

The machine has no automatic function—Stinger

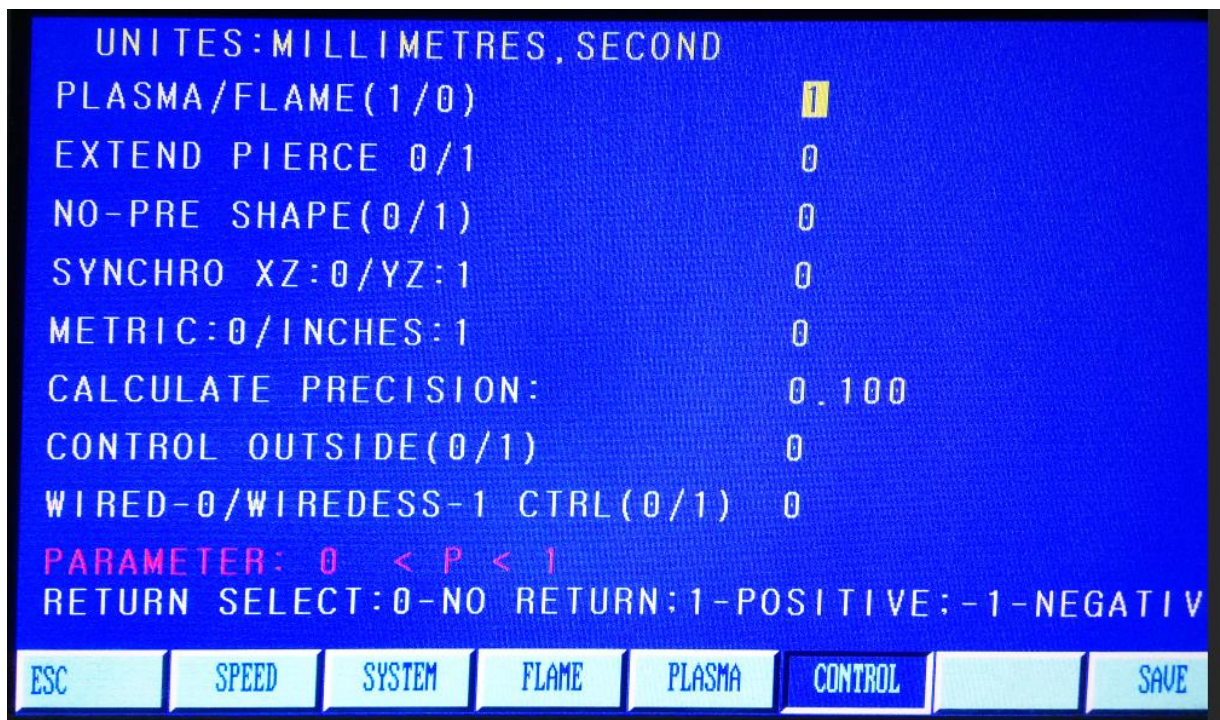
→ Problem: The machine does not have automatic adjustment function—Stinger

- 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 F4 **【SETUP】** into parameter interface → Press F5 **【CONTROL】** into Control interface → Modify **【PLASMA/FLAME(1/0)】 = 1】** --then press **【F7 SAVE】** enter as show pic;

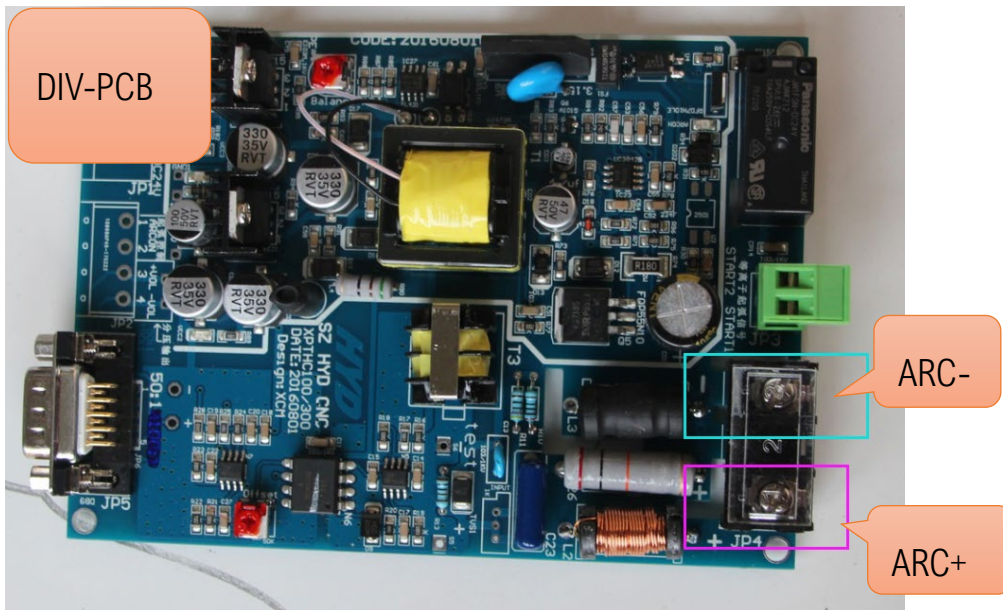


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Problem analysis:

- ✦ 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;



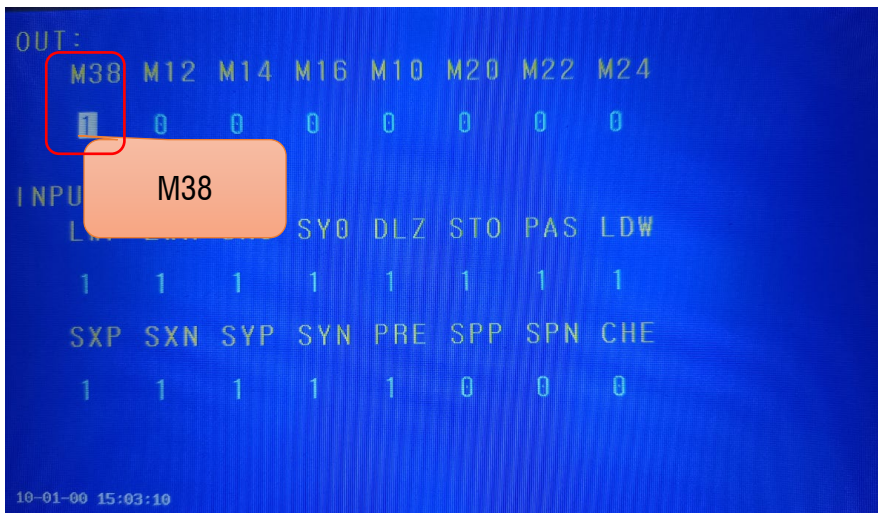
Problem analysis:

- ✦ 3. CNC whether automatic output signal;

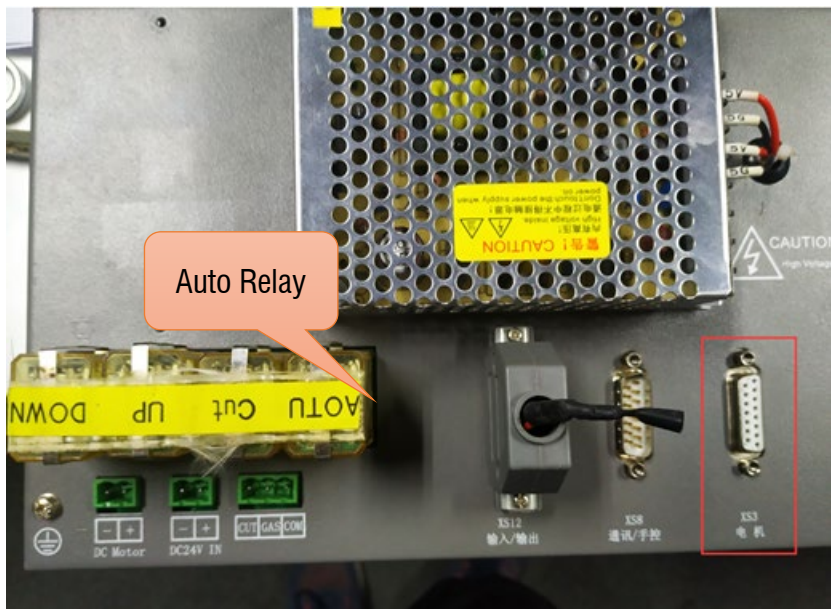
Solution: Step 1-Please ensure that the system is powered;

Step2- We test at the diagnostic interface; Main interface → Press F5 **【Diagnose】** into Diagnose interface → Press 1 key on the system keyboard Modify **【M38=1】** → The relay on the back of the system is active As show pic4. Simultaneously → Press **【ESC】** into Main interface → Press **【F1 AUTO】** into Auto interface → The system screen has an automatic signal output indicator light up; As show Pic5.

Note: M38 is Auto signal;

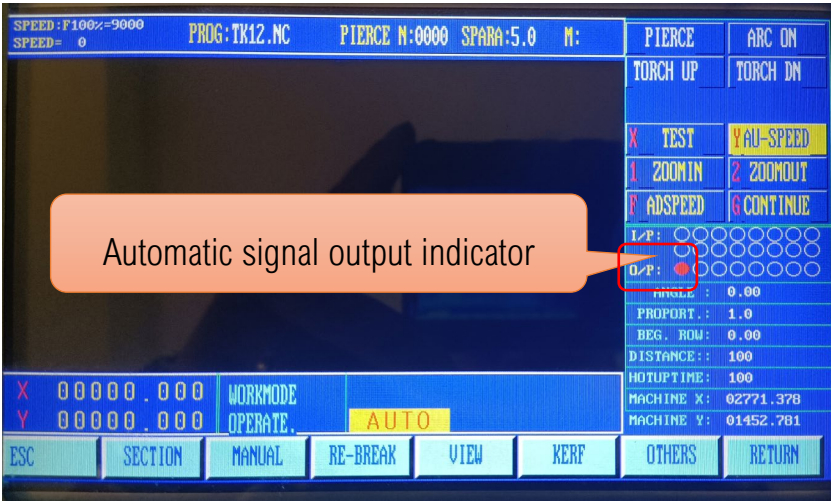


The Auto relay on the back of the system is active As show pic;



Pic4

The system screen has an automatic signal output indicator light up;



Pic5

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Problem analysis:

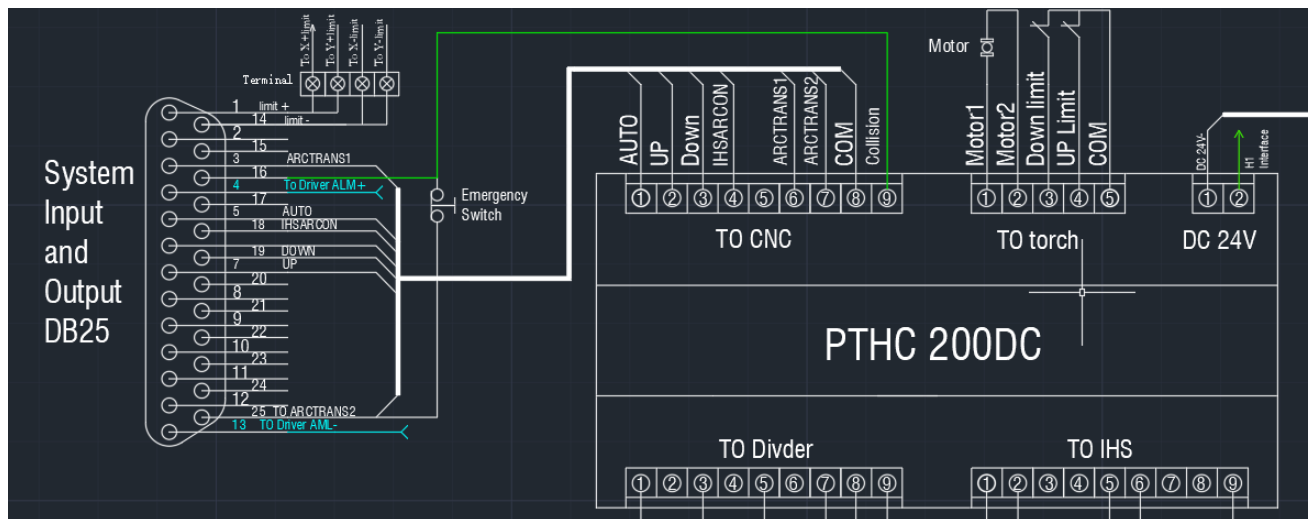
- ✦ 4. System to THC wiring;

Solution: Check with a multimeter; The communication cable between the DB25 port of system and the TO CNC port of THC.

5Pin of DB25 to 1Pin of TO CNC

25Pin or 13pin of DB25 to 8Pin of TO CNC;

If the line is disconnected, please fix it.

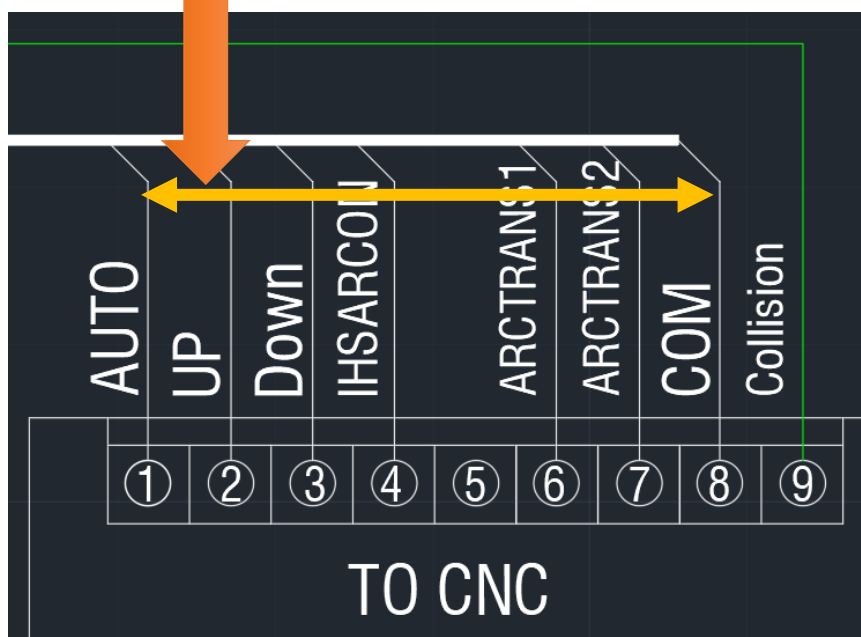


Problem analysis:

- ✦ 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;

