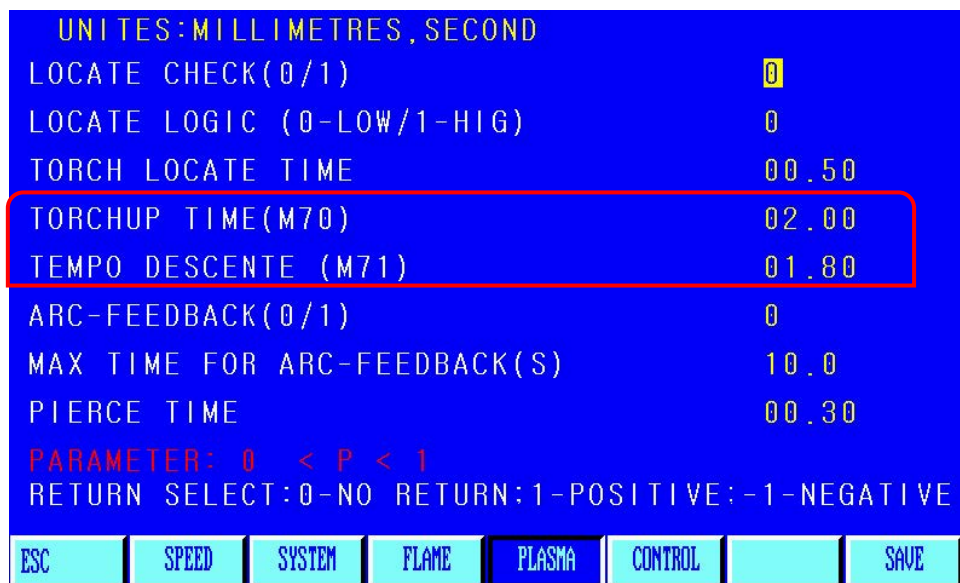# How to set the Torch Up/Dn Time—F2100S- THC

➔ Problem: Set the Torch Up/Dn Time of the system, This parameter controls the rising and falling of the torch;

Problem analysis:

❋ 1. CNC system parameter setting;

Solution：Step 1- Main interface →Press F4【SETUP】into Parameter interface→Press F4 【PLASMA】into Plasma interface as show pic1

```
UNITES:MILLIMETRES,SECOND
LOCATE CHECK(0/1)                      0
LOCATE LOGIC (0-LOW/1-HIG)             0
TORCH LOCATE TIME                      00.50
TORCHUP TIME(M70)                      02.00
TEMPO DESCENTE (M71)                   01.80
ARC-FEEDBACK(0/1)                      0
MAX TIME FOR ARC-FEEDBACK(S)           10.0
PIERCE TIME                           00.30
PARAMETER: 0  < P < 1
RETURN SELECT:0-NO RETURN:1-POSITIVE;-1-NEGATIVE

ESC   SPEED   SYSTEM   FLAME   PLASMA   CONTROL        SAVE
```

Pic1

Step2: To set TORCHUP HIGH(M70) and TEMPO DESCENTE(M71):

TORCHUP HIGH(M70)=Set Value 02.00,

TEMPO DESCENTE(M71):Set Value 02.30

Press 【 ↓ 】and 【 ↑ 】 to select the 4th row and change it into 02.00, Press【ENTER】go to the 5th row, change it into 02.30, Press【ENTER】, Press F7【GUAR/SAVE】to save the whole setting, Press 【ESC】back to the main interface.

Then have a trial cut and feedback.