

How to solve the machine without IHS function—Scout2

➔ Problem : The THC output IHS signal and the torch goes down but the plasma torch does not rise when touch the workpiece.

- Solution overview:
1. IHS HEIGHT is lower;
 2. The IHS switch is broken;
 3. THC is broken;

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.



Problem analysis:

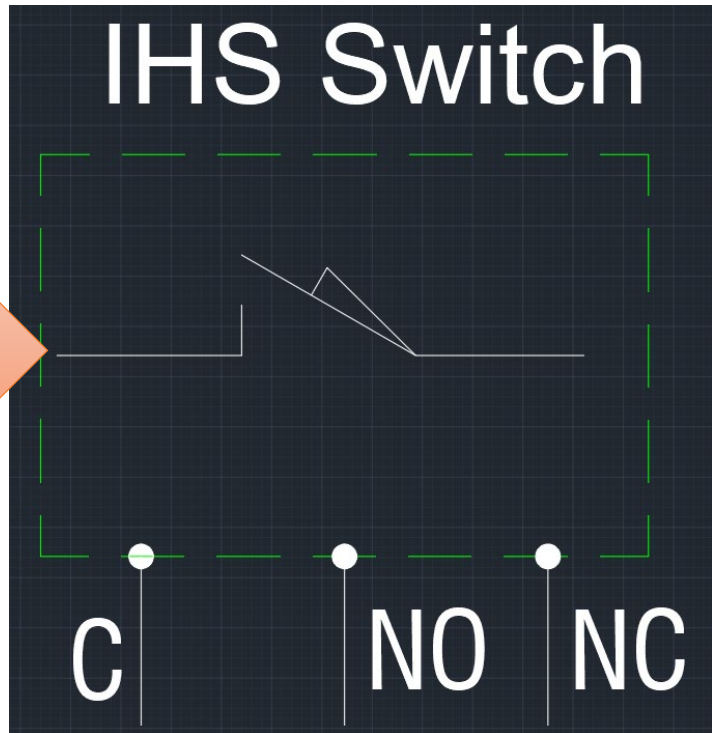
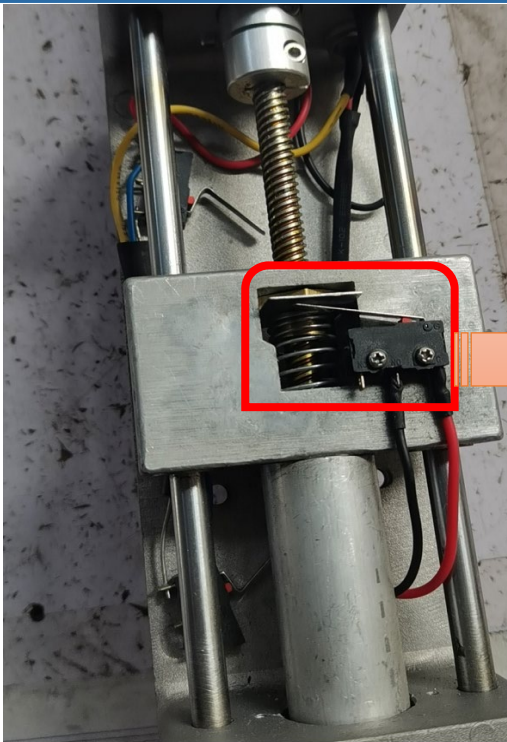
✳ 2. The IHS switch is broken; Check the IHS Switch with a multimeter;

Solution: Step1: Open the lifter cover; Check the limit with a multimeter. When the external force hits the IHS Switch, the NO and C are connected, and the natural state NO and C are disconnected.

When the external force hits the IHS Switch, If the NO and C are connected, Proof that the IHS switch is damaged,

Please replace with a new IHS switch.

Service Support Spirit



NOTE: Open the lifting cover; The iron sheet on the IHS switch is deformed, which can also cause problems.

Problem analysis:

✳ 3. THC is broken; Connect the IHS Signal to test.

Solution: Connect 3.2 【Signal】 and 3.3 【COM】 with a cable, the lifter is always rising;
If the lifter doesn't work, means the THC is broken; you need change your THC

