

## How to solve IHS functions do not work-THC200DC

➔ Problem phenomenon: The THC gives signal to IHS and the torch goes down during the cutting but the plasma torch does not rise when touch the workpiece;

- Problem analysis:
1. IHS HEIGHT is lower;
  2. The IHS cable is not connected
  3. IHS signal was not sent to THC or the THC is broken
  4. Rust of the workpiece leads to poor electrical conductivity of

the workpiece

Problem analysis:

- ✳ 1. The torch received signal from IS, but lift up too little;

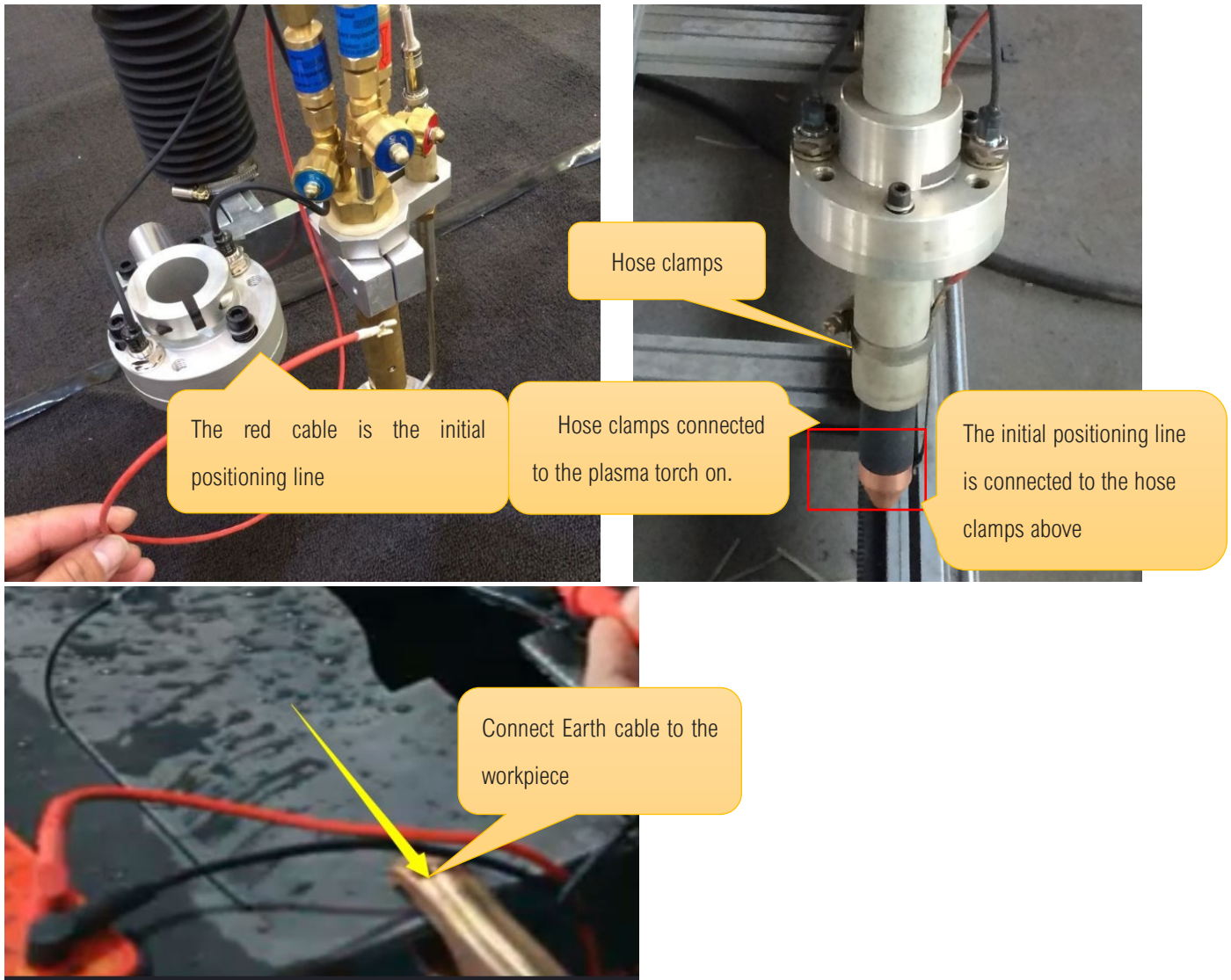
**Solution:** Turn the knob to adjust **【IHS HEIGHT】** value according to the thickness of the cutting material



Problem analysis:

- ✳ 2. If the IHS cable is connected with the ground port of THC, the lifer works means IHS functions good; You need to check the wiring; Otherwise--Go to step 3;

**Solution:** The initial positioning line is connected to the hose clamps above; Hose clamps connected to the plasma torch;

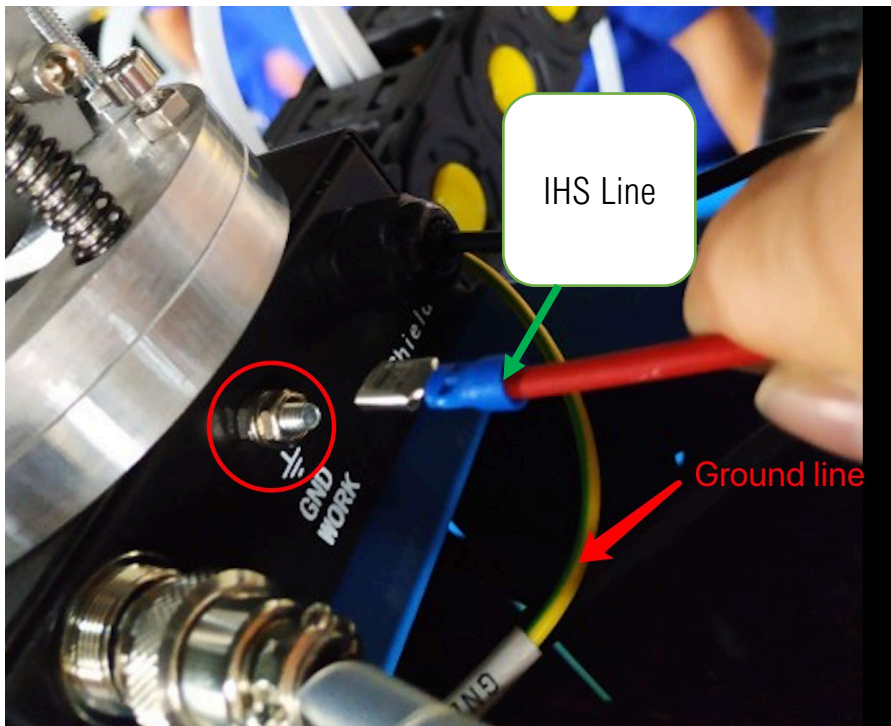


## Problem analysis:

- ✳ 3. Connect the IHS cable to the Ground point, the **【COLLISION】** indication light is on and torch rise, means that the THC can receive signal from IHS; Otherwise, no signal.

**Solution:** Reconnect the IHS cable to the Ground point, if the **【COLLISION】** indication light is off, means the THC is broken; If the **【COLLISION】** indication light is on but the lifer doesn't work, means the THC is broken; you need change your THC

# Service Support Spirit



Problem analysis:

- \* 4. Rust of the workpiece leads to poor electrical conductivity of the workpiece.

**Solution:** Remove rust and ensure the electrical conductivity of the workpiece



