How to solve THC screen appear A000 alarm—SDF-30A

➔ Problem: When A000 [A000] appeared on the THC，means that the machine does not automatically adjustment function;

Solution overview: 1. Plasma ARC+ and ARC- connection to the DIV PCB;

2. The original arc voltage is out of range;

3. The auto signal cable is in open circuit;

4. DIV PCB is damaged;

Problem analysis:

❋ 1. Plasma ARC+ and ARC- connection to the DIV PCB;

Solution：Step 1- Check whether the positive and negative signals of the arc voltage of the machine are correspondingly connected with the positive and negative signals of the plasma arc voltage;

NOTE: The picture shows the position of the Hypertherm plasma arc voltage signal.
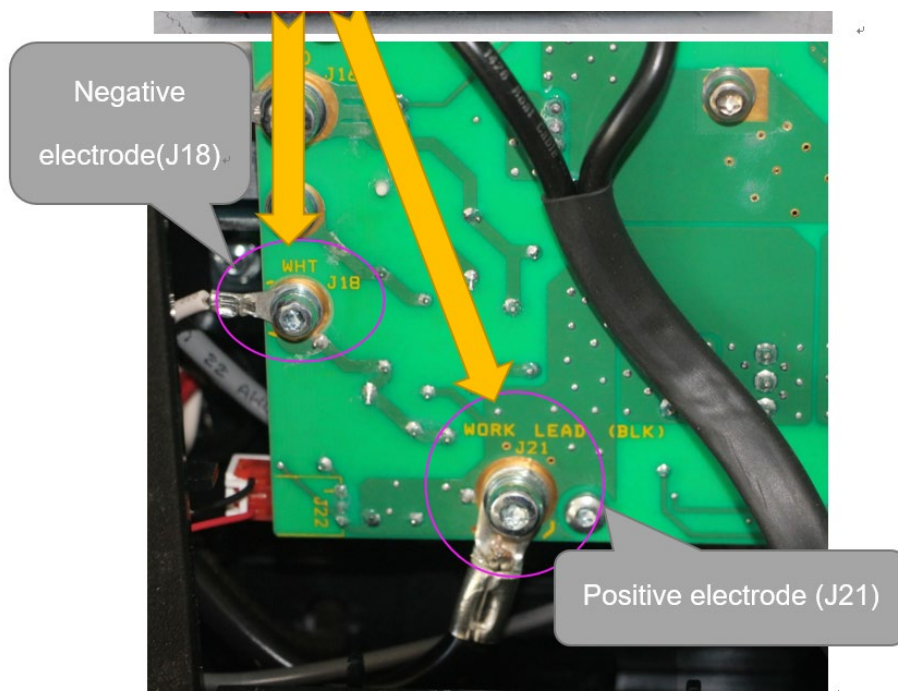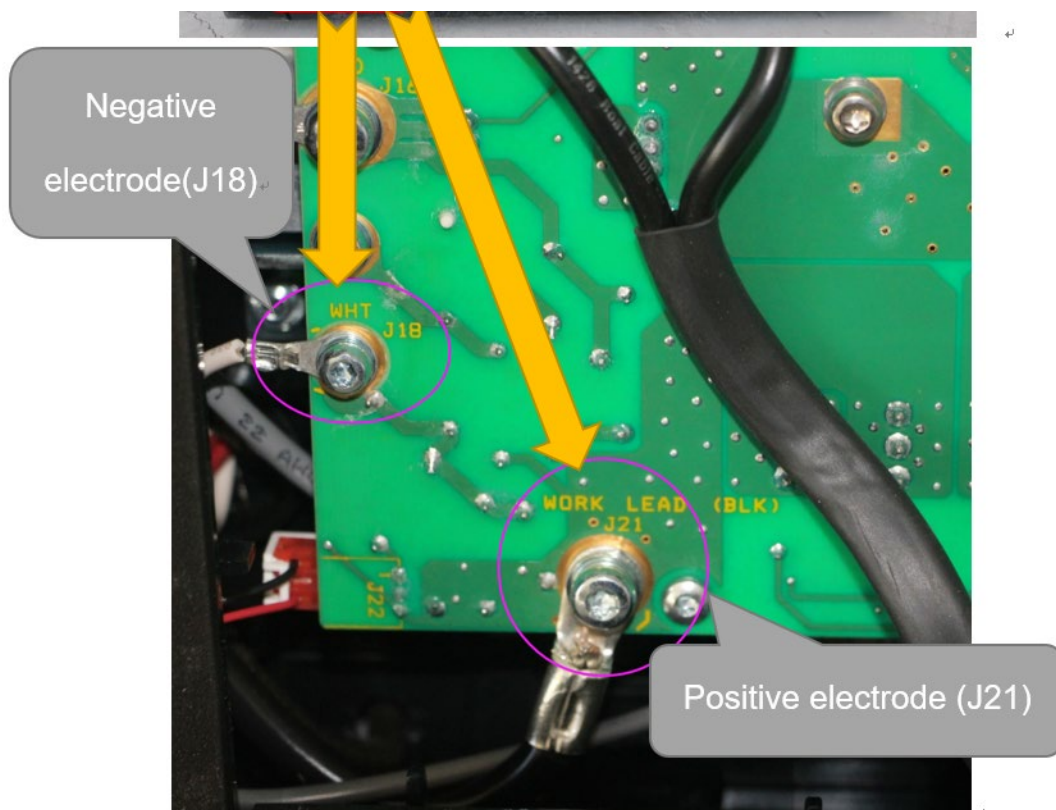
Problem analysis:

✳ 2 The original arc voltage of the plasma power supply is out of range;

Solution: The normal output voltage of the original plasma arc voltage is 60V-165V, check the voltage with multimeter; otherwise the output of original arc voltage is wrong;

Check the connection arc DIV between the CNC system and the plasma power source, ARC+/ARC- should be connected with the original arc voltage of the plasma, if the connection is right, check the original voltage, if it is 60V--100V, it is good;

If it is out of range, Please contact your plasma supplier, determine the original arc voltage value of the plasma;

NOTE: The picture on the right is the location of the original arc voltage of Hypertherm plasma, for reference only.
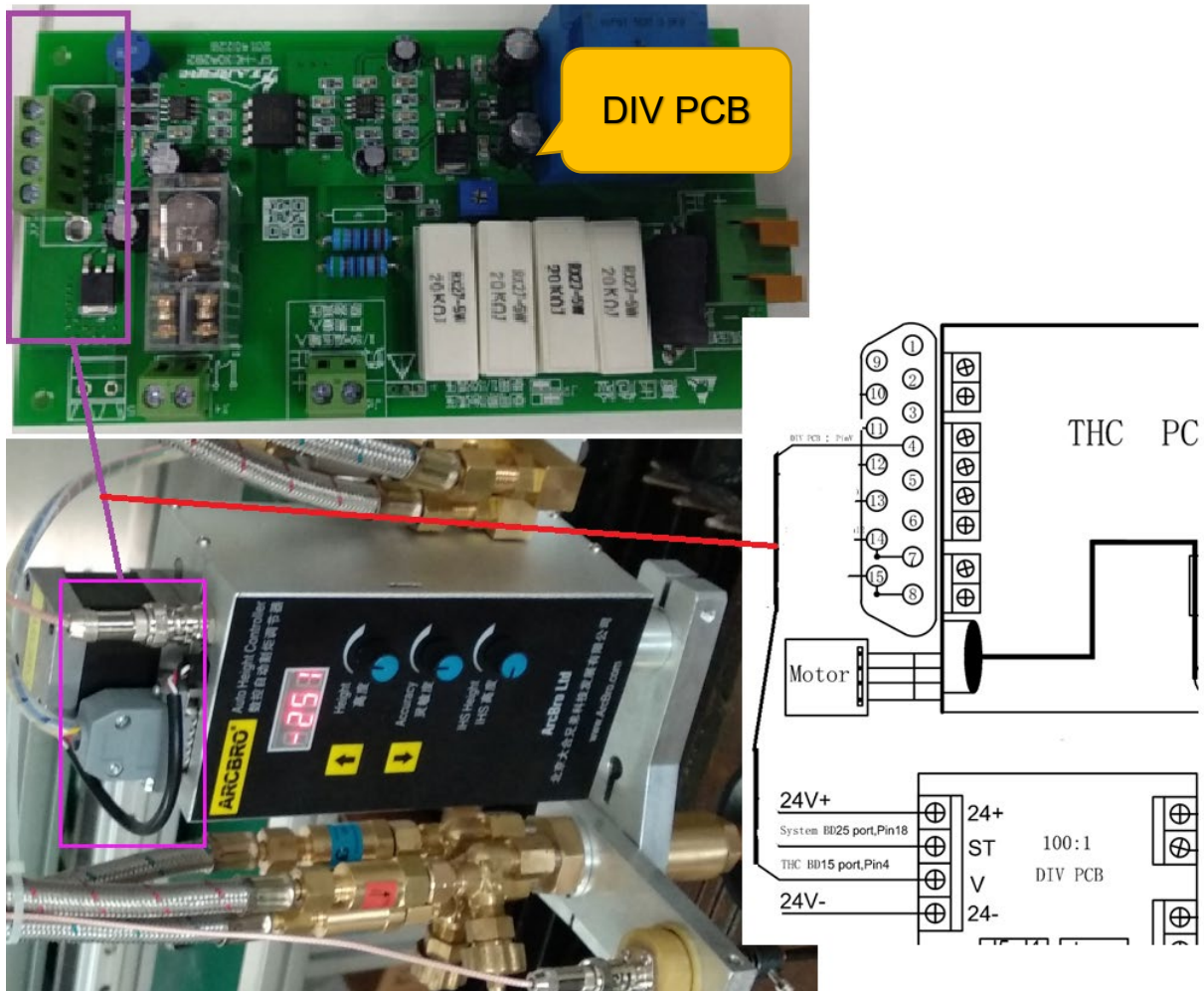
Problem analysis:

✳ 3. The auto signal cable is in open circuit;

Solution: The signal from DIV PCB cannot be transmitted to the THC; Pin4 of the THC should

be connected with the pin V of DIV PCB;

Check the connection with a multimeter

If disconnected, please connect pin4 of the THC with the pin V of DIV PCB as following:

Problem analysis:

✳ 4. The DIV PCB is damaged;

Solution: When the plasma is arcing, use a multimeter to measure the voltage between the pin V

and 24V- on the DIV PCB; this voltage is normally in the range of 1.2-3.3v;

If there is no voltage value or exceeds a large range, it proves that the DIV PCB is bad and needs to be replaced.