How to solve the machine without automatic function--Scout2

➜ Problem : The machine without automatic function--Scout2;

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

2. CNC system parameter setting;

3. THC system parameter setting;

4. CNC whether automatic output signal;

5. THC whether automatic output signal;

6. System to THC wiring;

Problem analysis:

※ 1. Plasma ARC+ and ARC- connection to the THC;

Solution: Step1. Arc output signal for plasma output: Open THC cover, Check ARC+ and ARC-

corresponding connect to WORK+/ELECTRODE- on THC ; Please check the order of this connection;

Work connect to ARC+; ELECTRODE connect to ARC-.
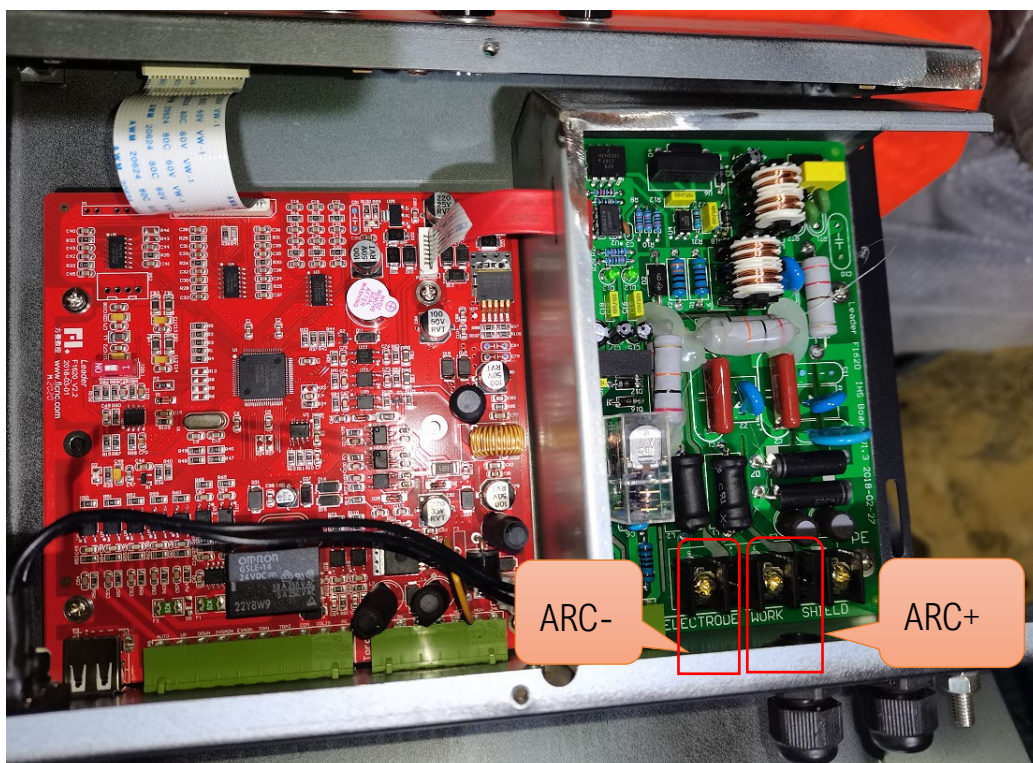
NOTE: If the plasma power supply is another brand, it is not provided by ARCBRO, nor is it hypertherm., thermal-dynamicst, lincolnelectric and other international brands;

The customer must communicate with the engineer of the plasma manufacturer. How to connect the arc voltage signal? You can also create a whatsapp group; we will solve this arc voltage connection problem together;

Problem analysis:

※ 2. CNC system parameter setting; In this case, usually a system has just been replaced.

Solution: Step 1- Main interface →Press F5【Diagnose】into Diagnose interface→Press F8【System Definition】into System Definition interface→Press F3【Define】into System   parameter definition interface→then input key【1396】--then press enter as show pic2

Pic1
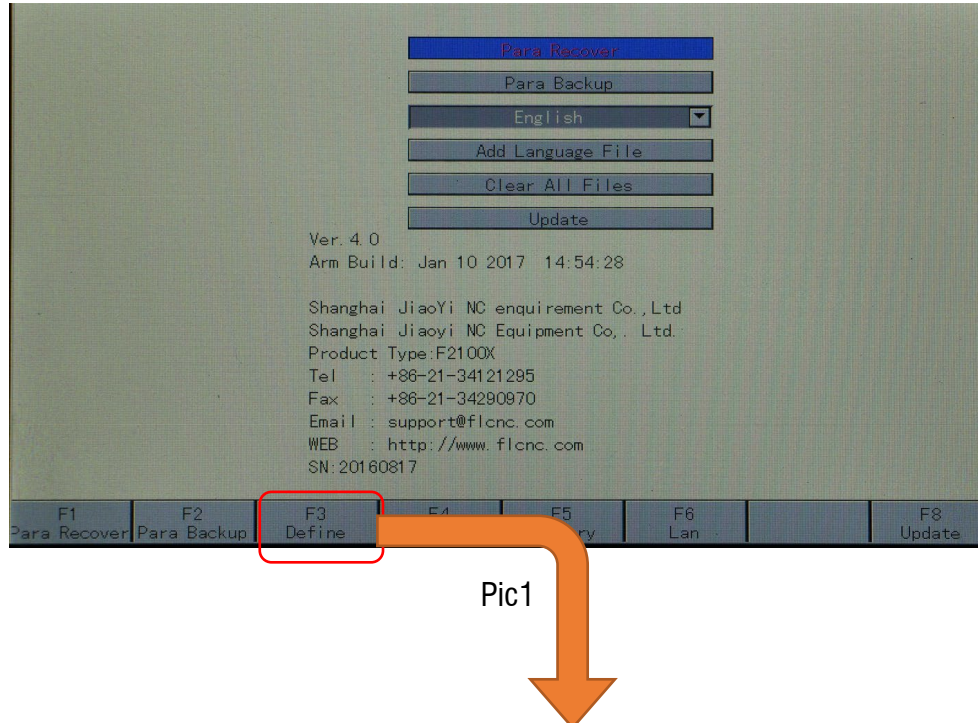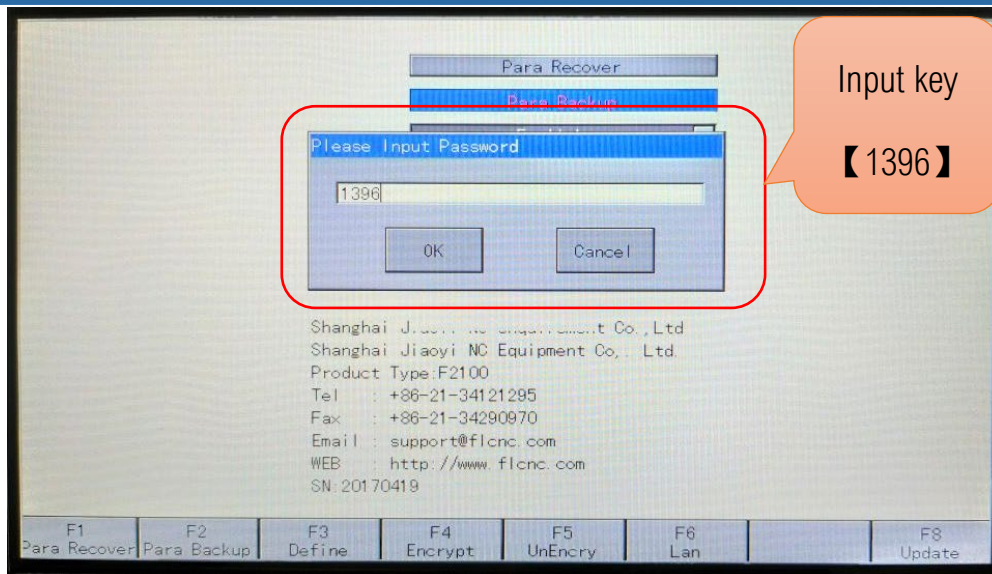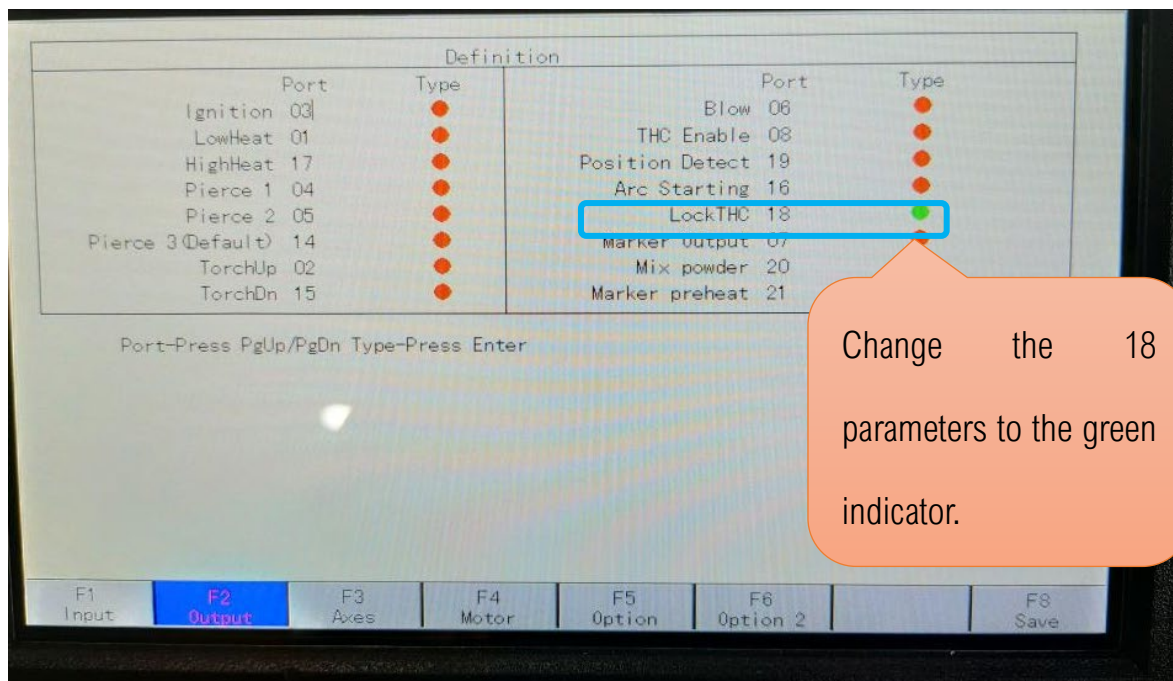
Pic2

→Press F2【Output】, Then press the direction keys to move the selection and change the 18 parameters to the **green indicator**(After selecting, press the enter indicator to turn red or green.).--Press F8 to save;
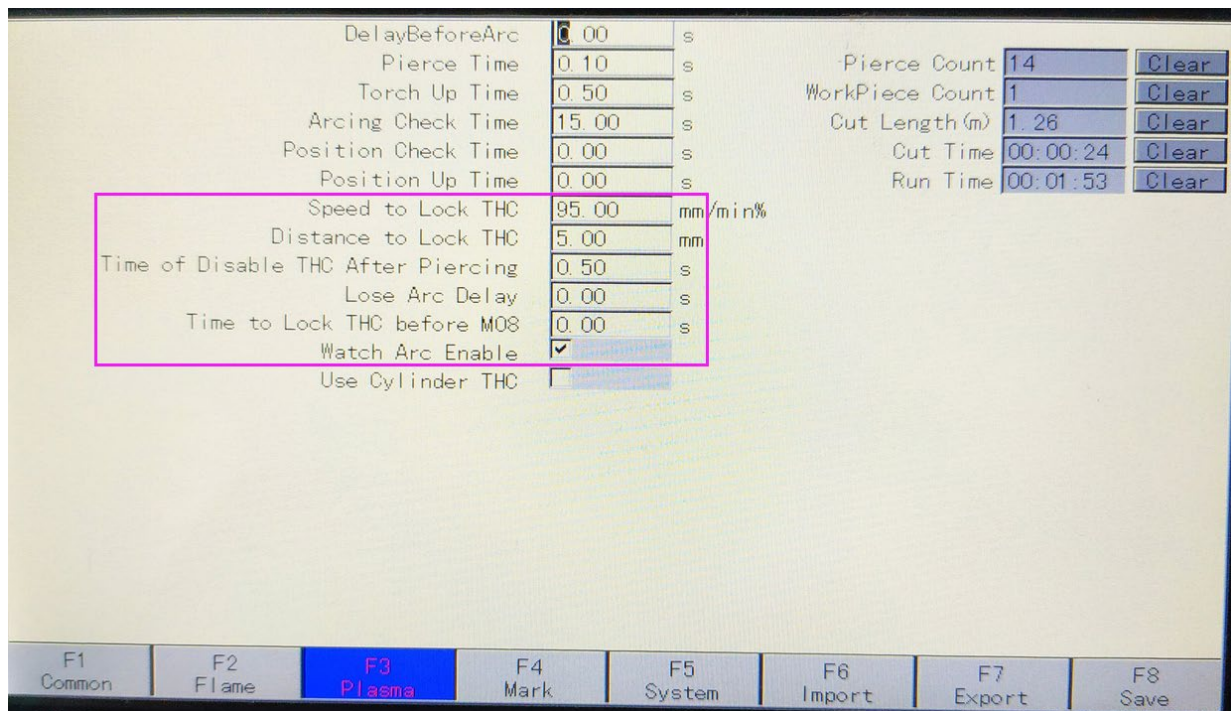
Note: Please restart the system after settings.

Pic3

Step 2- Main interface →Press F4【Setups】into Setups interface→Press F3【Plasma】

into Plasma interface -- Please refer to picture setting parameters as show pic4;

Pic4

Problem analysis:

❋ 3. THC system parameter setting; In this case, usually a system has just been replaced. Parameter standard: L06=0;L07=0;L09=1; THC only needs three parameters ,When using a new THC;

Solution overview: Step 1: THC Main interface →Press【MENU】into THC interface→Then the parameters in the **parameter display screen** will change, and whenever you press 【MENU】--Then The parameters are: stop pressing at , as shown in picture 2; →Set the parameters .

NOTE: If you press the【MENU】 several times, the **parameter display screen** has not found L01, please refer to the Unlock settings;

Parameter display screen

Pic-1

Parameter Value display screen

Pic-2

➔ **The Unlock settings**

THC Main interface →Press 【MENU】 into THC interface→Then the parameters in the **parameter display screen** will change, and whenever you press 【MENU】 --Then The parameters are: stop pressing at 【SYS】, as pic 3; →Unlock: Press

then Press 【ENTER】 --Into U00 interface then →Rotate the IHS knob to adjust the parameter to U03 (as pic 4); →Press 【ENTER】 into **Parameter Value display screen**→Rotate the IHS knob to adjust the **Parameter Value to 1**→Then Press 【ENTER】 →Press 【MENU】 3 times into Digital interface; Unlock successfully, then follow the first step to find L01.

Parameter display screen

Parameter Value display screen   Pic-3   IHS Knob

Pic-4

✎ Set the parameters：

Step 2: Into L01 interface →then Rotate the IHS knob to adjust the parameter to L06 (as pic

5); →Press【ENTER】into **Parameter Value display screen**→Rotate the IHS knob to adjust the

Parameter Value to 0→Then Press 【ENTER】→Into L06 interface Rotate the IHS knob;

Use the same method:

Parameter standard: L06=0; L07=0;L09=1;

Complete parameter setting Press 【MENU】3 times into Digital interface;

Parameter display screen

IHS Knob

Parameter Value display screen   Pic-5
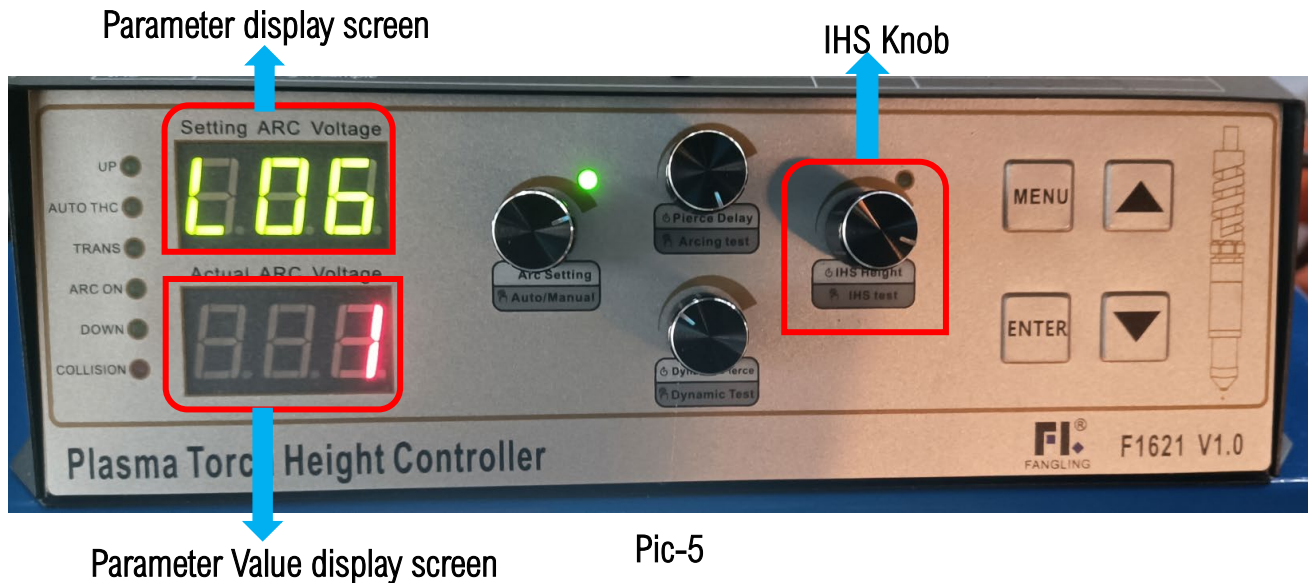
Problem analysis:

❋ 4. CNC whether automatic output signal; Check with the multimeter. In this case, the machine has been used for a long time and the circuit has been aging.

**Solution:** Step 1-Please ensure that the system is powered;

Step2- We test at the diagnostic interface; Main interface →Press F5【Diagnose】into Diagnose interface→Press F2【Output】into Output interface→Measure the voltage between pin 18 of the output-CN2 and 24V+ of System power supply port;

When the Lock THC indicator is red; the voltage of pin18(Output CN2) and DC24V+ (System power supply port) is DC24V;

When the Lock THC indicator is Green; the voltage of pin18(Output CN2) and DC24V+ (System power supply port) is DC0V;

If there is no DC24V for red or green light; prove that this CNC is damaged;

Please modify the system definition output pin. Or Replace with a new system
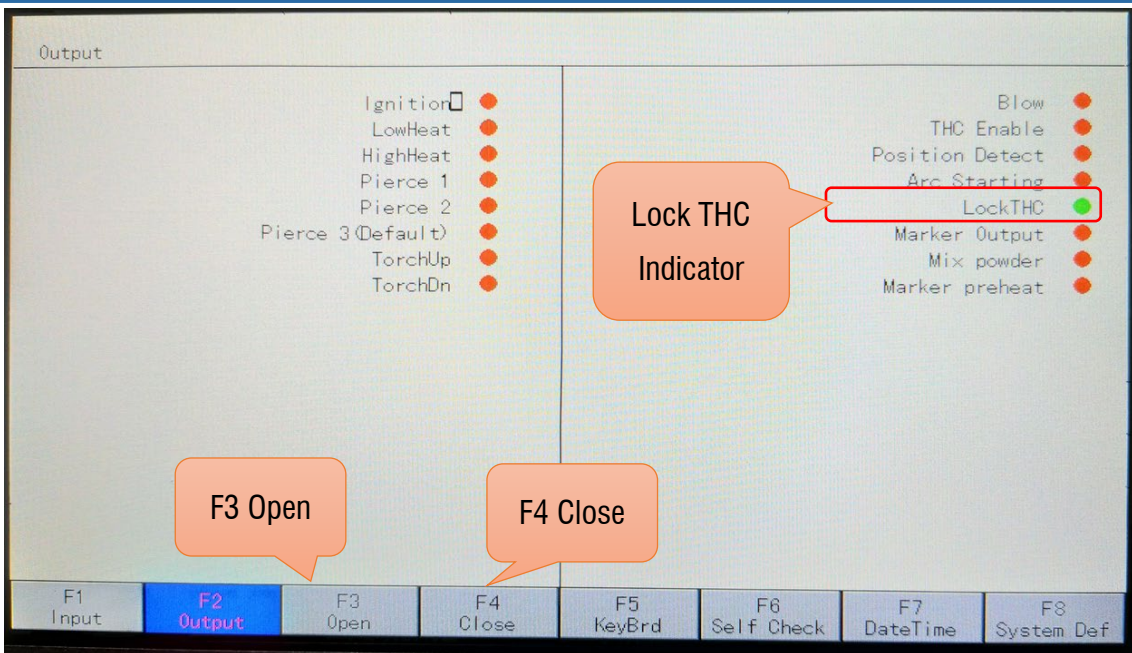
Note: You can press the direction keys to select 【Lock THC】, press F3 to turn on the indicator and press F4 to turn off the indicator.
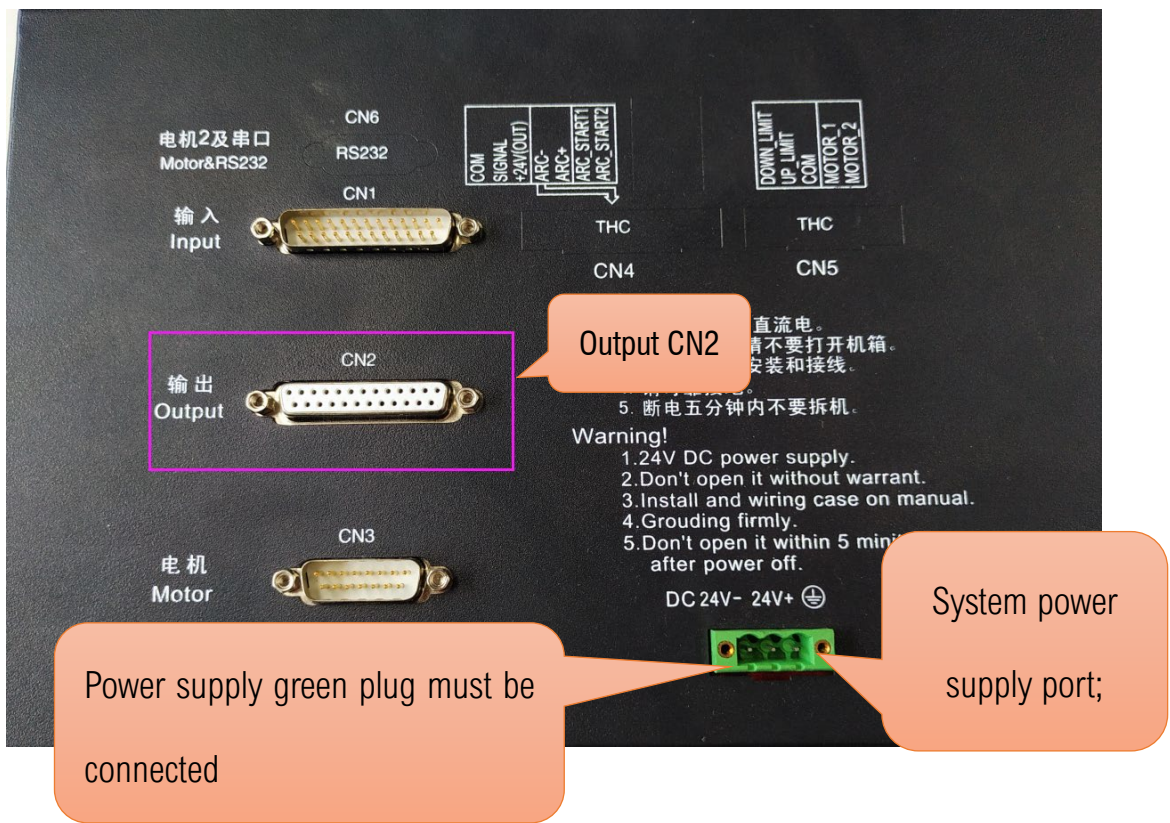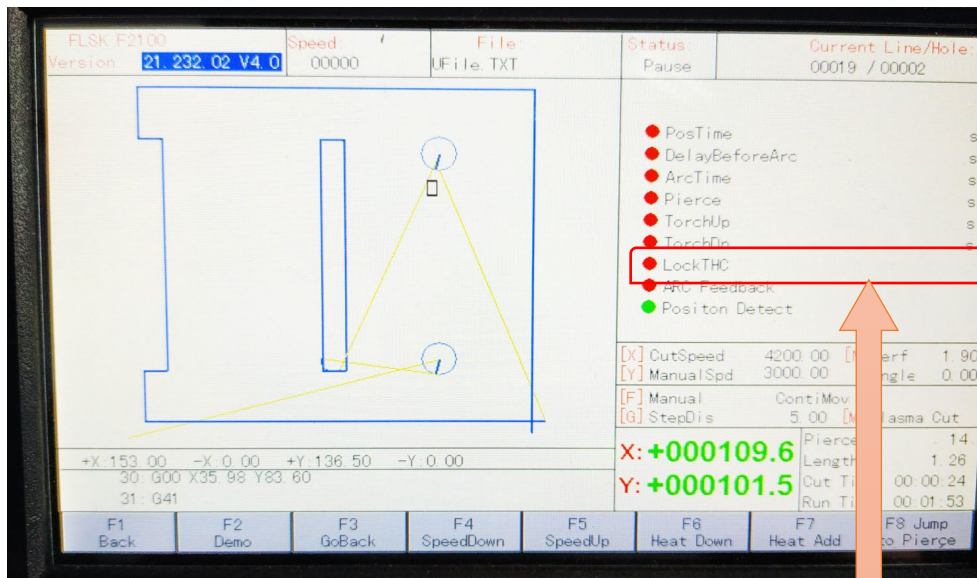
Problem analysis:

✷ 5. THC whether automatic output signal; Please make sure CNC Auto Signal is working. In this case, the machine has been used for a long time.

Solution: Import a graphic for cutting test, When cutting graphics, the system sends out an automatic signal, there is an automatic signal light on the THC panel. This is the indicator light for THC automatic function.

When the Lock THC indicator is red, Automatic signal output; When the Lock THC indicator is Green; Automatic signal off.

If the THC auto indicator lights up to prove that THC is good, otherwise it is bad;

Please replace with a new THC.

Problem analysis:

❈ 6. System to THC wiring; Check with the multimeter. In this case, the machine has been used for a long time and the circuit has been aging.

Please make sure there are no problems with the above steps

Solution overview: Check with a multimeter; The communication cable between the CN2 port of system and the TO CNC port of THC.

18Pin of CN2 to 1Pin of TO CNC

25Pin or 13pin of CN2 to 8Pin of TO CNC;

If the line is disconnected, please fix it.