

## Service Support Spirit

### How to solve the lifter only up and does not down during the cutting

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

- Solution overview:
1. The arc voltage is set too high;
  2. ARC+/ARC- signal connection is opposite;

#### Problem analysis:

- ✱ 1. The arc voltage is set too high;

**Solution:** Please adjust the Height knob to left and take the arc value smaller until the THC is work well when plasma cutting, then start cutting



#### Problem analysis:

- ✱ 1. ARC+/ARC- signal connection is opposite;

**Solution:** Check whether the ARC+/ARC- signals of the machine are correspondingly connected with the ARC+/ARC- signals of the plasma;

## Service Support Spirit

It may be the “arc+” and “arc-“connect the plasma source supply in the opposite position, Problems will happen;

Please change their positions each other when you power off the power supply.

Take Hypertherm Plasma as an example:

|         | According to the sticker on the wires of the cable | Corresponding interface of PMX125 |
|---------|--|-----------------------------------|
| Machine | CNC START  | 3                                 |
|         | CNC START  | 4                                 |
|         | DIV FINISH   | 12                                |
|         | DIV FINISH   | 14                                |
|         | DIV ARC+   | J27                               |
|         | DIV ARC-   | J28                               |