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-.



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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 \rightarrow Press F5 [Diagnose] into Diagnose interface \rightarrow Press F8 [System Definition] into System Definition interface \rightarrow Press F3 [Define] into System parameter definition interface \rightarrow then input key [1396] --then press enter as show pic2





 \rightarrow 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.

1 24		THE REAL PROPERTY	tion	Definit			
and a state	Type	Port		Туре	ort	F	
	•	Blow 06		•	3	Ignition	
	•	Enable 08		•	1	LowHeat	
	•)etect 19	F		7	HighHeat	
	•	arting 16)4	Pierce 1	
		ockTHC 18		•	5	Pierce 2	
a line and the	~	Jutput 07	12197		4	3 (Default)	Pierce
		owder 20		•)2	TorchUp	
					5	TorchOn	
he ^r	Change	reheat 21	r	ress Enter	o gDn Type-f	t-Press PgUp,	Por
he find the gree	Change parameters	reheat 21	r	ress Enter	^o gDn Type-f	t-Press PgUp.	Por
he the gree	Change parameters indicator.	reheat 21	r	ress Enter	o gDn Type−f	t-Press PgUp.	Por

Pic3

Make Work Simple

into Plasma interface -- Please refer to picture setting parameters as show 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 \rightarrow Press [MENU] into THC interface \rightarrow Then

the parameters in the parameter display screen will change, and whenever you press [MENU] -

Then The parameters are: stop pressing at LOLD, as shown in picture 2; → Set the parameters.
NOTE: If you press the 【MENU】 several times, the parameter display screen has not found
LO1, please refer to the Unlock settings;







THC Main interface \rightarrow Press [MENU] into THC interface \rightarrow 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; \rightarrow Unlock: Press



【ENTER】 --Into U00 interface then → Rotate the IHS knob to adjust the then Press parameter to U03 (as pic 4); \rightarrow Press **[ENTER]** into **Parameter Value display screen** \rightarrow 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.







 \checkmark Set the parameters:

Step 2: Into L01 interface \rightarrow 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 \rightarrow Then Press **[ENTER]** \rightarrow 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;

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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 \rightarrow 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 DCOV;

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

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Output Piero	Ignition LowHeat HighHeat Pierce 1 Pierce 2 3 (Default) TorchUp TorchDn	Lock	THC E	THC E Position E Arc Sta Lc Marker (Mix p Marker pr	Blow Enable Detect arting ockTHC Dutput Dowder reheat
F3 Open		F4 Close			
F1 F2 Input Output	F3 F4 Open Clos	F5 Se KeyBrd	F6 Self Check	F7 DateTime	F8 System Def

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.

电机2及 Motor&R5	CN6 串口 5232 吊S232 CN1	COM SIGNUL +2NY(OUT) ARC-	ARC START	DOWN LIMIT UP LIMIT COM MOTOR 1 MOTOR 2	
输入 Input	97		тнс	THC	
			CN4	CN5	
输出 Output	CN2		Output CN2 5. 断电五分钟 Warning! 1.24V DC pe 2.Don't oper 3.Install and 4.Grouding	直流电。 青不要打开机箱。 安装和接线。 中内不要拆机。 power supply. h it without warrat b wiring case on m firmly.	nt. nanual.
电机	CN3		5.Don't ope after pov	n it within 5 mini ver off.	
Motor	Q anananan	P	DC 24V-	- 24V+ 🖶	System power
Power supp	oly green plug	must be			supply port;
connected					

lake Work Simple

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 **L**d;

Please replace with a new THC.



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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.

