

How to solve THC without IHS function -SDF30A-THC

→ Problem: THC does not have automatic adjustment function—Thunder-XPRO;

- Solution overview:
1. IHS HEIGHT is lower;
 2. THC circuit board is damaged;
 3. Check the IHS iron sheet inside THC;
 4. System parameters need to be adjusted;
 5. The system or the relay on the back of the system is damaged;

Problem analysis:

✳ 1. IHS HEIGHT is lower. The torch received IHS signal, but lifter rising height is too small.

Solution: Turn the knob clockwise to increase the 【IHS HEIGHT】 value. IHS HEIGHT according to the thickness of the cutting material.



Pic-1

Service Support Spirit

Problem analysis:

* 2. THC circuit board is damaged;

Solution: Change to plasma mode;

Step1: Press the 【 ↑ 】 → Then press 【 ↓ 】 key on the THC, Keep pressing the 【 ↓ 】 button, the torch touches the steel plate and then rises for a certain distance :

If the torch automatically rises for a certain distance, it proves that THC is working.

If the torch does not rise, it proves that THC is damaged. Please check next, Or Replace THC



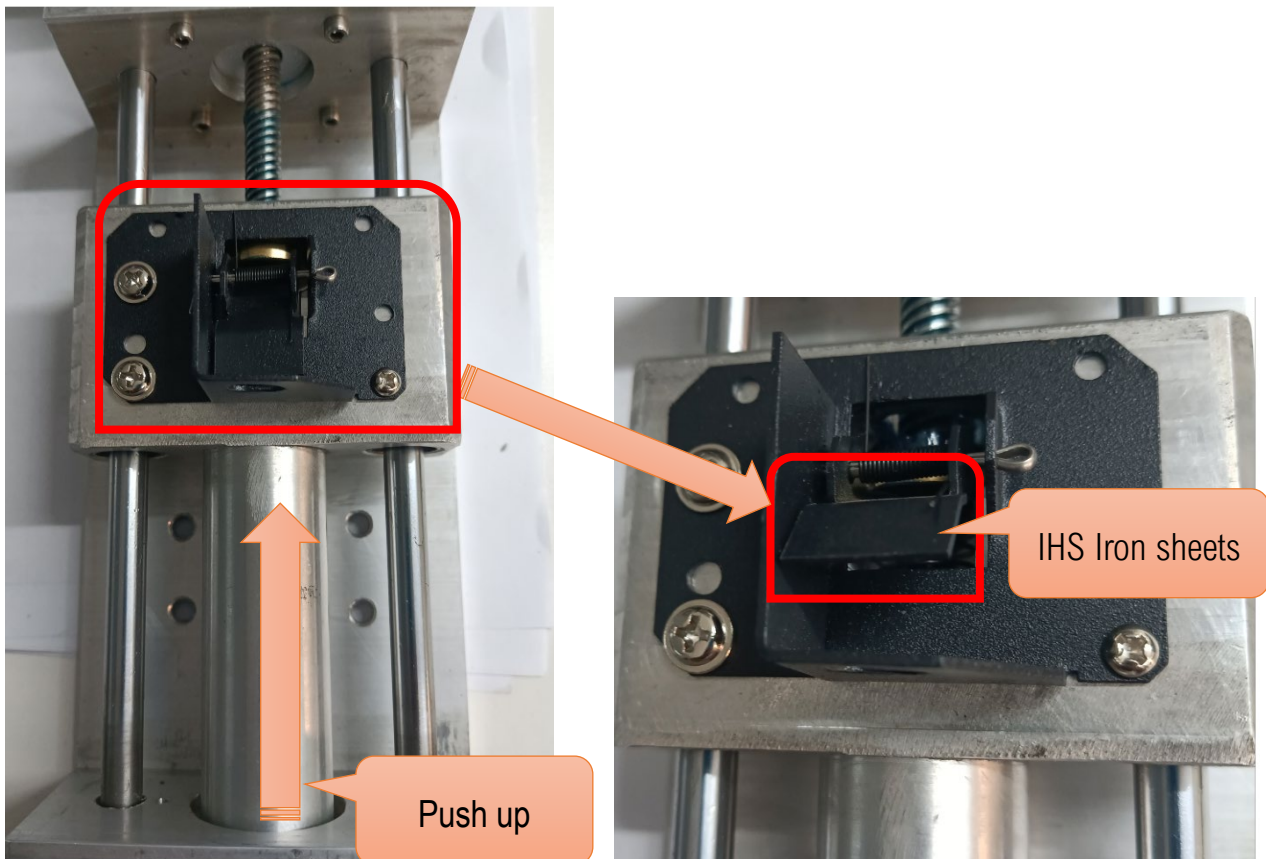
Service Support Spirit

Problem analysis:

- ✧ 3. Check the IHS iron sheet inside THC;

Solution: Step1: Open the lifter cover; Check whether iron sheets can open. When the external force hits the IHS iron sheets, IHS Iron sheets can open.

If IHS Iron sheets cannot open, Please repair this mechanical structure

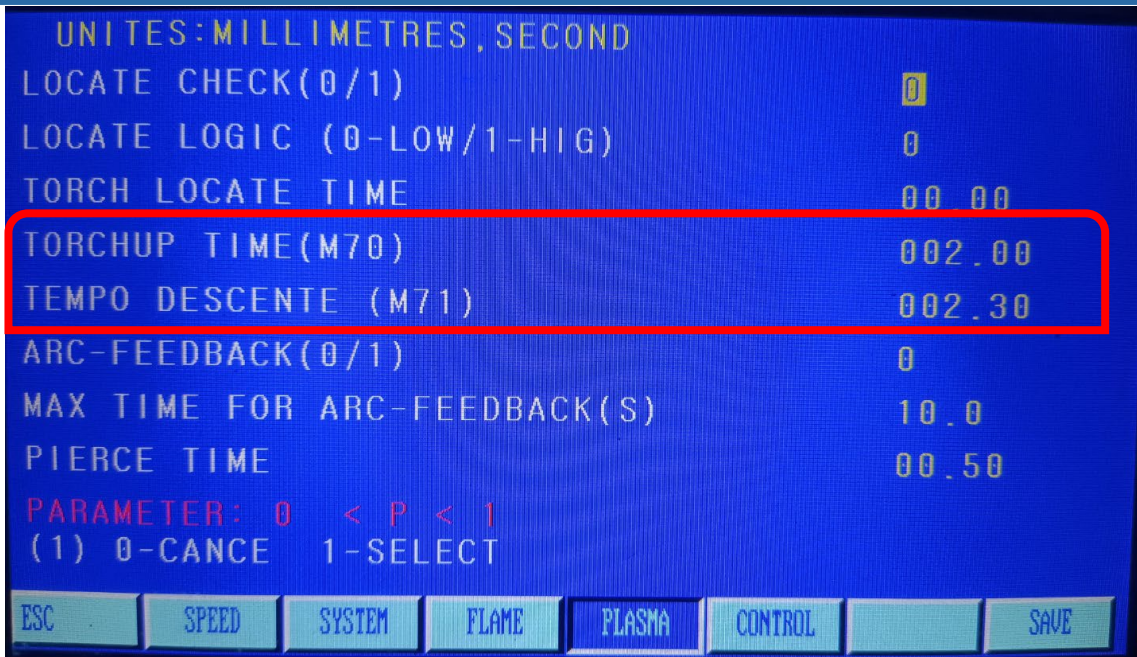


Open the THC Lifter, Push up the shaft and check the bended block piece, Use a Plier to Bend it back so that make this piece a little bit more flatter.

Problem analysis:

- ✧ 4. System parameters need to be adjusted;

Solution: Main interface → Press F4【SETUP】into Parameter interface→ Press F4【PLASMA】into PLASMA interface→ Reference picture to modify the two parameters of the mark.

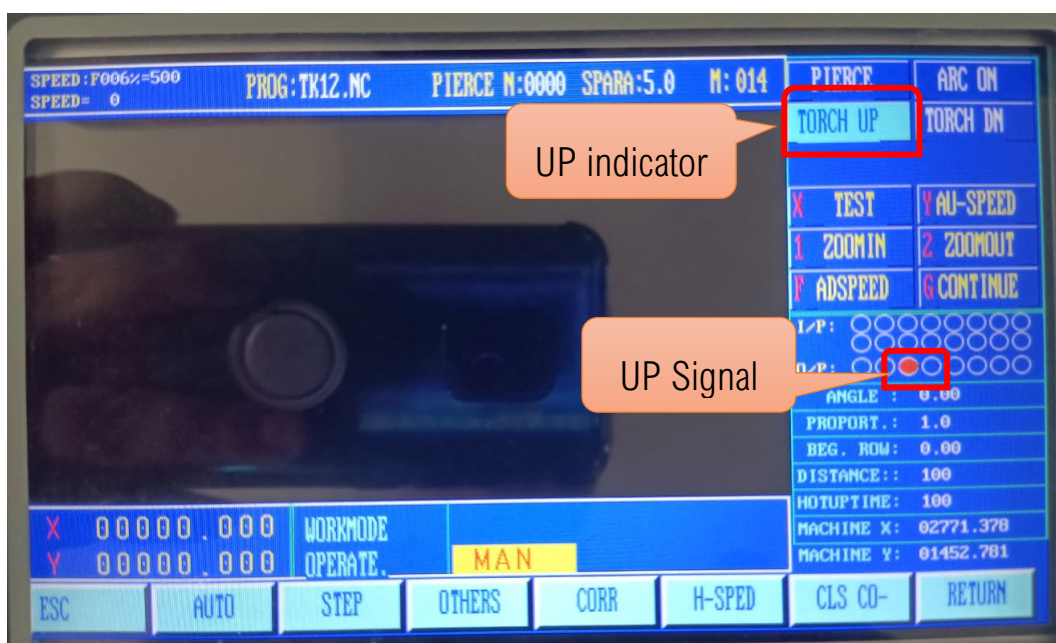


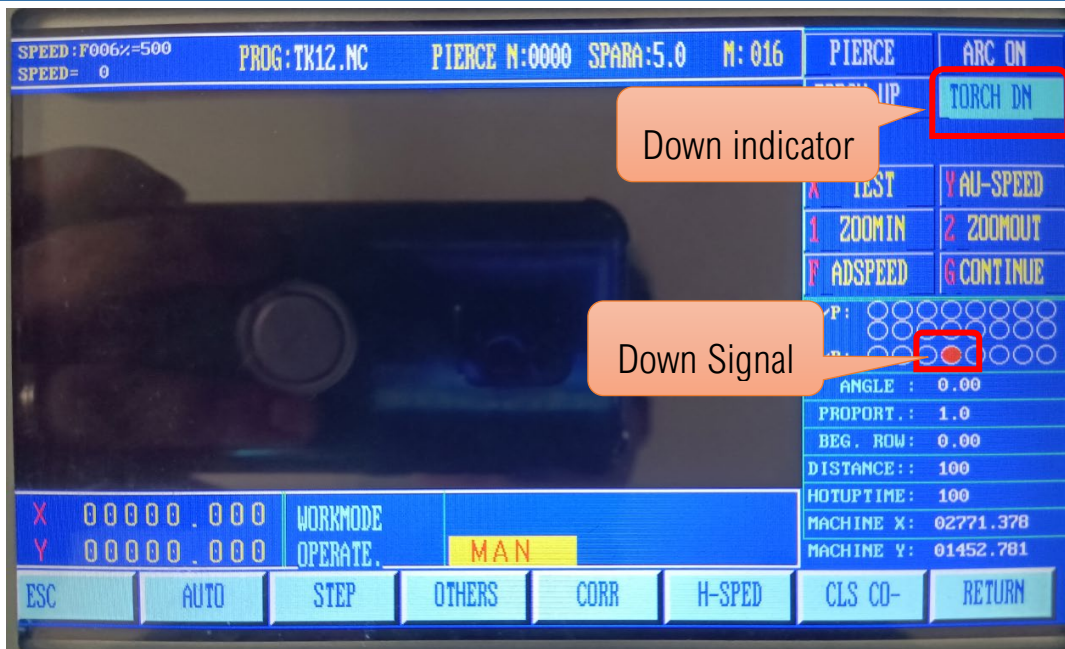
Problem analysis:

- * 5. The system up/down signal is not output;

Solution: Step1 Keep press **【S ↑】** and **【S ↓】** key on the system keyboard in the automatic interface or manual interface,

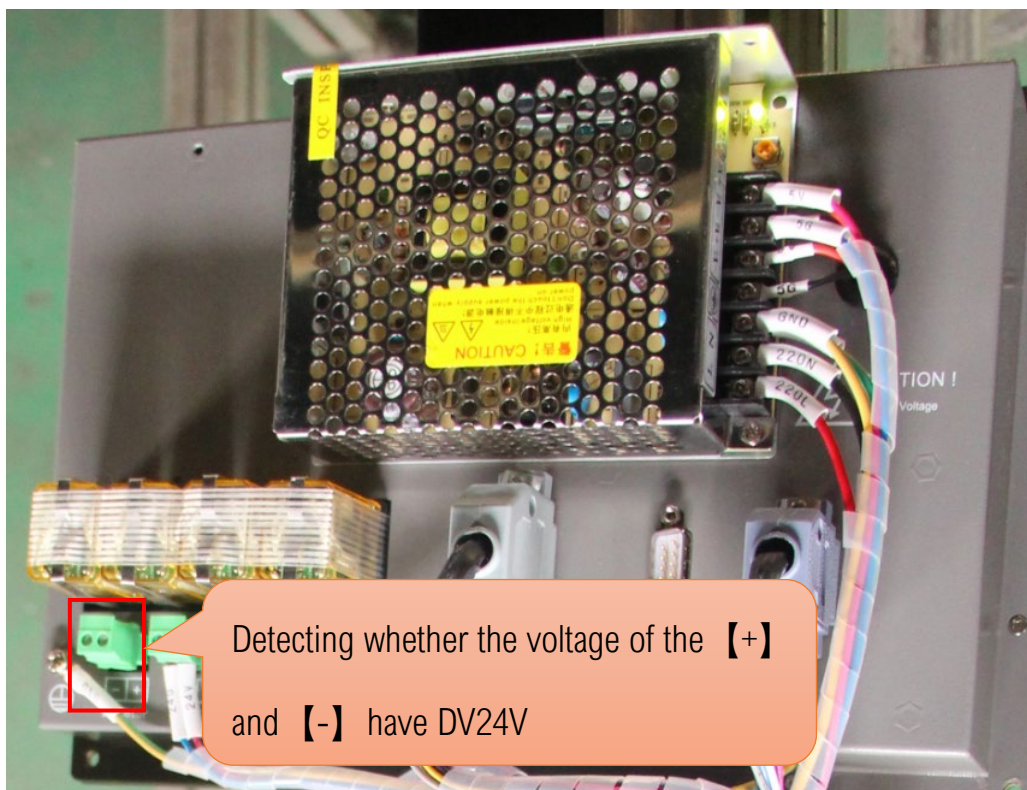
The system output signal will show as photo, when the third circle is red means up, fourth circle is red means down.





And meanwhile the motor plug at back of the system will output DC24V.

If System motor plug have DC24V output, Prove that the system is working.



If the system screen displays normally, System motor plug has no DC24V output, → Check the relay on the back of the system.

Service Support Spirit

When Keep Press 【S ↑】 and 【S ↓】 key, The relay does not work ;Proves that the relay is damaged; Need to replace the relay.

When Keep Press 【S ↑】 and 【S ↓】 key, The relay is working, Prove that the system is damaged. Need to replace the system.

