N001 G00 X60 Y80

N002 G22 L5-----start of the first-level loop

N003 G00 V50 U-25

N004 G22 L5-----start of the second-level loop

N005 G01 U5 V-10

N006 G80-----end of the first-level loop

25

N007 G80-----end of the second-level loop

N008 G28

N009 M02

10) Cutting tool radius compensation statement (G40、G41、G42)

Format: G41 (or G42) Rn

.

Program section in need of compensation

.

.

G40

Remark: G41 is along fabricating route, left compensation half of flame diameter

G42 is along fabricating route, right compensation half of flame diameter

G40 is excursion end

Because cutting tool compensation is finished automatically, before G41, G42, there should be G00 rapid location statement, so that the nozzle adjusts the position; after G40 cancels compensation, it needs a G00 statement to adjust the position back.

Finish M80 all output ports are closed

6-5 M assistant function

M00: program pause command, press [Start] to continue

M02: program end command, program is in the state of wait

M30: same as M02

M10/M11: gas (acetylene) valve switch, M10 (on), M11 (off)

M12/M13: cut oxygen valve switch, M12 (on), M13 (off)

M14/M15: torch up switch, M14 (on), M15 (off)

M16/M17: torch down switch, M16 (on), M17 (off)

M24/M25: preheat switch, M24 (on), M25 (off)

M20/M21: ignition switch, M20 (on), M21 (off)

M07: pierce fixed cycle (enter M07, can't return, can move torch)

M08: close cut fixed cycle

Flame cut operation as below,

M07

If gas (acetylene) valve is closed, then open gas (acetylene) ignition

Torch down (torch down delay, M71)

Turn on preheat oxygen valve, preheat delay start, if preheat time is not enough, press [Pause] key, preheat delay can automatically be longer to 100s, if preheat is ready, press [Start] key, preheat is over, and press F7 [Set] to end preheat and save parameter.

Note: it is different from SH series controller, and there are 3 options of extend, set and skip.

4, Torch up (pierce torch up delay, M72)

5, Turn on cut oxygen valve (M12), after delay pierce, torch down (pierce torch delay M73)

6, Turn on torch height controller (M38), start to run next program

Plasma cut operation as below:

M07

1, Torch down (torch delay, M71)

2, If choose pierce location (parameter setup) valid, then torch down, touch low limit switch, stop; torch up, after pierce location delay, torch stop

3, Turn on arc switch

4, check “arc voltage success” signal, if choose 0 (not check) in the parameter setup, then don’t check arc voltage, after start arc is successful, delay pierce (s)

5, Turn on torch height controller (M38), start to run next program

M08 turn off cut fixed loop

Flame cut operation as below:

1, Turn off cut oxygen (M13)

2, Turn off torch height controller (M39)

3, Torch up (M70)

Plasma cut operation as below:

1, Turn off arc voltage switch (M13)

2, Turn off torch height controller (M39)

3, Torch up (M70)

M50 pierce

1, torch up (M72), plasma has no this movement

2, Turn on cut oxygen (M12), or plasma start arc, check signal of “arc voltage success”

3, torch down (M73), plasma has no this movement

4, Turn on the torch height controller (M38)

M52 ignition fixed cycle

Turn on gas (acetylene) valve (M10), turn on high voltage ignition (M20), delay ignition, turn off high voltage ignition (M21)

M70 torch up fixed cycle

It’s used for the start and the end of a program, torch up, to make torch move to another position. Turn on torch up switch (M14), delay torch up (7.3 flame parameter), turn off torch up switch (M15)

M71 torch down fixed cycle

It’s used before piercing, has adverse function of M70, the value is small, because of gravity, down is faster than up. Turn on torch down switch (M16), delay torch down (7.3 flame parameter), turn off torch switch (M17)

M72 pierce torch up cycle

It's used after preheat, torch up, avoid flying slag blocking the nozzle when turning on cut oxygen. Turn on torch up switch (M14), delay pierce torch up (7.3 flame parameter), turn off torch up switch (M15)

M73 pierce torch down cycle

It's used after preheat, finish M72, after turning on cut oxygen, torch is in cutting position, the adverse movement of M72, and value is small, because of gravity, down is faster than up. Turn on torch down switch (M16), delay pierce torch down (7.3 flame parameter), turn off torch down switch (M17)

M75 torch location delay

Plasma torch location, firstly torch down (M16), touch low limit (input port 8 XXW), torch down stop (M17), then torch up turn on (M14), after torch location delay (7.4 plasma parameter), torch up stop (M15)

M62 draw line function starts

After M62, torch offsets a unit of a draw line offset (parameter-system) till M63. There is no kerf compensation when drawing line.

M63 draw line function ends

After running M63, draw line function is over, torch return an offset from current position

M80 close

Execute M80, all output ports are closed

6-6 Manage

In edit interface, press Manage to open file manager

File	Mana			
Name	Info	Select		
0. bmp	1572936	☐		
TK30. TXT	947	☐		
1. bmp	1572936	☐		
2. bmp	1572936	☐		
5. bmp	1572936	☐		
6. bmp	1572936	☐		
7. bmp	1572936	☐		
8. bmp	1572936	☐		
TK11. TXT	355	☐		
1126	355	☐		
9. bmp	1572936	☐		
10. bmp	1572936	☐		
11. bmp	1572936	☐		
Space 0. 945 G				PageUp
Used: 0. 043 G				PageDn
Obec 66				
LoDisk	UDisk	Save	View	Search
Save	Create	Copy	Select	OK

LoDisk (local disk), display local disk directory

U disk, display U disk directory

View (preview), display current part figure

Search, search file as file name

New, build file folder

Copy, copy file to U disk and local disk

OK, confirm input or choose

Enter key: choose current file

Del: delete current file

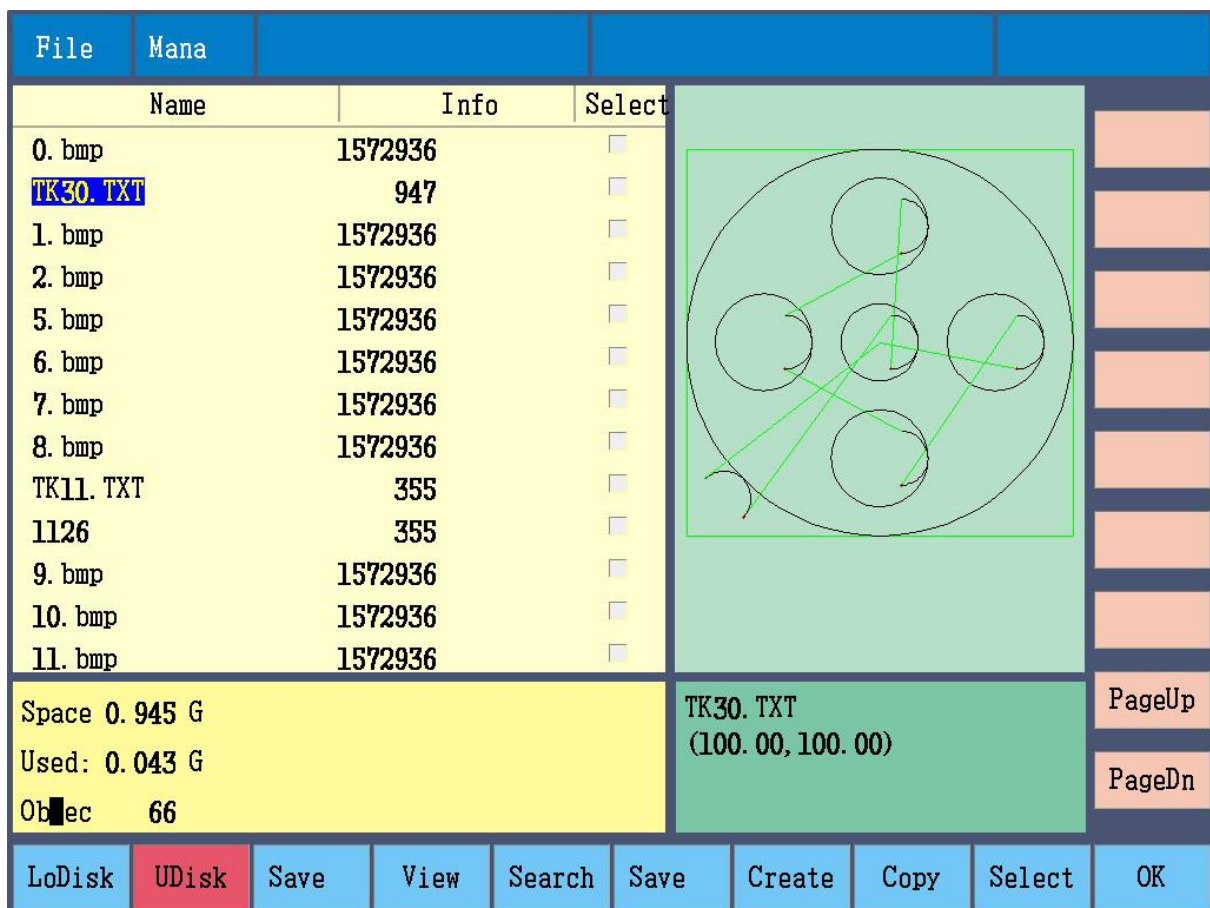
PgUp: pageup

PgDn: pagedown

Right key: enter file

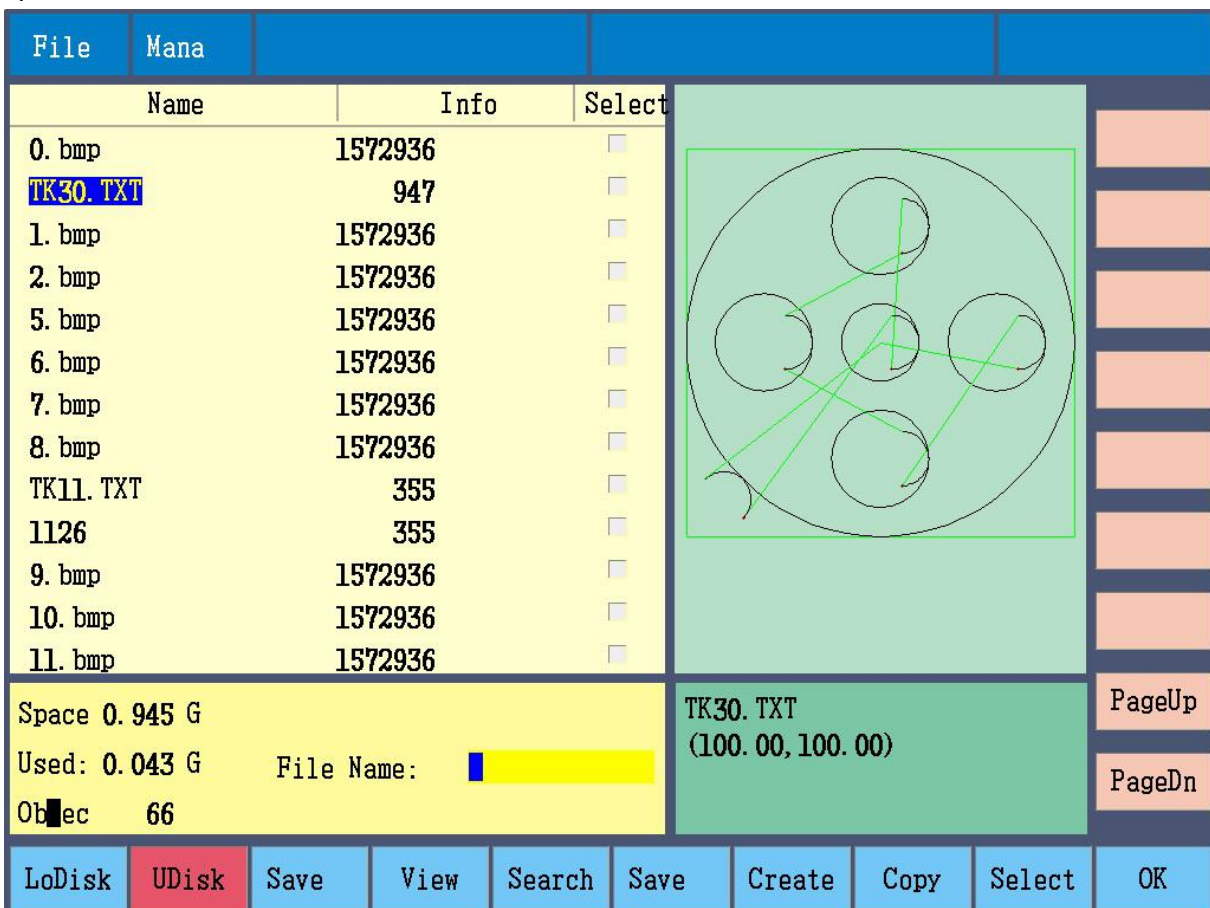
Left key: exit file

Preview current parts figure

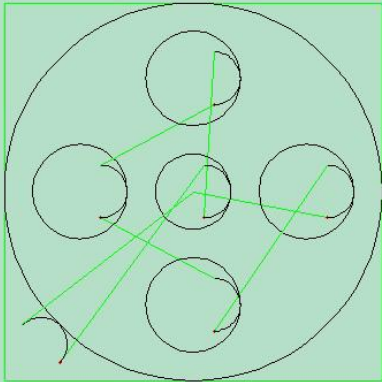


- 1, U disk format is FAT32
- 2 can copy and delete several files at the same after select
- 3, there is operation tip when cursor moves to file folder

Search, input file name to search



Create, input file folder name to build

File		Mana							
Name	Info	Select							
0. bmp	1572936	☐							
TK30. TXT	947	☐							
1. bmp	1572936	☐							
2. bmp	1572936	☐							
5. bmp	1572936	☐							
6. bmp	1572936	☐							
7. bmp	1572936	☐							
8. bmp	1572936	☐							
TK11. TXT	355	☐							
1126	355	☐							
9. bmp	1572936	☐							
10. bmp	1572936	☐							
11. bmp	1572936	☐							
Space 0. 945 G			TK30. TXT				PageUp		
Used: 0. 043 G			(100. 00, 100. 00)				PageDn		
Obec 66									
LoDisk	UDisk	Save	View	Search	Save	Create	Copy	Select	OK

Chapter 7 Diagnose

Main menu press Diag (diagnose)

7-1 diagnose

Diag		Input							
Name	Port	Level	State	Name	Port	Level	State		
Start	01	H	No	Z + Limit	17	H	No	Port	
Pause	02	H	No	Z - Limit	18	H	No	Logic	
Close	03	H	No	Z 0 Point	19	H	No		
Alarm	04	H	No	1# Locate	20	H	No		
GunCrash	05	H	No	2# Locate	21	H	No		
E Stop	06	H	No	3# Locate	22	H	No		
ArcSuccess	07	H	No	4# Locate	23	H	No		
	08	H	No		24	H	No		
X + Limit	09	H	No	Spare	25	H	No		
X - Limit	10	H	No	Spare	26	H	No		
X 0 Point	11	H	No	Spare	27	H	No		
Y + Limit	12	H	No	Spare	28	H	No		
Y - Limit	13	H	No	Spare	29	H	No		
Y 0 Point	14	H	No	Spare	30	H	No		
	15	H	No	Spare	31	H	No		
	16	H	No	Spare	32	H	No		
Port Tip: Start									
Input	Output	Drive	Encoder	AD/DA	Keyboard				Save

Input, display input state

Output, display output state
 Port, change output port level
 Logic, set current port state logic
 Save, save current port state logic

Input

Display current input port level high/low, can set current level high/low and logic, logic has “Yes”, “No” and “disable”.

“Yes”, current level has output signal.

“No”, current level has no output signal.

“Disable”, don’t send command to current port.

Output

Display current output port level high/low, can set current level high/low and logic, logic has “Yes”, “No” and “disable”.

“Yes”, current level has output signal.

“No”, current level has no output signal.

“Disable”, don’t send command to current port.

Diag	Output								
Name	Port	Level	State	Name	Port	Level	State	Port	
Gas/Preheat	01	H	No	Stir	13	H	No	Logic	
CutOxy/Arc	02	H	No	Auto THC	14	H	No		
Gun1Up	03	H	No	Ignit	15	H	No	State	
Gun1Dn	04	H	No	DriUp	16	H	No		
L Pre	05	H	No	DriDn	17	H	No		
Ignit	06	H	No	DriOn	18	H	No		
H Pre	07	H	No	Gun3Up	19	H	No		
Prehe	08	H	No	Gun3Dn	20	H	No		
Gun2Up	09	H	No	Gun4Up	21	H	No		
Gun2Dn	10	H	No	Gun4Dn	22	H	No		
L Oxy	11	H	No		23	H	No		
Powder	12	H	No		24	H	No		
Port Tip: Gas/Preheat M10									
Input	Output	Drive	Encoder	AD/DA	Keyboard			Save	

State, change output state

Adjust moving precision

Start ---> parameter-system (numerator:2, denominator: 1) ---> manual-point move-increment:100 ---> move-direction buttons-measure actual moving distance ---> parameter-system-calculation-input actual distance-press Enter, numerator & denominator change-save parameters ---> manual-point move verification ---> right or not ---> yes ---> end.

Controller upgrade

Start ---> connect U disk (FAT32 format, with upgrade file) ---> main menu GG9 ---> confirm upgrade ---> F2 Update ---> automatic upgrade, restart the controller ---> end.

Start ---> connect U disk (FAT32 format, with upgrade file) ---> press upgrade button and restart the controller ---> F2 Update ---> automatic upgrade, restart the controller ---> end.

Special setting after turn on the controller

Operation	Setting	Instruction
GG1	Check controller ID	Display controller ID
GG2	Revise time	Display or revise controller time
GG3	Format	Delete all programs in local disk
	ParaInitial (parameters initialization)	All parameters become controller factory default, if become machine supplier parameter settings, press “Parameter” – “High” – L1 back to default setting
	SetInitial (settings initialization)	All settings become controller factory default, such as “speed limitation”, “kerf” and other settings in auto and manual mode.
	Chinese/English	Chinese/English
	New Code	Set power-on password
GG5	User No.: Code:	Input machine supplier ID and verification code, we offer that ID for encryption.
GG6	Upgrade Word?	Upgrade word stock and power-on background picture
GG7	Version Info	Check controller software version
GG8	Is Change Logo Name	Connect U disk with company name
GG9	Upgrade?	Upgrade controller software
G90	Log in	There is a 6-digit number