

## How to solve the pause command on the system screen

→ Problem: CNC appears to pause command- screen display;

- Solution overview:
1. Manually press the pause button on the system;
  2. The pause code -M00 appears in the G code;
  3. The anti-collision on the machine is in working condition;
  4. The driver has an alarm;
  5. The plasma appears arc breaking;

Problem analysis:

- \* 1. Manually press  during cutting;

**Solution:** During the cutting process, please do not random press the [PAUSE] key ;As shown.



Pic 1

Problem analysis:

- \* 2. The pause code -M00 appears in the G code;

## Service Support Spirit

**Solution:** The G code has the wrong -M00, M00 appears in the wrong position, Machine phenomenon--The program will pause every time it runs to the same location; if the above phenomenon prove that the code is faulty.

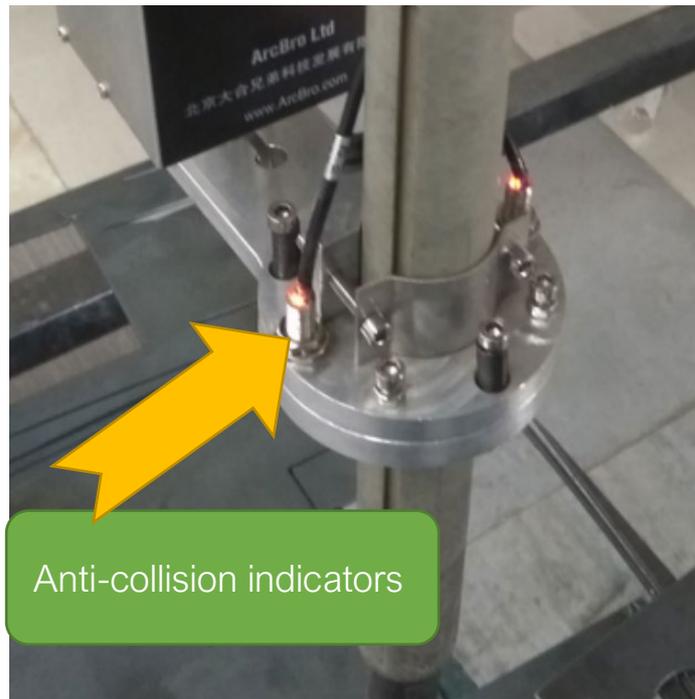
Please let the nesting software engineer check the code.

### Problem analysis:

✧ 3. The anti-collision on the machine is in - -The indicator light is on of the anti-collision;

**Solution:** During the cutting process, the external force hits the torch to trigger the anti-collision function and then the system pauses. Adjust the anti-collision device or the wire/screw or torch of the indicator to release the indicator error report;

NOTE: If the machine is not equipped with anti-collision, please do not check this item;



### Problem analysis:

✧ 4. The driver has an alarm;

## Service Support Spirit

**Solution:** During the cutting process, the drive has an alarm due to external force—the drive red light flashes and the system pauses; Check the meshing of the gear and the rack and the source of the external force, and then restart the driver power supply to eliminate the alarm;

The driver has an alarm.

### Problem analysis:

✧ 5. The plasma appears arc breaking;

**Solution:** The plasma is arc breaking due to external causes during the cutting process, the system does not detect the arc start signal → the system has a pause;

Detecting the cause of plasma arc breaking and releasing it; Then press the [PIERCE] piercing

button to start the arc successfully. Press the  start button. The machine continues to cut according to the original path;

