How to set the machine to Flame mode

➔ Problem : Set the machine to Flame mode-then cutting

Solution overview:　　1. Flame torch and Oxygen and gas connection to the machine;

2. Adjustment mode switch;

3. THC parameter debugging;

4. CNC parameter setting;

4. Cutting testing;

Problem analysis:

❋　1. Flame torch and signal connection to the machine;

Solution: Step1. The Flame torch installs to the lifter holder.

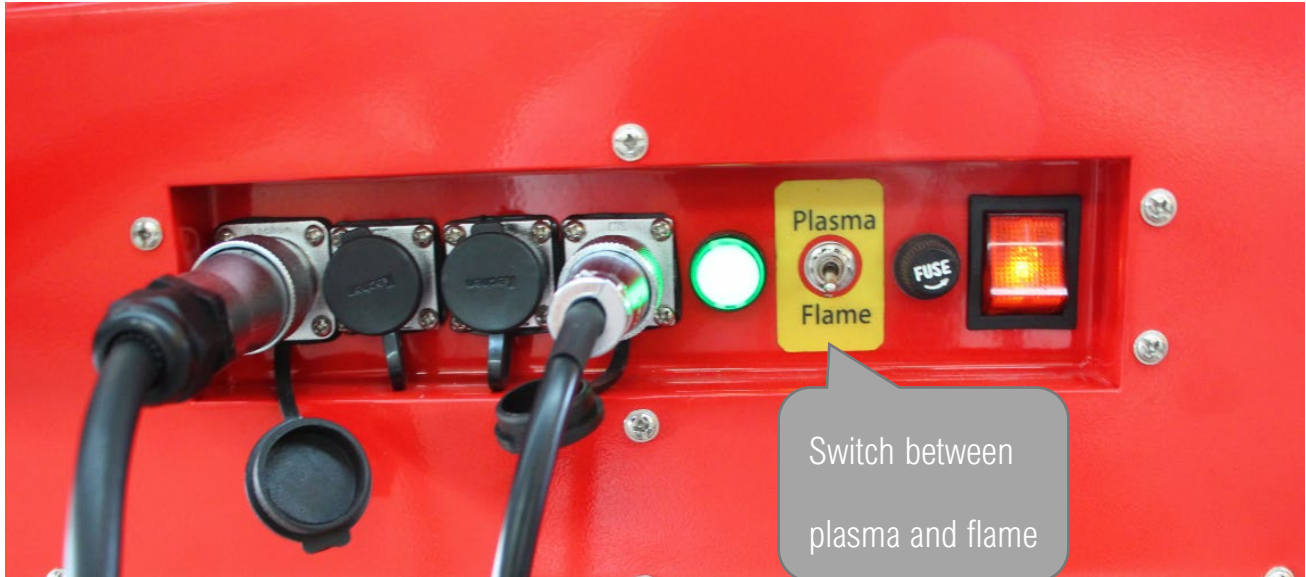Step2: Connect the Oxygen and gas to the machine

Connect the Oxygen and gas
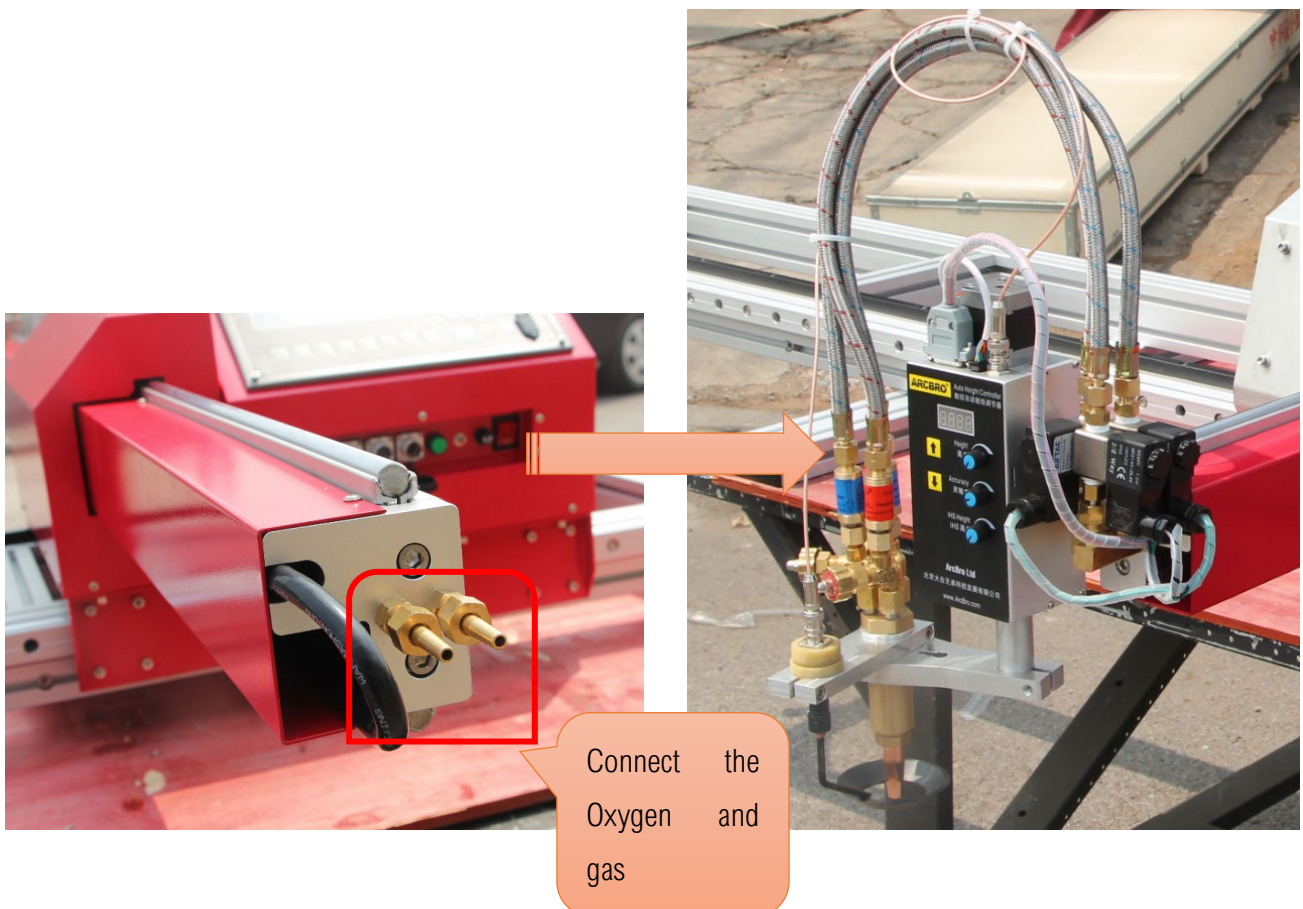
Problem analysis:

❋ 2. Adjustment mode switch;

Solution: Step1. Adjust the mode switch to Flame mode. Flip the switch Down;

Switch between

plasma and flame

Problem analysis:

❋ 3. THC parameter debugging;

Solution: Step1. The Flame torch passes through the beam and then installs to the lifter holder.

The first letter is "U" it means the THC

is working into plasma mode;

The first letter is "C" it means the THC

is working into flame mode.

THC knob instruction：

- ❋ 【Height】adjust the First knob, slight change the arc value and the height between torch and metal. Too low arc value can lead to shivering or broken arc. Too high arc value can the cutting quality or Cutting continuously

- ❋ 【Accuracy】adjust the second knob to far left: it means the susceptiveness of THC is best; if try cutting process, found that the sensitivity is too higher, may be appropriately adjusted again，Too much sensitivity leads to tremors；

Operating sequence of THC

Step 1: Turn the second knob to the max in clockwise: the susceptiveness of THC is highest; during cut, if you found the THC self-adjustment is too sensitive, you need adjusted this knob again. Usually rotate 1/3.

Step 2: Turn the first knob to change the arc value and then the torch height between torch and metal will change accordingly while cut.

Turn the adjusting knob counterclockwise: decrease the CHC voltage value Turn the adjusting knob clockwise: increase the CHC voltage value.
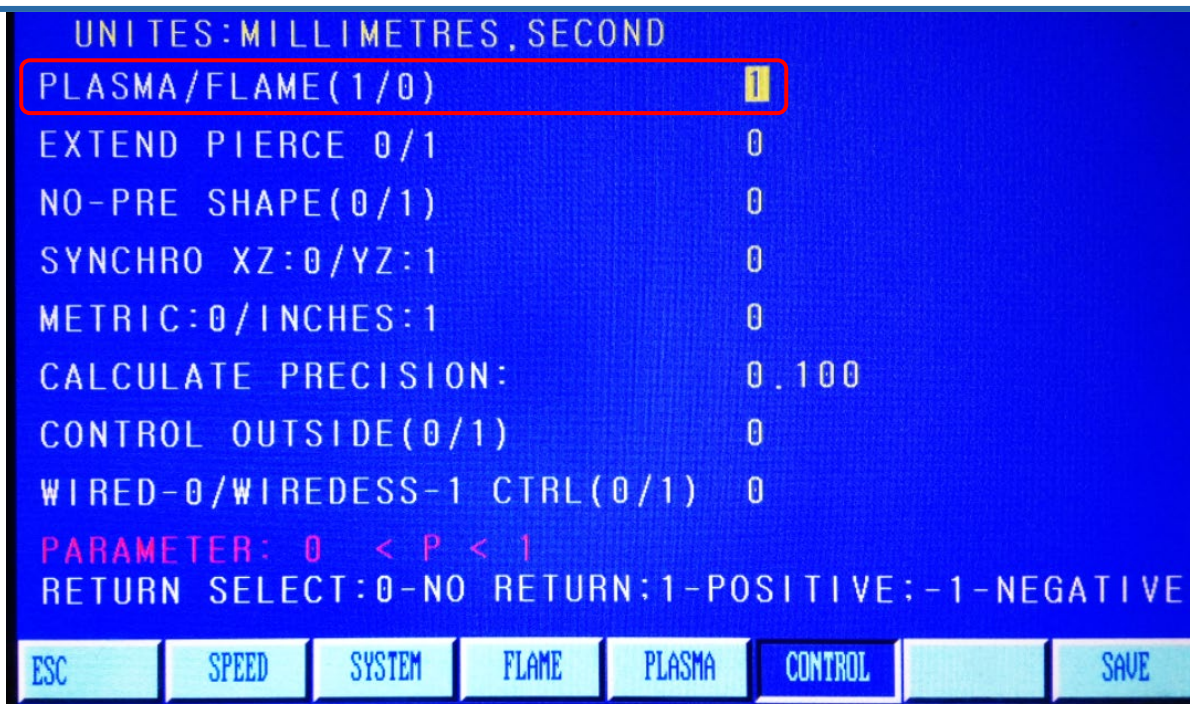
Cutting height is usually based on empirical values.

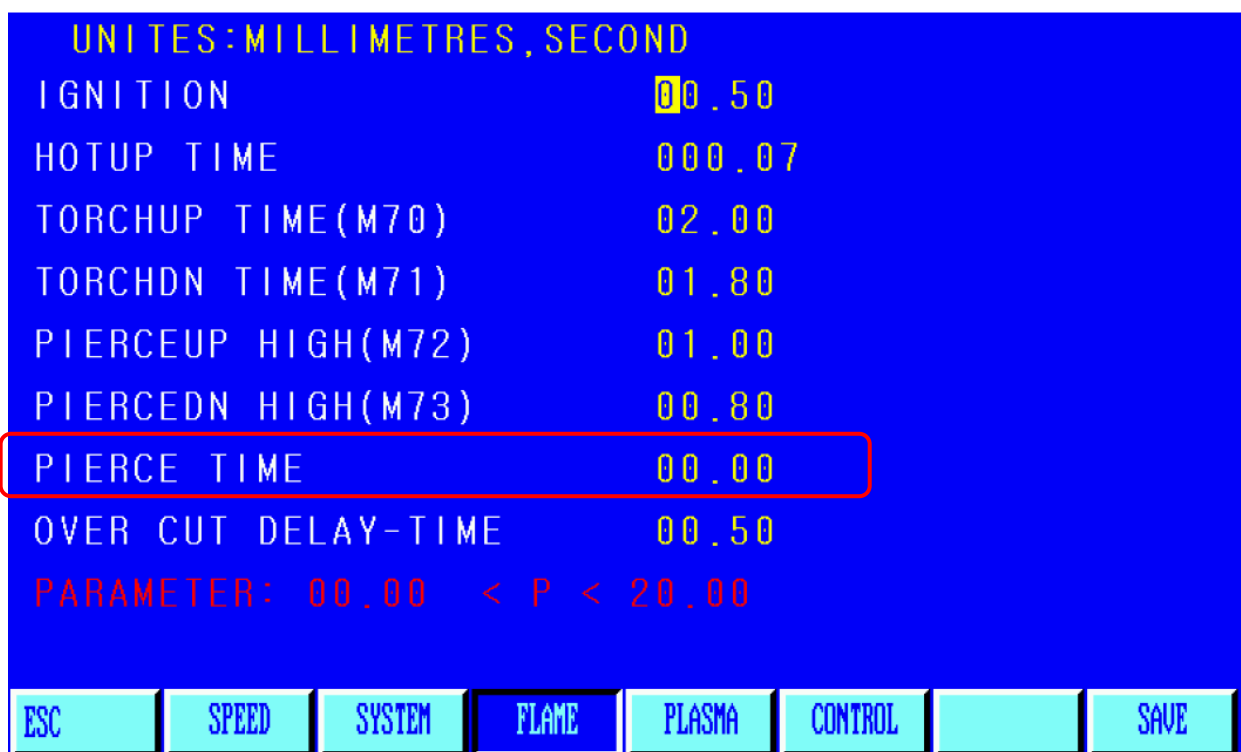Notes: For Flame cutting, you should remove the Plasma torch firstly.

Problem analysis:

- ❋ 3. CNC parameter setting;

Solution: Step 1: press F5 【CONTROL】 →Set parameter as the red mark, Change to 0；

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UNITES:MILLIMETRES,SECOND
PLASMA/FLAME(1/0)              1
EXTEND PIERCE 0/1             0
NO-PRE SHAPE(0/1)             0
SYNCHRO XZ:0/YZ:1            0
METRIC:0/INCHES:1            0
CALCULATE PRECISION:         0.100
CONTROL OUTSIDE(0/1)         0
WIRED-0/WIREDESS-1 CTRL(0/1)  0
PARAMETER: 0  < P < 1
RETURN SELECT:0-NO RETURN;1-POSITIVE;-1-NEGATIVE
```
| ESC | SPEED | SYSTEM | FLAME | PLASMA | CONTROL | | SAVE |

Step 2: Press F4 【SETUP】 in the main interface→F4 【FLAME】 →Only Set PIERCE TIME

parameter As picture;


```
UNITES:MILLIMETRES,SECOND
IGNITION                  00.50
HOTUP  TIME               000.07
TORCHUP  TIME(M70)        02.00
TORCHDN  TIME(M71)        01.80
PIERCEUP  HIGH(M72)       01.00
PIERCEDN  HIGH(M73)       00.80
PIERCE  TIME              00.00
OVER CUT DELAY-TIME       00.50
PARAMETER: 00.00  < P < 20.00
```
| ESC | SPEED | SYSTEM | FLAME | PLASMA | CONTROL | | SAVE |

NOTES: The pierce time 00.00 The pierce time due to the Steel Thickness, Steel is thicker, pierce

time is longer. Dont change other parameters . PIERCE TIME is usually based on empirical values.

Step 3: Press F7(SAVE) and turn back the main interface.

Problem analysis:

❋ 4. Cutting test;

Solution: Press F6【LIBMIN】→select one pattern→press the key "Enter"→press F6【APPLY】→press the key "ESC", return to the main interface→press F1 【AUTO】 →press the start key, and start cutting.