

Service Support Spirit

The machine does not have automatic function—Thunder-XPRO

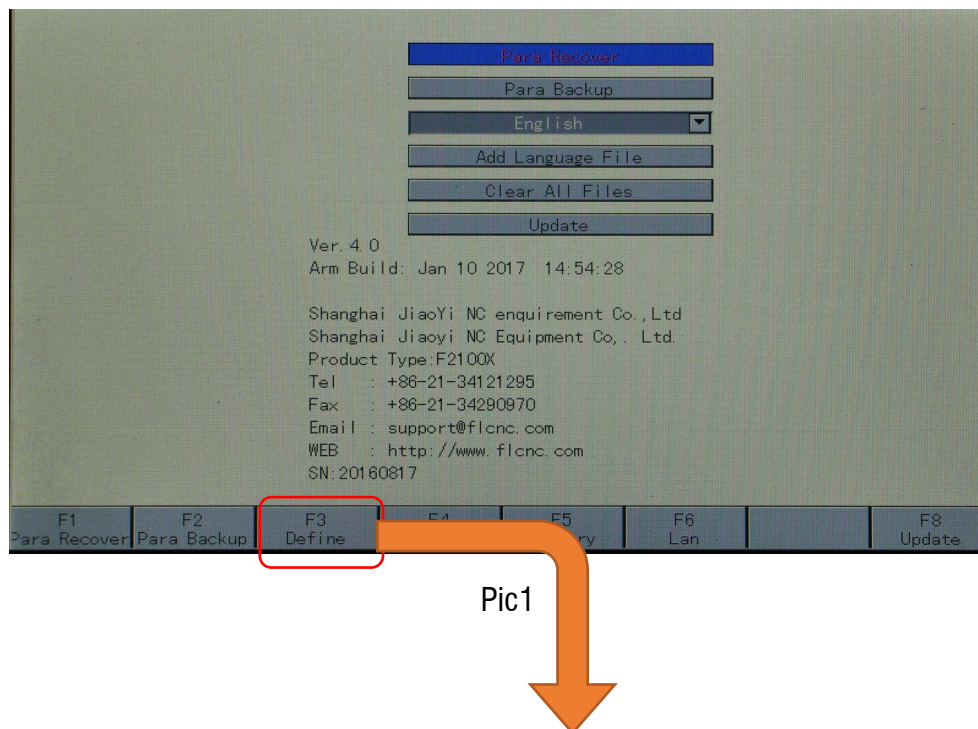
→ Problem : The machine does not have automatic adjustment function—Thunder-XPRO;

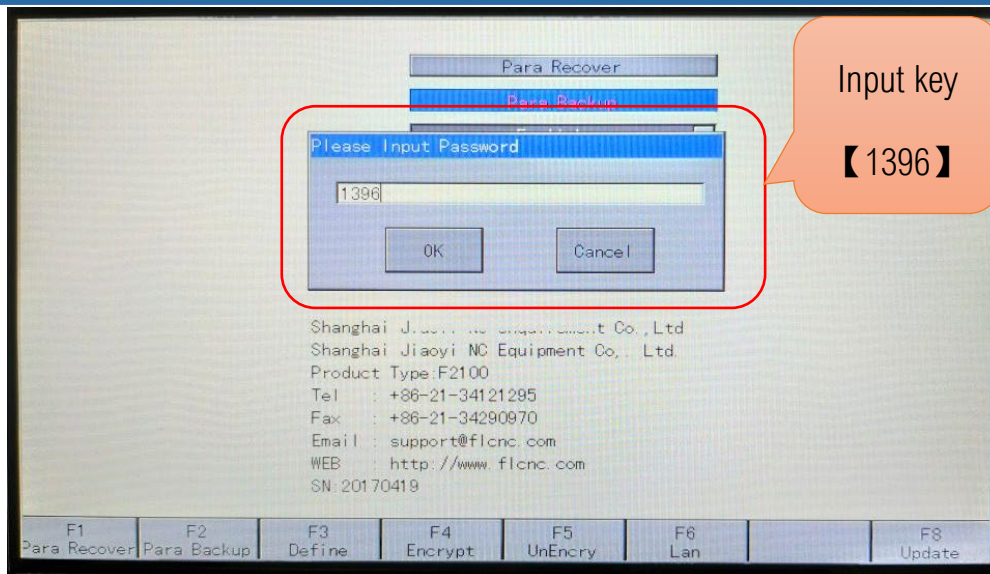
- Solution overview:
1. CNC system parameter setting;
 2. Plasma ARC+ and ARC- connection to the DIV PCB;
 3. CNC whether automatic output signal;
 4. System to THC wiring;
 5. THC whether automatic output signal;

Problem analysis:

- * 1. CNC system parameter setting;

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



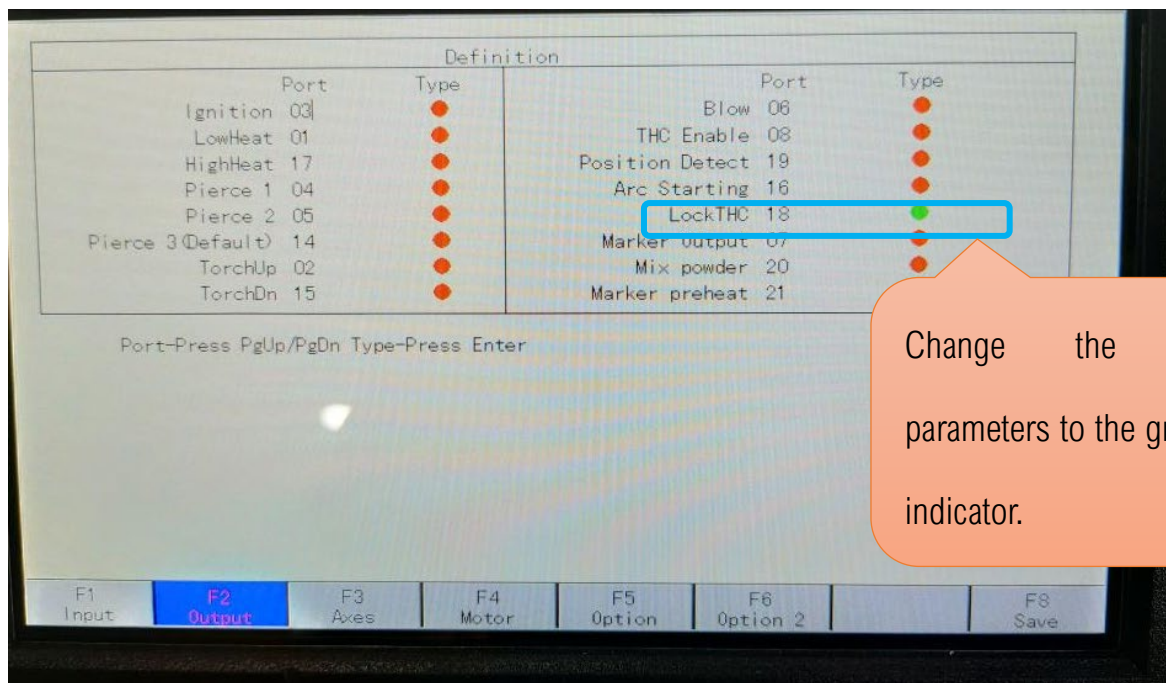


Pic2

→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.

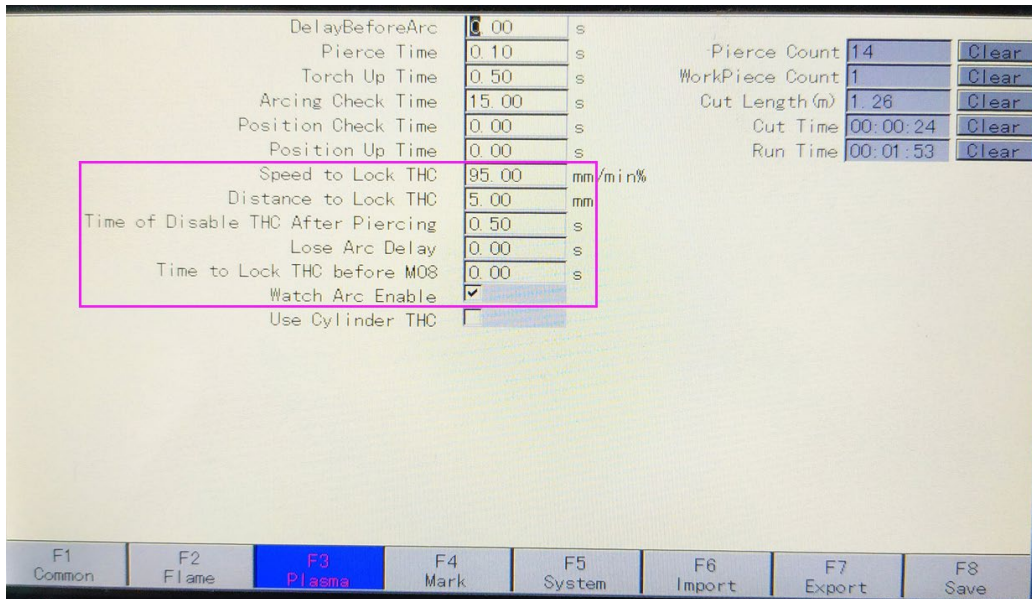


Pic3

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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;

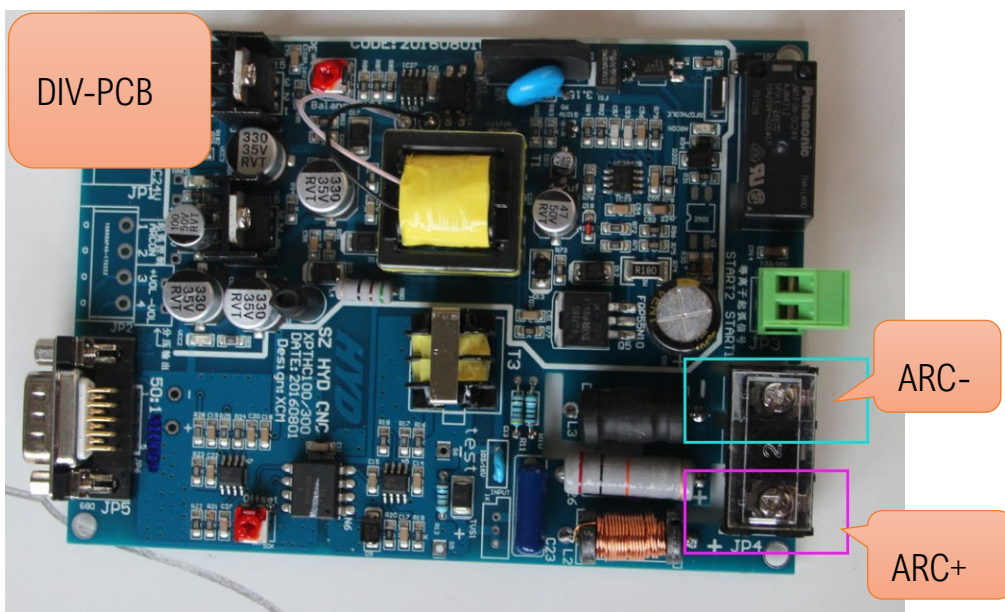


Pic4

Problem analysis:

- * 2. Plasma ARC+ and ARC- connection to the DIV PCB;

Solution: Arc output signal for plasma output: ARC+ and ARC- corresponding connect to +/- on DIV-PCB; Please check the order of this connection;



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Problem analysis:

✦ 3. CNC whether automatic output signal;

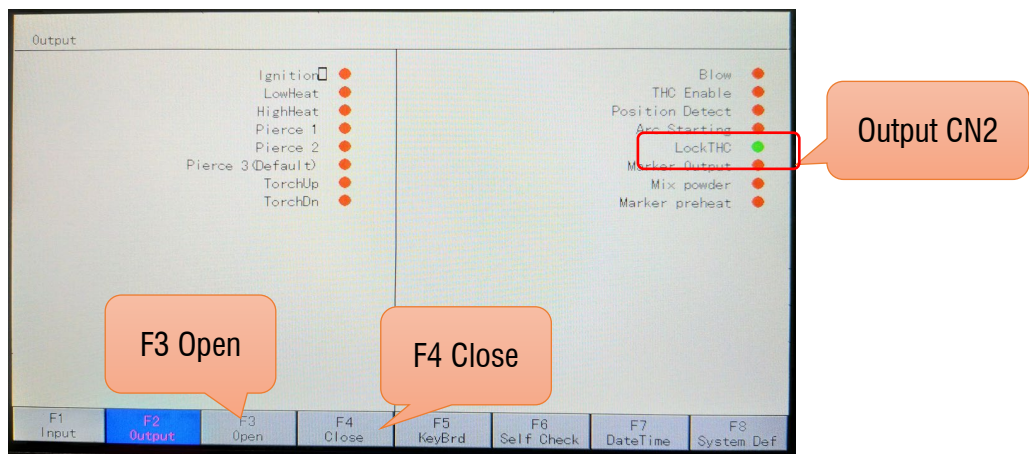
Solution: Step 1-Please ensure that the system is powered;

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 and pin 24 of the output-CN2;

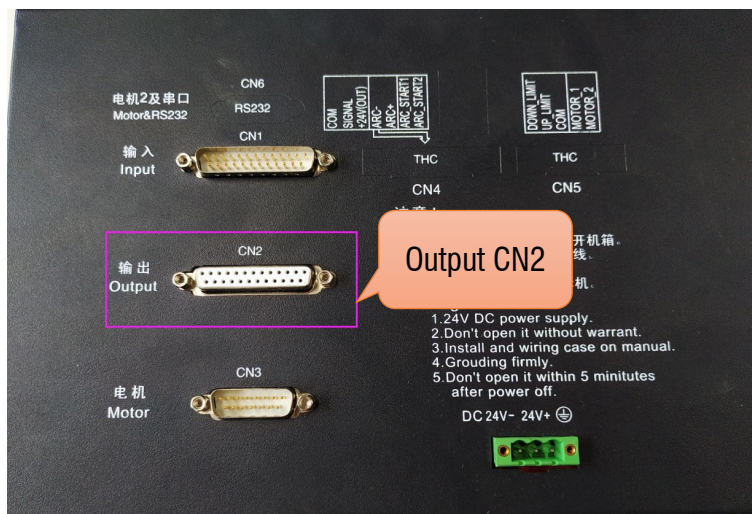
When the lack THC indicator is red; the voltage of pin18 and pin24 is DC24V;

When the lack THC indicator is Green; the voltage of pin18 and pin24 is DC0V;

If there is no DC24V for red or green light; prove that this pin18 is damaged; Please modify the system definition output pin



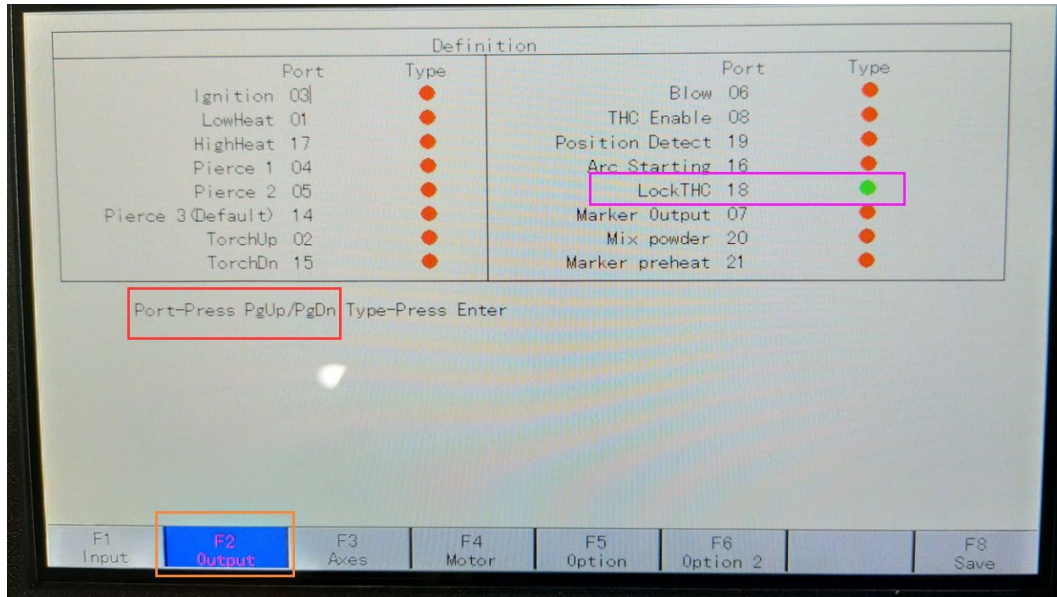
Note: You can press the direction keys to select 【Lock THC】 , press F3 to turn on the indicator and press F4 to turn off the indicator.



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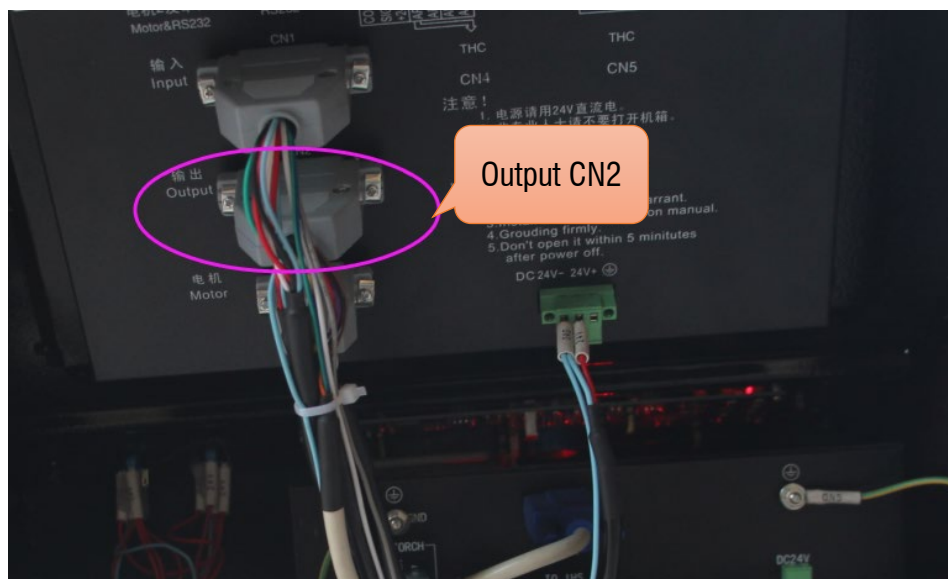
Please modify the system definition output pin:

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 pic



You can press the direction keys to select 【Lock THC】, Press PgUp/PgDn on the keyboard to modify the output pin; 18 modify to 9;

Transfer the cable of the system cn2 output port 18pin to 9pin;



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Problem analysis:

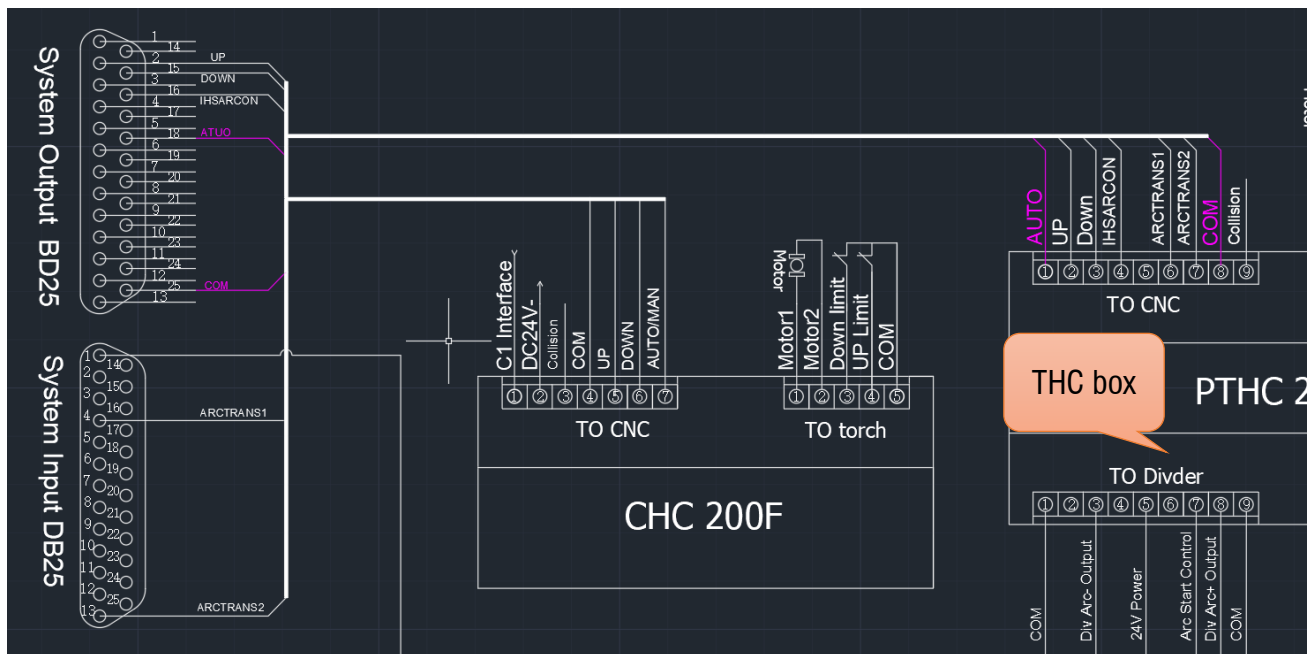
- * 4. System to THC wiring;

Solution: 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.

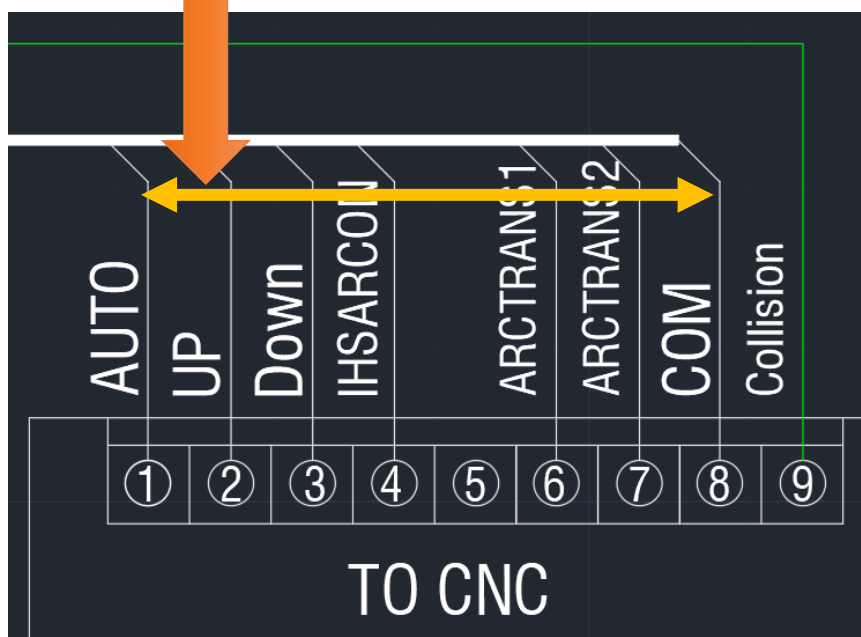


Problem analysis:

- * 5. THC whether automatic output signal;

Note: Please make sure there are no problems in the above four steps, then check THC;

Solution: Step 1- Please power THC, Removed only TO CNC plug; Connect Pin1 and Pin8 with cable;



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

