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Section 1: Safety

Read This Manual

Read and understand this instructional manual, the cutting machine manuals, and your employer's safety practices. **Note:** This product is not designed to be field serviceable. Please return to an authorized repair center for any required service.

Dangerous Machinery



Operation and maintenance of automated equipment involves potential hazards. Personnel should take precautions to avoid injury.

Injury and entanglement may occur if hands and limbs come in contact with moving machinery.

KEEP HANDS CLEAR of dangerous moving machinery. All control, including manual, can be effected using the front panel keys or remote interface.

Loose fitting clothing or ties may become entangled in the machinery. These items should not be worn while operating or servicing the machine.

High Voltages



Electric shock can kill. Be sure this equipment is safely installed in accordance with enclosed procedures and specifications.

Avoid contact with electrical wires and cabling while power is on.

This equipment should only be opened by trained service personnel.

Product Listings

Type “M” and “P” Controls



Note: This product has been designed and manufactured in accordance with CE and UL Safety Standards.

UL has successfully tested and listed the type “M” and “P” (with 10.4” display) control products in accordance with the applicable U.S. and Canadian Safety Standards. File number E178333. Note: Suitable for pollution degree 2 environment only.

This appliance has been successfully tested and listed by CE under the following standards; EN 500081-2 1994, EN 61000-6-2 1999 and EN 55011:1998. Certificate number: Retlif R-3909N

Type “E” and “V” Controls



Note: This product has been designed and manufactured in accordance with CE and UL Safety Standards.

UL has successfully tested and listed the type “E” and “V” control products in accordance with the applicable U.S. and Canadian Safety Standards. File number E178333.

This appliance has been successfully tested and listed by CE under the following standards; EN 500081-2 1994, EN 61000-6-2 1999 and EN 55011:1998. Certificate number: Retlif R-3738N1

Type “B” Controls



Note: This product has been designed and manufactured in accordance with CE Safety Standards.

This appliance has been successfully tested and listed by CE under the following standards; EN 500081-2 1994, EN 61000-6-2 1999 and EN 55011:1998. Certificate number: Retlif R-3909N

Note: This product has not been safety tested for outdoor use.

Section 2: Overview

Front Panel Layout

The front panel keypad of the control is shown below. In the upper center is the color LCD display. The power switch is located in the upper left-hand corner of the front panel. It is illuminated with a green lamp when in the on position.

Located in the upper half of the control is the View Screen. The View Screen offers a simple to follow graphical interface for the operator to view all aspects of control operation such as machine setup, part file management, part programming and cutting operations.

Below the View Screen, there are several groups of push buttons or keys on the front panel. The eight keys located directly below the display and labeled as Soft Keys act as programmable keys. The functions of these keys are shown in the display. This allows many different functions to be included without an excessive number of separate keys. It also gives us complete flexibility should we need to add a new feature at a later date.

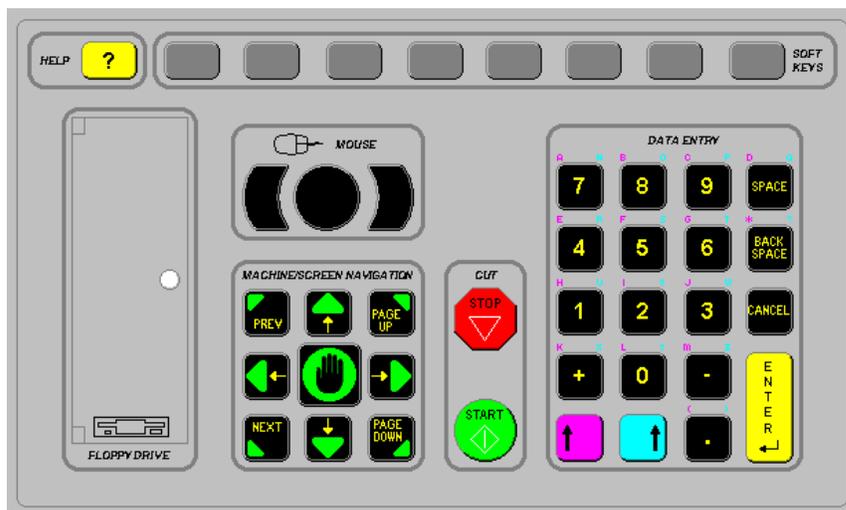
The yellow key labeled HELP is for on-line documentation and help. Simply press this key at any time and this document will be displayed.

The keys to the lower right of the front panel comprise the alpha numeric keypad, which is used for entering data. To the far left, under the label Machine/Screen Navigation, are keys which control manual motion and cursor location during data input. These include the MANUAL key (for Manual Mode jogs) and the eight arrow keys (for jog and cursor direction).

The two keys under the label CUT are for program start and stop.

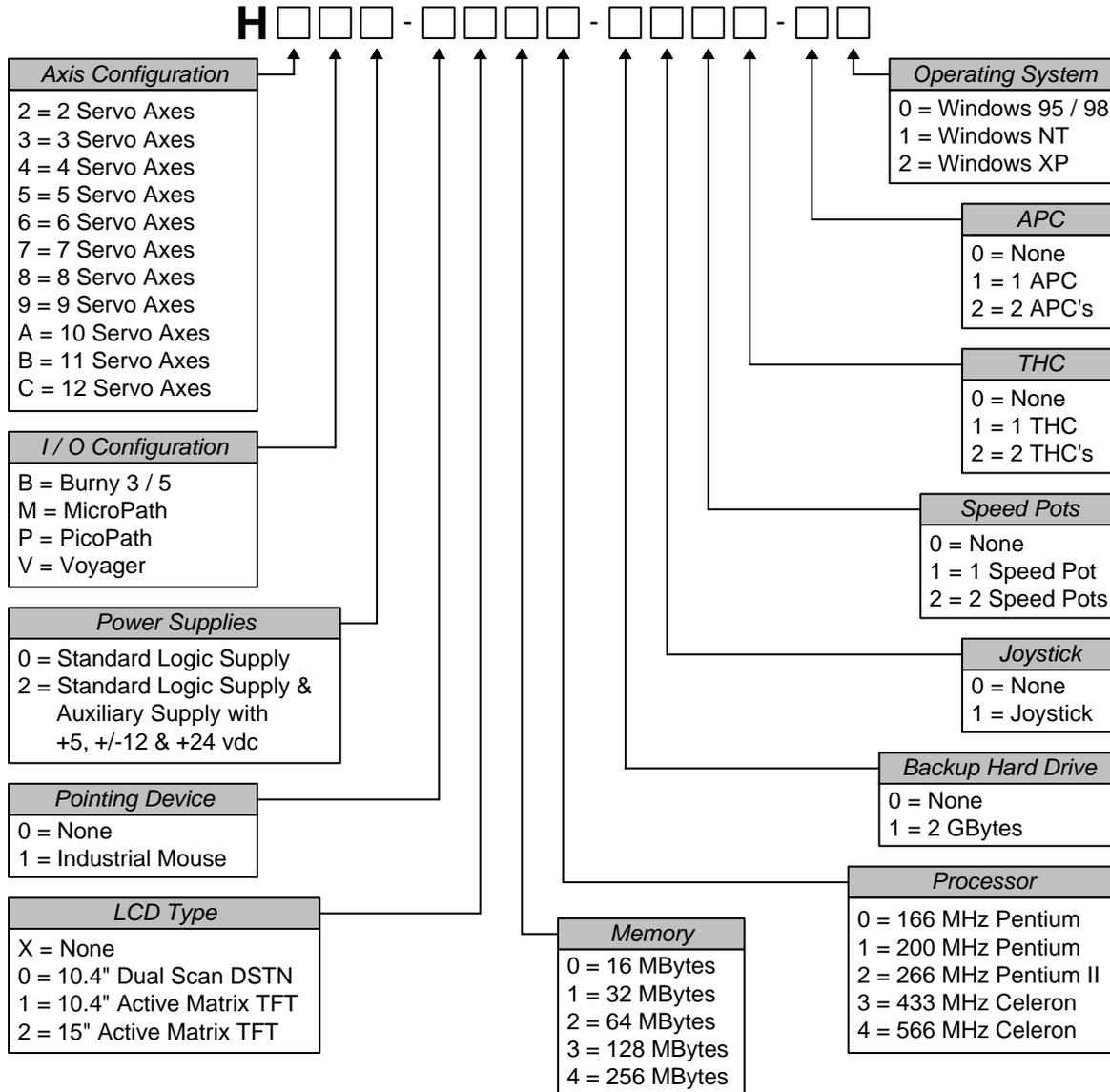
Behind the small door labeled *FLOPPY DRIVE* is the internal 3.5" 1.44 Mbyte floppy disk drive. In addition, there is a small potentiometer behind this door to adjust the LCD brightness and contrast. This potentiometer should only need to be set once, at the time of installation, unless the control is being operated in an extreme temperature environment.

Front Panel



Model Numbering System

The control is available with the following hardware and software configurations. Features and control configuration options in software are based on the I/O configuration of the control. Generally, the information presented in this guide is based on the I/O configuration as outlined below. Please refer to your control I/O configuration for available features and product information. The specific configuration is determined by the Model Number, as shown below:



Model Numbers

You may wish to record your Model Number in the space provided below.

Model Number Information
Model Number:
Serial Number:

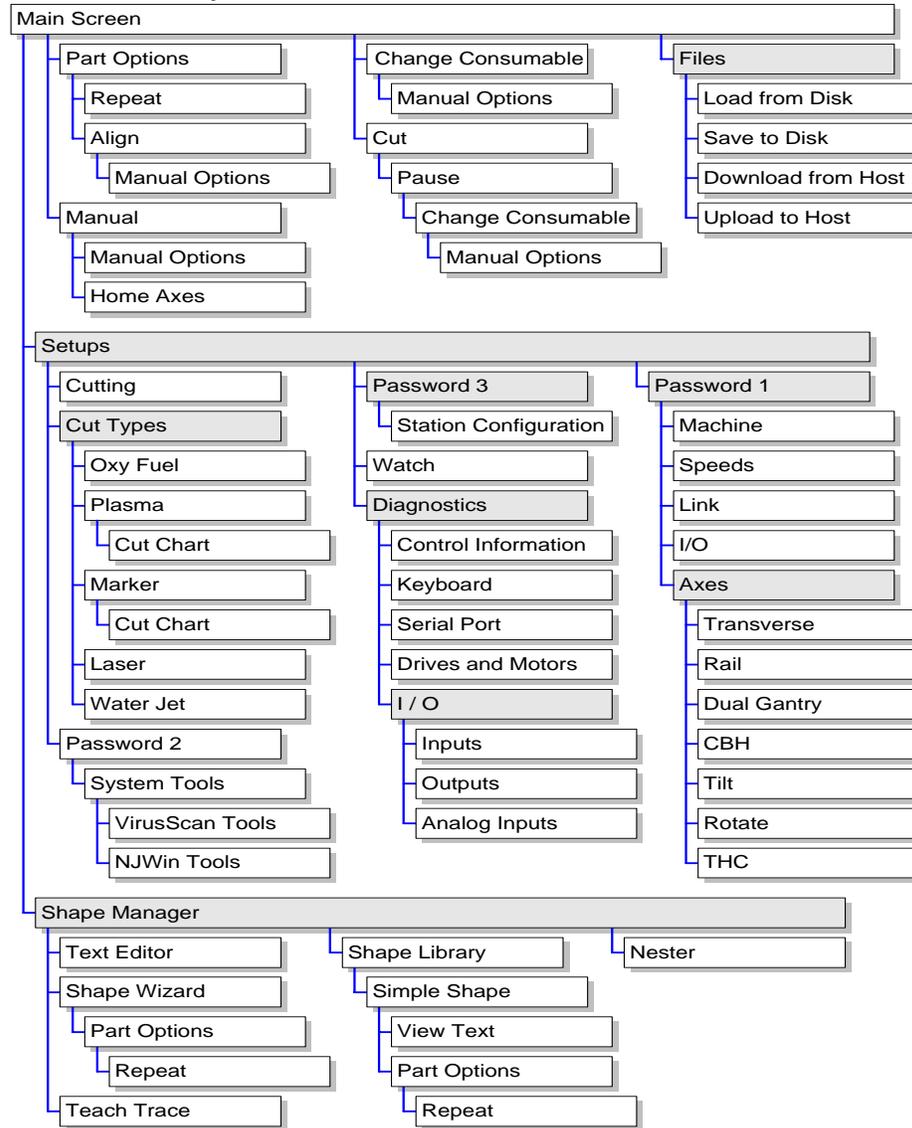
Operation Summary

The programming and operation of the control is menu-driven. The following diagram shows the Screen Hierarchy for the menu structure.

The menu that appears in the display when the unit is first turned on is referred to throughout this manual as the Main Menu. All other menus and functions are accessed at some level under Main Menu, or else appear as part of a special operational sequence, such as when the cutting process is interrupted during the middle of a part.

The **DONE** and CANCEL keys have special functions in relation to the menu structure. The **DONE** key returns to the menu from which the present selection was entered and retains any changes that were made. The CANCEL key returns to the menu from which it was entered and deletes/discards any changes that were made. There are, however, some operations during which CANCEL is not active.

Screen Hierarchy



Section 3: Diagnostics

Control Information

Shows the current software versions and hardware configuration of the control. This information is required when contacting the factory for support. Below is a typical control information screen.

Processor Type <input type="text" value="Celeron"/> Processor Speed <input type="text" value="566 MHz"/> Memory Installed <input type="text" value="255 MB"/> Hard Drive Size <input type="text" value="15.8 GB"/> Hard Drive Free <input type="text" value="11.4 GB"/> Motion Control Card <input type="text"/> Analog Input Card <input type="text"/> 128 I/O Card <input type="text"/>	Control Information Hardware Key ID <input type="text" value="59EE548F-0000"/> Model Number <input type="text"/> Axes Installed <input type="text" value="4"/> Serial Number <input type="text"/> I/O Installed <input type="text" value="32/32"/> Control Type <input type="text" value="Type V"/>
Software Versions Operating System <input type="text" value="5.01.2600"/> Operator Interface <input type="text" value="4.00"/> Virtual Device Driver <input type="text" value="4.00"/> Motion Control Card <input type="text"/>	Software Modules DXF Translator HyperNest CNC-1.00.0
Voltages +3.3 <input type="text" value="+3.29"/> volts +5 <input type="text" value="+4.99"/> volts +12 <input type="text" value="+12.32"/> volts -12 <input type="text" value="-12.10"/> volts	Temperatures 128 I/O Card <input type="text"/> Motherboard <input type="text" value="32.0 C"/> CPU <input type="text" value="40.0 C"/>
Fans CPU <input type="text" value="3879"/> rpm Chassis <input type="text" value="0"/> rpm	
<input type="button" value="Control Information"/> <input type="button" value="I / O"/> <input type="button" value="Keyboard"/> <input type="button" value="Ports"/> <input type="button" value="Drives and Motors"/> <input type="button" value="Done"/>	

Hardware

The Hardware section shows the current hardware configuration which includes the Processor Type, Processor Speed, Memory Installed, Hard Drive Size, Hard Drive Free Space and Motion Control Card revision.

Software Versions

The Software Versions section shows the current version of the Control's Operating System, Operator Interface (software version), Virtual Device Driver and the Motion Control Card software.

Control Information

The control Information section displays the Hardware Key number, the control model number, serial number, control I/O type, axes enabled and I/O enabled.

Software Modules

The Software Modules information will display the optional software features which have been loaded or have been enabled for use (e.g. DXF Translator, McAfee VirusScan Software or NJWIN font Viewer).

Voltage

System Voltages at the motherboard will be displayed for motherboards equipped with this monitoring feature.

Temperature

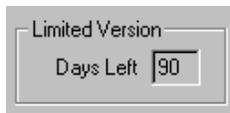
Temperature at the motherboard will be displayed for motherboards equipped with this monitoring feature.

Fans

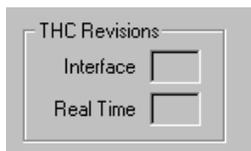
Fans speed at the motherboard will be displayed for motherboards equipped with this monitoring feature.

Limited Version

The Limited Version information will be displayed if the control is operating on a trial version of software. The version of software is available for 90 days of use and may be enabled for permanent use through use of a password available from the control vendor.

**THC Revision**

The current Command[®] THC Interface and Real Time Revision Levels will be displayed at the Control Information screen when enabled.



I/O

Inputs

This test continuously monitors and displays the current state of all of the optically-isolated discrete inputs in the control. The current state of each input, On or Off, is displayed to the left of the input name. Below is an input screen with all of the inputs off.

Inputs displayed with a white background allow for the input name to be changed by the user. To change the input name, use the Previous/Next arrow key to highlight the desired input and type the new text for the input name. The input can then be connected to the control and used as commanded in the part program. Example: The EIA W7 S1 code will pause the program and wait for input 7 to become active.

A password is required when entering this screen.

<input type="radio"/> Off	Torch Up Sense
<input type="radio"/> Off	Torch Down Sense
<input type="radio"/> Off	X-Overtravel Switch
<input type="radio"/> Off	Cut Sense
<input type="radio"/> Off	Tracer On Path
<input type="radio"/> Off	Y-Overtravel Switch
<input type="radio"/> Off	Input7
<input type="radio"/> Off	Input8
<input type="radio"/> Off	X Home Switch
<input type="radio"/> Off	X+Overtravel Switch
<input type="radio"/> Off	Y Home Switch
<input type="radio"/> Off	Y+Overtravel Switch

Inputs Outputs Analog Input Done

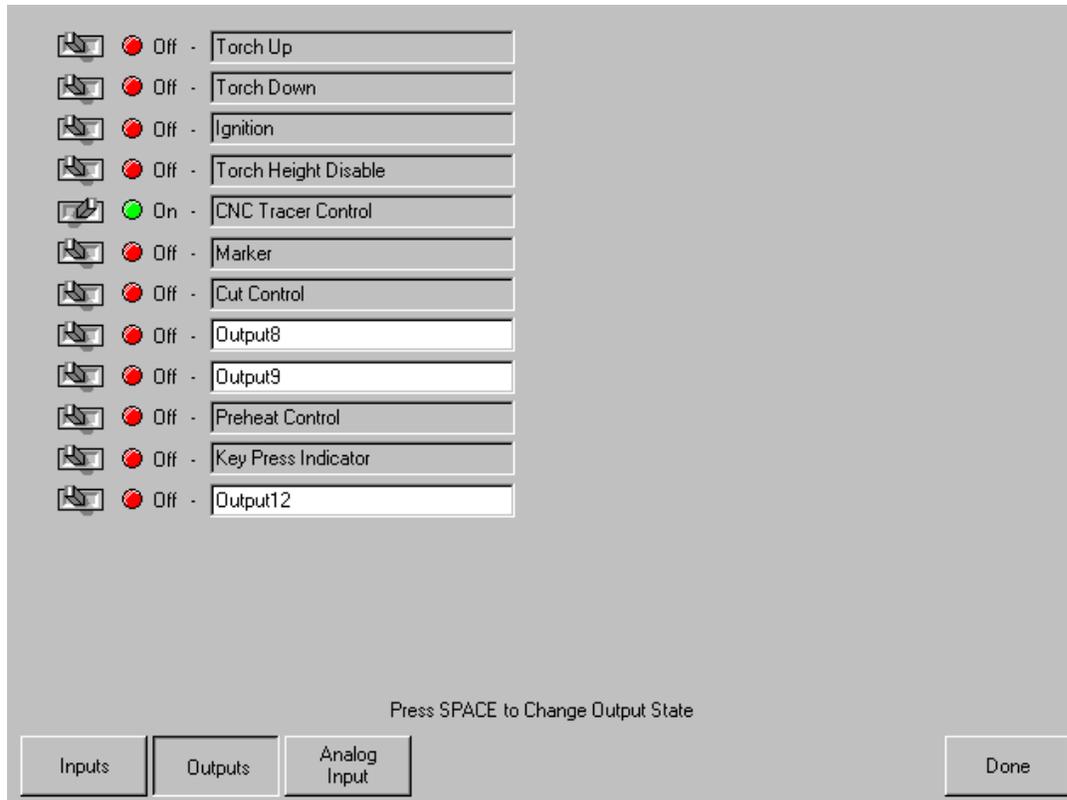
Note: The number and name of the Inputs will vary due to control software and hardware configurations.

Outputs

This test allows the activation of all optically-isolated discrete outputs in the control. Each Output's state can be changed by selecting the desired output with the PREV and NEXT keys and then pressing the SPACE key. The current state of each output, On or Off, is displayed to the left of the output name. Below is an output screen all of the outputs Off.



Warning: When manually activating the control's outputs, Machine, Torch and Marker motion may occur and the cutting device may activate.



Outputs displayed with a white background allow for the Output name to be selected by the user. To change the output name, use the Previous/Next arrow key to highlight the desired output and type the new text for the output name. The output can then be connected to the control and used as commanded in the part program. Example: The EIA M22 and M23 code will turn on and off output 12.

Note: The number and name of the Outputs will vary due to control software and hardware configurations.

Analog

The Analog I/O Diagnostic screen allows the user to view the input state and activate optically-isolated discrete outputs for the Analog Input card. The Analog Input card is used as an interface card to support option Sensor™ THC, APC™, Joystick and external Speed Pot options.

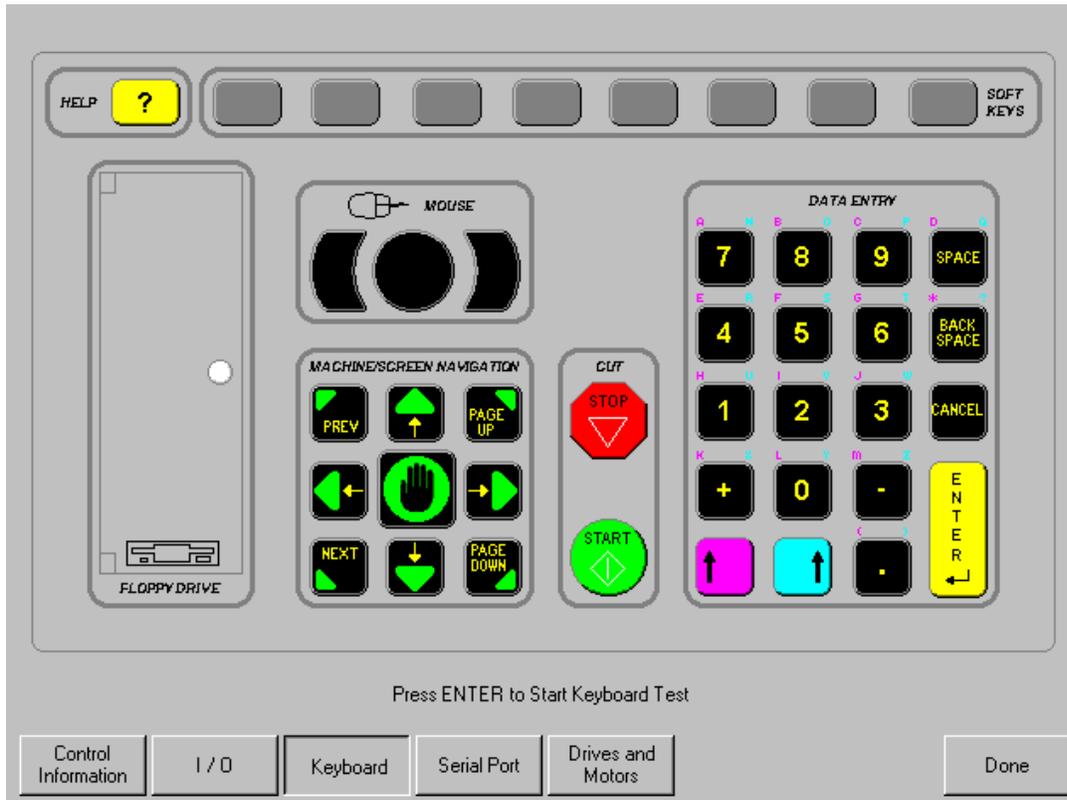
Note: The Analog Input screen will vary slightly depending on control hardware configuration.

The screenshot displays the Analog I/O Diagnostic screen with the following elements:

- Joystick Status:** Four rows, each with a red circle icon, the text "Off", and a text box containing the joystick direction: "Joystick Up", "Joystick Down", "Joystick Left", and "Joystick Right".
- PWM Outputs:** Six rows, each with the label "PWM Output" followed by a number (1-6), a text box containing "0", and a percentage sign (%).
- Analog Outputs:** Two rows, each with the label "Analog Output" followed by a number (1-2), a text box containing "0", and the unit "volts".
- Analog Inputs:** Twelve rows, each with the label "Analog Input" followed by a number (1-12), a text box containing "0.0", and the unit "volts".
- Navigation:** At the bottom, there are four buttons: "Inputs", "Outputs", "Analog Input" (which is highlighted), and "Done".

Keyboard

This diagnostic screen allows each key of the control keyboard to be tested. To start the keyboard test, press the ENTER key from within the keyboard diagnostic screen. As each key is pressed on the control keyboard, the corresponding key will activate on the display. If any of the keys do not activate on the display during the keyboard test, then the control keyboard may be defective and the factory should be consulted for further instructions. To exit the keyboard test, press and hold either Shift key and then press the CANCEL key. Below is the Keyboard Test Screen.



Serial Port

This diagnostic screen allows the testing of the control serial ports. To perform the test, install the appropriate jumper or jumpers. If the serial port being tested is configured for RS-232, jump pin 2 to pin 3. If the serial port being tested is configured for RS-422, jump pin 2 to pin 3 and pin 4 to pin 7. Select the appropriate serial port to test and press the Test Port softkey to initiate the test. If the serial port is functioning properly, the exact text in the Send window will appear in the Received window. If the serial port is not functioning properly, a Communications Time Out message will appear below the Received window. If the serial port test fails, then the control may be defective and the factory should be consulted for further instructions. Below is a serial port test screen with a successful test.

Port Serial 1 Serial 2

Test Once Continuously

Send:

To test the serial port:

1. Jumper pin 2 and pin 3 on the serial port.
2. Press the Test Port softkey.

If the test passes the text that appears in the Received box will exactly match the text that is in this box.

Received:

To test the serial port:

1. Jumper pin 2 and pin 3 on the serial port.
2. Press the Test Port softkey.

If the test passes the text that appears in the Received box will exactly match the text that is in this box.

Serial Port OK

Control Information I / O Keyboard Serial Port Drives and Motors Test Port Done

Port

The Port parameter is used to select which serial port (Serial 1 or Serial 2) will be tested..

Test

The Test feature is used to select a single or continuous signal is to be sent for testing.

Send

This window contains the text that will be transmitted during the serial port test.

Received

This window will contain the text that is received during the serial port test. If the test is successful, it should match the text contained in the Send window.

Test Port

Used to initiate the serial port test on the selected port..

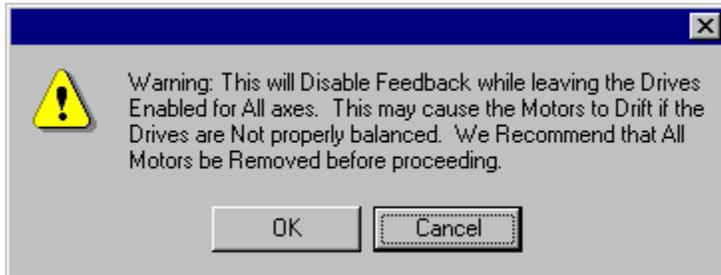
Drives and Motors

The Drives and Motors diagnostic screen allows a technician to send a direct signal to the drive amplifiers without enabling the servo loop for testing purposes.



Warning! When sending direct signals to the drive amplifiers, unexpected motion on the cutting table may occur and extreme caution should be used.

When the Drives and Motors screen has been pressed, the following warning message will appear.



Select OK and then enter the machine password to view the Drives and Motors screen.

Pulse Type Single Repeating

Pulse Direction Positive Negative Alternating

Pulse Magnitude volts

Pulse Duration sec

Output Signal

Volts

Transverse Position in

Rail Position in

Dual Gantry Position in

CBH Position deg

Speed

Transverse ipm

Rail ipm

Dual Gantry ipm

CBH rpm

Test Transverse Test Rail Test Dual Gantry Test CBH Test All Zero Positions Done

Pulse Type

Selects whether the signal that will be sent to the drive amplifier will be a single pulse or a repeated pulse. If the repeated pulse is selected, the signal will continue until the Test softkey for that axis is pressed again.

Pulse Direction

Selects whether the signal that will be sent to the drive amplifier will be a positive, negative or alternating pulse.

Pulse Magnitude

Sets the voltage of the signal to be sent to the drive amplifier.

Pulse Duration

Sets the amount of time for each segment of the signal to be sent to the drive amplifier.

Test Transverse/Rail/Dual Gantry/CBH

The Test buttons will send the selected output signal to the appropriate drive amplifier. If a repeating signal has been selected, any combination of available test buttons may be used for the test. Each drive amplifier will be sent the selected output signal until the selected output softkey has been pressed a second time to end the test.

Test All

Pressing the Test All softkey will send the selected output signal to all drive amplifiers.

Speed

The Speed window displays the current speed for each axis.

Error Messages

The control contains a number of error messages that will be displayed when programming, machine, or internal errors are detected. A list of the more common error messages are explained below.

No Part Loaded

This message is displayed whenever the control does not contain a valid part program in memory. To clear this error message, load a valid part program from either the Shape Library, hard drive, diskette or from a Host system.

Part Larger than Plate

This message will be displayed if the part program that has been loaded is larger than the plate size information in Setups. The operator may choose to ignore and continue the cut or return to Setups to correct the plate size.

Kerf too Large, Arc/Line has Disappeared. Abort Cut?

This message is displayed when the Kerf size selected is too large and will affect the shape of the part. The operator can continue to cut the part, abort the cut to review the Kerf information selected or abort the cut to review the part program for any errors. Electing to continue cutting of a part program which prompts the display of this error, may lead to unexpected results.

Cut Sense Lost

This message is displayed if the Arc ON Feedback setup parameter is enabled and the Cut Sense input is deactivated by the plasma unit while cutting. When this condition occurs, the control displays the Pause screen, which allows use of the Cut Recovery features to finish cutting the piece.

Communications Time Out

This message is displayed whenever the Host system does not respond within the Link Time Out setup parameter for either a Host Upload or Download. To correct this problem, increase the Link Time Out setup parameter and check the communications setup parameters on the Host system and the control.

Host Not Responding

This message is displayed whenever the communications is lost to the Host system after the initial communication was established. To correct this problem, try exiting and re-entering the Upload or Download to Host screens to re-establish communications and/ or check the communications setup parameters on the Host system and the control.

Scale Factor must be between .001 and 1000

This message is displayed whenever a value less than .001 or greater than 1000 is entered for a Scaling Factor. To correct this problem, enter a value between .001 and 1000 for the Scaling Factor.

Radius at Arc Beginning and Radius at Arc End are not within the Arc Radial Error Tolerance

This message is displayed whenever the radius beginning-arc and the radius-ending arc of a part program are not within the Arc Radial Error setup parameter in the Main Setup screen. To correct this problem, either increase the Arc Radial Error Tolerance setup parameter or correct the part program itself.

Transverse Position Error Exceeded

This message is displayed whenever the current Transverse position error exceeds the Servo Error Tolerance Setup parameter in the machine setups screen. It also may appear if the position feedback loops are not operating properly, or the machine is being commanded to move or accelerate faster than it is capable. To correct this problem, either increase the Servo Error Tolerance Setup parameter in the machine setups screen, re-tune the system, decrease the Maximum machine speed setup parameter or the acceleration rate setup parameter. Generally, this error is displayed when the setting for Incremental or Absolute EIA I and J codes is set to the wrong state for the active part program.

Rail Position Error Exceeded

This message is displayed whenever the current Rail position error exceeds the Servo Error Tolerance Setup parameter in the machine setups screen. It also may appear if the position feedback loops are not operating properly or the machine is being commanded to move or accelerate faster than it is capable. To correct this problem, either increase the Servo Error Tolerance Setup parameter in the machine setups screen, re-tune the system, decrease the maximum machine speed setup parameter, or the acceleration rate setup parameter. This error generally indicates a servo drive or motor problem. First check for fault indications on the servo drives.

Dual Gantry Position Error Exceeded

This message is displayed whenever the current Dual Gantry position error exceeds the Servo Error Tolerance Setup parameter in the machine setups screen. It also may appear if the position feedback loops are not operating properly or the machine is being commanded to move or accelerate faster than it is capable. To correct this problem, either increase the Servo Error Tolerance Setup parameter in the machine setups screen, re-tune the system, decrease the Maximum machine speed setup parameter, or the acceleration rate setup parameter. This error generally indicates a servo drive or motor problem. First check for fault indications on the servo drives.

Transverse Positive Hardware Overtravel Reached

This message is displayed whenever the control detects a positive limit switch in the Transverse axis. This can also occur if the limit switch input is set for the wrong polarity or the limit switch wiring is not properly connected. If the Transverse axis did trip the positive limit switch, use Manual mode to jog the Transverse axis away from the limit switch. This error generally indicates a servo drive or motor problem. First check for fault indications on the servo drives.

Rail Positive Hardware Overtravel Reached

This message is displayed whenever the control detects a positive limit switch in the Rail axis. This can also occur if the limit switch input is set for the wrong polarity or the limit switch wiring is not properly connected. If the Rail axis did trip the positive limit switch, use Manual mode to jog the Rail axis away from the limit switch.

Transverse Negative Hardware Overtravel Reached

This message is displayed whenever the control detects a negative limit switch in the Transverse axis. This can also occur if the limit switch input is set for the wrong polarity or the limit switch wiring is not properly connected. If the Transverse axis did trip the negative limit switch, use Manual mode to jog the Transverse axis away from the limit switch.

Rail Negative Hardware Overtravel Reached

This message is displayed whenever the control detects a negative limit switch in the Rail axis. This can also occur if the limit switch input is set for the wrong polarity or the limit switch wiring is not properly connected. If the Rail axis did trip the negative limit switch, use Manual mode to jog the Rail axis away from the limit switch.

Transverse Positive Software Overtravel Reached

This message is displayed whenever the Transverse axis position is greater than the Maximum Travel Limit setup parameter for the Transverse axis. When this occurs, use Manual mode to jog the Transverse axis to a position within the Travel Limit setup parameters.

Rail Positive Software Overtravel Reached

This message is displayed whenever the Rail axis position is greater than the Maximum Travel Limit setup parameter for the Rail axis. When this occurs, use Manual mode to jog the Rail axis to a position within the Travel Limit setup parameters.

Transverse Negative Software Overtravel Reached

This message is displayed whenever the Transverse axis position is less than the Minimum Travel Limit setup parameter for the Transverse axis. When this occurs, use Manual mode to jog the Transverse axis to a position within the Travel Limit setup parameters.

Rail Negative Software Overtravel Reached

This message is displayed whenever the Rail axis position is less than the Minimum Travel Limit setup parameter for the Rail axis. When this occurs, use Manual mode to jog the Rail axis to a position within the Travel Limit setup parameters.

Dual Gantry Skew Error Exceeded

This error message is displayed when the control has detected a position error fault between the two drive axes on the dual gantry. It also may appear if the position feedback loops are not operating properly, or the machine is being commanded to move or accelerate faster than it is capable. To correct this problem, either increase the Skew Error Tolerance Setup parameter in the machine setups screen, re-tune the system, decrease the maximum machine speed setup parameter or the acceleration rate setup parameter.

Need Station Selection

The Need Station Selection error message is displayed if the input for a station or process has not been activated. Example: When cutting in Plasma mode, a Plasma 1 or Plasma 2 input may be required to execute the selected Plasma cut process.

Buffer Time Out

This may appear if there is an instance where the motion buffer is full and cannot record the data being saved. This error allows the operator stop the motion back up on path to the last pierce and start over without a position error. This error should be reported to the control vendor.

CNC Time Out

This is a general error that may appear if there is an instance when any buffer is full and cannot record the data being saved. This error allows the operator stop the motion back up on path to the last pierce and start over. This error should be reported to the control vendor.

Unable to Find HASP

The HASP is Hardware protection key (dongle) that enables the software and features for use. If the HASP is not installed the control will not work. If this message appears and the hardware key is in place, please contact your control vendor for assistance.

System Recovery

In the unlikely event that an extreme system error has occurred which prevents the control from operating, a Recovery Software program is available from the control vendor to reset or replace core system files and re-enable operation of the control.

This Recovery Software is specifically designed for the control and will allow the control to recover from Registry, Setup and Application faults due to damaged files. These errors would result in the failure of the control software to operate or to operate correctly. This recovery process may also be used if corruption of the control software is suspected which would result in key operational errors. In this situation, Recovery should only be performed when instructed to do so by the control supplier.

There are two options for initiating the Recovery process. One is to use a bootable Recovery diskette from the control supplier. The other is through the AutoRecovery feature which is an automated function that detects that the control has failed to boot successfully on a previous attempt and will automatically begin the Recovery process on the next boot up attempt.

Shape cutting controls supplied with software release 1.25 or higher are shipped with the Recovery software loaded as standard. If the control does not have the AutoRecovery Software as standard, you will need to upgrade the control software to Version 1.25 or higher software and then load the AutoRecovery software onto the control using a Recovery diskette.

In general, the operation of the Recovery process is the same for all control types but is varied slightly depending on how the Recovery process is initiated. Recovery instructions displayed on screen may vary slightly depending on control software and hardware configurations. **Note:** Recovery software is only available for Windows® XP and Windows NT® based controls on disk.



WARNING!: The Recovery Process involves replacing core operation files for the operation of the control and should only be initiated when the control fails to boot or when instructed by the control supplier. Read and follow all instructions provided during the Recovery process carefully to ensure proper operation.

Diskette Recovery

The Recovery software may be obtained from the control supplier on diskette or transmitted via the internet.

To create a Recovery disk from the compressed software sent via the Internet:

The file sent by the Internet will be an auto-executable file which will place the required files onto a diskette to be used at the control. First place a blank diskette into your PC. Double click on the recovery EXE file. A message box will be displayed. Click on the "Create Floppy" button to execute. The EXE will copy the new files (up to 23 files including system files) to the floppy disk to take to the control.



WARNING!: Do not perform the Recovery software from the Recovery Diskette on a PC. The Registry file and the Autoexec.bat file will be replaced affecting the PC's operation.

Instructions for use of the Recovery diskette:

With the control turned off, place the Recovery diskette into the control and turn the unit on. The control will now be operating in a DOS window while the system boots up and during the recovery process. Simply follow the instructions on screen.

If the control was not previously loaded with the Recovery software or the Recovery software is being upgraded, the control will copy the current Recovery software to the hard drive. When completed, the control will indicate that Recovery installation was successful with the following message. "RECOVER Successfully Installed on Hard Drive. Remove Disk and Cycle Power if RECOVERY Not Needed Now or You May Press Any Key to Proceed with RECOVERY. Press Any Key to Continue...."

Press any key to begin the Recovery process.

AutoRecovery

If the control fails to boot after four attempts, turn the control off, wait 30 seconds and turn the control back on. The control will now be operating in a DOS window while the system boots up and during the recovery process. Simply follow the instructions on screen. You will be prompted with the message "Control Failed to Boot Properly Last Time...". It will then begin the Recovery Process. The AutoRecovery feature is not available on Windows® XP or Windows® NT operating systems.

Recovery Process

The Recovery process will begin with the following message. "WARNING RECOVERY Will Update Your Windows Files, Scan Your Hard Disk, Update Your Registry Files and Update Your Application Software. Are You Sure You Wish to Proceed With RECOVERY? Press Start or Help to Begin RECOVERY or Any Other Key to Boot Normally..."

Press the START or HELP key to begin Recovery.

Note: During Recovery many files are being added, deleted or replaced. It is common to see messages displayed indicating "File Not Found" or "Directory Missing". This is a normal part of the Recovery process.

If the control has a Backup Windows Directory, you will be prompted to replace the Working Windows directory with the Backup Windows Directory. The following message will be displayed. "ALERT-RECOVERY Has Detected a Backup Windows Folder. Recommend That Backup Windows Folder be Restored to Working Folder. Press Enter to Restore Windows Folder or Any Other Key to Skip..."

It is generally recommended that you replace the Windows directory with the Backup Windows Folder. Press the ENTER key to replace the Windows folder and continue.

At this point, the control will perform a Scan Disk of the Hard Drive to look for bad sectors. The control will display the message: "WARNING - RECOVERY can now Scan your HardDrive. Press 1 to Scan HardDrive or 2 to Skip Scan:". Press 1 to scan the hard disk. Scanning the hard drive will take approximately 15 - 30 minutes depending on hard drive size.

Next, the control will display the message: "WARNING – RECOVERY can now replace the Registry on your HardDrive. Press 1 to Replace Registry or 2 to Skip Registry:". Press 1 to replace the registry.

Upon completion of the registry replacement, the following message will be displayed: "If you have a Floppy Disk Drive, you may now choose to use a Floppy Disk for Saving Your Setups and

Updating Software. If your Setups are not corrupted and you do not need Updated Software you can skip RECOVERY for Setups and Software. Press 1=Use Floppy, 2=No Floppy, or 3=Skip RECOVERY for Setups and Software:". Press 1 if you have a Floppy Drive and want to use it to recover setups and software. Press 2 if you do not have a Floppy Drive or do not want to use it. Press 3 if you do not want to Recover Setups and Software.



Note: If you have selected option 1, insert a clean formatted diskette into the floppy drive the diskette must not be write protected. Failure to have a writable diskette in the floppy drive will result in failure of the Recovery process requiring the user to cycle power on the control and start the process over.

If your control is equipped with a floppy disk drive, confirm that a diskette is in the disk drive and press the number 1. This will delete the setup file and place a copy of the current control setups onto the floppy disk and to the Hard Drive setup file backup location.

If your control is NOT equipped with a floppy disk drive, Press the number 2. This will place a back up copy of the control setups on the control hard drive, delete the current setup file and exit the Recovery process.

Press the number 3 if you wish to exit Recovery.

If you choose options 1 or 2 the next message is displayed:

"WARNING - RECOVERY can Remove Setups from your HardDrive
WARNING - You MUST have a Blank Disk in the Drive Now (if using floppy)
WARNING - If Removed, Setups must be Reentered or Reloaded after RECOVERY
WARNING - Only remove setups if your Setups are Corrupted".
Press 1 to Remove Setups or 2 to Skip Setup Removal.

If you have selected option 1 or 2 above, the control will now offer the opportunity to replace the current version of operating software with the following message.

The next message is:

"WARNING - RECOVERY can now Update Software from Floppy Disk
WARNING - You MUST have a Software Update available on Floppy Disk(s)
WARNING - Your Software Version will be changed to the Floppy Version
WARNING - Only Update Software if Current Software Does Not Load".

If you wish to replace the current software and have an Update Disk available, press 1 to Update Software or press 2 to Skip Update. If you have chosen to replace the current version of software, you will be notified to cycle power after the operating software has been deleted. If the software is being updated from the Backup Software on the Hard Drive and not the Floppy Disk, a Software Update Complete message will be displayed.

The final message is: "Remove Floppy Disk and Cycle Power to Finish Recovery".

CYCLE POWER (turn the control off, wait 30 seconds and turn the control back on). NOTE: If you have removed the operating software, you will be prompted to insert an update disk on power up. After placing the update disk in the floppy drive, press ENTER to continue and update the operating software. If you selected not to use a Floppy Disk for the Software Update, the control will simply reboot.

The control will now launch the operating software and bring you to the main screen. A warning message may appear that will inform you it was unable to load setups. Press ENTER to accept the default setup values. Additionally, a message may be displayed that "Setups Removed, Modified or Corrupted. Use Back Up Setups?" Select "No" and press ENTER to accept the default setup values.

You may also be prompted to back up the Operating System. The following message may be displayed. "Your Operating System Has Not Been Backed Up. Recommend That You Back Up Operating System Now. Proceed With Back Up?" It is recommended that the operating software be backed up. Select Yes and press enter to Back up the Operating System.

The unique setups for your control may then be loaded onto the control through the special password screen in the normal fashion.

You should now be at the main cut screen. Select Setups/ Password/ enter the password to access the Special Password Screen. Insert a copy of the original machine setups into the floppy drive and press the Load Setup softkey. If a copy of the original machine setups is not available, place the RECOVERY disk or the disk used for Setups in the Recovery Process into the floppy and press Load Setups. You will be prompted to save from diskette or hard drive, select diskette and select the setup file name. The temporary setup file name saved on the disk during the Recovery process is "RECOVERY". Select Recovery as the file name and press ENTER to load the setups on to the control.

If the problem reoccurs after loading the Setup file, the Setup file may be faulty. You can then repeat the steps above to remove the Setup file and manually enter the machine setups to configure the control to the cutting machine. **NOTE:** If the control continues to exhibit problems, the control may need to be returned to an authorized agent for service. Contact the control vendor or service agent.

With the RECOVERY software now installed on the hard drive, the control will automatically detect when three failed attempts to boot have occurred and on the next Bootup attempt, prompt the user to begin Automatic Recovery.

System Maintenance - Windows XP®



The control Systems Maintenance involves operational knowledge of Windows® XP system and should only be performed by qualified personnel. A mouse and external Keyboard will be required to use the features for System Maintenance.

Restore / Back up from CD

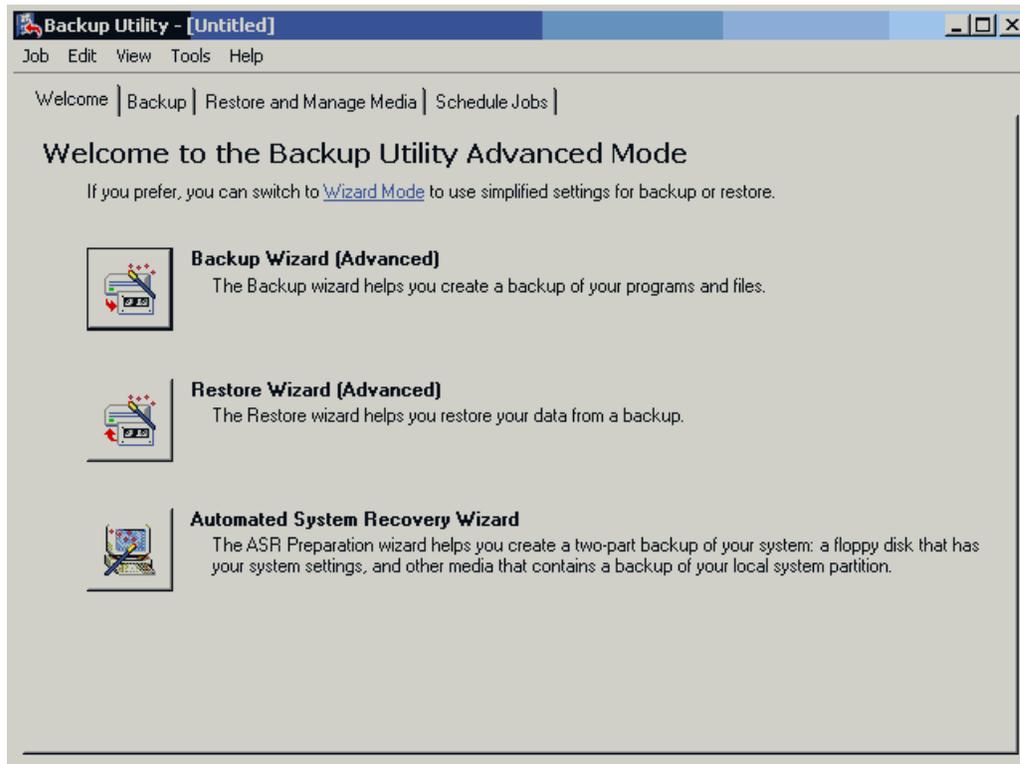
This Windows XP® feature allows the use of the Windows XP® Restore Utilities to maintain system performance and recover from system changes and faults. This is performed by replacing user selected files from a back up file located on a partition of the Hard Drive. The feature may be used through a Wizard to guide the user through the desired process, or the user may select to move directly to the Advanced tools.

This feature is initiated by booting from a CD supplied with the control. If your control is not supplied with a CD Drive an external one may be temporarily added to the control to take advantage of this feature. Please contact your control vendor for additional information on the temporary installation of the CD Drive.

Note: When booting from a CD, the drive designation will be temporarily changed. The main drive partition used for the control is Drive C. When booting from CD the first Drive designation (Drive C:) will be assigned to the CD Drive and the main control partition will be assigned to Drive D.

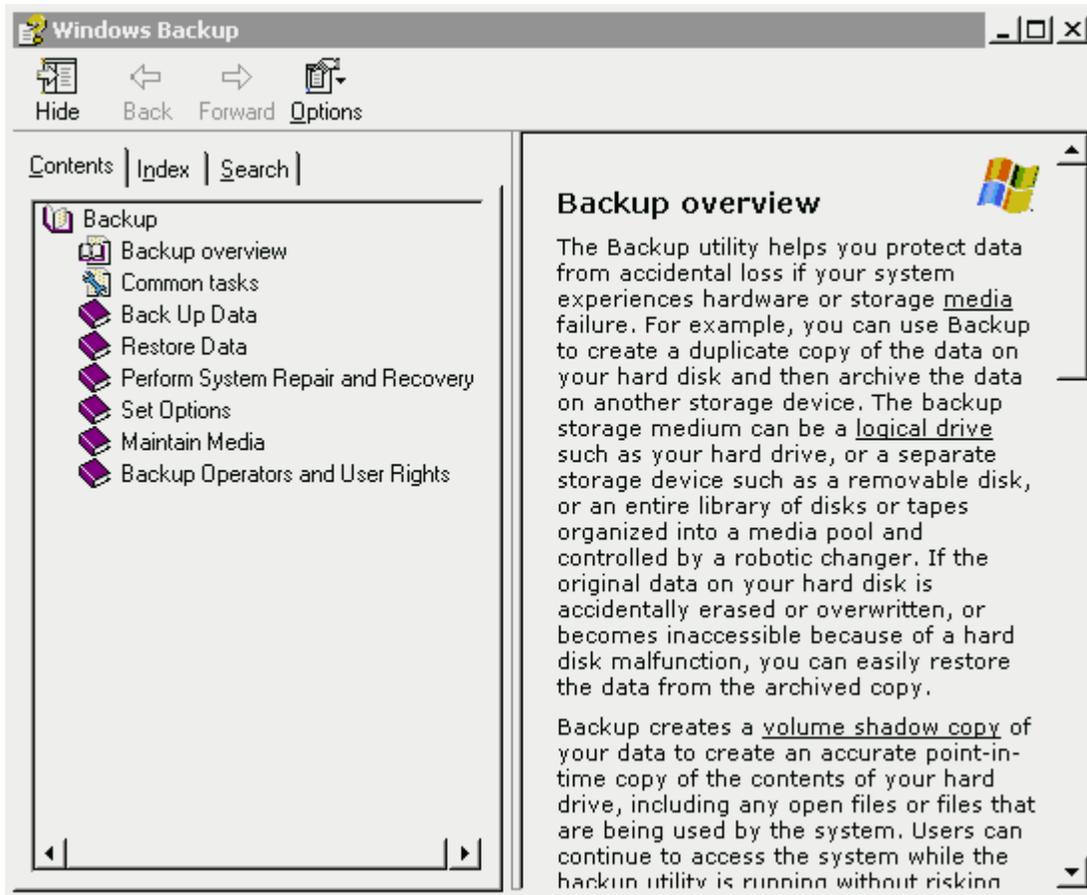
Important Guidelines:

- The default system back up file is located at D:\backup.bkf.
- Restore should be performed from D:\backup.bkf or E:\backup.bkf to D:\.
- DO NOT BACKUP backup.bkf or pagefile.sys on the Root of D:\.
- Under Tools/ Options/ Restore/ Select - Always Replace u Replace All Files when Restoring.



Help Features

On-line help features are available when using the Back Up Utility and may be accessed through the Help menu or by selection of a topic and pressing the F1 Key.



Also refer to the System Tools section of this guide for additional System Maintenance features.

Section 4: Password Setups

The following setup screens are only available with the supervisory passwords. This will help prevent unauthorized personnel from entering these screens.



Warning! Extreme care should be taken when changing these parameters as they may cause machine damage if incorrectly set. Only trained service personnel should have access to these passwords.

The “2865” password is provided for viewing of the Machine, Speeds, Link and Axes setups without allowing changes. This password is useful for verifying setups without the danger of accidentally changing them or revealing the supervisory password to an unauthorized user.



Note: After installation of the control to the cutting table or if any setup parameters are changed, it is important to save the current setup file to both the hard drive and floppy disk for future reference.

Machine

X Axis Orientation	<input checked="" type="radio"/> Transverse	<input type="radio"/> Rail	Table Size X	<input type="text" value="48"/> in	Y	<input type="text" value="96"/> in
Up Direction	<input checked="" type="radio"/> +Y	<input type="radio"/> +X	<input type="radio"/> -Y	<input type="radio"/> -X		
Right Direction	<input checked="" type="radio"/> +X	<input type="radio"/> -X				
Dual Gantry Installed	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
CBH Installed	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
X and Y Motor/Encoder	<input checked="" type="radio"/> Normal	<input type="radio"/> Swapped				
			Sensor THC's Installed	<input type="text" value="0"/>		
			THC On	<input type="checkbox"/> Plasma	THC On	<input type="checkbox"/> Marker
			Command THC's Installed	<input type="text" value="1"/>		
Key Press Logging <input checked="" type="radio"/> No <input type="radio"/> Yes						
Machine		Speeds		Ports		I / O
					Axes	
						Done

X Axis Orientation

The control allows specifying the X axis as being either the Transverse or Rail axis. The default setting is Transverse. This parameter should be set before cutting the part.

Up Direction

This parameter defines the machine motion that will occur when the ↑ arrow key is pressed during manual mode.

Right Direction

This parameter defines the machine motion that will occur when the → arrow key is pressed during manual mode.

Dual Gantry Installed

Selecting Yes will enable the Dual Gantry axis and allows configuring of that axis.

CBH Installed

Selecting Yes will enable the Contour Bevel Head axis and allows configuring of that axis.

X and Y Motor/Encoder

Selecting this feature as Swapped will internally swap the X and Y Axis encoder signals. This feature simplifies the installation to systems with alternate wiring configurations.

Key Logging

The Key Logging feature is used as a troubleshooting diagnostic tool to record key presses made at the control during operation. When enabled, all key presses and application faults will be saved to a daily log file that may be sent to the control manufacturer for evaluation. The files may be retrieved and stored to diskette through the Files screen at the control. Please refer to the Files Screen information provided in the operator's guide for additional information on this feature.

Table Size

Enter a value for the active cutting area for the X and Y axis. These values are used to limit the Plate size parameter in the cutting setup screen to the maximum size of the table.

The screenshot shows a configuration panel for THCs. At the top, 'THCs Installed' is set to 1. Below this, there are three dropdown menus: 'THC 1' (selected), 'Installed on' (selected as 'Axis 4'), and 'Analog 1' (selected). At the bottom, there are two checkboxes: 'THC On' checked for 'Plasma' and 'THC On' checked for 'Marker'.

THCs Installed

The THC Installed parameter defines the total number of Sensor™ THC Axes assigned for operation at the control.

THC Installed On Axis / Analog

This setup parameter is used to define the THC Axis for use. The user can select which axis the THC is to be commanded on, the analog input to use (arc voltage feedback) and which plasma.

THC On

The THC On parameter is used to indicate which processes are using Sensor™ THCs on the control. This does not assign a process to a specific THC but rather updates the selected process screens to enable any specific Sensor™ THC features. Refer to the Sensor™ THC appendix of this guide for additional information on the setup and use of the Sensor™ THC.

Command THCs Installed

The Command® THC selection is used to enable the Command THC serial Link. For more information on this feature, please refer to the Command® THC section of this guide.

Speeds

The Speeds setup screen is used for setting the various machine speeds for different operating modes.

Given that the drives, motors, gearboxes and mechanics are capable, the control is capable of operating over a wide range of speeds.

The screenshot shows the Speeds setup screen with the following parameters and values:

Speed 0 to	1000	ipm
Acceleration Rate	10	mG
Fast Deceleration Rate	100	mG
Maximum Machine Speed	1000	ipm
Limited Machine Speed	35	ipm
High Jog Speed	500	ipm
Medium Jog Speed	10	ipm
Low Jog Speed	10	ipm
Minimum Corner Speed	10	ipm
Fast Home Speed	20	ipm
Slow Home Speed	10	ipm
Creep Speed	25	% of Cut Speed
Plasma Hi/Lo Speed	90	% of Cut Speed
Plasma Distance to Corner	0	in
Plasma Distance from Corner	0	in

At the bottom of the screen, there are navigation buttons: Machine, Speeds (selected), Ports, I/O, Axes, and Done.

Speed 0 To

This parameter allows the technician to input selected speed ranges to customize the acceleration rates for the various speeds selected. When a speed range lower than the maximum speed is entered, a new range at the maximum machine speed setting will be created, up to a maximum of five. To reduce the number of Speed To ranges, input the maximum machine speed into the range that is to be the highest speed selection and the additional range fields will be removed from the screen.

Acceleration Rate

All mechanical systems have different acceleration and deceleration rates to move the cutting device smoothly. The higher the acceleration rate, the quicker the machine will get up to speed. The lower the acceleration rate the smoother the machine will position the cutting device. This setup parameter is used to determine both the acceleration and deceleration rate for all motion.

Enter a value in milligees for the desired acceleration rate. A milligee (milliG) is 1/1000 of a G, which is the acceleration due to gravity. One milligee is approximately 0.384 inches per second². A good starting point for most systems is 10 mgee's.

Fast Stop Deceleration Rate

Activated by the Fast Stop or Torch Collision Input, the Fast Stop Deceleration Rate Parameter specifies in milligees how quickly the system will stop when the Fast Stop Input is active. Generally, this value is much higher than the Acceleration rate.

A milligee (milliG) is 1/1000 of a G, which is the acceleration due to gravity. One milligee is approximately 0.384 inches per second².

Maximum Machine Speed

Enter the maximum value at which the system is capable of contouring. This parameter will be used to range limit all subsequent speed entries. In addition, it is used to scale the speedometer widget in the Watch window during runtime operation.

The maximum speed at which the control can contour can be calculated with the following equation.

Maximum Contouring Rate (IPM) =

$$\frac{60 \text{ seconds}}{\text{minute}} \times \frac{1 \text{ Inch}}{\text{User edges}} \times \frac{100,000 \text{ edges}}{\text{second}}$$

For example: the control could command a cutting machine with 4000 edges per inch resolution at 1,500 IPM.

Limited Machine Speed

The Limited Speed feature allows for a user-defined maximum machine speed when the Limited Speed Input is active. This is commonly used to set a reduced machine speed for the purpose of increased safety when testing or maintenance of the machine is being performed.

High Jog Speed

Enter a value for the desired high manual motion speed.

Medium Jog Speed

Enter a value for the desired medium manual motion speed.

Low Jog Speed

Enter a value for the desired low manual motion speed.

Minimum Corner Speed

This is the minimum speed to use when negotiating corners. The control has sophisticated centripetal velocity and acceleration contouring algorithms, which should provide optimal cut quality for most cut operations. In some situations it may be desirable to enter a minimum corner speed to prevent over-burning at corners. In normal operations, this parameter should be set to zero.

Fast Home Speed

Enter the machine speed the control will use during the first phase of the homing sequence. During the first phase, the cutting device will move towards the home limit switches at the fast rate.

Slow Home Speed

Enter the machine speed the control will use during the second phase of the homing sequence. During the second phase, the cutting device will move off the home limit switch and proceed to the marker pulse. Upon detection of the marker pulse, the control will decelerate to a stop and perform a small move in the opposite direction to the marker pulse.

Creep Speed Percentage

The Creep Speed Percentage parameter allows the operator to select what percentage of the machine cut speed will be used when creeping. Generally, this is 25% of the cut speed.

Plasma Hi/Lo Speed Percentage

The Hi/Lo Speed specifies the percentage of the entered Cut Speed below which the control will activate the Torch Height Disable output. The plasma system may use this output to switch from low to high current or to disable the height control. **Note:** The Dual Grid/THC feature must first be enabled at the Plasma Setups Screen.

Plasma Distance To Corner

The Plasma Distance to Corner parameter specifies the distance to the corner at which the plasma system should switch from High current to low current and disable the Automated Height Sensor. Distance to Corner is active whenever the speed drops below the Plasma Hi/Lo Percentage, or segments intersect at an angle greater than the tangent angle. **Note:** The Dual Grid/THC feature must first be enabled at the Plasma Setups Screen.

Plasma Distance From Corner

The Plasma Distance from Corner parameter specifies the distance from the corner when exiting, at which the plasma system should enable the Automated Height Sensor. Distance from Corner is active whenever the speed drops below the Plasma Hi/Lo Percentage, or segments intersect at an angle greater than the tangent angle. **Note:** The Dual Grid/THC feature must first be enabled at the Plasma Setups Screen.

For additional details on how the Torch Height Disable feature of this control operates, please refer to the Cutting Section of this guide.

CBH Speed Setups (Shown only when enabled)**CBH Acceleration Rate**

This parameter allows the operator to set the acceleration rate for smooth and stable movement of the contoured bevel head. The higher the acceleration rate the quicker the CBH will get up to speed. The lower the acceleration rate the smoother the machine will position the cutting device. Values are entered in Rev/ Sec².

Maximum CBH Speed

Enter the maximum speed for the CBH rotation in Rev/Min.

CBH High Jog / Home Speed

Enter a value for the desired manual CBH jog and fast Home speed.

CBH Low Jog / Home Speed

Enter a value for the desired CBH slow home speed.

THC Speed Setups (Shown only when enabled)

THC Acceleration Rate

This parameter allows the operator to set the acceleration rate for smooth and stable movement of the Sensor™ Torch Height Control. The higher the acceleration rate, the quicker the THC will get up to speed. The lower the acceleration rate, the smoother the machine will position the cutting device. Values are entered in milligees.

Maximum THC Speed

Enter the maximum speed for the Sensor™ THC movement in inches per minute.

THC Jog Speed

Enter a value for the desired THC jog speed.

THC Home/Fast IHS Speed

The THC Home/Fast IHS Speed entered here is used to home the torch at the top of the slide and to move the torch from the selected IHS height towards the plate, looking for the surface of the plate.

THC Slow IHS Speed

The THC IHS Speed is used to retract the torch after the plate has been sensed. The torch will retract at this speed until the contact sense is lost. This determines the exact distance to the plate regardless of any flexing of the plate. A very small speed is recommended for optimal accuracy.

Torch Height Disable Feature

The Torch Height Disable Feature is used to activate the Torch Height Disable output and “freeze” or disable the automatic adjustment of the Automated Torch Height Control system and prevent diving or crashing of the torch in corners. **Note:** The Dual Grid/THC feature must first be enabled in the Plasma Setups screen.

This output is activated by the control based on the values of Plasma Hi/Lo % of Cut Speed, Plasma Distance to Corner and Plasma Distance from Corner setup parameters. When any one of these conditions is met, the Torch Height Disable feature will be implemented. The definition of a corner is based on the tangent angle in the Special Password screen and the value of the Plasma Hi/Lo speed.

Tangent Angle

This parameter is used to set degree of the tangent angle for control motion. Segments within a part that intersect at angles greater than the selected tangent angle will decel to zero or minimum corner speed. Segments within a part that intersect at angles less than or equal to the selected tangent angle will not decel, unless the next segment is a speed limited arc.

Plasma Hi/Lo Speed Percentage

The Hi/Lo Speed specifies the percentage of the entered Cut Speed below which the control will activate the Torch Height Disable output. The plasma system may use this output to switch from low to high current or to disable the height control.

Plasma Distance To Corner

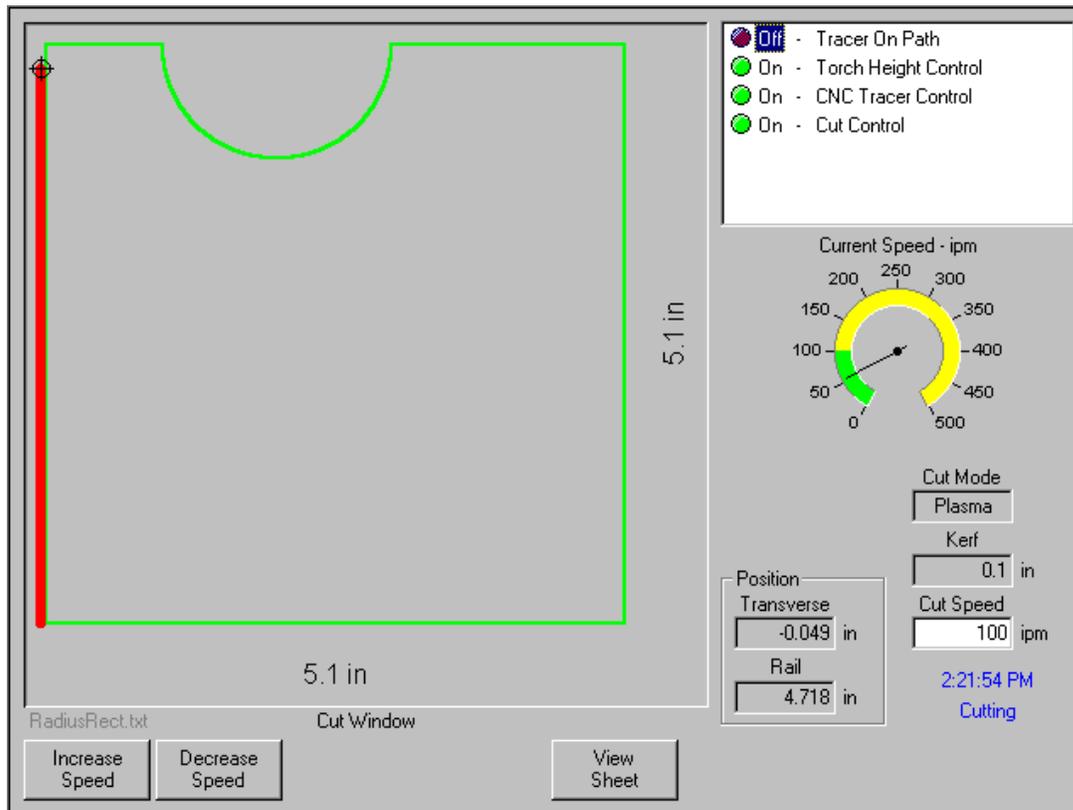
The Plasma Distance to Corner parameter specifies the distance to the corner at which the plasma system should switch from low current to high current or disable the Automated Height Sensor. Distance to Corner is active whenever the speed drops below the Plasma Hi/Lo Percentage, or segments intersect at an angle greater than the tangent angle.

Plasma Distance From Corner

The Plasma Distance from Corner parameter specifies the distance from the corner when exiting, at which the plasma system should enable the Automated Height Sensor. Distance from Corner is active whenever the speed drops below the Plasma Hi/Lo Percentage, or segments intersect at an angle greater than the tangent angle.

Example:

For the example illustrated below, the Torch Height Disable output will be activated based on the values of the setup parameters.



Plasma Hi/Lo Percentage Value	90%
Distance to Corner Value	.5 inches
Distance from Corner Value	.5 inches
Tangent Angle Value	20 Degrees

For the above listed values, the Torch Height Disable output is active .5 inches before and .5 inches after each 90 degree corner. The THD output is also activated as the torch accelerates

away from the pierce and through the arc due to the speed being below the Plasma Hi/Lo value. Finally, because the arc intersects at greater than the 20 degree tangent angle, the THD output is activated for .5 inches before and after the beginning of the arc, and is activated for .5 inches before and after the end of the arc.

Ports

The control comes standard with two RS-232C serial ports, which may be converted to an RS-422 configuration. For more information on the how to change the serial ports to the RS-422 configuration, please refer to Serial Port Connections. This port has been specially design with opto-isolation and filtering to minimize EMI/RFI noise problems common in many cutting operations. Parameters are enabled and disabled depending on Port feature selections.

The control may be configured to use the communication link provided on the control or the user may enter information to create a custom communication link at the Link Screen to communicate with a host computer. Information on how to access the Phoenix Communication Link Software is provided later in this section.

The following parameters are available to help configure the Serial Ports for your specific communications package and selected communication features.

The screenshot shows a configuration window for serial ports. At the top, there are two dropdown menus: 'Link' (set to 'Link') and 'None' (set to 'None'). Below these are several radio button options for Baud Rate (4800, 9600, 19200, 38400, 57600, 115200), Parity (None, Odd, Even), Data Bits (7, 8), Flow Control (None, Xon/Xoff, Hardware), and During Jog on Path (None, Forward Only, Forward and Backward). There are also input fields for Retry on Time Out (3 times), Time Out (15 sec), Transmit Delay (5 sec), Rewind (8), Dialog Start (33), Dialog Done (42), Dialog Prompt (3), Dialog Pause (126), Dialog Acknowledge (62), and End of Transmission (26). On the right side, there are radio button options for Using Phoenix Link (No, Yes), Show Host File Names (No, Yes), File Dump Mode (Off, On), Allow M85 Auto Reload (No, Yes), Essi Program Termination (0, 63, 64, 99, /, =), Download Updates (No, Yes), Use Multidrop (No, Yes), and Control Monitoring (Off, On). At the bottom, there is an 'Address' input field (set to 1) and a 'Control Monitoring' radio button (set to Off). At the very bottom, there are several buttons: 'Machine', 'Speeds', 'Ports', 'I/O', 'Axes', and 'Done'.

Port Designation

This parameter allows the user to select which serial port will be configured for link use with the following remote communication settings. Select Link, Messaging, HD4070, FineLine or Command THC (type"V" controls).

Baud Rate

Allows selection of the desired baud rate for the remote Communications Link. The available Baud rates are shown. The control also incorporates a unique compression utility that allows the effective baud rate to be doubled. For example, for links configured to run at 9600 baud, the effective rate will be 19.2K Baud.

Note: For Serial Messaging communication speeds from 1200 Baud to 115200 Baud are available. See Serial Messaging in the Program Code section for more information.

Parity

Enter the desired parity for the remote Communications Link.

Data Bits

Enter the number of data bits the remote link is using. This value is **8** for the link software included with the control.

Time Out Delay

Enter the amount of time the control will wait prior to display communications error should it not be able to establish a link with a remote device.

Transmit Delay

Enter the amount of delay the control will insert between each character that is transmitted over the serial port. Some communications links require a small delay to avoid missing characters that have been sent to them. This parameter should normally be set to zero.

The following parameters allow the user to create a custom communication link on the control by entering the ASCII code equivalent to the character or symbol used by the host computer for dialog start.

For example: The ASCII Decimal Code 33 is equal to the ! symbol

Rewind

This setup parameter is only enabled when Link File Dump Mode has been enable. Enter the ASCII code equivalent to the character or symbol used by the host computer for tape rewind at the host tape drive system. Enter the number zero to eliminate the rewind command.

Dialog Start

Enter the ASCII code equivalent to the character or symbol used by the host computer for dialog start.

Dialog Done

Enter the ASCII code equivalent to the character or symbol used by the host computer for dialog done.

Dialog Prompt

Enter the ASCII code equivalent to the character or symbol used by the host computer for dialog rompt.

Dialog Pause

Enter the ASCII code equivalent to the character or symbol used by the host computer for dialog pause.

Dialog Acknowledge

Enter the ASCII code equivalent to the character or symbol used by the host computer for dialog acknowledge.

End of Transmission

Enter the ASCII code equivalent to the character or symbol used by the host computer for dialog acknowledge.

Using Phoenix Link

If you are using the Phoenix Communication link program supplied on the control select Yes and the control will automatically enter the appropriate ASCII codes in to the communication link dialog parameters listed above.

Show Host File Names

The Show Host File Names feature allows the user to select whether or not File Names are shown at the Download from Host screen. This is a time saving feature for operators who have very large part folders at the host computer and know the exact file name of the part program to be loaded. The Using Phoenix Link parameter must be set to ON to enable this feature.

File Dump Mode

Select On to configure the link communication protocol to communicate with link programs which operate in File Dump Mode. This will allow the control to accept part programs as one long uninterrupted stream of information as with a tape reader style link.

Allow M65 Auto Reload

Available when a generic link communication has been enabled, this parameter allows the user to select whether the EIA M65 code will be used as an Auto-reload code or ignored.

ESSI Program Termination

This parameter allows the operator to tell the control which ESSI code (0,63, 64 99, / or =) is to be used as machine stop.

Download Updates

The Download Updates parameter allows the operator to download control software updates through the link communications to the host PC. To use this feature, the "Using Phoenix Link" parameter must be set to yes. The new update file would then be placed in the same folder location as the Link software. When the Update Software softkey is pressed at the Special Password screen, the control will search for the new software update via the link rather than the floppy drive.

Use Multi Drop

Selecting the Use Multi Drop feature will allow the control to be enabled to work with the Phoenix link software Multi Drop feature. The Multi Drop feature allows the Phoenix Link software to communicate with multiple controls to one communications port at the host PC. Up to eight controls may be supported with the Multi Drop feature.

Please note: The "Using Phoenix Link" parameter must be set to YES to enable this feature and specific hardware (serial communications board Rev C or higher) may be required to support this feature. Please contact your control supplier for more details.

Address

The Address Parameter defines the control identification address when using the Multi Drop communications feature. The Phoenix Link software uses this address at the Host PC to know which control it is communicating with.

Control Monitoring

When enabled, the Control Monitoring feature allows the user to view control status at the host PC. Status for File Name, position, cut mode and cut information is displayed. This feature is only available with the Phoenix Link communication software.

Please refer to the Phoenix Link information section of this guide for additional information on the Phoenix link.

The following additional parameters are available when Serial Messaging has been enabled. See Serial Messaging in the Program Code section of this guide for more information.

Flow control

Select to use None, Xon/Xoff or Hardware.

During Jog on Path

The user may select whether messages will be sent when jogging Forward or Backward on Path while at the Pause screen. Note: All messaging will stop when the Stop Key has been pressed or the Remote Pause input becomes active.

Note: The Message Type 21 will not be executed for "Backup on Path".

Retry on Time Out

For the Message Type 22 (which requires an acknowledgement from the external device after the message) an automatic retransmit of the message may be sent. The user may select the number of retries allowed before faulting from a lack of response from the external device. The fault prompt "Message Error" will be displayed when in a Time Out condition.

Time Out

The Time Out value may be used for the Message Type 22 (which requires an acknowledgement from the external device after the message) if there is no Time Out value used in the command string of the program code. Refer to the Delay Time / Time Out information for more information.

I/O

Pressing the I/O softkey allows the operator to configure the inputs and outputs for the shape cutting table.

I/O Configuration Type “M”, “P” and “V”

The screenshot displays the I/O Configuration interface. At the top left, the 'Input Logic' is set to 0. Below it is a list of inputs with their logic states: 'Normally' (Normally Open), 'Input' (Input1), and four 'Open' states (Dual Gantry Home, Program Inhibit, Cut/Mark Sense). The 'Input 1' dropdown is set to 'Spare'. To the right, there are radio buttons for 'Joystick Installed' (No) and 'Speed Pot. Installed' (Yes). Below these are percentage override fields: 'Plasma Override' (70 to 130%), 'Oxy Fuel Override' (0 to 120%), and 'Trial Override' (0 to 120%). Further down are dropdowns for 'Speed Pot. 1' (Installed on Analog 3), 'Laser Pierce Sense' (Installed on Analog 2), and 'Analog Offset 1' (0 volts). At the bottom left, 'Output Logic' is set to 0, with a list of outputs: 'Normally' (Normally Open), 'Output' (Torch Up, Torch Down, Ignition, Torch Height Disable), and 'Output 1' set to 'Torch Up'. Below this are radio buttons for 'Drive Enables' (Independent) and 'Series', and an 'Initial Feedback Delay' field set to 0 sec. At the bottom, there are navigation buttons: 'Machine', 'Speeds', 'Ports', 'I/O', 'Axes', and 'Done'.

Input Logic

The control comes standard with up to 32 discrete inputs. The Input Logic parameter is used as a mask to determine whether or not the input is to be treated as a normally open contact or normally closed contact. Entering a numerical value here will set all the Inputs to a predefined set of logic states for all of the inputs.

With Input Logic set to zero (0), an active input will be displayed as active or On (green lamp) in the input diagnostic screen.

Logic Selection Box

The Logic Selection Box allows the user to select the Logic state for each input to be either normally open or normally closed. The Logic state for the inputs may be switched by selecting the desired input and pressing the space key.

Input Selection

The Input Selection box feature is used to define which inputs will be used by the control and their physical location on the control interface. All controls are shipped with the default selection of Inputs and interface locations for the selected control Interface (I/O) configuration.

Input Definitions

Input	Description
Spare	Spare inputs are activated through the part program. If a Spare input is located in the part program, the control will pause the process until the input state is detected. The Spare inputs may be used by use of specific EIA "O" and "M" codes indicating the input number and function. Refer to Appendix A in the operator's manual for a complete description of these commands.
Torch Up Sense	Confirmation signal indicating that the torch is in the full up position.
Torch Down Sense	Confirmation signal indicating that the torch is in the full down position.
Preheat Sense	Confirmation signal indicating that the Preheat Input from the torch is active.
Cut Sense	Activation of this input indicates that the plasma arc has transferred to the work piece. If the "Arc On Feedback" setup parameter is ON, then machine motion will begin at the activation of this input. Type "M" and "P" controls.
Tracer on Path	Tracer On Path is used with the Teach Trace feature and indicates that the tracing system has detected the template line.
Drive Disabled	If the Drive Disabled input is activated, the control will stop all motion and generate a fault message. Position information will be lost.
Remote Pause	A Remote Pause input, when activated, will stop all control motion and display the Pause screen. No motion will be allowed until this input is deactivated.
Remote Start	When a Remote Start input is detected, it will begin the selected program cycle as if the Start button on the control had been pressed.
Program Inhibit	The Program Inhibit input will force the control to command the motion output to a zero (0) speed. This is generally used as a dwell to pause motion during a tool change or as a pause from a PLC interface.
Raise/ Lower Torch	The type "V" control has the ability to operate multiple Sensor™ THCs which are commanded by the control, as separate axes. The Sensor™ THC Torch Raise and Torch Lower commands may be made through the software softkeys or through the use of these external inputs to the control.
Station Select Input	The type "V" control system has the ability to operate multiple Sensor™ THCs which are commanded by the control as separate axes. The control requires an input to indicate which Sensor™ THCs are active. Is Input is also used for tracking of consumable data for the specified Plasma or Oxy Torch. Station 1-8 are designated for Plasma and stations 9-20 are designated for Oxy Fuel.

X Home Switch	This input indicates that the machine has traveled to its X axis home position. If the X axis “Use Home Limit Switch” parameter is set to YES and a Homing function is performed, the X axis moves in the specified home direction at the Fast Home Speed until the input is activated. The X axis then decelerates to a stop and moves in the opposite direction at the Slow Home Speed until the switch is deactivated. Once the switch is deactivated, the X axis will either decel to a stop or continue on until the encoder marker pulse is detected, if the “Use Marker Pulse” parameter is set to YES.
Y Home Switch	This input indicates that the machine has traveled to its Y axis home position. If the Y axis “Use Home Limit Switch” parameter is set to YES and a Homing function is performed, the Y axis moves in the specified home direction at the Fast Home Speed until the input is activated. The Y axis then decelerates to a stop and moves in the opposite direction at the Slow Home Speed until the switch is deactivated. Once the switch is deactivated, the Y axis will either decel to a stop or continue on until the encoder marker pulse is detected, if the “Use Marker Pulse” parameter is set to YES.
Z Home Switch	Z Axis Home Limit Switch indicates that the machine has traveled to its Z axis home position. If the Z axis “Use Home Limit Switch” parameter is set to YES and a Homing function is performed, the Z axis moves in the specified home direction at the Fast Home Speed until the input is activated. The Z axis then decelerates to a stop and moves in the opposite direction at the Slow Home Speed until the switch is deactivated. Once the switch is deactivated, the Z axis will either decel to a stop or continue on until the encoder marker pulse is detected, if the “Use Marker Pulse” parameter is set to YES.
Y Overtravel Switch	This input indicates that the machine has traveled into its full positive travel of a Y axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion and generate a fault message. Motion will not be re-enabled until the switch is deactivated.
X Overtravel Switch	This input indicates that the machine has traveled into its full positive travel of a X axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion and generate a fault message. Motion will not be re-enabled until the switch is deactivated.
Limit Switch	This input indicates that the machine has traveled into its full positive travel of an axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion and generate a fault message. Motion will not be re-enabled until the switch is deactivated. (Type “M” configuration only)
Ready to Fire PS 1-4	Exclusive to the HD4070 [®] multiple power supply configuration, the Ready to Fire Input is used to ensure that all HD4070 [®] power supplies have completed each individual Initial Height Sense and are ready for use. The torch ignition is held off by the Hold Ignition Input to the power supply from the control.
Raise /Lower 4070 1-2	Exclusive to the HD4070 [®] multiple power supply configuration, the Raise / Lower 4070 Torch Input is used as a manual raise/lower

command to the selected HD4070[®] integrated THC through the control serial – power supply communication link.

X +Overtravel Switch	This input indicates that the machine has traveled into its full positive travel in the X axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion, generate a fault message and only allow manual motion in the X axis negative direction.
X -Overtravel Switch	This input indicates that the machine has traveled into its full negative travel in the X axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion, generate a fault message and only allow manual motion in the X axis positive direction.
Y +Overtravel Switch	This input indicates that the machine has traveled into its full positive travel in the Y axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion, generate a fault message and only allow manual motion in the Y axis negative direction.
Y -Overtravel Switch	This input indicates that the machine has traveled into its full negative travel in the Y axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion, generate a fault message and only allow manual motion in the Y axis positive direction.
Power Supply OK	This is an input used for the optional Automated Process Controller (APC). It is used to confirm a ready condition from the Plasma Power Supply before beginning the cut process.
Fast Stop	The Fast Stop input is used as an urgent stop input command to the control. When the Fast Stop input becomes active, the control will decelerate motion using a special Fast Stop Decel parameter, and forces the operator to the Pause Screen. One second after the input becomes active, the Drive Enable output from the control will turn off and disable motion. Position information and I/O points will be maintained while the input is active. This will allow the operator to recover the last position after the input has been cleared. <i>Note:</i> The Fast Stop Decel parameter is located on the password protected Speeds setup screen.
Torch Collision	The Torch collision input is used on torch systems with “break away” style mounts. In the event that a torch should make contact with the plate or any obstacle which causes the break away mount to release, an input for the mount would be tied back to the control indicating a torch collision has occurred. The operator will then be forced to the Pause screen. While the input is active, the Cut output will be turned off and manual motion will be enabled, allowing the operator to raise, lower and move the torch position to clear the fault. <i>Note:</i> Position information, motion command and I/O points are maintained, allowing the operator to return to the cut path and resume cutting. This feature uses the Fast Stop Deceleration rate. Manual raise inputs may be used.

Joystick (Direction)	The Joystick directional inputs (Up, Down, Left and Right) are used to command manual motion when using an external joystick.
Fume Extraction Sense	If selected, the Fume Extraction input is used to confirm that an external Fume Extraction system on the cutting table is operational prior to beginning the cut. An option to override is displayed if the input has not been satisfied at the time of the cut.
Cut/Mark Sense 1 & 2	Cut/Mark Sense (arc on feedback) is used to verify that the plasma torch or marker tool has established the Arc for the selected process. This indicates to the control that motion can begin. (Type "V" controls).
THC Cut Sense	THC Cut Sense (arc on feedback) is used to verify that the plasma torch or marker tool has established the Arc for the selected Sensor™ THC . This indicates to the control that motion can begin. (Type "V" controls).
Plasma Select 1 & 2	The Plasma Select 1 & 2 are used to select which Plasma process logic will be used by the control. These inputs are generally run by external switches. (Type "V" controls).
Marker Select 1 & 2	The Marker Select 1 & 2 are used to select which Marker process logic will be used by the control. These inputs are generally run by external switches. (Type "V" controls).
Sensor THC Enable	The type "V" control system has the ability to operate multiple Sensor™ THCs which are commanded by the control, as separate axes. The control requires an input to indicate which Sensor™ THCs are active. This input is now supported by the Station Select input.
THC Homing to Limit	The THC Enable Input is used during Sensor™ THC Homing as the Current Limit input if the "Home to Hard Stop Current Limited" option is selected.
Nozzle Contact Sense	The Nozzle Contact Sense Input is used during Sensor™ THC Initial Height Sense to detect the location of the cut surface. This input is tied back to the control through the external Voltage Divider Card.
THC Homing to Switch	The Nozzle Contact Sense Input is used during Sensor™ THC Homing as the Home Switch input, if the "Home to Switch" option is selected.
THC Automatic	This input is used as an external input to switch the Sensor™ THC between Automatic and Manual operation.
Speed Limit Input	The Speed Limit Input is used to limit the machine speed for safety during machine testing and maintenance. When active, motion will be limited to the user defined Limited Machine Speed selected in the password protected Speeds screen.
Tilt +/- Overtravel Switch	This input indicates that the machine has traveled into its full positive travel in the Tilt axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion, generate a fault message and only allow manual motion in the Tilt

axis opposite direction. The Tilt Overtravel Input is also used for Homing of the Tilt Axis.

Tilt +/-	Tilt +/- inputs are used for manual jog commands for the Tilt Axis.
Tilt Home Feature	This feature uses the Tilt Overtravel Switch input to indicate that the machine has traveled to its Tilt axis home position. When a Homing function is performed, the Tilt axis moves in the specified home direction at the Fast Home Speed until the input is activated. The Tilt axis then decelerates to a stop and moves in the opposite direction at the Slow Home Speed until the switch is deactivated. Also see Tilt Overtravel Switch
Rotate +/-	Rotate +/- inputs are used for manual jog commands for the Rotate Axis.
Rotate Home Switch	This input indicates that the machine has traveled to its Rotate axis home position. When a Homing function is performed, the Rotate axis moves in the specified home direction at the Fast Home Speed until the input is activated. The Rotate axis then decelerates to a stop, moves in the opposite direction at the Slow Home Speed until the switch is deactivated.
Pierce Complete	The Pierce Complete input is used for the Laser Cut Process and is used to confirm that the pierce is complete.
Gas Control Read Comp.	The Gas Control Read Complete input is used as part of the HD3070 [®] Automatic Gas Console communications to confirm communications is complete.
Gas Control Error	The Gas Control Error input is used as part of the HD3070 [®] Automatic Gas Console communications to notify of an error from the Auto Gas Console.
Enable Oxy Fuel 1-12	These inputs are used for tracking of consumable data for the specified Oxy Torch. This input is now supported by the Station Select input.
Enable Plasma 1-8	These inputs are used for tracking of consumable data for the specified Plasma Torch. This input is now supported by the Station Select input.
Arc Error Counter 1-8	Used as part of the tracking for consumable data, this input triggers a counter on the Change Consumable Screen. A Plasma Enable Input must be mapped to have this enable available for use.
Test Lifter	This Input is used to perform a test IHS function with a Sensor [™] THC.

Output Logic

The control comes standard with up to 32 discrete outputs. The Output Logic parameter is used as a mask to determine whether or not the output is to be treated as a normally open contact or normally closed contact.

Logic Selection Box

The Logic Selection Box allows the user to select the Logic state for each input to be either normally open or normally closed. The logic state for the inputs may be switched by selecting the desired Output and pressing the space key.

Output Selection

The Output Selection box feature is used to define which inputs will be used by the control, and their physical location on the control interface. All controls are shipped with the default selection of Outputs and interface locations for the selected control Interface (I/O) configuration.

Output Definitions

Output	Description
Spare	Spare outputs are activated through the part program. If a Spare output is located in the part, the control will turn on the output as directed. The Spare outputs may be used by use of specific EIA "W" and "M" codes indicating the output number and function. Refer to Appendix A in the operator's manual for a complete description of these commands.
Torch Up	This output is used to raise the cutting torch. It is activated for the "Primary Torch Up Time" and the "Pierce Torch Up Time" in oxy fuel mode. It is activated for the "Torch Up Time" in plasma mode.
Torch Down	This output is used to lower the cutting torch. It is activated for the "Primary Torch Down Time" and the "Pierce Torch Down Time" in oxy fuel mode. It is activated for the "Torch Down Time" in plasma mode.
Ignition Control	This output is used to turn on the igniters in oxy fuel mode or ignite the plasma system in plasma mode.
Torch Height Disable /Dual Grid Control	This output is used to disable the automatic torch height controller in plasma mode. It is activated whenever the current axis position is within the "Plasma Distance To Corner" or the "Plasma Distance From Corner" parameters while cutting a part. It is also active whenever the current cutting speed drops below the result of (Programmed Cut Speed x (Plasma High/Lo Speed/100)). This Output is also used to reduce the plasma current in a switchable current plasma system when the machine speed is less than the Plasma Hi/Lo speed percentage.
Reduce Current	Used with the HD4070 [®] , this output switches the plasma to low current mode.

CNC/Tracer	This output is used to control a CNC relay. The CNC relay determines whether the control, tracing system or joystick is commanding the amplifiers. This output is deactivated whenever the control is off, in Teach Trace mode or is disabled. Otherwise it is always activated.
Marker / Marker Enable	This output is used to activate an external marking device. It can only be activated by the appropriate "M" code in the part program. Refer to Appendix A in the operator's manual for a complete description of appropriate "M" code commands.
Cut Control	This output is used to enable the cutting oxygen in oxy fuel mode or start the plasma system in plasma mode. This output can also be used to activate a marking device.
Low Preheat Control	The Low Preheat Control output is used to enable the low preheat gas when cutting in oxy fuel mode. It is activated for the "Low Preheat Time" when initiating a cut.
Preheat Control	This output is used to enable the high preheat gas when cutting in oxy fuel mode. It is activated for the "High Preheat Time" when initiating a cut.
Key Press Indicator	The Key Press Indicator output is activated whenever a key is pressed on the control.
Motion Indicator	The Motion Indicator output is activated whenever the control is commanding machine motion.
Plasma Select	The Plasma Select output is activated whenever the control is in the Plasma cutting mode.
Bleed Off Gas	The Bleed Off Gas Output is used by the Oxy fuel cut logic to send an output to the Oxy torch to purge gases at the end of a cut. This Output is on for the duration of the Bleed Off Time selected in setups.
Pierce Control	The Pierce Control Output is used by the Plasma and Oxy fuel cut logic to send an output to the torch during the pierce. This Output is on for the duration of the Pierce Time selected in setups.
Turn ON / Off Supply	The Turn ON OR Turn Off Supply Output is used by the Optional APC (Automated Process Controller) to turn On or Off the plasma supply through the control
N2 Select	The Turn On Supply Output is used by the Optional APC (Automated Process Controller) to enable the use of nitrogen while cutting.
Drive Enable	The Drive Enable Output is used to enable the Drives during normal functions and to disable the Drives during fault conditions.
Shutter Open	The Shutter Open Output is used exclusively with the Laser cut logic and is used to open the Laser Shutter for use.

Assist Gas	The Assist Gas Output is used exclusively with the Laser cut logic and is used to activate the Assist gas.
Digital Beam	The Digital Beam Output is used exclusively with the Laser cut logic and is used to activate the Digital Beam.
Laser Start	The Laser Start Output is used exclusively with the Laser cut logic and is used to activate the Laser System.
Abrasive Control	The Abrasive Control Output is used exclusively with Water Jet cut logic and activates the abrasive control adding abrasive to the cut stream while cutting or for charging the abrasive prior to cutting.
Plasma Enables	These outputs are used for external logic. The appropriate Output(s) is on during plasma cutting, based on the Plasma Select Inputs.
Marker Enables	These outputs are used for external logic. The appropriate Output(s) is on during marking, based on the Marker Select Inputs.
Nozzle Contact Enable	The Nozzle Contact Enable Output is active during Sensor™ THC Initial Height Sense. This input is tied back to the control through the external Voltage Divider Card. This output may also be used to switch an external drive system to low output mode (if equipped) during IHS for stall force plate sensing.
Hold Ignition	The Hold Ignition Output is part of the Sensor™ THC operation and used to hold ignition of the external Plasma Supply. This output may be tied back to the control through the external Voltage Divider Card or direct to the Power Supply depending on configuration.
Gas Flow Set 1 – 100	The Gas flow Set Output is used as part of the HD3070® Automatic Gas Console communications (BCD) to set Gas Flow rates.
Valve Select 1 – 8	The Valve Select Output is used as part of the HD3070® Automatic Gas Console communications to select the appropriate valves for operation.
Gas Control Write	The Gas Control Write Output is used as part of the HD3070® Automatic Gas Console communications to configure the unit for operation.
Remote Test Operate	The Remote Test Operate Output is used as part of the HD3070® Automatic Gas Console communications to Initiate the Remote Test.
Remote Test Preflow	The Remote Test Preflow Output is used as part of the HD3070® Automatic Gas Console communications to test operation of Preflow gases.

Remote Air Plasma	The Remote Air Plasma Output is used as part of the HD3070 [®] Automatic Gas Console communications to signal the Air Plasma Output.
Remote H35/ N2 Plasma	The Remote H35/N2 Plasma Output is used as part of the HD3070 [®] Automatic Gas Console communications to signal the H35/N2 Output.
Remote O2 Plasma	The Remote O2 Plasma Output is used as part of the HD3070 [®] Automatic Gas Console communications to signal the O2 Output.
Change Consumable	This output becomes active when a consumable data value at the Change Consumable Screen has reached it's preset maximum. Generally, this output is tied to an external indicator light or audible alarm to prompt the system operator to change the appropriate consumable (torch tip / electrode). The affected consumable data must be reset at the Change Consumable Screen to clear the output.
Current Set BCD	The Current Set BCD outputs are used to set the current at the plasma power supply or marker supply for use. These outputs are tied to the BCD inputs. Combinations of the current values are used to attain the desired current set point.
Marker Control	The Marker Control Output is used to activate the Marker tool when in the Marking Process. Traditionally, the Marker tool is activated through the combination of Marker Enable and Cut Control Outputs. All the noted options are available and may be configured at the Marker Setup screen for the desired process timing and operational results.
Program Running	The Program Running Output is active any time the control is operating within a part program.
Station Eenable 1-20	Station Select outputs are used to activate any function specific to a torch station and are controlled through M37T and M38T codes within a part program. Typically these are used to enable a torch station for use. Stations 1-8 are plasma and stations 9-20 are oxy fuel / other.
Station Lock 1-19	The Station Lock Outputs are used as part of the Automated Torch Spacing feature. The Station lock is used to Lock the unused torch station to the gantry or beam when not in use.
Station Clamp 1-19	The Station Clamp Outputs are used as part of the Automated Torch Spacing feature. The Station Clamp is used to Clamp the selected torch station to the transverse axis for standard cutting.
Station Mirror 1-19	The Station Clamp Outputs are used as part of the Automated Torch Spacing feature. The Station Clamp is used to Clamp the selected torch station to the transverse axis for mirrored cutting.

Drive Enables

This setup parameter allows the user to select how the control responds to drive faults. If the setting is Series, then all axes must complete their individual fault ramp times before the drives are disabled. If the setting is independent, each drive is disabled immediately as soon as its axis fault ramp time is finished.

Initial Feedback Delay

This feature allows the initial feedback from the Drive System to be held off after initial power up. This allows the Drive System to fully enable prior to enabling the position loop.

Joystick Installed

Select "Yes" to enable the optional external Joystick. Not available for all control types and optional control hardware required.

Speed Pot Installed

Select "Yes" to enable the optional external Speed Potentiometer. Not available for all control types and optional control hardware required.

Plasma Override %

The Plasma Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the plasma Speed Pot based on a percentage of the set cut speed. The Speed Pot feature must be enabled for use.

Oxy Fuel Override %

The Oxy Fuel Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the oxy fuel Speed Pot based on a percentage of the set cut speed. The Speed Pot feature must be enabled for use.

Trial Override %

The Trial Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the Trial Speed Pot based on a percentage of the set Trial speed. The Speed Pot feature must be enabled for use.

Speed Pot Installed On

The Speed Pot installed on Parameter is used to assign Speed Pot inputs to the desired Analog Input if a dedicated Speed Pot input is not available on the Analog input card being used.

Analog Offset 1- 12

The Analog Offsets 1 through 12 are used to correct for any imbalance or "Zero" the incoming analog voltage to the Analog Input Card.

I/O Configuration Type “B”

Input Logic

Normally	Input
Open	Oxygen Cut Sense
Open	Drive Disabled
Open	Plasma Select
Open	Arc On Sense

Input 1 - Oxygen Cut Sense

Output Logic

Normally	Output
Open	Oxygen Enable
Open	Oxygen Start
Open	Preheat
Open	Plate Marker No. 1

Output 1 - Oxygen Enable

Drive Enables Independent Series

Initial Feedback Delay sec

Joystick Installed No Yes

Speed Pot. Installed No Yes

Plasma Override to %

Oxy Fuel Override to %

Trial Override to %

Speed Pot. 1 Installed on Analog 3

Laser Pierce Sense Installed on Analog 2

Analog Offset 1 volts

Machine Speeds Ports I/O Axes Done

Input Logic

The control comes standard with five discrete inputs. The Input Logic parameter is used as a mask to determine whether or not the input is to be treated as a normally open contact or normally closed contact. Entering a numerical value here will set all the Inputs to a predefined set of logic states for all of the inputs.

With Input Logic set to zero (0), an active input will be displayed as active or On (green lamp) in the input diagnostic screen.

Logic Selection Box

The Logic Selection box allows the user to select the Logic state for each input to be either normally open or normally closed. The logic state for the inputs may be switched by selecting the desired input and pressing the space key.

Input Selection

The Input Selection box feature is used to define which inputs will be used by the control and their physical location on the control interface. All controls are shipped with the default selection of Inputs and interface locations for the selected control Interface (I/O) configuration.

Input Definitions

Input	Description
Spare	Spare inputs are activated through the part program. If a Spare input is located in the part, the control will pause the process until the input state is detected. The Spare inputs may be used by use of specific EIA "W" and "M" codes indicating the input number and function. Refer to Appendix A in the operator's manual for a complete description of these commands.
Oxygen Cut Sense	Activation of this input confirms that Cut Oxygen is on and that motion can begin after any selected preheat or pierce dwells are completed. Note: The control requires a transition on this input before it will command any motion along the cut path. If an Oxygen Cut Sense output is not available on the machine, the control's Oxygen Start output can be wired back into the Oxygen Cut Sense input.
Program Inhibit	The Program Inhibit input will force the control to command the motion output to a zero (0) speed. This is generally used as a dwell to pause motion during a tool change or as a pause from a PLC interface.
Plasma Select	If the Plasma Select input is on, the control will apply Plasma cut logic while cutting. If off, it will assume Oxy Fuel cutting is required and Oxy Fuel cut logic is applied when cutting. This is generally activated by use of an external switch to indicate Plasma mode.
Arc On Sense	Activation of this input indicates that the plasma arc has transferred to the work piece. If the "Arc On Feedback" setup parameter is On, then machine motion will begin at the activation of this input.
Drive Disabled	If the Drive Disabled input is activated, the control will stop all motion and generate a fault message. Position information will be lost.
Remote Pause	A Remote Pause input, when activated, will stop all control motion and display the Pause screen. No motion will be allowed until this input is deactivated.
Limit Switch	This input indicates that the machine has traveled into its full positive travel of an axis. If the hardware overtravels are enabled and this input is activated, the control will stop all motion and generate a fault message. Motion will not be re-enabled until the switch is deactivated. (Type "M" configuration only)
Remote Start	When a Remote Start input is detected, it will begin the selected program cycle as if the Start button on the control had been pressed.
Fast Stop	The Fast Stop input is used as an urgent stop input command to the control. When the Fast Stop input becomes active the control will decelerate motion, using a special Fast Stop Decel parameter, and forces the operator to the Pause Screen. One second after the input becomes active, the Drive Enable output from the control will turn off

and disable motion. Position information and I/O points will be maintained while the input is active. This will allow the operator to recover the last position after the input has been cleared. *Note:* The Fast Stop Decel parameter is located on the password protected Speeds setup screen.

Torch Collision

The Torch collision input is used on torch systems with “break away” style mounts. In the event that a torch should make contact with the plate or any obstacle which causes the break away mount to release, an input for the mount would be tied back to the control indicating a torch collision has occurred. The operator will then be forced to the Pause Screen. While the input is active, the Cut output will be turned off and manual motion will be enabled allowing the operator to raise, lower and move the torch position to clear the fault. *Note:* Position information, motion command and I/O points are maintained allowing the operator to return to the cut path and resume cutting.

Output Logic

The control comes standard with eight discrete outputs. The Output Logic parameter is used as a mask to determine whether or not the output is to be treated as a normally open contact or normally closed contact.

Logic Selection Box

The Logic Selection box allows the user to select the Logic state for each input to be either normally open or normally closed. The logic state for the inputs may be switched by selecting the desired Output and pressing the space key.

Output Selection

The Output Selection box feature is used to define which inputs will be used by the control and their physical location on the control interface. All controls are shipped with the default selection of Outputs and interface locations for the selected control Interface (I/O) configuration.

Output Definitions

Output

Spare

Description

Spare outputs are activated through the part program. If a Spare output is located in the part, the control will turn on the output as directed. The Spare outputs may be used by use of specific EIA “O” and “M” codes indicating the output number and function. Refer to Appendix A in the operator’s manual for a complete description of these commands.

Oxygen Enable

The Oxygen Enable Output is used to enable the oxygen circuit prior to the Oxygen Start Output to begin the cut.

Oxygen Start

This output is used to enable the cutting oxygen in oxy fuel mode. This output can also be used to activate a marking device.

Preheat

This output is used to enable the high preheat gas when cutting in oxy fuel mode. It is activated for the “High Preheat Time” when initiating a cut.

Plasma Enable	The Plasma Enable Output is used to enable the oxygen circuit prior to the Plasma Start Output to begin the cut.
Plasma Start	This output is used to start the plasma system in plasma mode.
Plasma Height Disable	This output is used to disable the automatic torch height controller in plasma mode. It is activated whenever the current axis position is within the "Plasma Distance To Corner" or the "Plasma Distance From Corner" parameters while cutting a part. It is also active whenever the current cutting speed drops below the result of (Programmed Cut Speed x (Plasma High/Lo Speed/100)).
Plate Marker No. 1	This output is used to activate a marking device. This output is enabled by marking codes within the part program.
Plate Marker No. 2	This output is used to activate a marking device. This output is enabled by marking codes within the part program.
CNC Tracer	This output is used to control a CNC relay. The CNC relay determines whether the control, tracing system or joystick is commanding the amplifiers. This output is deactivated whenever the control is off, in Teach Trace mode or is disabled. Otherwise it is always activated.
Bleed Off Gas	The Bleed Off Gas output is used by the Oxy fuel cut logic to send an output to the Oxy torch to purge gases at the end of a cut. This Output is on for the duration of the Bleed Off Time selected in setups.
Aux Tool Select	The Auxiliary Tool Select Output is used with the type "B" I/O configuration to allow the control to activate multiple tools on the cutting table. The output is activated through use of Marking codes (EIA M10 / M11) within the part program.
Drive Enable	The Drive Enable Output is used to enable the Drives during normal functions and to disable the Drives during fault conditions.

Drive Enables

This setup parameter allows the user to select how the control responds to drive faults. If the setting is Series, then all axes must complete their individual fault ramp times before the drives are disabled. If the setting is independent, each drive is disabled immediately as soon as its axis fault ramp time is finished.

Initial Feedback Delay

This feature allows the initial feedback from the Drive System to be held off after initial power up. This allows the Drive System to fully enable prior to enabling the position loop.

Joystick Installed

Select "Yes" to enable the optional external Joystick. Not available for all control types and optional control hardware required.

Speed Pot Installed

Select "Yes" to enable the optional external Speed Potentiometer. Not available for all control types and optional control hardware required.

Plasma Override %

The Plasma Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the plasma Speed Pot based on a percentage of the set cut speed. The Speed Pot feature must be enabled for use.

Oxy Fuel Override %

The Oxy Fuel Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the oxy fuel Speed Pot based on a percentage of the set cut speed. The Speed Pot feature must be enabled for use.

Trial Override %

The Trial Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the Trial Speed Pot based on a percentage of the set Trial speed. The Speed Pot feature must be enabled for use.

Speed Pot Installed On

The Speed Pot installed on Parameter is used to assign Speed Pot inputs to a desired the Analog Input if a dedicated Speed Pot input is not available on the Analog input card being used.

Analog Offset 1- 12

The Analog Offsets 1 through 12 are used to correct for any imbalance or "Zero" the incoming analog voltage to the Analog Input Card.

To calibrate the Analog Inputs, jumper the two pins specific to the input together and view the incoming voltage at the Diagnostics Analog I/O screen. The incoming voltage should be zero. If any voltage is displayed at the diagnostic screen, an Offset Voltage equal to the incoming voltage being read can be entered here to "Zero" the incoming voltage. Please refer to the installation instructions later in this section for more details.

Axes

Transverse/Rail

The following screen is identical for both the traverse and rail setup screens.

The control comes with both an advanced position and velocity servo loop. The following parameters are available to help configure the servo loops for your specific drive and mechanical system.

Speed 0 to	<input type="text" value="500"/>	to	<input type="text" value="800"/>	to	<input type="text" value="1000"/>	ipm
Proportional Gain	<input type="text" value="175"/>	<input type="text" value="200"/>	<input type="text" value="225"/>			
Integral Gain	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>			
Derivative Gain	<input type="text" value="15"/>	<input type="text" value="20"/>	<input type="text" value="20"/>			
Feedforward Gain	<input type="text" value="100"/>	<input type="text" value="100"/>	<input type="text" value="100"/>			
Velocity Gain	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>			
Servo Error Tolerance	<input type="text" value="0.25"/>	in	Home	<input type="text" value="to Home Switch"/>		
Encoder Counts per in	<input type="text" value="20000"/>	Absolute Home Position		<input type="text" value="0"/>	in	
Fault Ramp Time	<input type="text" value="0.5"/>	sec	Home Offset Distance	<input type="text" value="0"/>	in	
Drive Type	<input checked="" type="radio"/> Velocity	<input type="radio"/> Current	Home Direction	<input checked="" type="radio"/> Positive	<input type="radio"/> Negative	
DAC Polarity	<input checked="" type="radio"/> Positive	<input type="radio"/> Negative		Use Marker Pulse	<input checked="" type="radio"/> No <input type="radio"/> Yes	
Encoder Polarity	<input checked="" type="radio"/> Positive	<input type="radio"/> Negative		Use Software Travel Limits	<input type="radio"/> No <input checked="" type="radio"/> Yes	
Encoder Decode Mode	<input type="radio"/> 1X	<input type="radio"/> 2X	<input checked="" type="radio"/> 4X	Maximum Travel Limit	<input type="text" value="0"/> in	
Use Hardware Overtravels	<input checked="" type="radio"/> No <input type="radio"/> Yes		Minimum Travel Limit	<input type="text" value="0"/> in		
Backlash Compensation	<input type="text" value="0"/> in					
<input type="button" value="Transverse"/> <input type="button" value="Rail"/> <input type="button" value="Dual Gantry"/>			<input type="button" value="Done"/>			

Speed 0 To

This parameter allows the technician to input selected speed ranges to customize the gains for the various speeds selected. **Note:** These speed parameters are directly tied to the Speed To field for the acceleration rates previously noted on the Speeds setup screen. Changing these speed parameters will replace the Speed To values entered at the Speeds setup screen.

Proportional Gain

Proportional Gain correlates to Elastic Stiffness in the control loop. Increasing the proportional gain increases the static stiffness, but decreases response of the servo loop.

Under proportional loop control, the drive system will apply a restoring torque to the motor in proportion the position error of the axis.

With a Proportional Gain too high, the system will be unstable which will result in overshoots, and a generally “nervous” and shaky axis. This is also referred to as a “hot” control loop.

With a proportional gain too low, the system will respond in a loose or sloppy manner. This can be seen in the test pattern when the outside corners become rounded and the circle segments do not all meet in the center.

Integral Gain

Integral Gain improves the positioning accuracy of the control loop. Integral Gain can be used to compensate for static friction or gravity. Excessive Integral Gain can result in system instability.

For most shape cutting machines, this parameter should be set to Zero (0).

Derivative Gain

Derivative Gain helps to dampen out sudden changes in velocity. The higher the derivative gain, the slower the response time to the control loop. For most velocity loop drives, this parameter will be set to Zero (0).

Feedforward Gain

Feedforward Gain can be used to drive the following error to zero during machine motion. In all digital control loops there is a finite amount of error that is introduced by the velocity command. Increasing Feedforward Gain can reduce this introduced error.

Velocity Gain

When using a current loop amplifier, the internal velocity loop in the control can be used to provide dampening without an external tachometer.

Using the internal velocity loop with a current loop amplifier can result in higher static stiffness, smoother machine motion, and less overshoot.

Servo Error Tolerance

Allows the user to program the amount of servo loop Following Error to be allowed prior to display an error message. The parameter is limited to a maximum value of five inches.

Encoder Counts per inch

Enter a value that is the number of encoder edges per inch of machine travel. It is possible to enter fractional encoder units and the control will keep track of these fractions automatically. Encoder Counts per inch are equal to the resolution of the encoder, multiplied by the encoder revolutions per inch or mm (based on the machine drive gearing).

For example: The resolution of a 4X - 1000 line encoder counts both edges (lines) of channel A and channel B to equal 4 counts per line multiplied by the 1000 lines per revolution would equal 4000 counts per revolution. If the encoder revolutions per inch to travel are 1:1, we would have 4000 encoder counts per inch of travel.

Encoder Counts/ Inch = 4 Counts/ Line x 1000 Lines/ Rev x 1 Rev/ Inch = 4000

Fault Ramp Time

This parameter sets the motion deceleration time after a fault occurs. At the end of "Fault Ramp Time, The drives will be disabled.

Drive Type

This parameter is used to tell the control what type of control loop to run. If you are running an external velocity loop drive (indicated by having an integrated tachometer in the motor), select Velocity. If you are running in torque mode (no tachometer), select Current.

DAC Polarity

This parameter allows changing of the analog output polarity to establish proper control loop feedback without any wiring changes.

Encoder Polarity

This parameter allows changing of the encoder input polarity to establish proper counting for positive machine motion without any wiring changes.

Encoder Decode Mode

Currently, the control only supports 4X encoder decode mode. This has been done to increase positional accuracy.

Use Hardware Overtravels

Select whether or not the cutting machine will be using Hardware Overtravels. If Hardware Overtravels are used, the control will disable feedback and display an error message if the inputs become active. It is recommended that Hardware Overtravels be installed.

Backlash Compensation

The Backlash Compensation parameter is used to offset or compensate for any backlash in the mechanics of the drive system.

Home

The Home parameter is used to activate use of the Home feature. Depending on control I/O configuration, the table may be Homed to either a designated Home Switch or an Overtravel Switch.

The Home feature is used to set a known absolute physical position location on the cutting table that is used for referencing future manual "Go to Home" and other motion commands. This is generally performed through activation of a home switch positioned on the appropriate axis giving it a known physical location.

When the Homing command is entered at the control, the control will move the axis towards the Home Switches at the Fast Home Speed until the switches have been activated. Once the switches have been activated, motion stops and then the axis moves in the opposite direction off switch at the Slow Home Speed. The moment that the switch is deactivated, the position is recorded at the control, providing an absolute reference point for future motion commands.

Absolute Home Position

Defines the position of the axis when the Home Limit Switch or Marker Pulse is detected.

Home Offset Distance

Allows the user to set an offset distance from the Home Limit Switch.

Home Switch Normally

If a Home Limit Switch is used, the user is prompted for switch polarity.

Home Direction

Determines which direction the axes will travel during phase one of the homing sequence.

Use Marker Pulse

When enabled, the absolute home position will be assigned at the instant the marker pulse is detected. It is recommended that the Marker Pulse be used for optimal homing repeatability.

Use Software Travel Limits

The control is capable of running with software Overtravel limit switches. These switches act just like the hardware switches, but require no additional hardware.

Software Overtravels are only practical in cutting machines when Absolute RS-274D programming is used.

Maximum Travel Limit

If Software Overtravels are enabled, the user is prompted for the maximum travel of the cutting machine.

Minimum Travel Limit

If Software Overtravels are enabled, the user is prompted for the minimum travel of the cutting machine.

Dual Gantry

The following setup screen is available if the control is configured for a Dual Gantry Axis.

The Dual Gantry Axis is commanded as a separate axis on the control that mirrors the output of the main Rail Axis. Additionally, performance of the Dual Gantry Axis is compared to the main Rail Axis and additional output command is given to keep the axis in position.

The definitions for the setup parameters are the same as for the Transverse/Rail Axes. However, the number of selections are reduced as features for overtravels and homing do not apply.

The screenshot shows a configuration screen for the Dual Gantry axis. It features several input fields and radio buttons for parameter selection. At the bottom, there are four tabs: Transverse, Rail, Dual Gantry (which is selected), and THC. A Done button is located in the bottom right corner.

Speed 0 to	<input type="text" value="500"/>	to	<input type="text" value="800"/>	to	<input type="text" value="1000"/>	ipm
Proportional Gain	<input type="text" value="175"/>	<input type="text" value="175"/>	<input type="text" value="175"/>			
Integral Gain	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>			
Derivative Gain	<input type="text" value="15"/>	<input type="text" value="15"/>	<input type="text" value="15"/>			
Feedforward Gain	<input type="text" value="100"/>	<input type="text" value="100"/>	<input type="text" value="100"/>			
Velocity Gain	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>			

Skew Error Tolerance in

Encoder Counts per in

Drive Type Velocity Current

DAC Polarity Positive Negative

Encoder Polarity Positive Negative

Encoder Decode Mode 1X 2X 4X

Use Home Limit Switch No Yes

Switch Offset Distance in

Backlash Compensation in

Transverse Rail Dual Gantry THC Done

Speed 0 To

This parameter allows the technician to input selected speed ranges to customize the gains for the various speeds selected. **Note:** These speed parameters are directly tied to the Speed To field for the acceleration rates previously noted on the Speeds setup screen. Changing these speed parameters will replace the Speed To values entered at the Speeds setup screen.

Proportional Gain

Proportional Gain correlates to Elastic Stiffness in the control loop. Increasing the proportional gain increases the static stiffness, but decreases response of the servo loop.

Under proportional loop control the drive system will apply a restoring torque to the motor in proportion the position error of the axis.

With a Proportional Gain too high, the system will be unstable which will result in overshoots, and a generally “nervous” and shaky axis. This is also referred to as a “hot” control loop.

With a proportional gain too low, the system will respond in a loose or sloppy manner. This can be seen in the test pattern when the outside corners become rounded and the circle segments do not all meet in the center.

Integral Gain

Integral Gain improves the positioning accuracy of the control loop. Integral gain can be used to compensate for static friction or gravity. Excessive Integral Gain can result in system instability.

For most shape cutting machines this parameter should be set to zero (0).

Derivative Gain

Derivative Gain helps to dampen out sudden changes in velocity. The higher the derivative gain, the slower the response time to the control loop.

For most velocity loop drives this parameter will be set to zero (0).

Feedforward Gain

Feedforward Gain can be used to drive the following error to zero during machine motion. In all digital control loops there is a finite amount of error that is introduced by the velocity command. Increasing Feedforward Gain can reduce this introduced error.

Velocity Gain

When using a current loop amplifier, the internal velocity loop in the control can be used to provide dampening without an external tachometer.

Using the internal velocity loop with a current loop amplifier can result in higher static stiffness, smoother machine motion, and less overshoot.

Skew Error Tolerance

If the Dual Gantry Axis is installed, the user will be prompted for Skew Error Tolerance. This is the amount of position error allowed between the master and slave gantry drive axes prior to an error message being displayed.

Encoder Counts per inch

Enter a value that is the number of encoder edges per inch of machine travel. It is possible to enter fractional encoder units and the control will keep track of these fractions automatically. Encoder Counts per inch are equal to the resolution of the encoder, multiplied by the encoder revolutions per inch (based on the machine drive gearing).

For example: The Resolution of a 4X - 1000 line encoder counts both edges (lines) of channel A and channel B to equal 4 counts per line multiplied by the 1000 lines per revolution would equal 4000 counts per revolution. If the encoder revolutions per inch to travel is 1:1, we would have 4000 encoder counts per inch of travel.

Encoder Counts/Inch = 4 Counts/Line x 1000 Lines/Rev x 1 Rev/Inch = 4000

Drive Type

This parameter is used to tell the control what type of control loop to run. If you are running an external velocity loop drive (indicated by having an integrated tachometer in the motor), select Velocity. If you are running in torque mode (no tachometer), select Current.

DAC Polarity

This parameter allows changing of the analog output polarity to establish proper control loop feedback without any wiring changes.

Encoder Polarity

This parameter allows changing of the encoder input polarity to establish proper counting for positive machine motion without any wiring changes.

Encoder Decode Mode

Currently the control only supports 4X encoder decode mode. This has been done to increase positional accuracy.

Use Home Limit Switch

Selecting "Yes" will enable the Home feature for the Dual Gantry Axis. Note: The Z Home Switch must first be defined and mapped to an input location in the I/O screen to enable this feature.

Switch Offset Distance

The Switch Offset Distance is used to specify any physical position offset between the Dual Gantry and Rail Home Switch positions. This allows the control to very accurately position the two axes for operation and remove any skew of the gantry.

Backlash Compensation

The Backlash Compensation parameter is used to offset or compensate for any backlash in the mechanics of the drive system.

CBH

The following setup screen is available if the control is configured for a Contour Bevel Head.

The definitions for the setup parameters are the same as for the Transverse/Rail Axes, with the exception of Absolute Home Angle and Home Offset Angle. These two setup parameters serve the same basic function as previously described but are measured in degrees of rotation rather than inches or millimeters. However, the number of selections are reduced as these parameters are not used with a Contour Bevel Head.

The screenshot shows a configuration window for a Contour Bevel Head (CBH). It contains several input fields and radio button options. At the bottom, there are three tabs: 'Transverse', 'Rail', and 'CBH', with 'CBH' being the active tab. A 'Done' button is located in the bottom right corner.

Proportional Gain	<input type="text" value="65"/>	Auto Home at Power Up	<input checked="" type="radio"/> No <input type="radio"/> Yes
Integral Gain	<input type="text" value="0"/>	Absolute Home Angle	<input type="text" value="0"/> deg
Derivative Gain	<input type="text" value="6"/>	Home Offset Angle	<input type="text" value="0"/> deg
Feedforward Gain	<input type="text" value="10"/>	Use Home Limit Switch	<input checked="" type="radio"/> No <input type="radio"/> Yes
Velocity Gain	<input type="text" value="0"/>	Home Direction	<input checked="" type="radio"/> Positive <input type="radio"/> Negative
Servo Error Tolerance	<input type="text" value="10"/> deg	Use Marker Pulse	<input checked="" type="radio"/> No <input type="radio"/> Yes
Encoder Counts per rev	<input type="text" value="20320"/>		
Drive Type	<input checked="" type="radio"/> Velocity <input type="radio"/> Current		
DAC Polarity	<input checked="" type="radio"/> Positive <input type="radio"/> Negative		
Encoder Polarity	<input checked="" type="radio"/> Positive <input type="radio"/> Negative		
Encoder Decode Mode	<input type="radio"/> 1X <input type="radio"/> 2X <input checked="" type="radio"/> 4X		
Follower Initially	<input checked="" type="radio"/> Off <input type="radio"/> On		

Proportional Gain

Proportional Gain correlates to Elastic Stiffness in the control loop. Increasing the proportional gain increases the static stiffness, but decreases response of the servo loop.

Under proportional loop control, the drive system will apply a restoring torque to the motor in proportion the position error of the axis.

With a Proportional Gain too high, the system will be unstable which will result in overshoots and a generally “nervous” and shaky axis. This is also referred to as a “hot” control loop.

With a proportional gain too low, the system will respond in a loose or sloppy manner. This can be seen in the test pattern when the outside corners become rounded and the circle segments do not all meet in the center.

Integral Gain

Integral Gain improves the positioning accuracy of the control loop. Integral Gain can be used to compensate for static friction or gravity. Excessive Integral Gain can result in system instability.

For most shape cutting machines, this parameter should be set to zero (0).

Derivative Gain

Derivative Gain helps to dampen out sudden changes in velocity. The higher the Derivative Gain, the slower the response time to the control loop.

For most velocity loop drives, this parameter will be set to zero (0).

Feedforward Gain

Feedforward Gain can be used to drive the following error to zero during machine motion. In all digital control loops there is a finite amount of error that is introduced by the velocity command. Increasing Feedforward Gain can reduce this introduced error.

Velocity Gain

When using a current loop amplifier, the internal velocity loop in the control can be used to provide dampening without an external tachometer.

Using the internal velocity loop with a current loop amplifier can result in higher static stiffness, smoother machine motion, and less overshoot.

Servo Error Tolerance

Allows the user to program the amount of servo loop Following Error to be allowed prior to display an error message. The parameter is limited to a maximum value of 90 degrees.

Encoder Counts per rev

Enter a value that is the number of encoder edges per revolution of the Contour Bevel Head axis. It is possible to enter fractional encoder units and the control will keep track of these fractions automatically. Encoder Counts per rev are equal to the resolution of the encoder multiplied by the encoder revolutions per rev.

For example: The Resolution of a 4X - 1000 line encoder counts both edges (lines) of channel A and channel B to equal 4 counts per line time multiplied by the 1000 lines per revolution would equal 4000 counts per revolution.

Encoder Counts/Rev = 4 Counts/Line x 1000 Lines/Rev = 4000

Drive Type

This parameter is used to tell the control what type of control loop to run. If you are running an external velocity loop drive (indicated by having an integrated tachometer in the motor), select Velocity. If you are running in torque mode (no tachometer), select Current.

DAC Polarity

This parameter allows changing of the analog output polarity to establish proper control loop feedback without any wiring changes.

Encoder Polarity

This parameter allows changing of the encoder input polarity to establish proper counting for positive machine motion without any wiring changes.

Encoder Decode Mode

Currently the control only supports 4X encoder decode mode. This has been done to increase positional accuracy.

Follower Initially

This parameter is used to determine if the CBH axis will be On when the control is first powered up.

Auto Home At Power Up

Determines if the Contour Bevel Head will automatically go into the homing routine upon powering up the control.

Absolute Home Angle

Defines the position of the axis when the home limit switch or marker pulse is detected.

Home Offset Angle

Allows the user to set an offset angle from the home limit switch.

Use Home Limit Switch

Tells the control to look for a home limit switch during phase one of the homing sequence.

Home Direction

Determines which direction the axes will travel during phase one of the homing sequence.

Use Marker Pulse

When enabled, the absolute home position will be assigned at the instant the marker pulse is detected. It is recommended that the marker pulse be used for optimal homing repeatability.

Station Configuration

This password protected screen for the Voyager™ II controller is used to configure a Plasma or Marker torch station for use. This provides a single location to assign the Tool Selection , Process Selection and Lifter selection for the station. Up to eight stations for the Plasma 1 & 2 and Marker 1 & 2 process selections may be configured.

The “4532” password is provided for viewing of the Station Configuration setup screen without allowing changes. This password is useful for verify setups without the danger of accidentally changing them or revealing the supervisory password to an unauthorized user.

This Station configuration screen is also used to enable the serial link for the Command® THC and the serial communication for the HD4070® High Definition Plasma System.

Main Screen

Station	Lifter	Plasma 1	Plasma 2	Marker 1	Marker 2
Station 1	Sensor THC 1	MAX200	None	None	None
Station 2	Sensor THC 2	None	HD3070	None	None
Station 3	Sensor THC 3	None	None	Other	None
Station 4	Command THC	None	None	None	Other

Buttons at the bottom: Stations 1 thru 4, Stations 5 thru 8, Reset, Done

These stations may be selected for use through codes within the part program. These codes enable the desired Station (THC) and are used in conjunction with the Process Select codes to configure the desired cut / mark process for use.

When a Station Select has been executed through the program codes the corresponding Station Select Output will be active.

Stations 1-4 / 5-8

The Stations 1-4 / 5-8 Softkey is used to access the desired Station for configuration.

Reset

The Reset Softkey may be used to reset or clear all Station setup parameters setting the values to “None”

Part Program Support

The following program codes are used to enable a station for use. Station Select and Process Select codes should be placed prior to the cut / mark.

Station Selects

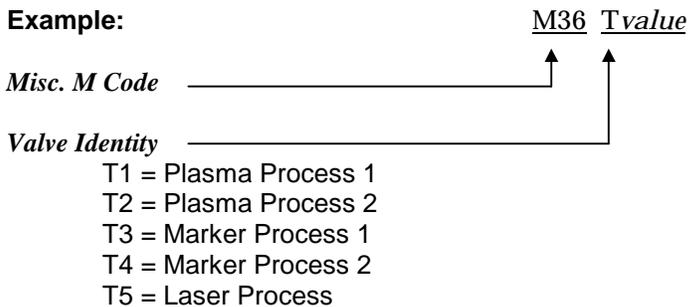
Stations (Lifter / THCs) may be selected / de-selected using an EIA-274D program code with the following format.

Code	Description
M19 Tvalue	Cancel All Station Selections
M37 Tvalue	Select Station 1-20 (Tvalue)
M38 Tvalue	De-Select Station 1-20 (Tvalue)

Additionally, these Station Select program codes may be overridden using the user selected THC inputs to the control. The feature to override the part program must be enabled at the Cutting Setup Screen.

Process Selects

Process Selections may be selected using an EIA-274D program code with the following format.



Station Configuration Variables

The following options are available for the station configuration

Lifter

None
 Sensor THC
 Command THC (w/ Serial Link)
 HD4070 Integrated THC 1 or 2 (used only with the HD4070® power supply)
 Other (any stand alone Lifter Station)

Power Supplies

None	HD4070 Torch 1or 2
Max100/ 100D	HT4001
Max200	HT4100
HT2000	HT4400
HD3070	Other (any other Plasma system)

Marker

None	ArcWriter
HD4070 Torch 1or 2	Other (any stand alone Marker)

Station Selects may be overridden by manual inputs by setting the Station Select Override feature in Cutting Setups.

Process Selects may be overridden by manual inputs by setting the Process Select Override feature in Cutting Setups.

Overview

First press the Stations 1-4 or Station 5-8 Softkey to access the desired station. Select the appropriate Lifter selection for the desired station from the list of available Lifter types. Next select the appropriate tool (Plasma Power Supply / Marker Tool) selection for that station from the list of available tools in the Plasma and Marker Process fields. The tool selection should reflect the actual tools in use for that individual Lifter. The Station may be configured so that all four Plasma and Marker Processes operate on one Station or distributed throughout all 8 stations. If needed, the Reset Softkey may be used to reset or clear all Station setup parameters setting the values to "None".

Station	Lifter	Plasma 1	Plasma 2	Marker 1	Marker 2
Station 1	Sensor THC 1	MAX200	HD3070	ArcWriter	Other
Station 2	None	None	None	None	None
Station 3	None	None	None	None	None
Station 4	None	None	None	None	None

Buttons: Stations 1 thru 4, Stations 5 thru 8, Reset, Done

Selections made for the four processes and THC designations may limit the overall configuration. Additionally, selection of some of certain power supplies may also limit configuration.

Example: If Station 1 has been defined as having a Sensor™ THC and a MAX200® for Plasma Process 1, no other power supply type can be selected for Plasma Process 1. However, MAX200® for Plasma Process 1 if a Sensor THC has been selected.

Station	Lifter	Plasma 1	Plasma 2	Marker 1	Marker 2
Station 1	Sensor THC 1	MAX200	None	None	None
Station 2	Sensor THC 2	MAX200	None	None	None
Station 3	Sensor THC 3	MAX200	None	None	None
Station 4	Command THC	None	None	ArcWriter	None

Command® THC Support

Selecting a Command THC as the lifter for a process enables the serial Link for a single Command® THC. This also configures the selected Plasma / Marker Cut Types screen to display the Command® THC features. If a Command® THC has been selected for a station but does not use the serial communication feature to the control, then the Lifter type should be set to "Other".

Please refer to the Command® THC section of this manual for additional information on the operation of the Command® THC

HD4070® Support

The HD4070® feature establishes the Serial Link HD4070® Power Supply communication link and configures the selected Plasma / Marker Cut Types screen to display the HD4070® features. The Single HD4070® must be assigned to Stations 1 & 2.

The HD4070® has the ability to use two Integrated Command® THCs. These are controlled by the HD4070® and as such have designated Station locations.

Station	Lifter	Plasma 1	Plasma 2	Marker 1	Marker 2
Station 1	HD4070, Integrated THC 1	HD4070, Torch 1	None	HD4070, Torch 1	None
Station 2	HD4070, Integrated THC 2	None	HD4070, Torch 2	None	HD4070, Torch 2
Station 3	None	None	None	None	None
Station 4	None	None	None	None	None

Buttons: Stations 1 thru 4, Stations 5 thru 8, Reset, Done

In the previous example, you can see that the Cutting and Marking with the HD4070[®] Integrated Torch 1 is limited to Plasma Process 1 / Maker Process 1 on Station 1. Additionally, the Cutting and Marking with HD4070[®] Integrated Torch 2 is limited to Plasma Process 2 / Maker Process 2 on Station 2. These stations may be configured to Cut or Mark or both.

FineLine 100 / 200 Support

Serial communications to INNERLOGIC's FineLine 100 and FineLine 200 may be enabled and configured for use with selected THCs.

Special

Date

Allows the user to enter the current date.

Time

The value for the current time would be entered at this parameter and displayed at the main screen.

Display Time

The Display Time parameter allows the user to select the display time to be shown in either AM/PM format or 24 hour clock format.

Mouse Pointer

If the control has been equipped with the optional industrial mouse, select On to enable this feature.

Motion Cursor

This parameter allows the user to select the style of Motion Cursor used.

Tangent Angle

This parameter is used to set the degree of the tangent angle for control motion. Segments within a part that intersect at angles greater than the selected tangent angle will decel to zero or minimum corner speed. Segments within a part that intersect at angles less than or equal to the selected tangent angle, will not decel unless the next segment is a speed limited arc.

File Extensions

The parameter allows the user to enter the file extensions of the part files that will be accepted at the control.

Adding Folders

This parameter determines whether the control operator has the ability to add Folders from the parts directory on the control or the host computer.

Deleting Folders

This parameter determines whether the control operator has the ability to delete Folders from the parts directory on the control or the host computer.

Deleting Files

This parameter determines whether the control operator has the ability to delete Folders from the parts directory on the control or the host computer.

Mapping Drives

This parameter determines whether the control operator has the ability to map to external drives from the control through the optional Network feature.

Configuring Watch

When enabled, this parameter will allow the control operator to change the selected items in the Watch Window.

Force Simulation

When activated, this feature will force the control into a simulation mode that will allow the control to operate with motion disabled and I/O feedback enabled.

Tools Installed

This setup parameter is used to select or limit the cut modes available to the control operator.

Message Enables

The following pull down box is used to enable and disable system messages. To change the status of a message, highlight the selected message and press the Space key.

Ready to Start Cutting Message

When enabled, the Ready Message feature will display a ready message when the Start button is pressed.

Kerf Too Large Warning Message

The Kerf Too Large Warning setup parameter allows the user to disable the “Kerf Too Large” warning message. This message is used to notify the user that when a part has been loaded and translated at the control, a conflict with the cut paths has been detected for the given Kerf value and that some detail may be lost when cut. Disabling the “Kerf Too Large” message may lead to unexpected results and allow cutting of invalid parts.

Homing Must Be Performed Message

This message is used to prompt the operator to home the selected axis before motion can begin. The selected axis must have homing enabled on the axes setup screen.

Example:



Values Have been Changed Message

This message is displayed as a confirmation when it has been detected that the values within the current configuration screen have changed. This ensures that changes are not made in error when exiting the screen.

Home Torch Height Control Message

This message is used to prompt the operator to home the Sensor™ THC axis at power up and before motion can begin.

Ready to Final Align Message

This message appears as part of the skew alignment function and is displayed just prior to final motion to position the tool is executed.

Part Larger than Plate Message

This message is displayed when the dimensions of the part that have been loaded exceed the selected plate dimensions.

Cut Chart Data Has Changed Message

This message is displayed as a confirmation when it has been detected that the values within the current Cut Chart screen have changed. This ensures that changes are not made in error when exiting the screen.

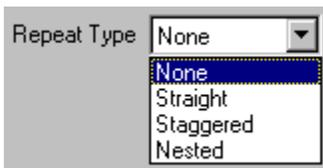
Latched Manual Keys

This parameter will enable or disable the Latched Manual Key feature which allows the manual motion keys to remain on with a single key press.

Auto Drop Down

When enabled, the Auto Drop Down feature will automatically show the entire list of options at a selection box.

Example:



Zero Positions

This parameter determines whether the control operator has the ability to zero positions. When disabled, the zero positions softkey will be grayed out and will be unavailable to the operator.

Save Part for Rush Job

This feature will enable or disable the Resume Part prompt for Rush Job Interrupt.

Auto Size App.

When enabled, the Auto Size App. feature is used for the demo software to size the application software to full screen display or the standard size of 640x480 (disabled).

Language

The language selection parameter allows the user to select the language displayed on the control from the available languages stored on the control. Languages may be added to the control by performing the standard software update with a language specific update file. Eastern languages may also require the installation of a font viewer to properly display the required characters. To change to a different language, select the desired language and press the DONE softkey. You will then be prompted to cycle power on the control for the new language to be displayed.

Password

The password parameter allows the user to enter a new password for machine setups. Numbers or letters may be used.

Special Password

The password parameter allows the user to enter a new password for special setups. Numbers or letters may be used.

Station Configuration Password

The password parameter allows the user to enter a new password for Station Configuration setups. Numbers or letters may be used.

Temperature

The Temperature parameter allows the user to select that the internal control temperature be displayed in Fahrenheit or Celsius in the Watch Window.

Note: Not available for all control types and optional control hardware required.

Auto Update Max Consumable Life

When enabled, this feature will continue to track the consumable life values beyond the user defined set point and assign that maximum values as the new set point. If disabled, the user defined set point for maximum consumable life will not be updated.

Machine Position Resets

When enabled, the Machine Position Resets feature will reset the absolute machine position when the Zero Positions softkey is pressed. When disabled, pressing the Zero Positions softkey will not reset the absolute machine position. Position information based on homing will not be lost. Only the current incremental motion (part) position will be reset to zero.

Auto Gas Control

When enabled, this feature allows the control to communicate with the Auto Gas Console for the HD3070® and allows access to the related setup parameters.

Arc Speed Limit Check

This feature allows the user the ability to turn off the Speed Limit Check performed by *Softmotion* for arcs larger than 10". This may be used to compensate for abrupt motion commands caused by non-tangent line arc segments, smoothing out motion.

Save Setups

Pressing the Save Setups button will save the current control setting to the floppy disk or hard drive. A window will be displayed to select the drive and enter a file name.



Note: After installation of the control on the cutting table or if any setup parameters are changed, it is important to save the current setup file to both the hard drive and floppy disk for future reference.

Load Setups

Pressing the Load Setups will load the selected control setting from the floppy or hard drive on to the control. A window will be displayed to select the drive and enter the file name.

Update Software

Pressing the Update Software button will update the control operating software from a floppy disk.

Update Help

Pressing the Update Help button will update the control help files from a floppy disk.

System Tools

Pressing the System Tools button will access core Windows® features for system performance. Features include **Update Registry**, **Scan Hard Disk**, **Defrag Hard Disk** and **Format Diskette**. System Tools also accesses features for virus scanning and adding special fonts for some languages.

Restore Last Version

Restore Last Version will restore the control to the previous version of system software.

Make Link Disk

The control is shipped with a proprietary Communication Link software used to communicate with a host computer. Pressing this softkey will transfer the Link software to a floppy disk so it may be loaded on to a host computer for use. Included with the software is a text file to instruct the user on setup and use of the link.

System Tools – Windows® 98

Automated Backup None Daily Weekly Monthly

Computer Name

Workgroup

Computer Description

User Name

Domain

Backup Hard Drive Scan Hard Disk Defragment Hard Disk Format Floppy Disk Reset Setups VirusScan Tools NJWin Tools Done

Network Log On

The Following parameter are available to define the User Log On information for the optional Network feature. Please refer to the Networking information section of this guide for additional information.

Computer Name
Work Group
Computer Description
User Name
Domain

Automated Backup

The Automated Backup feature allows the user to select the frequency of the automatic reminder for the backup of main hard drive to the spare hard drive. At the selected time, the user will be prompted to backup the system at power up. **Note:** This feature will only be available if the optional spare hard drive has been installed.

Backup Hard Drive

Pressing the Backup Hard Drive softkey will manually save the contents of the main hard drive to the spare hard drive. **Note:** This feature will only be available if the optional spare hard drive has been installed.

Scan Hard Disk

The Scan Hard Disk feature will search the hard disk for errors and correct them. This task should be performed approximately every three months.

Defragment Hard Disk

The Defragment Hard Disk feature will scan the control hard disk for file locations and rearranges them for optimum performance. This task should be performed approximately every three months.

Format Floppy Disk

Pressing the Format Floppy Disk softkey will format a floppy disk placed into the floppy drive. This is advantageous in the event that the control has difficulty reading a floppy disk formatted by a computer. **Note:** Formatting the diskette will remove any files that are stored on the diskette.

Reset Setups

Reset Setups will delete the current setup file, forcing default values to be loaded. A new setup file can then be loaded on the control through the Special Password screen.

If the control supplier has installed a customized setup file containing information specific to the cutting table, the Reset Setups softkey is renamed Restore Setups. This custom setup file then becomes the new default setup file and pressing the Restore Setup key will return the control to the original factory settings as configured by the control supplier.

VirusScan Tools

The VirusScan softkey will access the VirusScan[®] setup screen to install and perform virus scanning.

NJWin[®] Tools

The NJWin[®] softkey will access the NJWin[®] font viewer set up screen.

VirusScan®

The VirusScan® feature allows the operator to search files being loaded on to the control for known viruses. Virus Scan® is a registered trademark of McAfee Associates, Inc. Please contact your control vendor for information on how to obtain the Virus Scan® software for use on your control.



Install VirusScan®

Pressing the install VirusScan® softkey begins the installation process of loading the virus scanning software through the serial link communications.

Uninstall VirusScan®

The Uninstall VirusScan feature removes the VirusScan® software from the control hard disk.

Scan Hard Disk

Scan Hard Disk will search the control hard disk for software viruses.

Scan Floppy Disk

Scan Floppy Disk will search a floppy diskette for software viruses.

Virus Boot Disk

Pressing the Virus Boot Disk button will save a bootable recovery disk to a floppy disk. In the event that a virus has corrupted the control operating system, this Virus Boot Disk will allow the user to start the control and search for software viruses.

Update Virus Data Files

This feature allows the operator to load new virus scanning software information on to the control from the VirusScan[®] supplier to keep the VirusScan[®] search feature current with any new types of viruses through the serial link communications.

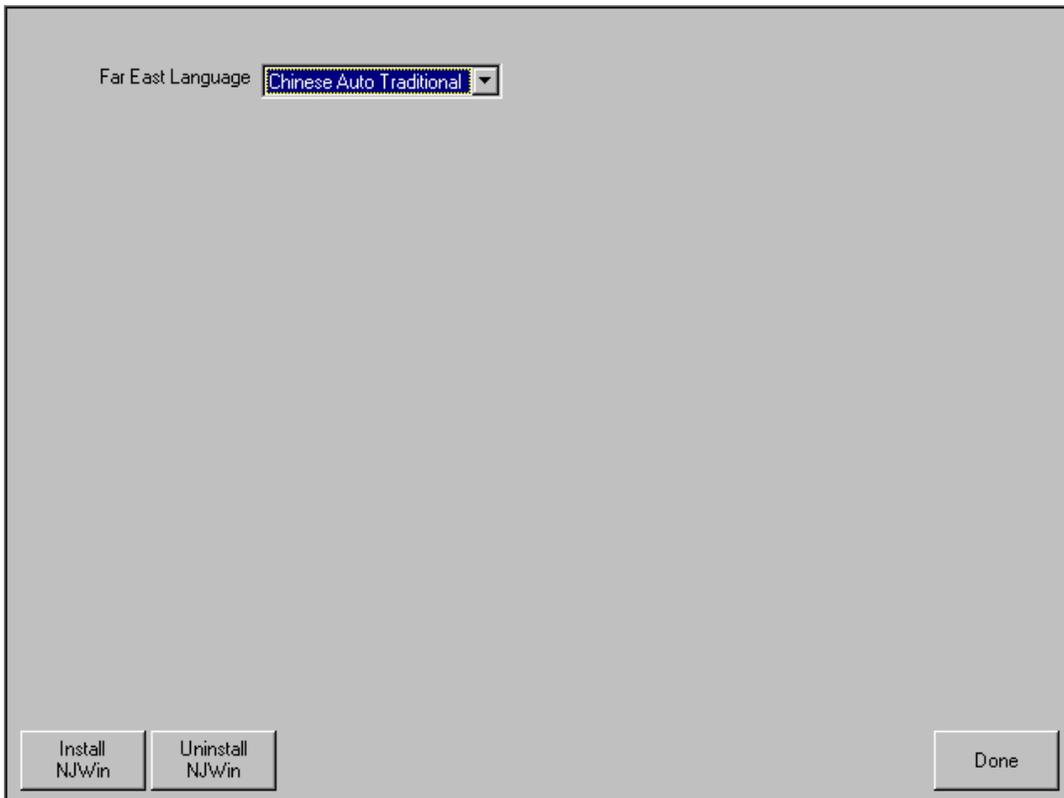
Save Scan Log File

Pressing the Save Scan Log File will save the data of the scan performed to a diskette.

NJWin[®]

NJWIN[®] is a font viewing software program that is used to display the proper characters for eastern languages. To view eastern languages, NJWIN[®] must be loaded on the control and the required eastern language selected at the NJWIN[®] screen. The translated update/operating software must be loaded on to the control and the required language selected at the special password screen.

Please contact your control vendor for software and information on languages available. NJWIN[®] is a registered trademark of NJStar Software Corporation.



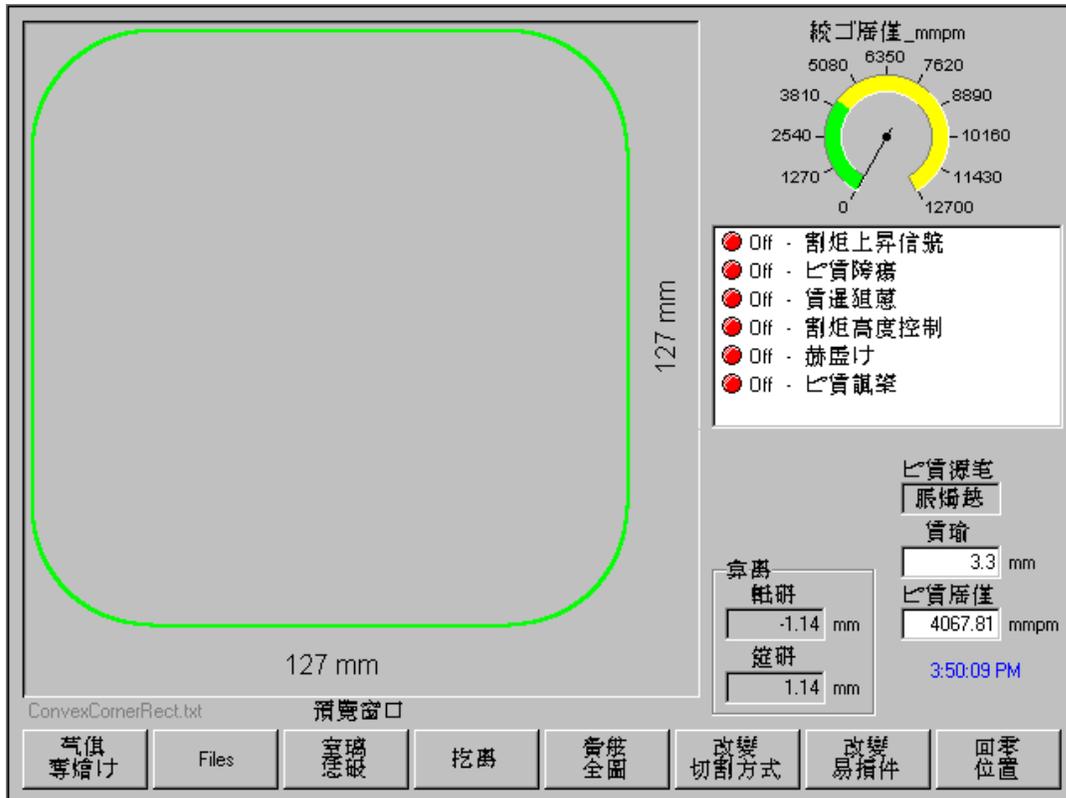
Install NJWin®

Press the Install NJWIN® softkey to install the NJWIN® font viewer software on to the control.

Uninstall NJWin®

Press the Uninstall NJWIN® softkey to remove the NJWIN® font viewer software from the control.

Example:



System Tools – Windows® XP



The control Systems Tools involves operational knowledge of Windows® XP system and should only be performed by qualified personnel.

Note: A reminder will be posted on screen when entering the Systems Tools that a Mouse and Keyboard will be required for proper operation. The Mouse and Keyboard should be connected to the control before entering the System Tools.



System Tools



Automated Backup

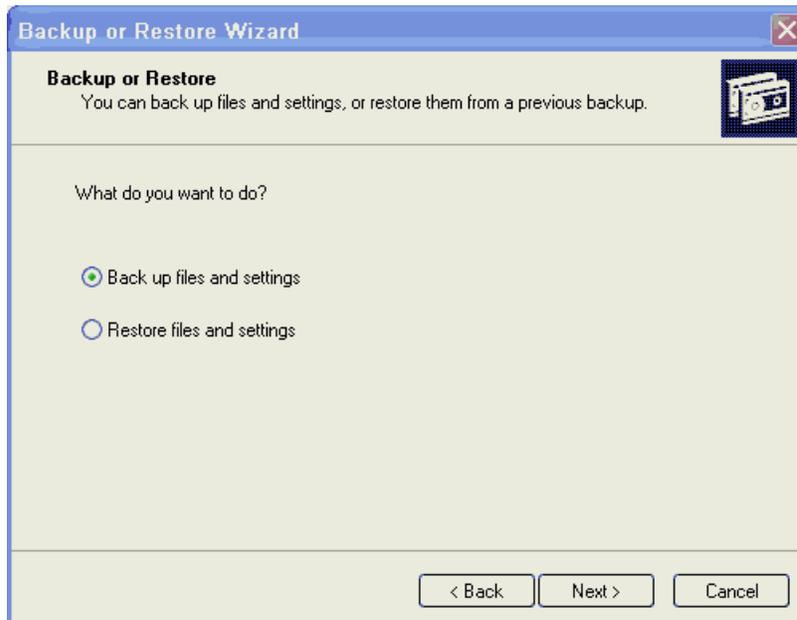
The Automated Backup feature allows the user to select the frequency of the automatic reminder for the backup of main hard drive information. At the selected time, the user will be prompted to backup the system at power up.

Backup Hard Drive

Pressing the Backup Hard Drive softkey will manually save the contents of the main hard drive to a specified location on the control hard drive or mapped location using the Windows® XP Back Up and Restore Wizard. The information from the backup location may also be used to restore the main system information

Follow the Back Up or Restore Wizard screen instructions. Users familiar with this feature may wish you use to the advanced mode.

Example



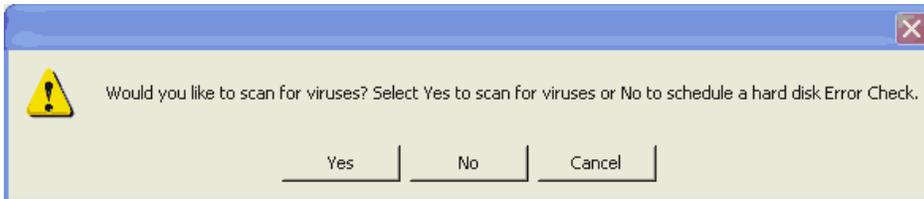
Note: When booting from a CD, the drive designation will be temporarily changed. The main drive partition used for the Control is Drive C. When booting from CD the first Drive designation (Drive C:) will be assigned to the CD Drive and the main control partition will be assigned to Drive D.

Important Guidelines:

- The default system back up file is located at D:\backup.bkf.
- Restore should be performed from D:\backup.bkf or E:\backup.bkf to D:\.
- DO NOT BACKUP backup.bkf or pagefile.sys on the Root of D:\.
- Under Tools/ Options/ Restore/ Select - Always Replace u Replace All Files when Restoring.

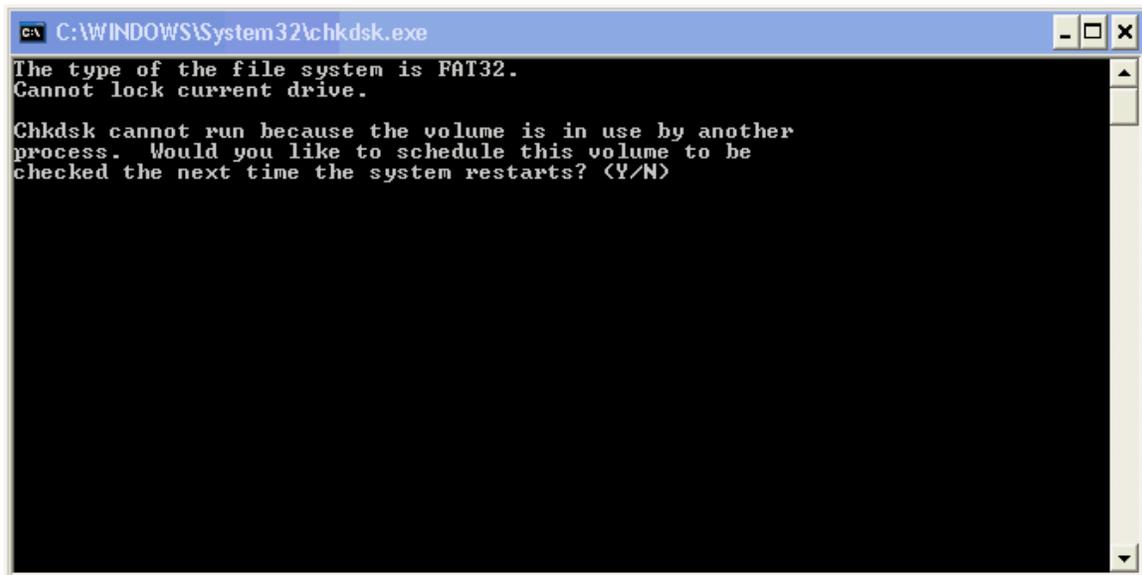
Scan Hard Disk

Pressing the Scan Hard Disk softkey allows the user to scan the Hard Drive for viruses or to Scan the Hard Drive for disk errors.



Scan Hard Disk - Selecting NO will allow the user to scan the Hard Drive for errors and correct them using the Windows® XP CHKDSK (check disk) utility. This task should be performed approximately every three months depending on the number of files loaded to and removed from the control.

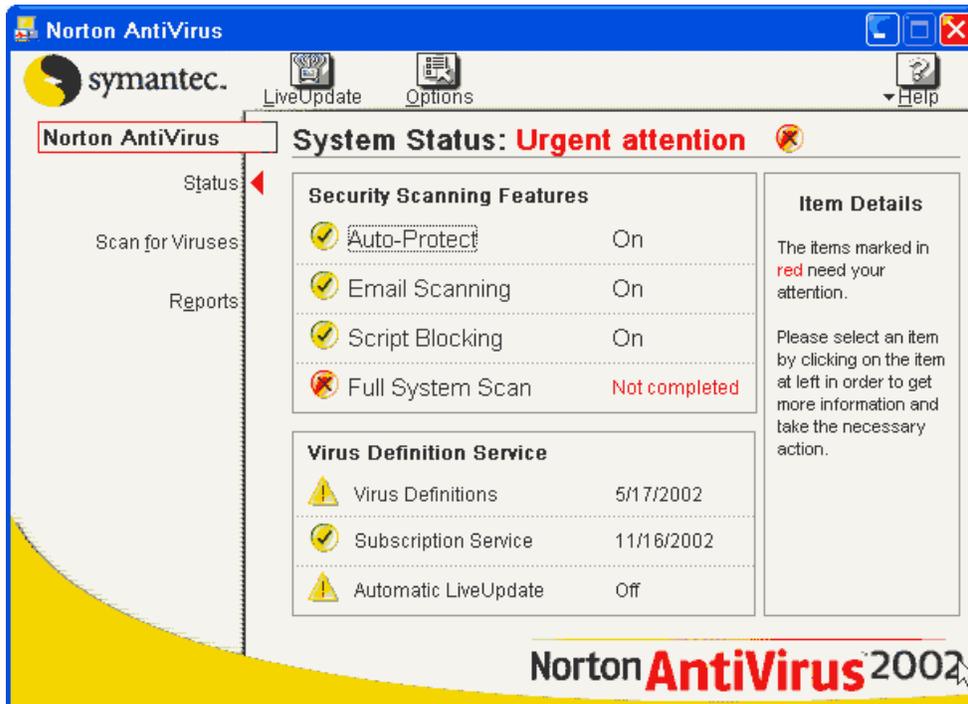
The Check Disk (CHKDSK) function cannot operate while the control software is in operation. You will be prompted to press “Y” for yes to perform the Check Disk at the next boot up of the control.



Scan Hard Disk - Selecting YES will allow the user to scan the Hard Drive for viruses using Norton's Anti-virus software.

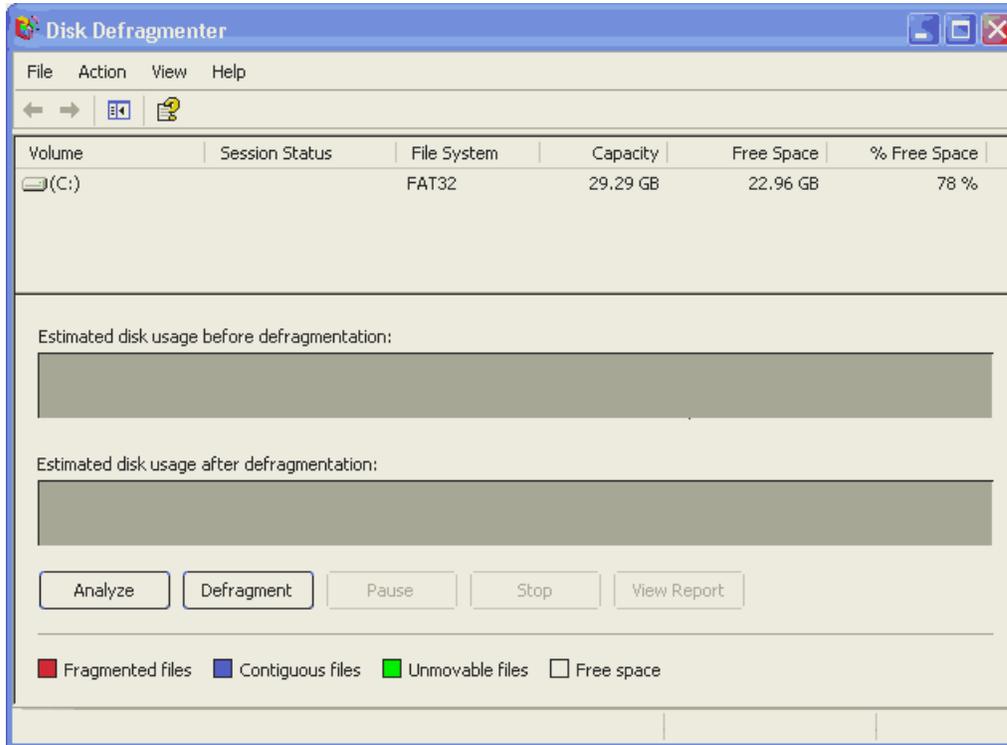
Antivirus™

The AntiVirus™ feature allows the operator to search files being loaded on to the control for known viruses. Norton AntiVirus™ is a trademark of Symantec™ Corporation. Please contact your control vendor for information on how to obtain the AntiVirus™® software for use on your control.



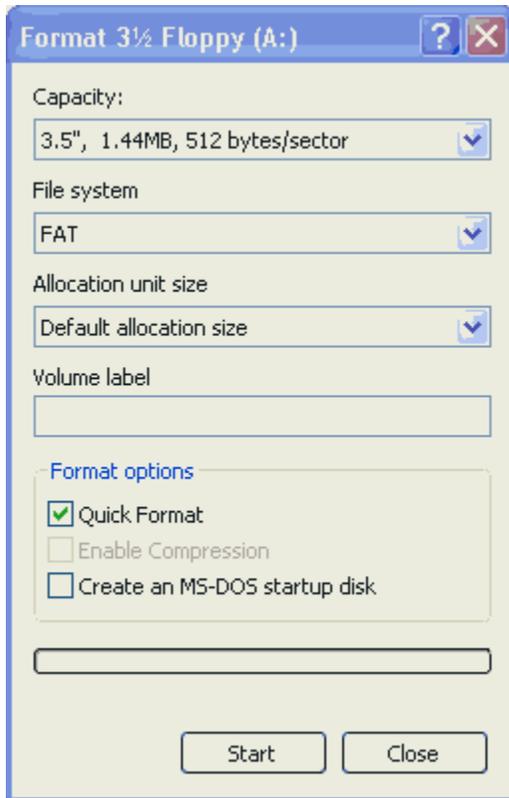
Defragment Hard Disk

The Defragment Hard Disk feature will scan the control hard disk for file locations and rearranges them for optimum performance. This task should be performed approximately every three months.



Format Floppy Disk

Pressing the Format Floppy Disk softkey will format a floppy disk placed into the floppy drive. This is advantageous in the event that the control has difficulty reading a floppy disk formatted by a computer. **Note:** Formatting the diskette will remove any files that are stored on the diskette.



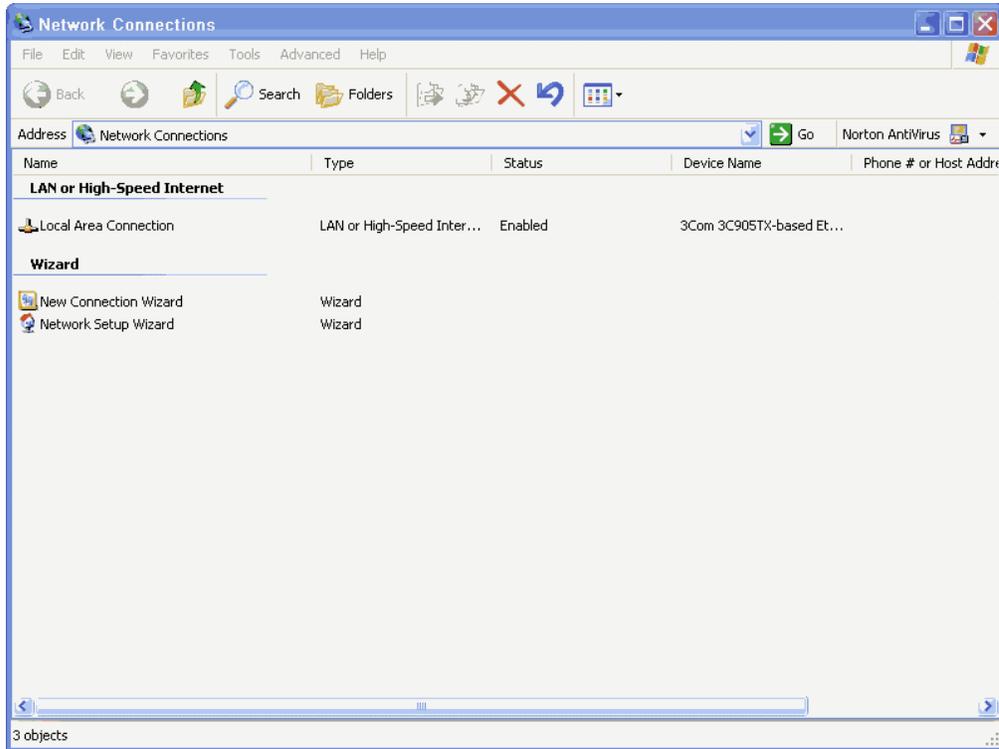
Reset Setups

Reset Setups will delete the current setup file, forcing default values to be loaded. A new setup file can then be loaded on the control through the Special Password screen.

If the control supplier has installed a customized setup file containing information specific to the cutting table, the Reset Setups Softkey is renamed Restore Setups. This custom setup file then becomes the new default setup file and pressing the Restore Setup Key will return the control to the original factory settings, as configured by the control supplier.

Network Tools

Pressing the Network Tools softkey accesses the Windows® XP Network Connection Utility. Network configuration and Network maintenance should only be performed by authorized personnel or system administrator.



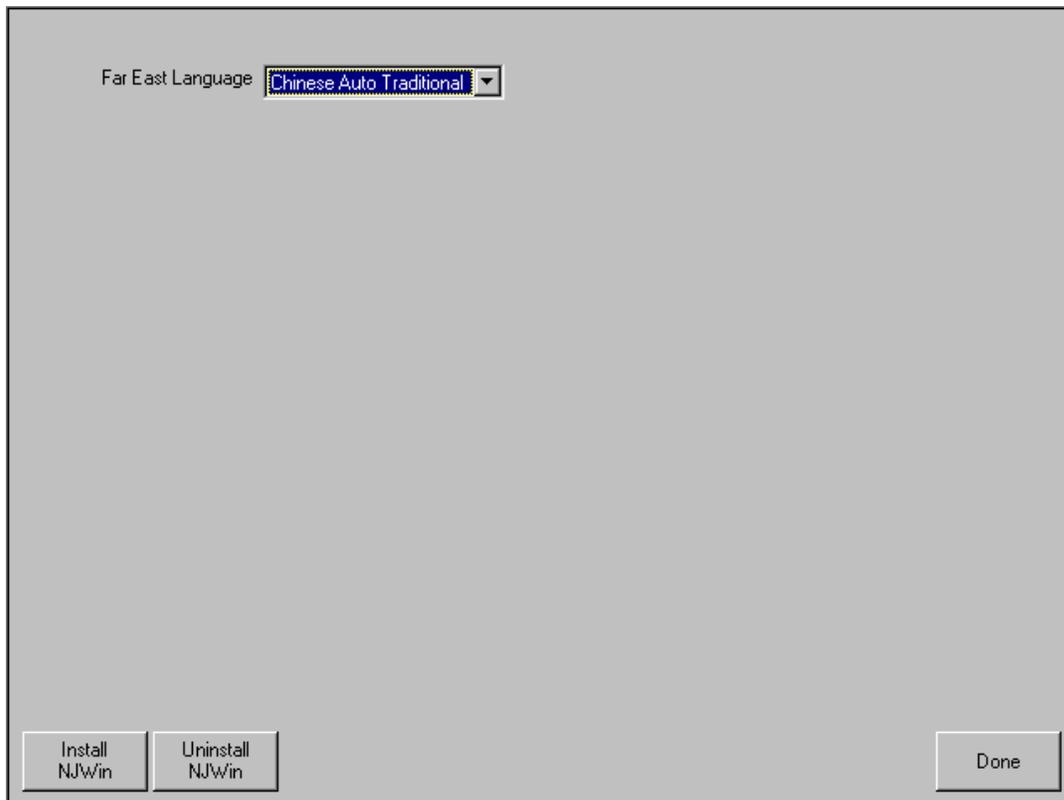
NJWin® Tools

The NJWin® softkey will access the NJWin® font viewer set up screen.

NJWin®

NJWIN® is a font viewing software program that is used to display the proper characters for eastern languages. To view eastern languages, NJWIN® must be loaded on the control and the required eastern language selected at the NJWIN® screen. The translated update/operating software must be loaded onto the control and the required language selected at the special password screen.

Please contact your control vendor for software and information on languages available. NJWIN® is a registered trademark of NJStar Software Corporation.



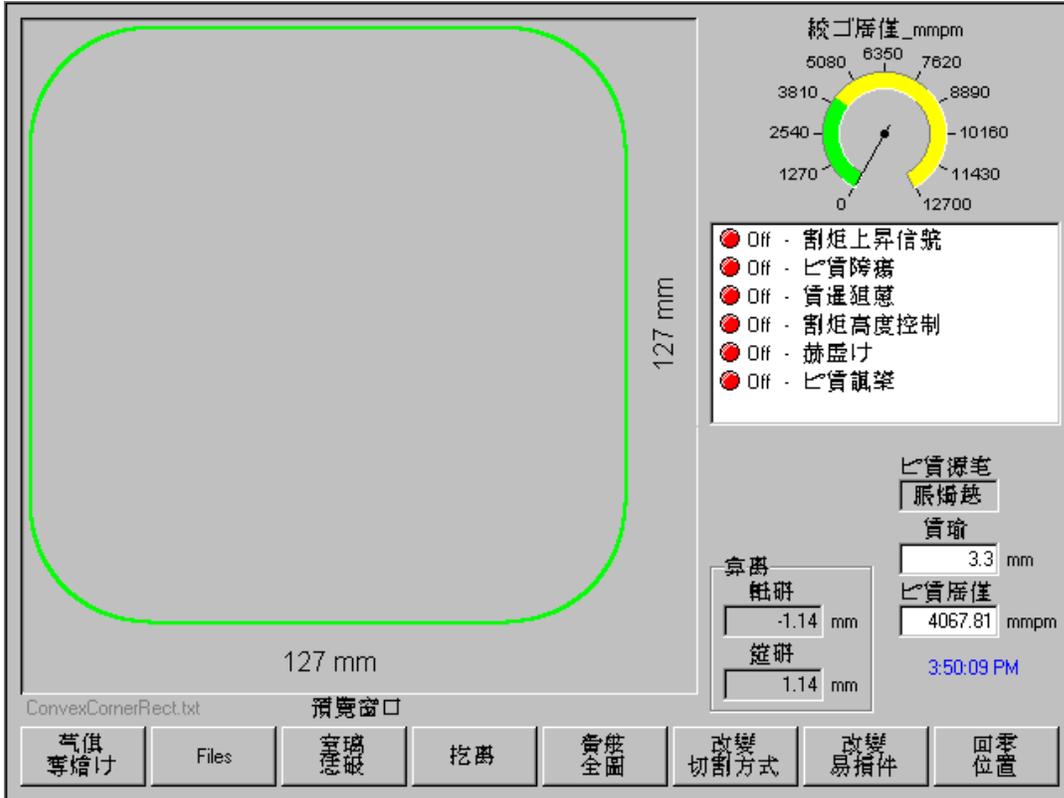
Install NJWin®

Press the Install NJWIN® softkey to install the NJWIN® font viewer software onto the control.

Uninstall NJWin®

Press the Uninstall NJWIN® softkey to remove the NJWIN® font viewer software from the control.

Example:



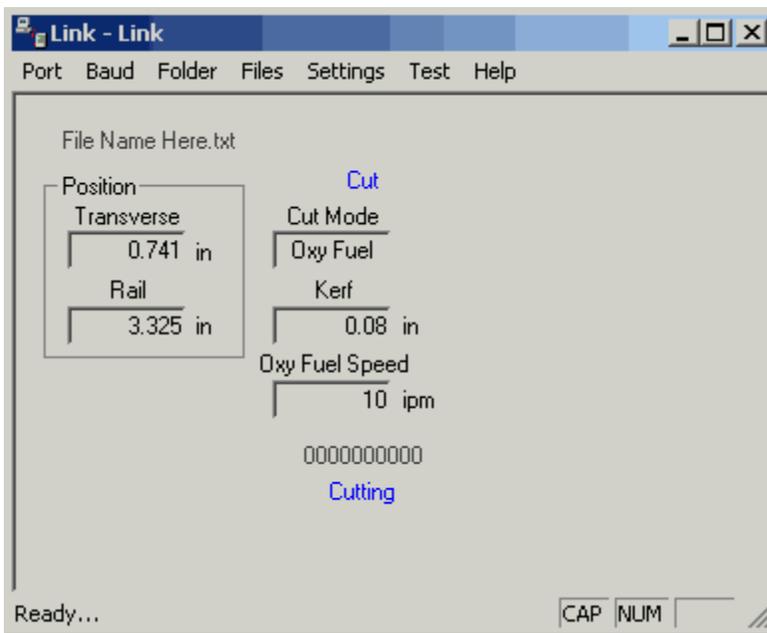
Section 5: Phoenix Link

Phoenix Link Overview

The Phoenix Link Communication Software is a proprietary communication package supplied with the control for optimal communication of part files and consumable database files between the control and the host computer. The program uses a 2X compression feature that allows the communications system to operate at speeds up to 230K Baud.

Phoenix Link

When the Phoenix Link Communication Software is operating, the following window will be displayed at the host computer for configuration. Once the software is running, the window may be minimized.



The following is a brief description of the available setup parameters for the Phoenix Link. Simply left click with the computer mouse on the selected feature in the drop down box to select, enable or execute that feature.

Port

This setup parameter allows the user to select the communication port to be used on the host computer.

Baud

This setup parameter allows the user to select the Baud rate used for communication on the host computer. Baud Rates: Min 9600 bps – Max 115,200 bps

Folder

The Folder setup parameter allows the operator to change the path of the Master Folder (Parts Folder). Sub folders and the part files within this Folder will be viewed at the control.

Files

The files setup parameter allows the user to indicate which file extensions will be recognized as acceptable part program files for download by the link software and will be viewed at the control.

Settings

The Settings setup parameter allows the user to configure the link to allow the Auto Reload (M65) feature to be enabled and recognized during communication. Additionally, the user may also select to communicate to multiple controls using the Multi Drop feature and configure it for use.

Test

The Test feature is used to test the operation of the selected communications port. To test, simply connect the transmit and receive signals on the selected communications port by inserting a paper clip and click on the desired port to test. The status of the test will be displayed in the lower left corner of the window.

Help

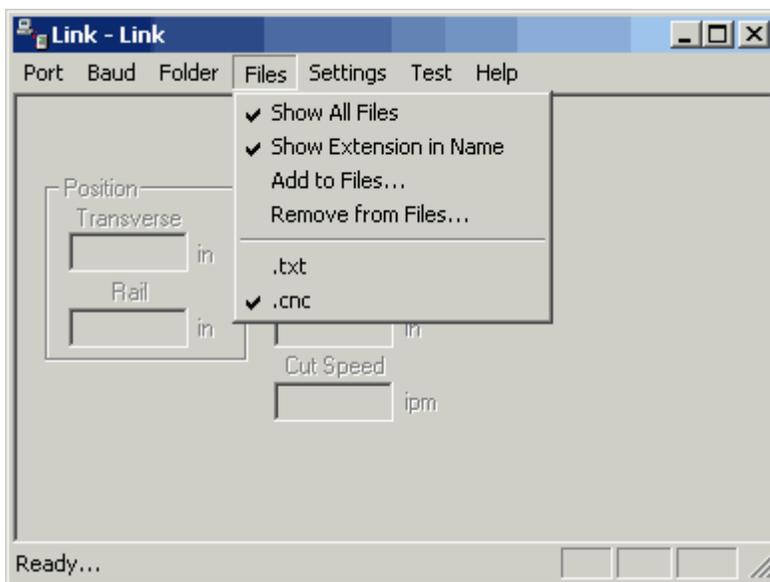
Selecting Help will display the current version of link software being used.

Files

The Files setup parameter allows the user to indicate which file extensions will be recognized as acceptable part program files for download by the link software and will be viewed at the control.

Once a file has been successfully saved on the control, it is assigned the “txt” file extension for use internally on the control. The operator must be aware of this as **part programs with the same name, but different file extensions, will be overwritten during multiple file downloads.** A warning will be displayed at the control prior to a file being overwritten. Care must be taken when downloading.

The list of acceptable part program types is listed in the lower half of the of the Files option box. The checkmark (✓) before the file extension indicates which selected file type will be displayed at the control. Please note that the checkmark (✓) in the file extension listing also indicates the file extension which will be placed on a part program when uploading a file to the host.



The following options are available to define what part programs may be viewed at the control.

Show All Files

Enabling this feature allows all file types in the selected parts folder to be viewed at the control. A checkmark (✓) located before this feature indicates that it has been enabled.

Show Extension in Name

This feature allows the user to view the file extension as part of the name at the control. For the file name "Job123.CNC", the control would only display "Job123_CNC" in the filename location of the download screen. The control would display "Job 123" if this feature was not enabled. This feature is advantageous if more than one file has the same file name with different file extensions is being used. A checkmark (✓) located before this feature indicates that it has been enabled.

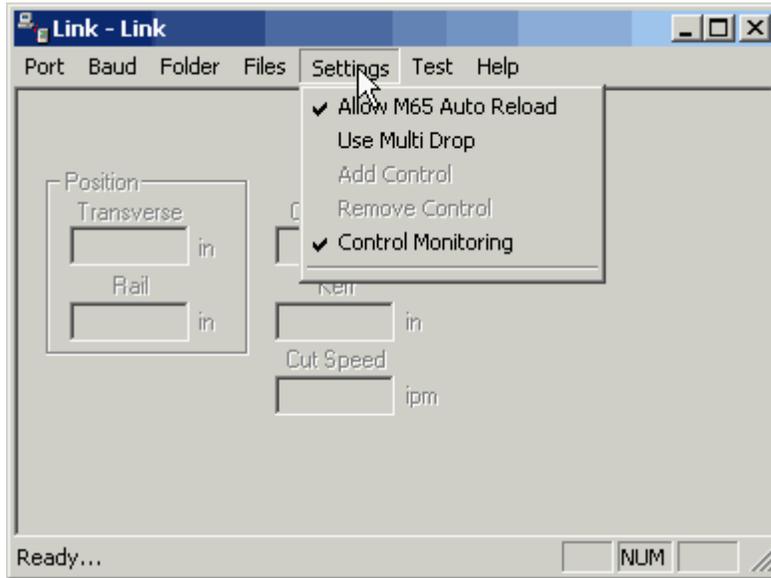
Add to Files

The Add to Files feature allows the user to add to the list of acceptable part program types to be viewed at the control. Up to four file types (extensions) may be added to the default .txt extension. A checkmark (✓) located before a file extension will indicate which file extension will be placed onto any part file being uploaded to the host.

Remove from Files

The Remove from Files feature allows the user to remove file extensions from the list of acceptable part program types.

Settings



Allow M65 Auto Reload

Selecting the M65 Auto Reload Feature allows part programs to be partitioned into smaller part programs separated by the M65 code. During the download, the control will download the individual sections of the part program and allow the operator to execute that section of the part. When that section of the program has been completed, the next section of the program will be automatically downloaded for execution. The downloads will continue until an end of program (M02) code is detected.

Use Multi Drop

The Use Multi Drop feature allows the Link to be configured to communicate with multiple controls through one communication port on the host PC. Up to eight controls may be supported with the Multi Drop feature.

Please note: The “Using Phoenix Link” parameter must be set to yes at the control to enable this feature and specific hardware for the control (serial communications board Rev D or higher) and host PC may be required to support this feature. Please contact your control supplier for more details.

Add Control

The Add Control feature is used to add a new control to the list of controls to communicate with. The corresponding control number must then be assigned to the new control in the link set up screen.

Remove Control

The Remove Control feature is used to remove a control from the list of controls that the host PC will communicate with.

Control Monitoring

When enabled, the Control Monitoring feature allows the user to view control status the host PC. Status for File Name, position, cut mode and cut information is displayed. This feature is only available with the Phoenix Link Communication Software.

Installation

Below is an item list to outline the step by step procedure for the communication setup of the control and installation of the Phoenix Link Communication software:

Disclaimer of Warranty: This link software and accompanying written material (including instructions for use) are provided “as is” without warranty of any kind.

Minimum System Requirements

Processor:	Pentium® 100MHZ
Hard Drive Space	0.5 MB
Memory:	4MB
Display:	VGA
Floppy Drive:	3.5”
Operating System:	MS Windows® 95, 98, NT, 2000, ME or XP
Serial Port:	One RS-232 or RS422 serial port will be required per control.

Software

- 1) At the control, access the Special Password screen, place a diskette into the floppy drive and press the Make Link Disk softkey. Three files will be transferred to the floppy disk. The Link software (Link.exe), a Setup file (Setup.exe) and a Readme file (Readme.txt). The Setup file will create a Link folder on the root directory of the host PC and will copy the Link software into it. The “Readme” file contains additional information about installation and setup of the Link software on to the host computer.
- 2) When the light goes out on the floppy drive, transfer the floppy disk to the host computer and place the disk into the floppy (A) drive. From the Windows® Start button, select Run. At the opening prompt type A:\Setup.bat and select OK. The setup file will expand the files and create a “Link” directory on the root directory. Placed in this directory will be the Link.exe file. **Please note:** The Link software must be located and run on the PC that is connected to the communication cable coming from the control.
- 3) From the Windows® Start button, select Run. At the opening prompt, type A:\Link\Link.exe and select OK. After the link software has been launched, two other files will be created. A link.ini file, which contains the Link software configuration information, and a Parts folder, which is the default Master parts folder. It is recommended that a shortcut to the Link.exe be placed on the desktop of the host PC for ease of use.
- 4) At the host computer, create one or more folders under the “Parts” directory. Place in to these folders any part programs to be accessed by the control.

For example, if you wish to add the folders “Workfile 1” and “Workfile 2” to the parts directory, the structure of the files would look as below:

Path C:\Link\Parts\Workfile 1 and C:\Link\Parts\Workfile 2



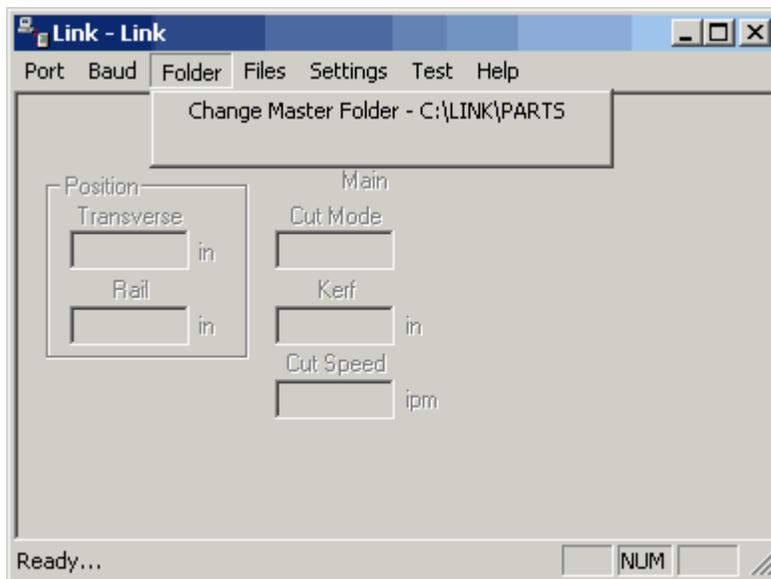
Any part programs to be viewed and downloaded at the control would be placed here. Only the sub folders Workfile 1 and Workfile 2 and the program files located within them will be viewed at the control.

Change Master Folder

If the host computer currently has existing part programs and folders, the Link software may be configured to operate with the current folder names. This master parts folder may be located on the host PC or another PC that is networked to the host PC. **Please note:** The Link software must be located and run on the PC that is connected to the communication cable coming from the control.

This is accomplished by configuring the Link software through the “Change Master Folder” feature to point the Link to the folder that contains the required part programs.

Launch the Link Software at the host computer and Link window will be displayed.



Select Files\Change Master Folder.

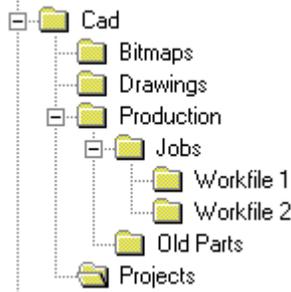


The Master file may now be changed from the current folder to the selected folder by typing in the selected path. Select OK to accept the change.

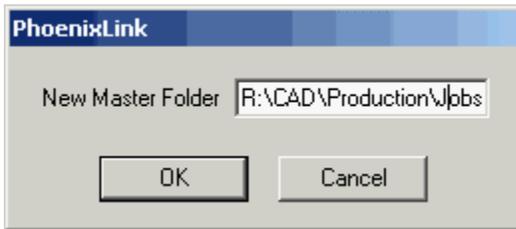
The same procedure would also apply when selecting a master folder located on a network.

For example, if the folders which contain the part programs are currently located in a folder named "Jobs" located on the PC named "R" drive, the Link.exe could be configured to the Change Master folder option to access these files.

Example path: R:\Cad\Production\Jobs



Again, start by launching the Link Software at the host computer. Select Files\Change Master Folder.



The Master file may now be changed from the current folder to the selected "Jobs" folder by typing in the path R:\Cad\Production\Jobs. Select OK to accept the change.

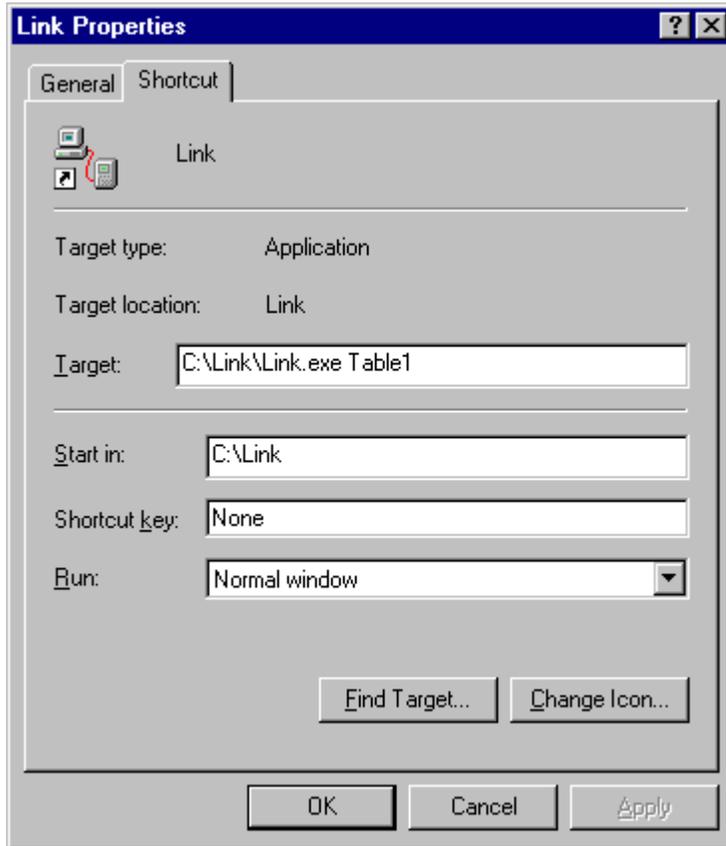
The final step to setup the Link software is to configure the Link software for Port, Baud, Files and Settings to match those being used at the control. It is recommended that a shortcut to the Link.exe be placed on the desktop of the host PC for ease of use.

Operating Multiple Links

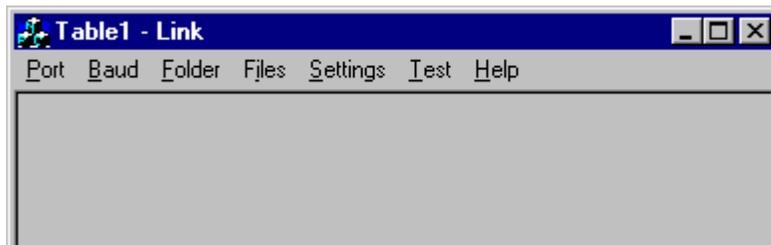
To connect more than one control to the host PC without the use of the Multi Drop feature, a Link software specific to each control may be installed. Each version of Link being operated will require its own dedicated communications port on the host PC.

Start by creating individual folders for each cutting table and placing a copy of the Link.exe into each folder. Create a shortcut for each Link.exe and place the shortcut on the desktop. Using a mouse, right click on the shortcut to open the shortcut properties dialog box. Add to the shortcut target command line information to indicate which table the Link will be in communication with.

In the target command line example below, “Table1” has been added to the end of the command line to indicate the Link will be specific to communications with Table 1.



This “table” information, added to the Target command line, will then be noted in the title bar of the Link window. The Link may now be launched from the shortcut and configured specific to this table. When the Link is closed, a “Table1.ini” with the specific Link setup file will be saved in the folder.



Continue to configure each additional Link for communication to each control. The separate Link files may be configured to point to the same or different master parts folders.

Hardware

Note: It is suggested for the purpose of establishing the proper setup of communications, that the control be placed next to the host computer and connected via a short communication cable. Once communications have been successfully established, the control can then be located on the cutting table and connected to the host computer via the appropriate cable or short haul modem system.

- 1) Configure the selected RS232/RS422 serial port on the control for operation, as described in the Serial Port information of this guide.
- 2) Test the control's communication port in the Diagnostic Screen to confirm proper operation of the serial port. Directions for testing of the serial port are described in the Diagnostic section of this guide.
- 3) Enter the control's Link setup screen to select the use of the desired communication port, select the Baud rate and select to use Phoenix Link. It is suggested to start at the lowest baud rate and increase until the maximum is achieved. Communicating at too high a speed may cause error messages to be displayed due to lost characters or information.
- 4) Enter the control's Special Password screen to add the file extension of the part programs being used to the current list of acceptable file extensions.
- 5) Load and configure the Link software at the host computer as previously described in this section.
- 6) Test the host computer's selected serial port through the "Test Port" feature of the Link software as outlined in the Phoenix Link software overview.
- 7) Connect the control to the host computer's selected communications port with the appropriate cable or modem system.

Operating Phoenix Link

- 1) The Phoenix Link software must be running at the host computer to communicate with your shape cutting control. Start the Link software at the host PC from the desktop shortcut or select the Windows Start Button, then select Run. From the opening prompt, type C:\Link\Parts\Link.exe (or appropriate path to the Link.exe) and select OK. The Phoenix Link window will appear. The Link software window may be minimized during operation if desired.
- 2) At the control, press the Files softkey and select to Upload or Download to Host. As the control is connecting to the host computer, a status display in blue text for the communication can be viewed in the lower right corner of the screen.
- 3) The control will initialize the port, open the port, and then try to contact the host. If this attempt at communication fails, an error message will be displayed in red. If successful, the control will download the available folder and part file names to be viewed on screen. **Note:** If the "Show Host File Names" parameter at the control has been set to "No", only folder names will be viewed.

Common Errors

Below is a listing of common errors encountered when installing a communications system.

- 1) The port selected at the host computer has already been assigned to another software program.
- 2) The host and control have been configured to different setup values.
- 3) The cable has been connected to the incorrect port or software has been configured to the incorrect port.
- 4) The selected modem or cabling system being used has swapped the transmit and received signals, causing a communications failure.
- 5) Trying to transmit over too long a cable without a modem or using incorrect wire for the distance being traveled.
- 6) Trying to communicate at too high a baud rate for the modem system selected.
- 7) The correct file extension has not been entered at the control's Special Password screen, preventing part programs from being displayed at the control.

Error Messages

Below is a listing of common error messages and some possible causes.

Unable to Open Port (control)

The selected communications port could not be opened. The wrong port has been selected or the communications port has failed.

Unable to Open Port (host)

The selected communications port could be opened. The wrong port has been selected, the communications port has failed or another software application is using the port.

Unable to Initialize Port

The selected communications port was unable to be initialized. The wrong port has been selected, the communications port has failed or another software application is using the port.

Port Failed

The Port Failed error message will be displayed if the communications port test has failed for the selected port. This may be due to a fault with the test wire connection, incorrectly connecting to the proper transmit and receive pins location, or failure of the communications port.

Host Not Responding

This message will be displayed if the communications port has been successfully opened the port, but has failed to establish communication with the Link software. This may be due to a fault with the cable connection, cable configuration or the host computer's communications port.

Communication Failed

This message will be displayed if after establishing communication with the host, an expected message from the host is not correct.

Communications Time Out

This message will be displayed if the specified amount of time allowed for a response from the host computer expires. This amount of time can be configured in the Link setup screen. This may be due to a fault with the cable connection, cable configuration or the host computer's communications port.

Checksum Error

The Checksum Error message will be displayed at the control if after a part has been uploaded or downloaded, the checksum calculated by the host and the control do not match. The Checksum calculation is performed by adding the numeric values of the ASCII codes used. This error may be due to incorrect cabling or transmitting at too high a speed for the communications system selected.

Warning: The Master Folder Selected does Not Contain any Folders

This error message will be displayed at the host computer if the selected master folder does not contain any subfolders. You may choose to add subfolders if they do not exist. If subfolders do exist, the path to the master folder may be incorrect.

For additional assistance in trouble shooting the Phoenix Link in the event of a failure, please contact our control vendor or representative.

Appendix A: Voyager II™

Voyager II™ Overview

The Voyager II™ is Hypertherm's premier PC-based CNC Control for the metal cutting industry utilizing our proprietary Graphical User Interface (GUI) and *SoftMotion™* Technology. This product sets the standard for operational features, ease of use and increased productivity in the shape cutting industry.

This product offers motion control operation of up to six axes with 64 I/O signals providing a high degree of flexibility in operation and table configurations. This control system supports Multiple Sensor™ Torch Height Controls and direct communication to Hypertherm's HD3070® High Definition® Plasma and ArcWriter®.

This appendix is intended to note additional product features, highlight modified view screens and familiarize the operator with the screen structure of the Voyager II™ shape cutting control. Many view screens will change only slightly and this section will only reference the new features for that view screen. **Note:** The Voyager II™ control has the ability to control several cutting processes. View screens which simply duplicate the setup parameters or features for the additional process, have not been included. The Voyager II™ control utilizes a type "V" I/O configuration.



Diagnostics

Drives & Motors

Pulse Type Single Repeating

Pulse Direction Positive Negative Alternating

Pulse Magnitude volts

Pulse Duration sec

Volts

+10

0

-10

Output Signal

Transverse Position

0.000 in

Rail Position

0.000 in

Dual Gantry Position

0.000 in

THC 1 Position

0.000 in

Speed

Transverse

ipm

Rail

ipm

Dual Gantry

ipm

THC 1

ipm

Test Transverse Test Rail Test Dual Gantry Test THC 1 Test All Zero Positions Done

The Voyager II™ control has the ability to control up to six axes of motion. When entering the Drives & Motors Diagnostic screen, the user will be prompted to select which group of axes will be available for testing.

Axes 1 thru 4 5 thru 8

OK Cancel

Please refer to the Diagnostics Section of this guide for additional information on the Drives & Motors Diagnostic features.

Password Setups

Machine

X Axis Orientation	<input checked="" type="radio"/> Transverse	<input type="radio"/> Rail	Table Size X	<input type="text" value="48"/> in	Y	<input type="text" value="96"/> in
Up Direction	<input checked="" type="radio"/> +Y	<input type="radio"/> +X	<input type="radio"/> -Y	<input type="radio"/> -X		
Right Direction	<input checked="" type="radio"/> +X	<input type="radio"/> -X	Sensor THC's Installed <input type="text" value="0"/>			
Dual Gantry Installed	<input checked="" type="radio"/> No	<input type="radio"/> Yes	<input type="text" value=""/>	Installed on	<input type="text" value=""/>	<input type="text" value="Analog 1"/>
CBH Installed	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
X and Y Motor/Encoder	<input checked="" type="radio"/> Normal	<input type="radio"/> Swapped				
Auto Torch Spacing	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
Tilt Rotator Installed	<input type="radio"/> No	<input checked="" type="radio"/> Yes				
Dual Tilt Rotator Installed	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
Auto Home at Power Up	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
Follower Initially	<input checked="" type="radio"/> Off	<input type="radio"/> On				
Dual Tilting Rotator Mode	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
Key Press Logging	<input checked="" type="radio"/> No	<input type="radio"/> Yes				
<input type="button" value="Machine"/>	<input type="button" value="Speeds"/>	<input type="button" value="Ports"/>	<input type="button" value="I / O"/>	<input type="button" value="Axes"/>	<input type="button" value="Done"/>	

Tilt Rotator Installed

The Tilt Rotator Installed parameter is used to enable use of the Tilt Rotator feature. Tilt Rotator is a unique rotational cutting tool which combines a rotational axis with a Tilt (bevel) axis allowing for compound cutting. Note: The Tilt Rotator feature will execute the commanded Tilt Angle motion over the length of the line segment (linear interpolation).

Auto Home At Power Up

Determines if the Contour Bevel Head (CBH) and Tilt / Rotate axes will automatically go into the homing routine upon powering up the control.

Follower Initially

This parameter is used to determine if the CBH and Rotate features will always be enabled after power up or would be enabled through the part program.

Dual Tilting Rotator Mode

The Dual Tilting Rotator Mode defines the Tilt Rotator to use two Tilt Axes rather than a Rotation Axis and Tilt Axis for Rotational Bevel Cutting. Tilt Rotator parameter must be active for this feature.

Key Logging

The Key Logging feature is used to record key press and other related information in a daily log file. This is intended for use by Service Technicians when a fault occurs to help review events prior to the fault experienced. When enabled, the file will be saved to the hard drive then may be retrieved

through the Files feature by transferring the file to floppy diskette. Generally, this parameter is set to NO unless instructed by a technician to be enabled.

THCs Installed

THC 1 Installed on Analog 1

THCs Installed

The THC Installed parameter defines the total number of Sensor™ THC axes assigned for operation at the control.

THC Installed On Axis / Analog

This setup parameter is used to define the THC axis for use. The user can select which axis the THC is to be commanded on, the analog input to use (arc voltage feedback) and which plasma.

Note: Refer to the Station Configuration and Sensor™ THC sections of this guide for additional information on the setup and use of the Sensor™ THC.

Speeds

The following Speeds setup parameter will be available when Tilt Rotator has been enabled.

Speed 0 to ipm
Acceleration Rate mG

Fast Deceleration Rate mG
Maximum Machine Speed ipm
Limited Machine Speed ipm
High Jog Speed ipm
Medium Jog Speed ipm
Low Jog Speed ipm
Minimum Corner Speed ipm
Fast Home Speed ipm
Slow Home Speed ipm
Creep Speed % of Cut Speed
Plasma Hi/Lo Speed % of Cut Speed
Plasma Distance to Corner in
Plasma Distance from Corner in

Rotate Acceleration Rate rev/sec²
Maximum Rotate Speed rpm
Rotate Fast Jog/Home Speed rpm
Rotate Slow Jog/Home Speed rpm
Tilt Acceleration Rate rev/sec²
Maximum Tilt Speed rpm
Tilt Fast Jog/Home Speed rpm
Tilt Slow Jog/Home Speed rpm

Machine Ports Axes

Rotate Acceleration Rate

This parameter allows the operator to set the acceleration rate for smooth and stable movement of the contoured bevel head. The higher the acceleration rate, the quicker the Rotate Axis will get up to speed. The lower the acceleration rate, the smoother the machine will position the cutting device. Values are entered in Rev/ Sec².

Maximum Rotate Speed

Enter the maximum speed for the Rotate Axis rotation in RPM.

Rotate High Jog Speed

Enter a value for the desired Rotate Axis High Jog Speed.

Rotate Low Jog Speed

Enter a value for the desired Rotate Axis Low Jog Speed.

Tilt Acceleration Rate

This parameter allows the operator to set the acceleration rate for smooth and stable movement of the contoured bevel head. The higher the acceleration rate the quicker the Tilt Axis will get up to speed. The lower the acceleration rate the smoother the machine will position the cutting device. Values are entered in Rev/ Sec².

Maximum Tilt Speed

Enter the maximum speed for the Tilt Axis in RPM.

Tilt High Jog Speed

Enter a value for the desired Tilt Axis High Jog Speed.

Tilt Low Jog Speed

Enter a value for the desired Tilt Axis Low Jog Speed.

Inputs

Please refer to the Setups section of this guide for more information on Input/ Output definitions and details on how to change Input / Output locations.

<input type="radio"/> Off	Input1	<input type="radio"/> Off	Gas Control Read Complete
<input type="radio"/> Off	Z Home Switch	<input type="radio"/> Off	Gas Control Error
<input type="radio"/> Off	Program Inhibit	<input type="radio"/> Off	Raise Torch 1
<input type="radio"/> Off	Cut/Mark Sense 1	<input type="radio"/> Off	Lower Torch 1
<input type="radio"/> Off	Cut/Mark Sense 2	<input type="radio"/> Off	Enable THC 1
<input type="radio"/> Off	Remote Pause	<input type="radio"/> Off	Raise Torch 2
<input type="radio"/> Off	Drive Disabled	<input type="radio"/> Off	Lower Torch 2
<input type="radio"/> Off	Input8	<input type="radio"/> Off	Enable THC 2
<input type="radio"/> Off	X Home Switch	<input type="radio"/> Off	Input25
<input type="radio"/> Off	X +Overtravel Switch	<input type="radio"/> Off	Input26
<input type="radio"/> Off	Y Home Switch	<input type="radio"/> Off	Input27
<input type="radio"/> Off	Y +Overtravel Switch	<input type="radio"/> Off	Input28
<input type="radio"/> Off	Plasma 1 Select	<input type="radio"/> Off	Input29
<input type="radio"/> Off	Plasma 2 Select	<input type="radio"/> Off	Input30
<input type="radio"/> Off	Marker 1 Select	<input type="radio"/> Off	Input31
<input type="radio"/> Off	Marker 2 Select	<input type="radio"/> Off	Input32

Inputs Outputs Analog Input Done

Outputs

Press SPACE to Change Output State

		Off	Torch Up
		Off	Torch Down
		Off	Ignition
		Off	Torch Height Disable
		Off	Hold Ignition
		Off	Marker
		Off	Cut Control
		Off	Plasma 1 Enable
		Off	Plasma 2 Enable
		Off	High Preheat Control
		Off	Low Preheat Control
		Off	Marker 1 Enable
		Off	Marker 2 Enable
		Off	Gas Control Write
		Off	Remote Test Operate
		Off	Remote Test Preflow
		Off	Remote Air Plasma
		Off	Remote H35/N2 Plasma
		Off	Remote O2 Plasma
		Off	Gas Flow Set 1
		Off	Gas Flow Set 2
		Off	Gas Flow Set 4
		Off	Gas Flow Set 8
		Off	Gas Flow Set 10
		Off	Gas Flow Set 20
		Off	Gas Flow Set 40
		Off	Gas Flow Set 80
		Off	Gas Flow Set 100
		Off	Valve Select 1
		Off	Valve Select 2
		Off	Valve Select 4
		Off	Valve Select 8

Inputs Outputs Analog Input Done

Rotate Axis

Proportional Gain	<input type="text" value="0"/>	Absolute Home Angle	<input type="text" value="0"/> deg
Integral Gain	<input type="text" value="0"/>	Home Offset Angle	<input type="text" value="0"/> deg
Derivative Gain	<input type="text" value="0"/>	Use Home Limit Switch	<input checked="" type="radio"/> No <input type="radio"/> Yes
Feedforward Gain	<input type="text" value="0"/>	Home Direction	<input checked="" type="radio"/> Positive <input type="radio"/> Negative
Velocity Gain	<input type="text" value="0"/>	Use Marker Pulse	<input checked="" type="radio"/> No <input type="radio"/> Yes
Servo Error Tolerance	<input type="text" value="10"/> deg		
Encoder Counts per rev	<input type="text" value="4000"/>		
Drive Type	<input checked="" type="radio"/> Velocity <input type="radio"/> Current		
DAC Polarity	<input checked="" type="radio"/> Positive <input type="radio"/> Negative		
Encoder Polarity	<input checked="" type="radio"/> Positive <input type="radio"/> Negative		
Encoder Decode Mode	<input type="radio"/> 1X <input type="radio"/> 2X <input checked="" type="radio"/> 4X		

Transverse	Rail	Dual Gantry	THC	Rotate	Tilt	Done
------------	------	-------------	-----	--------	------	------

Absolute Home Angle

Defines the position of the axis when the home limit switch or marker pulse is detected.

Home Offset Angle

Allows the user to set an offset angle from the home limit switch.

Tilt Axis

Proportional Gain	<input type="text" value="0"/>	Absolute Home Angle	<input type="text" value="0"/> deg
Integral Gain	<input type="text" value="0"/>	Home Offset Angle	<input type="text" value="0"/> deg
Derivative Gain	<input type="text" value="0"/>	Use Home Limit Switch	<input checked="" type="radio"/> No <input type="radio"/> Yes
Feedforward Gain	<input type="text" value="0"/>	Home Direction	<input checked="" type="radio"/> Positive <input type="radio"/> Negative
Velocity Gain	<input type="text" value="0"/>	Use Marker Pulse	<input checked="" type="radio"/> No <input type="radio"/> Yes
Servo Error Tolerance	<input type="text" value="10"/> deg		
Encoder Counts per rev	<input type="text" value="4000"/>		
Drive Type	<input checked="" type="radio"/> Velocity <input type="radio"/> Current		
DAC Polarity	<input checked="" type="radio"/> Positive <input type="radio"/> Negative		
Encoder Polarity	<input checked="" type="radio"/> Positive <input type="radio"/> Negative		
Encoder Decode Mode	<input type="radio"/> 1X <input type="radio"/> 2X <input checked="" type="radio"/> 4X		
Use Hardware Overtravels	<input checked="" type="radio"/> No <input type="radio"/> Yes		

Absolute Home Angle

Defines the position of the axis when the home limit switch or marker pulse is detected.

Home Offset Angle

Allows the user to set an offset angle from the home limit switch.

Note: Homing to a limit switch uses the Tilt Overtravel Switch (+/ -) input.

Tilt Rotator Part Codes

Kerf Table

Code	Description
G59 D1-200Xvalue	Sets kerf table variable from 1-200
G41 D1-200	Enables Left Kerf using a Kerf Table variable
G42 D1-200	Enables Right Kerf using a Kerf Table variable
G43 D1-200	Changes current kerf value via Kerf Table using previously set Left or Right kerf

Tilt/Rotator

Code	Description
G00 Avalue	Sets Tilt angle – A is the angle value in degrees
G00 Avalue Fvalue	Sets Tilt angle – Angle value in degrees with a speed command in RPM
M28	Disables Follower
M29	Enables Follower
M90	Preparatory Cmd - Aligns Rotator to Tangent angle of next cut segment
M75	A axis/Tilt Goto Home Cmd - Rapid Index

HD3070[®] Auto Gas Interface

This section outlines information specific to the HD3070[®] Auto Gas Interface. The Auto Gas screen is available from the Cut Types screen.

Note: The Auto Gas feature must first be enabled at the Special Password screen.

The screenshot displays the 'Plasma Gas Data' interface. It features a list of six gas valves, each with a numerical input field set to '0' and a percentage symbol. The valves are: Preflow Shield Gas-Valve 1, Preflow Shield Gas-Valve 2, Cut Shield Gas-Valve 3, Cut Shield Gas-Valve 4, Cut Plasma Gas-Valve 5, and Cut Plasma Gas-Valve 6. Below these is a 'Remote Plasma Gas' dropdown menu currently set to 'Oxygen'. At the bottom of the screen, there are five buttons: 'Save Data', 'Load Data', 'Test Cutting Gases', 'Test Preflow Gases', and 'Done'.

The top of the Auto Gas screen lists the valve parameter settings for the HD3070[®]. Valve settings for the 3070[®] Auto Gas console are documented in the HD3070[®] manual. When the values are set, these become the current setting and the operator can choose to save the file to the diskette or hard drive.

The settings at the supply are updated at control power up, whenever the settings are changed at this screen or through commands in a part program. Supply settings are also updated if power is lost and re-enabled at the power supply. There may be a brief delay as these power supply settings are communicated from the control to the power supply.

Save Data

Pressing the Save Data softkey will allow the operator to save the current Autogases setting to diskette or hard drive for future use.

Load Data

Pressing the Load Data softkey will allow the operator to Load stored Autogases setting from diskette or hard drive for use.



If you save the data, a file is created with G59 codes with the selected valve settings. Here is an example of the data file where all percentages are set to zero.

```
G59 V65 B0
G59 V66 B0
G59 V67 B0
G59 V68 B0
G59 V69 B0
G59 V70 B0
G59 V71 B0
```

Test Cutting Gases

Pressing the Test Cutting Gases softkey allows the operator to test the HD3070® Cut Gases.

Test Preflow Gases

Pressing the Test Preflow Gases softkey allows the operator to test the HD3070® Preflow Gases.

HD3070® Auto Gas I/O

The Interface to the HD3070® Auto Gas console is made through of Single Ended and BCD (Binary Coded Decimal) inputs. The BCD style of interface allows for exact settings by use of multiple inputs being active at any time. The active BCD input values are summed together to obtain the exact set point.

These I/O points are wired in the same fashion as our other Single Ended I/O points. The following I/O points are supplied for use of the HD3070® Auto Gas Console

Inputs

Gas Control Read Complete
Gas Control Error

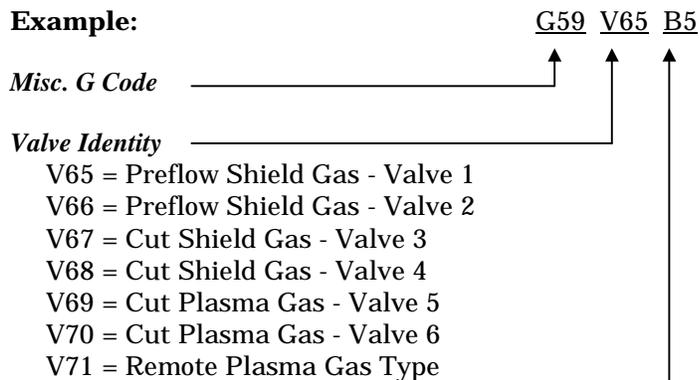
Outputs

Gas Control Write	Remote Test Operate
Remote Test Preflow	Remote Air Plasma
Remote H35/ N2 Plasma	Remote O2 Plasma
Gas Flow Set 1-100 (BCD)	Valve Select 1-8 (BCD)

HD3070® Part Program Support

The same valve setting data which is used at the Auto Gas setup screen may also be used within a part program to configure the HD3070® for use. This code is used to select the valve and indicate the valve set point.

Using a EIA-274D G59 code with the following format.

Example:

For Valves V65 – V70

A whole integer is used to set the desired percentage value.

For Valve 71

0 = Oxygen
1 = H35/N2
2 = O2

For the example given, the part program code (G59 V65 B5) would set the Autogas Preflow Shield Gas valve to 5%. Multiple G59 codes can be used to set and adjust the desired valves.

HD4070® Interface

The Voyager II™ control offers the additional option of interfacing directly to Hypertherm's HD4070® HyDefinition® Power Supply for setup. This feature has the ability to improve the ease of power supply setup and operational accuracy, while having the flexibility to fine tune the process specific to the operator's needs.

Using this advanced feature, all necessary power supply settings are transmitted from the control directly to the HD4070® configuring it for use via serial communications. The power supply setup is performed through the use of a Cut Chart (cut process parameter database) which is based on eight process selections. The combination of these eight process selections are used as key reference settings to transmit all necessary cut process parameters (e.g. arc voltage, pierce delay, etc.) to the supply.

This database allows the user to select factory recommended settings or amend the database for personalized settings. The Cut Chart information may be saved or loaded via the hard drive or floppy drive. The Cut Chart files containing the factory recommended settings are available from Hypertherm®.

HD4070® Cut Chart

		Plasma		Shield	
		Gas 1	Gas 2	Gas 1	Gas 2
Power Supply Type	HD4070	Preflow Setting	31	0	0 80 %
Torch Type	HT4400	Cutflow Setting	31	45	0 80 %
Material Type	Stainless Steel				
Current Setting	200A				
Plasma / Shield Gases	H35 / N2				
Cutting Surface	Above Water				
Material Thickness	3/8"				
Water Muffler	Not Installed				
Cut Speed	80 ipm	Preflow Time	0	0	sec
Kerf	0 in	Purge Time	0	0	sec
Set Arc Voltage	160 volts	Pierce Time	0.5	0	sec
Cut Height	0.156 in	Creep Time	0	0	sec
Pierce Height	150 % 0.234 in				
Save Data		Reset Data		Save Database	
		Load Database		Done	

Please refer to the control Operator's Guide for additional information on setup and use of the HD4070® Cut Chart.

HD4070[®] I/O and Diagnostics

The HD4070[®] I/O and remote diagnostics screen is accessed through the standard Diagnostic screen after serial link communications has been established. Status for the supply Software Revisions, Gas Pressure, Usage, I/O and Remote tools will be available.

HD4070[®] Miscellaneous

Status items for the for the HD4070[®] supply are available at the HD4070 Misc. Screen.

The screenshot displays the HD4070 I/O and Diagnostics screen with the following panels and controls:

- HD4070 Power Supply:** Output Current (0) Amps, Output Voltage (0) Volts, Control Voltage (0) Volts.
- Total HD4070 Torch 1 Usage:** Total Torch 1 Starts (0), Total Torch 1 Errors (0), Total Torch 1 Hours (0).
- Inlet Gas Pressures:** Gas 1 (Not Used) 0 PSI, Gas 2 (Not Used) 0 PSI, Gas 3 (Not Used) 0 PSI.
- Total HD4070 Torch 2 Usage:** Total Torch 2 Starts (0), Total Torch 2 Errors (0), Total Torch 2 Hours (0).
- HD4070 Software Revisions:** Data Base Rev (), HD4070 Software Rev ().
- Torch Coolant Input:** Off - Coolant Flow Switch ().

At the bottom, there are navigation buttons: HD4070 Inputs 1, HD4070 Inputs 2, HD4070 Outputs 1, HD4070 Outputs 2, HD4070 Misc, and Done.

Remote Tools

While in the 4070 Diagnostics screen, you may press the Purple Shift Key to access the following remote tools.

The screenshot shows the Remote Tools menu with the following buttons: Test Preflow, Test Cutoff, Test Pump, Update 4070 Software, and Done.

Test Preflow

Pressing the Test Preflow Softkey performs the Test Preflow Gases feature at the HD4070[®] power supply. This feature is useful in setting the inlet gas pressures under normal flow conditions to the recommended level.

Test Outflow

Pressing the Test Outflow softkey performs the Test Outflow Gases feature at the HD4070® power supply. This feature is useful in setting the inlet gas pressures under normal flow conditions to the recommended level.

Test Pump

Pressing the Test Pump softkey performs the Test Coolant Pump feature at the HD4070® power supply. This feature is useful in purging the air bubbles from the coolant loop after installation or repair.

Update 4070 Software

Pressing the Update 4070 Software softkey will initiate the process of the Software Update at the HD4070® power supply. Step by step instructions will be displayed on screen to guide the user through the update process.

HD4070® Inputs

The HD4070® Input screen shows the current status of the supply inputs.



Inputs (cont.)

<input type="radio"/> Off	Spare In 11	<input type="radio"/> Off	CNC Corner Hold
<input type="radio"/> Off	Spare In 12	<input type="radio"/> Off	CNC Plasma Sync
<input type="radio"/> Off	Spare In 13	<input type="radio"/> Off	CNC Emergency Stp
<input type="radio"/> Off	Spare In 14	<input type="radio"/> Off	CNC Machine Cable
<input type="radio"/> Off	Spare In 15	<input type="radio"/> Off	CNC Spare Input
<input type="radio"/> Off	Spare In 16	<input type="radio"/> Off	Watchdog Interlock
<input type="radio"/> Off	Spare In 17	<input type="radio"/> Off	THC1 IHS Complete
<input type="radio"/> Off	Spare In 18	<input type="radio"/> Off	Cable Check B In
<input type="radio"/> Off	THC1 Retract Cmpl		
<input type="radio"/> Off	THC1 Cable Install		
<input type="radio"/> Off	THC1 Discrete Error		
<input type="radio"/> Off	THC2 Retract Cmpl		
<input type="radio"/> Off	THC2 Cable Install		
<input type="radio"/> Off	THC2 Discrete Error		
<input type="radio"/> Off	THC2 IHS Complete		
<input type="radio"/> Off	CNC System Start		

HD4070 Inputs 1 HD4070 Inputs 2 HD4070 Outputs 1 HD4070 Outputs 2 HD4070 Misc Done

HD4070® Outputs

Similar to the standard Output Diagnostic screen, the HD4070® Input screen shows the current status of the listed supply outputs. Note: Outputs for the HD4070® cannot be activated through the diagnostic screen.

<input type="radio"/> Off	Select 160 Amp	<input type="radio"/> Off	Slave Contactor
<input type="radio"/> Off	Select 80 Amp	<input type="radio"/> Off	Slave DC Output On
<input type="radio"/> Off	Select 40 Amp	<input type="radio"/> Off	Pump Control
<input type="radio"/> Off	Select 20 Amp	<input type="radio"/> Off	Torch #1 Coolant
<input type="radio"/> Off	Select 10 Amp	<input type="radio"/> Off	Torch #2 Coolant
<input type="radio"/> Off	Select 1/10 Current	<input type="radio"/> Off	Spare Output
<input type="radio"/> Off	Fan Control	<input type="radio"/> Off	Transfer 1
<input type="radio"/> Off	Contactor Control	<input type="radio"/> Off	Spare Out 2
<input type="radio"/> Off	DC Output On	<input type="radio"/> Off	Spare Out 14
<input type="radio"/> Off	Slave 160 Amp Sel	<input type="radio"/> Off	Spare Out 15
<input type="radio"/> Off	Slave 80 Amp Sel	<input type="radio"/> Off	Spare Out 16
<input type="radio"/> Off	Slave 40 Amp Sel	<input type="radio"/> Off	Spare Out 17
<input type="radio"/> Off	Slave 20 Amp Sel	<input type="radio"/> Off	Spare Out 7
<input type="radio"/> Off	Slave 10 Amp Sel	<input type="radio"/> Off	Spare Out 8
<input type="radio"/> Off	Slave 1/10 Current	<input type="radio"/> Off	Spare Out 20
<input type="radio"/> Off	Slave Fan Control	<input type="radio"/> Off	Spare Out 21

HD4070 Inputs 1	HD4070 Inputs 2	HD4070 Outputs 1	HD4070 Outputs 2	HD4070 Misc	Done
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Outputs (cont.)

<input type="radio"/> Off	Transfer 2	<input type="radio"/> Off	Gas State 1
<input type="radio"/> Off	Transfer 3	<input type="radio"/> Off	Gas State 2
<input type="radio"/> Off	Select 5 Amp	<input type="radio"/> Off	Gas State 3
<input type="radio"/> Off	Select 2 Amp	<input type="radio"/> Off	Spare Out 19
<input type="radio"/> Off	Watchdog Output	<input type="radio"/> Off	CNC Transfer
<input type="radio"/> Off	Slave 5 Amp Sel	<input type="radio"/> Off	CNC Motion
<input type="radio"/> Off	Slave 2 Amp Sel	<input type="radio"/> Off	THC1 Corner Hold
<input type="radio"/> Off	Cable Check B Out	<input type="radio"/> Off	THC2 Corner Hold
<input type="radio"/> Off	Pilot Arc Relay	<input type="radio"/> Off	CNC Ready to Fire
<input type="radio"/> Off	Surge Injection Sel	<input type="radio"/> Off	CNC Arc Transfer
<input type="radio"/> Off	Spare Out 13	<input type="radio"/> Off	CNC MachineMotion
<input type="radio"/> Off	THC1 Cycle Start	<input type="radio"/> Off	CNC Retract Cmplt
<input type="radio"/> Off	THC2 Cycle Start	<input type="radio"/> Off	CNC Spare Output
<input type="radio"/> Off	Analog6 Check Out	<input type="radio"/> Off	CNC System Error
<input type="radio"/> Off	Cable Check A Out	<input type="radio"/> Off	Serial Select 1
<input type="radio"/> Off	Spare Out 18	<input type="radio"/> Off	Serial Select 2

HD4070 Inputs 1	HD4070 Inputs 2	HD4070 Outputs 1	HD4070 Outputs 2	HD4070 Misc	Done
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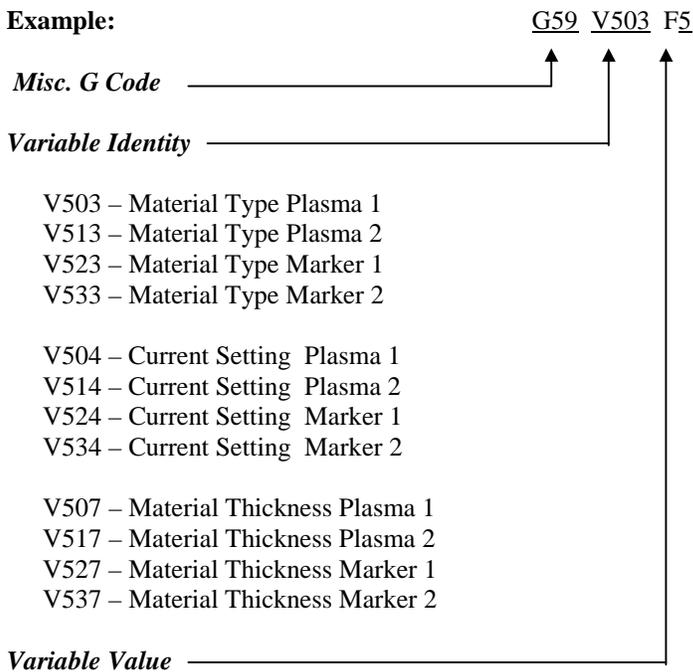
HD4070® Part Program Support

The same Cut Chart data which is used at the Cut Chart setup screen may also be used within a part program to configure the HD4070® for use. This code is used to select the set point for each variable.

It is not necessary to have a line of code for each Cut Chart variable within a part program. Only those variables which are being adjusted in the Cut Chart need be inserted into the part program (e.g. Material Thickness or Material Type).

Part program codes for the HD4070® should be grouped together at the beginning of the program. The three variables which may be set through the part program are Material Type, Current Setting and Material Thickness.

Cut parameters for the HD4070® may be configured using a EIA-274D G59 code with the following format.

Example:

V503 – Material Type Plasma 1
 V513 – Material Type Plasma 2
 V523 – Material Type Marker 1
 V533 – Material Type Marker 2

V504 – Current Setting Plasma 1
 V514 – Current Setting Plasma 2
 V524 – Current Setting Marker 1
 V534 – Current Setting Marker 2

V507 – Material Thickness Plasma 1
 V517 – Material Thickness Plasma 2
 V527 – Material Thickness Marker 1
 V537 – Material Thickness Marker 2

V503, V513, V523, V533 – Material Type

1 = Mild Steel
 2 = Stainless Steel
 3 = Aluminum

V504, V514, V524, 534 – Current Setting

7 = 7A	70 = 70A
10 = 10A	100 = 100A
30 = 30A	200 = 200A
45 = 45A	

Variable Value (continued)

V507 – Material Thickness

1 = None	12 = 10GA	23 = 9/16" & 14mm
2 = 28GA	13 = 1/16" & 1.5mm	24 = 5/8" & 15mm
3 = 27GA	14 = .075" & 2mm	25 = 3/4" & 20mm
4 = 26GA	15 = 3/32" & 2.5mm	26 = 7/8" & 22mm
5 = 24GA	16 = 1/8" & 3mm	27 = 1" & 25mm
6 = 22GA	17 = 3/16" & 5mm	28 = 1 1/8" & 29mm
7 = 20GA	18 = 1/4" & 6mm	29 = 1 1/4" & 32mm
8 = 18GA	19 = 5/16" & 8mm	30 = 1 3/8" & 35mm
9 = 16GA	20 = 3/8" & 10mm	31 = 1 1/2" & 38mm
10 = 14GA	21 = 7/16" & 11mm	32 = 1 3/4" & 44mm
11 = 12GA	22 = 1/2" & 12mm	33 = 2" & 50mm

Notes:

- Please refer to the power supply operator's manual for complete information on the operation and setup of the HD4070[®].
- A serial communications port for the HD4070[®] must first be selected at the Port configuration screen to be enable the feature for use.
- The HD4070[®] Power Supply parameters must first be enabled in password protected Station Configuration Screen to allow the Cut Chart Information for the HD4070[®] to be available for use.
- Power Supplies equipped with the Integrated Command[®] THC may be used with the control setups. The Command[®] THC must first be enabled for use in password protected Station Configuration Screen.

Note: System connections for Cut Output and Arc on feedback will be required.

HD4070[®] Serial Communication Interface**RS-422C Connections to HD4070[®] CNC Interface**

Control (male)		HD4070[®] (male)	
Signal Name	DB-9 Pin	Signal Name	DB-37 Pin
TxD-	2	RxD-	2
RxD-	3	TxD-	1
TxD+	4	RxD+	21
RxD+	7	TxD+	20

Multiple HD4070

The Serial Communication Link supported by the CNC can also be extended to multiple HD4070 power supplies.

This unique feature is implemented through the use of the serial link and I/O points. It is assumed that the all HD4070 systems are configured similarly and will be used simultaneously. If any of the selected power supplies has a fault, the fault must be cleared before the cut can begin.

Specific hardware and software versions for both the control and the power supply are required. Please refer to the HD4070™ Manual for additional information on operation and installation.

Inputs and Outputs**Raise 4070 1-4 And Lower 4070 1-4**

The Raise / Lower 4070 inputs will be used to control the Integrated Command™ THC lifters on multi-dropped HD4070s for the selected process.

Note: When using this feature with the Sensor™ THCs rather than the Integrated Command™ THCs, the Sensor™ THC Torch Raise and Torch Lower commands for the selected process may be made through the software softkeys or through the use of these external inputs to the control.

Cut Sense 1-4

THC Cut Sense Input (arc on feedback) is used to verify that the plasma torch or marker tool has established the arc for the selected torch. This indicates to the control that motion can begin.

Ready to Fire PS 1-4

This signal is an output from each 4070 and is used in multiple plasma systems. It notifies the CNC that the integrated 4070 THC has completed the IHS cycle and Preflow is complete. This indicates that the torch is ready to fire. On the HD4070, this signal is used along with the CNC Plasma Sync Input. The CNC Hold Ignition output is connected to the HD4070 CNC Plasma Sync" inputs. When all configured HD4070s return active "Ready to Fire" signals, the Hold Ignition signals are removed.

Hold Ignition

The Hold Ignition Output is used to delay ignition of the external plasma supply and allow the individual supplies to complete Preflow and IHS before torch ignition. For this application, the Hold Ignition would be tied to the Plasma Sync Inputs for multi-dropped HD4070s.

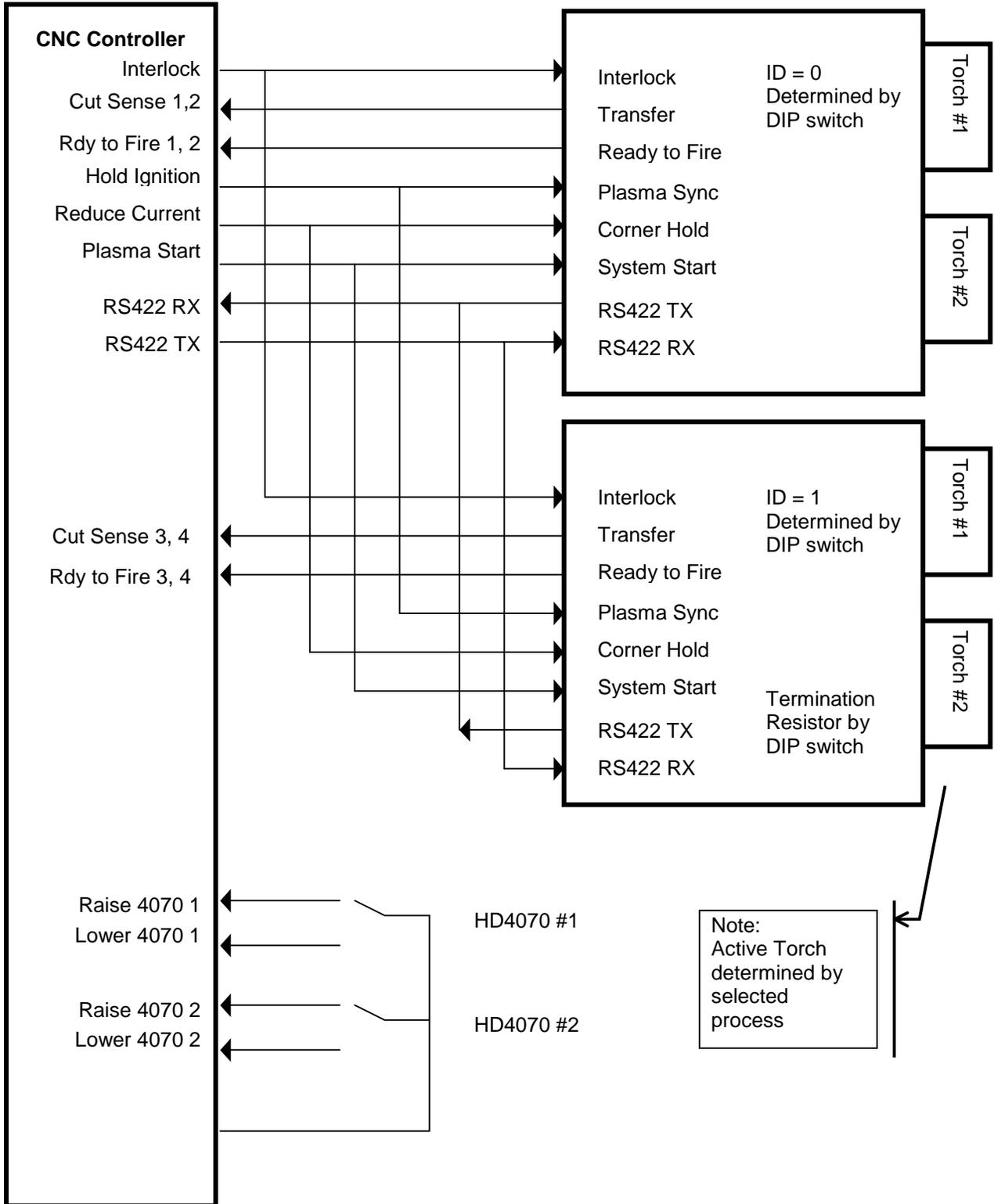
Reduce Current

Used with the HD4070 to switch the plasma to low current mode. This signal is functionally different from the Torch Height Disable Output in that it is not active during the initial torch ignition, pierce, and accelerate to speed after Plasma Start. For this application, the Reduced Current output would be tied to the Corner Hold Inputs for multi-dropped HD4070s.

The Corner Current Parameter located on the Plasma Setup Screen, is a user defined value for setting the percentage of the corner current.

NOTE: Proper mult-drop operation requires a Rev C or higher Breakout board in the 4070 as well as Rev K or higher control software in the 4070.

RS-422 Multidrop Interface to Multiple HD4070s



FineLine® Overview

The “Type V” control offers the additional option of interfacing directly to INNERLOGIC’s FineLine Power Supply for setup via a user selected RS-422 serial port. This advanced feature transmits all necessary power supply settings from the control directly to the FineLine power supply configuring it for use.

The power supply setup is performed through the use of a Cut Chart (cut process parameter database) which is based on eight process variables. The combination of these eight process variables are tied to the settings for the cut process parameters (e.g. arc voltage, pierce delay, etc.) that are transmitted to the supply. For additional convenience, consumable part numbers for the FineLine are displayed at the Change Consumable screen.

This database allows the user to select factory recommended settings or amend the database for personalized settings. The Cut Chart information may be saved or loaded via the hard drive or floppy drive. Specialized Cut Chart files containing the factory recommended settings are available from the control vendor.

The Power Supply parameter must first be enabled in the password protected Station Configuration setups to allow the Cut Chart Information for the feature to be enabled for use. Once selected at the Station Configurations screen, the port must then be selected for communications on the Ports setup screen and the selected port must then be configured as RS-422. For more information on configuration of the port, refer to the Ports information section of this guide.

Station Configuration (example)

The screenshot displays a configuration window for four stations. Each station has five dropdown menus for different parameters. The settings are as follows:

Station	Lifter	Plasma 1	Plasma 2	Marker 1	Marker 2
Station 1	Other	FineLine200	None	Other	None
Station 2	Other	None	Other	None	Other
Station 3	None	None	None	None	None
Station 4	None	None	None	None	None

At the bottom of the window, there are four buttons: "Stations 1 thru 4", "Stations 5 thru 8", "Reset", and "Done".

Additional Features

FineLine Part Program Support

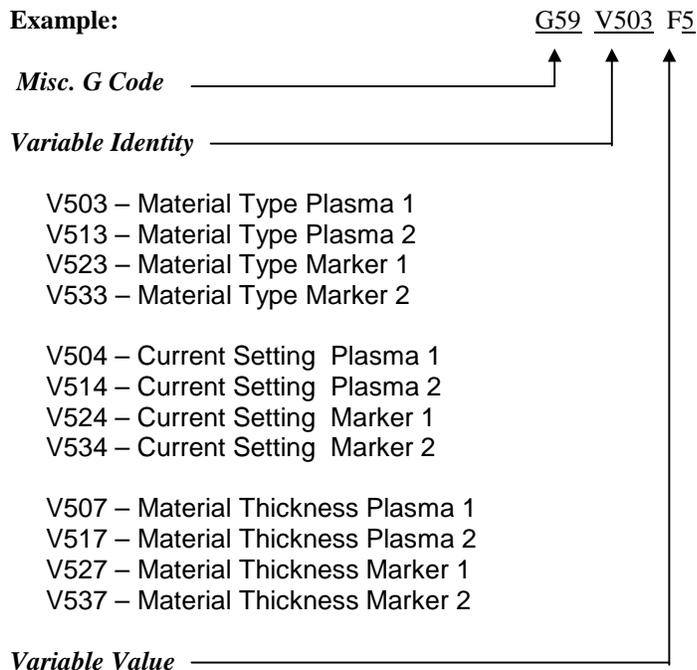
The same Cut Chart data which is used at the Cut Chart setup screen may also be used within a part program to configure the FineLine for use. This code is used to select the set point for each variable.

It is not necessary to have a line of code for each Cut Chart variable within a part program. Only those variables which are changing need be inserted into the part program (e.g. Material Thickness or Material Type).

Part program codes for the FineLine should be grouped together at the beginning of the program. The three variables which may be set through the part program are Material Type, Current Setting and Material Thickness.

Cut parameters for the FineLine may be configured using a EIA-274D G59 code with the following format.

Example:



V503, V513, V523, V533 – Material Type

1 = Mild Steel
 2 = Stainless Steel
 3 = Aluminum

V504, V514, V524, 534 – Current Setting

8 = 8A	50 = 50A
9 = 9A	70 = 70A
10 = 10A	100 = 100A
30 = 30A	200 = 200A

Variable Value (continued)

V506 – Cutting Surface

- 1 = Above Water
- 2 = 3" Below Water
- 3 = Mild Steel Cold Rolled (50 AMP)

V507 – Material Thickness

1 = None	12 = 10GA	23 = 9/16" & 14mm
2 = 28GA	13 = 1/16" & 1.5mm	24 = 5/8" & 15mm
3 = 27GA	14 = .075" & 2mm	25 = 3/4" & 20mm
4 = 26GA	15 = 3/32" & 2.5mm	26 = 7/8" & 22mm
5 = 24GA	16 = 1/8" & 3mm	27 = 1" & 25mm
6 = 22GA	17 = 3/16" & 5mm	28 = 1 1/8" & 29mm
7 = 20GA	18 = 1/4" & 6mm	29 = 1 1/4" & 32mm
8 = 18GA	19 = 5/16" & 8mm	30 = 1 3/8" & 35mm
9 = 16GA	20 = 3/8" & 10mm	31 = 1 1/2" & 38mm
10 = 14GA	21 = 7/16" & 11mm	32 = 1 3/4" & 44mm
11 = 12GA	22 = 1/2" & 12mm	33 = 2" & 50mm

Notes:

- Please refer to the power supply operators manual for complete information on the operation and setup of the FineLine Power Supply.
- The FineLine Power Supply parameters must first be enabled in the password protected Station Configuration Screen to allow the Cut Chart Information for the FineLine to be available for use.
- Serial communications for the FineLine Power supply are established on the user selected communication port. The port must be configured for RS-422 operation.

Automatic Torch Spacing

The Automatic Torch Spacing feature uses codes within the part program, and designated outputs, to perform precise positioning of individual torch stations for multi-torch cutting processes.

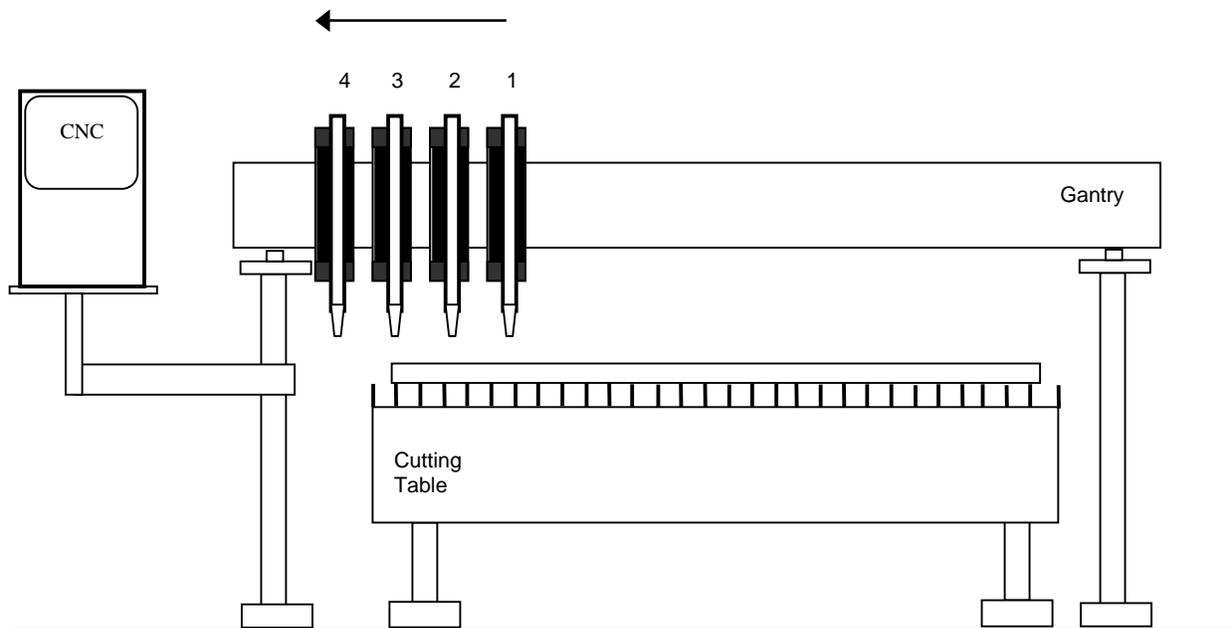
This Feature must be enabled in Machine Setups for use. The Auto Torch Spacing Override feature in Cutting Setups must also be enabled.

In this process, the master torch station has a fixed mount to the transverse axis and the other slave torch stations have the ability to clamp to the mechanics of the transverse axis during use or lock to the gantry or beam when not in use.

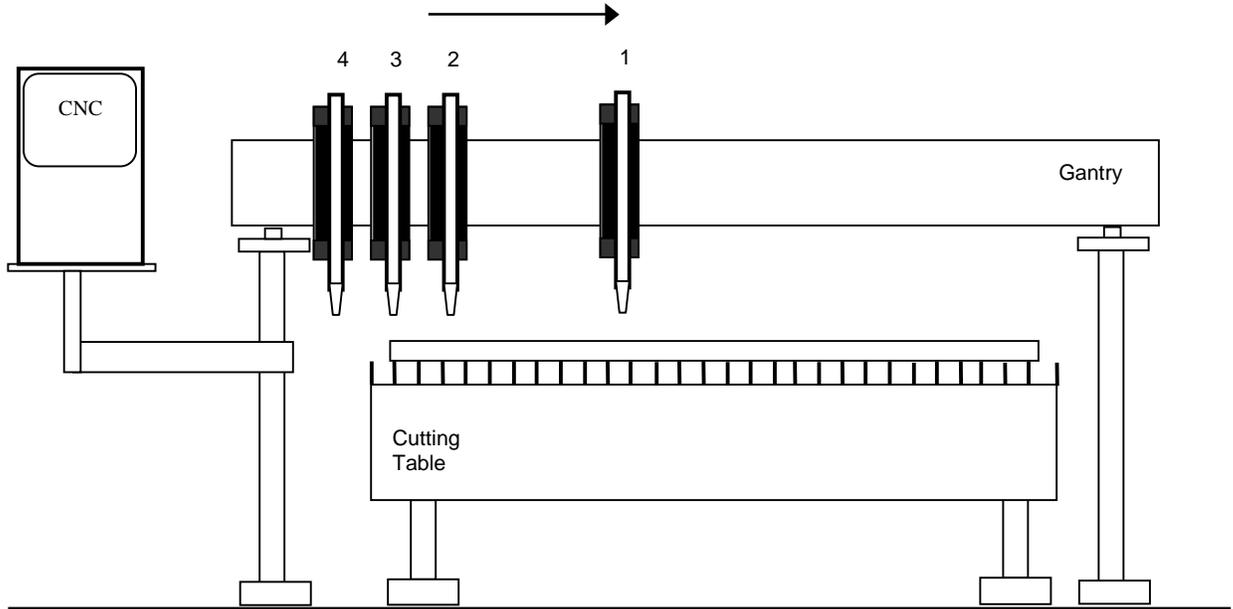
For the example, below Torch 1 is the master station and Torch 2-4 are the slave stations.

Typical use is as follows:

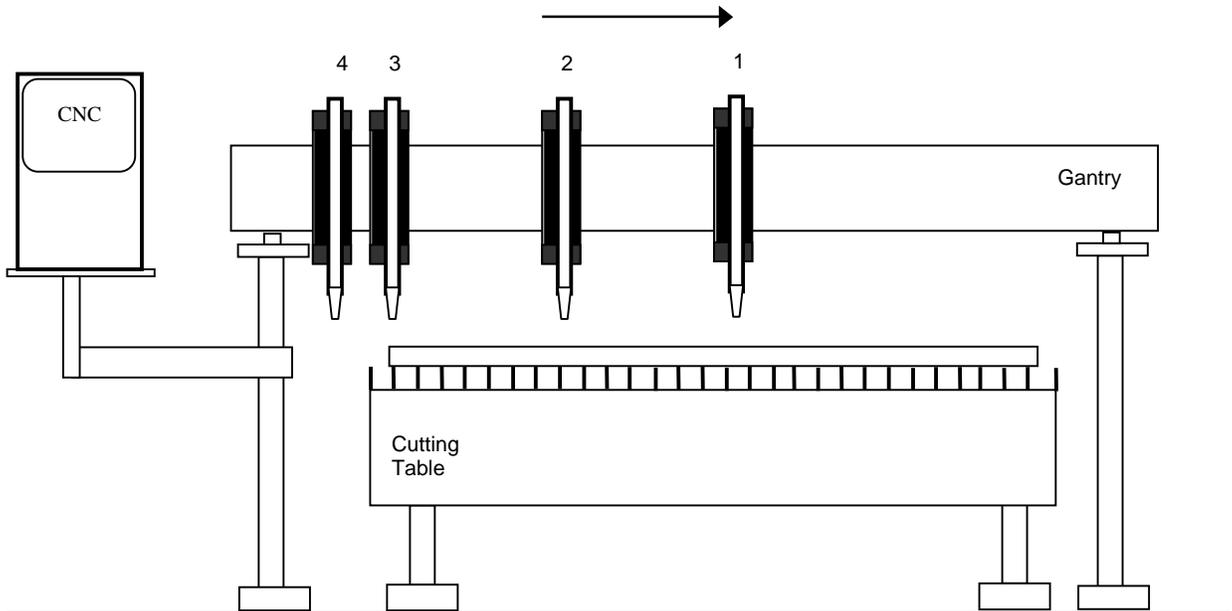
- 1) Unclamp and Unlock all stations (except the first which is fixed and slides the others)
- 2) Go to Home Command on Transverse Axis (M77 or M78 depending on orientation)



- 3) Clamp and Unlock all carriages and G00 index inward on transverse (optional command - may used to space all stations away from edge / OT switch of machine)
- 4) Lock and Unclamp all and G00 index to space first station (remember-first station has no clamping/locking on board)



- 5) Unlock and Clamp next station and G00 index to space next station.



- 6) Repeat 5 above until as many stations as needed are spaced.

Note: Homing will also automatically include the commands necessary to push the stations to the side and lock / clamp them whenever the transverse is homed, if Auto Torch Spacing is enabled. Unclamp/ Clamp and Unlock / lock commands execute a one second delay before moving.

Automatic Torch Spacing Program Codes

Code	Description
M32	Unclamp / Unlock All Stations
M33	Unclamp / Lock All Stations
M34	Clamp / Unlock All Stations
M34T <i>value</i>	Clamp / Unlock "T" Station, where T = 1 through 19
M35	Clamp / Unlock All Stations Mirror
M35T <i>value</i>	Clamp / Unlock Mirror "T" Station, where T = 1 through 19
M77	Go to Home position Y Axis
M78	Go to Home position X Axis
G00 Xn Yn	Traverse command where n = value to move the desired axes a distance.

Automatic Torch Spacing I/O

Station Lock 1-19	The Station lock is used to Lock the unused torch station to the gantry or beam when not in use.
Station Clamp 1-19	The Station Clamp is used to Clamp the selected torch station to the transverse axis for standard cutting.
Station Mirror 1-19	Station Clamp is used to Clamp the selected torch station to the transverse axis for mirrored cutting.

Example Part Program

Transverse axis defined as X axis
Three station cut of 20 inch vertical rip.

Code	Description
G70	English Units
G91	Incremental Mode
G99 X1 Y0 I0 J0	Axes Preset zero Scaling
M32	Unclamp / Unlock All Stations
M78	Home X Axis (move all stations to Home position)
M34	Clamp All / Unlock All
G00X2Y0	Traverse X axis 2 inches (to move off edge/ switch)
M33	Unclamp All / Lock All
G00X10Y0	Traverse X axis 10 inches (to set 10 inch space – station 1)
M34 T1	Clamp Station 1 / Unlock Station 1
G00X10Y0	Traverse X axis 10 inches (to set 10 inch space– station 2)
M34 T2	Clamp Station 2 / Unlock Station 2
G41	Left Kerf
M07	Cut On
G01 X0 Y20	Line segment (Y axis 20 inches)
M08	Cut Off
G40	Kerf Off
M02	End of Program

Appendix B: Program Codes

EIA RS-274D

The control supports EIA RS-274D part programs. An EIA RS-274D program lists the sequence of Lines, Arcs, Speeds, Kerf and I/O functions used to create a part. While the user is free to program in EIA using the standard text editor, it is recommended that the *ShapeWizard*[®] Graphical Programming environment be used instead.

Following is a list of the EIA codes that are directly supported, mapped, or currently unsupported by the control. Mapped EIA codes are automatically converted upon program load into directly supported EIA codes. Unsupported EIA codes are ignored. All other EIA codes will generate an error.

Directly Supported EIA Codes

EIA CODE	DESCRIPTION
<i>Fvalue</i>	Machine Speed (if Speed Override enabled)
<i>Nvalue</i>	Line Number
(<i>text</i>)	Comments
<i>Xvalue</i>	X Axis Endpoint or other Data
<i>Yvalue</i>	Y Axis Endpoint or other Data
<i>Ivalue</i>	I Axis Integrand or Part Option Data
<i>Jvalue</i>	J Axis Integrand or Part Option Data
<i>Ovalue Svalue</i>	Output (1-64), State (0-Off or 1-On)
<i>Wvalue Svalue</i>	Wait for Input (1-64), State (0-Off or 1-On)
G00	Rapid Traverse Linear Interpolation
G00 <i>Avalue</i>	Sets Tilt angle – A is the angle value in degrees
G00 <i>Avalue Fvalue</i>	Sets Tilt angle – Angle value in degrees with a speed command in RPM
G00 Xn Yn	Traverse command where n = value to move the desired axes a distance.
G01	Linear Interpolation (at Cut Speed)
G02	Clockwise Circular Interpolation
G03	Counterclockwise Circular Interpolation
G04	Preset Dwell (uses Setup Dwell Time)
G04 <i>Xvalue</i>	Program Dwell in Seconds
G08 <i>Xvalue</i>	Repeat Subroutine X Times
G20	Select English Units (inches)
G21	Select Metric Units (mm)
G40	Disable Kerf Compensation
G41	Enable Left Kerf Compensation
G42	Enable Right Kerf Compensation
G43 <i>Xvalue</i>	Kerf Value
G41 D1-200	Enables Left Kerf using a Kerf Table variable
G42 D1-200	Enables Right Kerf using a Kerf Table variable
G43 D1-200	Sets the current Kerf value via the Kerf Table using prior set Left or Right Kerf
G59 D1-200Xvalue	Sets Kerf table variable from 1-200

EIA CODE	DESCRIPTION
G59 <i>Vvalue Fvalue</i>	Sets the Plasma Supply current through Outputs or Serial Link (HD4070®) for Vprocess (504,514,524,534) at Fcurrent value V504 – Current Setting Plasma 1 V514 – Current Setting Plasma 2 V524 – Current Setting Marker 1 V534 – Current Setting Marker 2
G82	Oxy-Fuel Cut Mode
G83	Oxy-Fuel Cut Mode Contour Bevel Head
G84	Plasma Cut Mode
G85	Plasma Cut Mode Contour Bevel Head
G90	Absolute Programming Mode
G91	Incremental Programming Mode
G92	Set Axis Presets
G97	Program Repeat Pointer
G97 <i>Tvalue</i>	Program Repeat Pointer. Executes the repeat T times
G98	Repeat at G97, or start of program if no G97
G99	Part Options
M00	Program Stop
M01	Optional Program Stop (uses Setup Parameter)
M02	End of Program
M07	Cutting Device On
M08	Cutting Device Off
M09	Enable Marker 1
M10	Disable Marker 1
M11	Marker Offset 1 On
M12	Marker Offset 1 Off
M13	Enable Marker 2
M14	Disable Marker 2
M15	Cut On
M16	Cut Off
M17	Oxy Gas On
M18	Oxy Gas Off
M19	Cancel All Stations
M26	Station Select On
M27	Station Select Off
M28	CBH / Rotator Disable
M29	CBH Rotator Enable
M30	End of Program (same as M02)
M31	Reset Functions (Cut Off, Marker Off, Kerf Off)
M32	Unclamp / Unlock All Stations
M33	Unclamp / Lock All Stations
M34	Clamp / Unlock All Stations
M34 <i>Tvalue</i>	Clamp / Unlock 'T' Station, where T = 1 through 19
M35	Clamp / Unlock All Stations Mirror
M35 <i>Tvalue</i>	Clamp / Unlock Mirror 'T' Station, where T = 1 through 19
M36 <i>Tvalue</i>	Process Select 'T' where T value selects the process 1- Plasma 1 2- Plasma 2 3- Marker 1 4- Marker 2 5- Laser
M37 <i>Tvalue (1-20)</i>	Select Station 'T' where T = 1 through 20

EIA CODE	DESCRIPTION
M38 <i>Tvalue</i> (1-20)	Deselect Station "T" where T = 1 through 20
M40	Start of Subroutine
M40 <i>Xvalue</i>	Start of Subroutine. Executes the repeat X times
M41	End of Subroutine
M50	Height Sensor Disable
M51	Height Sensor Enable
M52	Height Sensor Disable and Raise Torch
M53	Height Sensor Enable and Lower Torch
M65	End of Program (same as M02)
M72	Marker Offset 2 Off
M73	Marker Offset 2 On
M75	A Axis/Tilt Go to Home Command - Rapid Index
M76	C Axis/Rotate Go to Home Command - Rapid Index
M77	Go to Home position Y Axis
M78	Go to Home position X Axis
M79 <i>Tvalue</i> (1-4)	Go To Home Position (1-4)
M90	Aligns CBH / Rotator to Tangent angle of next cut segment
M274	Marker Offset 3 Off
M275	Marker Offset 3 On
M276	Marker Offset 4 Off
M277	Marker Offset 4 On
M278	Marker Offset 5 Off
M279	Marker Offset 5 On
M280	Marker Offset 6 Off
M281	Marker Offset 6 On
M282	Marker Offset 7 Off
M283	Marker Offset 7 On
M284	Marker Offset 8 Off
M285	Marker Offset 8 On
M286	Marker Offset 9 Off
M287	Marker Offset 9 On
M288	Marker Offset 10 Off
M289	Marker Offset 10 On
M290	Marker Offset 11 Off
M291	Marker Offset 11 On
M292	Marker Offset 12 On
M293	Marker Offset 12 On

Mapped EIA Codes

EIA CODE	DESCRIPTION	MAPPED TO
G04 <i>Fvalue</i>	Program Dwell	G04 <i>Xvalue</i>
G05	Set Axis Presets	G92
G21	Linear Interpolation (at cut speed)	G01
G22	CW Circular Interpolation	G02
G23	CCW Circular Interpolation	G03
G41 <i>Kvalue</i>	Left Kerf with Value	G41 with Kerf Value
G42 <i>Kvalue</i>	Right Kerf with Value	G42 with Kerf Value
G97 <i>TValue</i>	Subroutine Loop	G08 <i>Xvalue</i> and M40

EIA CODE	DESCRIPTION	MAPPED TO
G45	Lead In to Kerfed Part	G01, G02, or G03
G70	Select English Units	G20
G71	Select Metric Units	G21
G98	End of Subroutine Loop	M41
M03	Cutting Device On/Off	M07 (Oxy Fuel) or M08 as appropriate
M04	Cutting Device On	M07
M05	Cutting Device Off	M08 (Oxy Fuel)
M06	Cutting Device Off	M08
M06	Enable Marker 2	M13
M07	Disable Marker 1 or 2	M10 or M14 as appropriate
M08	Enable Marker 1	M09
M09	Disable Marker 1 or 2	M10 or M14 as appropriate
M10	Enable Marker 2	M13
M14	Height Sensor Disable	M50
M15	Height Sensor Enable	M51
M20	Cutting Device On/Off	M07 or M08 as appropriate (Plasma)
M21	Cutting Device On/Off	M07 or M08 as appropriate (Plasma)
M20	Output 9 On	O9 S1
M21	Output 9 Off	O9 S0
M22	Output 12 On	O12 S1
M23	Output 12 Off	O12 S0
M24	Wait for Input 7 On	W7 S1
M25	Wait for Input 8 On	W8 S1
M25	CBH Enable	M29
M26	Wait for Input 7 Off	W7 S0
M26	CBH Disable	M28
M27	Wait for Input 8 Off	W8 S0
M67, M02	Kerf Left	G41
M68, M03	Kerf Right	G42
M69, M04	Kerf Off	G40
M65, M70	Cutting Device On	M07
M66, M71, M73	Cutting Device Off	M08
M70	Marker Offset 1 Off	M12
M71	Marker Offset 1 On	M11
M70T01	Marker Offset 1 Off	M12
M71T01	Marker Offset 1 On	M11
M70T02	Marker Offset 2 Off	M72
M71T02	Marker Offset 2 On	M73
M70T03	Marker Offset 3 Off	M274
M71T03	Marker Offset 3 On	M275
M70T04	Marker Offset 4 Off	M276
M71T04	Marker Offset 4 On	M277
M70T05	Marker Offset 5 Off	M278
M71T05	Marker Offset 5 On	M279
M70T06	Marker Offset 6 Off	M280
M71T06	Marker Offset 6 On	M281
M70T07	Marker Offset 7 Off	M282
M71T07	Marker Offset 7 On	M283
M70T08	Marker Offset 8 Off	M284
M71T08	Marker Offset 8 On	M285
M98	End Comment)

EIA CODE	DESCRIPTION	MAPPED TO
M99	Start Comment	(
M221	No Mirror, No Rotate	G99 X1 Y0 I0 J0
M222	Mirror Y, No Rotate	G99 X1 Y0 I0 J1
M223	Mirror X and Y	G99 X1 Y0 I1 J1
M224	Mirror X, No Rotate	G99 X1 Y0 I1 J0
M225	Mirror X/Y on -45 Deg	G99 X1 Y270 I1 J0
M226	Rotate 90 Deg CCW	G99 X1 Y90 I0 J0
M227	Mirror X/Y on +45 Deg	G99 X1 Y270 I0 J1
M228	Rotate 90 Deg CW	G99 X1 Y270 I0 J0
M245	Output 1 On	O1 S1
M246	Output 1 Off	O1 S0
M247	Output 2 On	O2 S1
M248	Output 2 Off	O2 S0
M249	Output 3 On	O3 S1
M250	Output 3 Off	O3 S0
M251	Output 4 On	O4 S1
M252	Output 4 Off	O4 S0
M253	Wait for Input 1 On	W1 S1
M254	Wait for Input 1 Off	W1 S0
M255	Wait for Input 2 On	W2 S1
M256	Wait for Input 2 Off	W2 S0
M257	Wait for Input 3 On	W3 S1
M258	Wait for Input 3 Off	W3 S0
M259	Wait for Input 4 On	W4 S1
M260	Wait for Input 4 Off	W4 S0

Unsupported EIA Codes

EIA CODE	DESCRIPTION
G46	Table 0 Select
G99	Freestanding G99
G103 <i>Qname</i>	Stop Current Program/ Load New Program
G201	Incremental Line In2
G202	Incremental CW Arc In2
G203	Incremental CCW Arc In2
G211	Incremental Line In3
G212	Incremental CW Arc In3
G213	Incremental CCW Arc In3
G221	Absolute Line In2
G222	Absolute CW Arc In2
G223	Absolute CCW Arc In2
G231	Absolute Line In3
G232	Absolute CW Arc In3
G233	Absolute CCW Arc In3
G240	Programmable Kerf
G247	Table 1 Select
G248	Table 2 Select
G249	Table 3 Select
G250	Table 4 Select
G276	Internal Variable Load

Unsupported EIA Codes (cont.)

EIA CODE	DESCRIPTION
G277	External Variable Load
G278	X Axis Home
G279	Y Axis Home
G280	X Home Return
G281	Y Home Return
M22	PLC Control Code
M75	PLC Control Code
M210	X Sign Toggle
M211	Y Sign Toggle
M212	X and Y Swap and Toggle
M231	Aux. State Reset
M261	Aux. Torch Master On
M262	Aux. Torch Master Off

The unsupported EIA codes previously noted are ignored when read. Some of these codes may be supported in the future. Any EIA codes that are not listed above will result in a translator error upon loading the EIA program. Known EIA codes that will not be accepted include, but are not limited to:

<i>Pvalue</i>	Program Number
<i>Dvalue</i>	Indexed Kerf Operations
<i>Vvalue</i>	Internal Variable Load

EIA Comments

Comments may be placed into the part program to be displayed on screen and viewed by the operator. The comment line must first be preceded by a program stop command (EIA M00 code or ESSI 0 code).

EIA Example:

M00 – Pauses Program
(Comment) – Text to be displayed

ESSI

The control supports ESSI part programs as defined by the International Standards Organization in ISO 6582. An ESSI program lists the sequence of Lines, Arcs, Speeds, Kerf and I/O Functions used to create a part. While the user is free to program in ESSI using a standard text editor, it is recommended that the *ShapeWizard*[®] Graphical Programming environment be used instead.

While the user is free to download ESSI programs to the control, it is important to note that all Part Programs will be internally converted to EIA for execution in the control. Following is a list of the ESSI codes that are mapped into the control, or currently unsupported by the control. Mapped ESSI codes are automatically converted upon program load into directly supported EIA codes. Unsupported ESSI codes are ignored. All other ESSI codes will generate an error.

Mapped ESSI Codes

ESSI CODE	DESCRIPTION	MAPPED TO EIA
%	Start of Program	Not Used-Automatic
+/-value...	Line or Arc	G00, G01, G02 or G03 as appropriate
0	End Program or Stop	M02 or M00 (if 64 is End Program)
3	Start Comment	(
4	End Comment)
5	Enable Rapid Traverse	Not Used-Automatic
6	Disable Rapid Traverse	Not Used-Automatic
7	Cutting Device On	M07
8	Cutting Device Off	M08
9	Enable Marker 1	M09
10	Disable Marker 1	M10
11	Marker Offset 1 On	M11
12	Marker Offset 1 Off	M12
11+1	Marker Offset 1 On	M11
12+1	Marker Offset 1 Off	M12
11+2	Marker Offset 2 On	M73
12+2	Marker Offset 2 Off	M72
11+3	Marker Offset 3 On	M275
12+3	Marker Offset 3 Off	M274
11+4	Marker Offset 4 On	M277
12+4	Marker Offset 4 Off	M276
11+5	Marker Offset 5 On	M279
12+5	Marker Offset 5 Off	M278
11+6	Marker Offset 6 On	M281
12+6	Marker Offset 6 Off	M280

ESSI CODE	DESCRIPTION	MAPPED TO EIA
11+7	Marker Offset 7 On	M283
12+7	Marker Offset 7 Off	M282
11+8	Marker Offset 8 On	M285
12+8	Marker Offset 8 Off	M284
13	Enable Marker 2	M13
14	Disable Marker 2	M14
15	Marker Offset 2 On	M73
16	Marker Offset 2 Off	M72
21	No Mirror, No Rotate	G99 X1 Y0 I0 J0
22	Mirror Y, No Rotate	G99 X1 Y0 I0 J1
23	Mirror X and Y	G99 X1 Y0 I1 J1
24	Mirror X, No Rotate	G99 X1 Y0 I1 J0
25	Mirror X/Y on -45 Deg	G99 X1 Y270 I1 J0
26	Rotate 90 Deg CCW	G99 X1 Y90 I0 J0
27	Mirror X/Y on +45 Deg	G99 X1 Y270 I0 J1
28	Rotate 90 Deg CW	G99 X1 Y270 I0 J0
29	Enable Left Kerf Comp	G41
30	Enable Right Kerf Comp	G42
38	Disable Kerf	G40
39+ <i>value</i>	Machine Speed	<i>Fvalue</i>
40+ <i>value</i>	Programmable Kerf	G43 <i>Xvalue</i>
41	Preset Dwell	G04
41+ <i>value</i>	Program Dwell in mSec	G04 <i>Xvalue</i>
45	Ht Sensor Enable/Lower	M53
46	Ht Sensor Disable/Raise	M52
47	Ht Sensor Enable	M51
48	Ht Sensor Disable	M50
51	CBH Enable	M29
52	CBH Disable	M28
53	Cutting Device On	M07
54	Cutting Device Off	M08
63	Reset Functions	M31
64	End Program	M02
65	End of Program/ Reload	M65
67	Ht Sensor Disable	M50
68	Ht Sensor Enable	M51
70	Select English Units (in)	G20
71	Select Metric Units (mm)	G21
79+1	Go To Home Position 1	M79 T1
79+2	Go To Home Position 2	M79 T2
79+3	Go To Home Position 3	M79 T3
79+4	Go To Home Position 4	M79 T4
81	Incremental Mode	G91
82	Absolute Mode	G90
83	Set Axis Presets	G92
90	End of Program	M02
97	Program Repeat Pointer	G97
97+ <i>value</i>	Subroutine Loop	M40 <i>Xvalue</i>
98	Repeat at 97, Subroutine loop or start of program if no 97	G97, G98 or M41 as appropriate
99	End of Program	M02

ESSI CODE	DESCRIPTION	MAPPED TO EIA
245	Output 1 On	O1 S1
246	Output 1 Off	O1 S0
247	Output 2 On	O2 S1
248	Output 2 Off	O2 S0
249	Output 3 On	O3 S1
250	Output 3 Off	O3 S0
251	Output 4 On	O4 S1
252	Output 4 Off	O4 S0
253	Wait for Input 1 On	W1 S1
254	Wait for Input 1 Off	W1 S0
255	Wait for Input 2 On	W2 S1
256	Wait for Input 2 Off	W2 S0
257	Wait for Input 3 On	W3 S1
258	Wait for Input 3 Off	W3 S0
259	Wait for Input 4 On	W4 S1
260	Wait for Input 4 Off	W4 S0
282	Marker Offset 3 On	M275
283	Marker Offset 3 Off	M274
284	Marker Offset 4 On	M277
285	Marker Offset 4 Off	M276
286	Marker Offset 5 On	M279
287	Marker Offset 5 Off	M278
288	Marker Offset 6 On	M281
289	Marker Offset 6 Off	M280
290	Marker Offset 7 On	M283
291	Marker Offset 7 Off	M282
292	Marker Offset 8 On	M285
293	Marker Offset 8 Off	M284

Unsupported ESSI Codes

ESSI CODE	DESCRIPTION
103+Name	Stop Current Program/ Load New Program
237	X Sign Toggle
238	Y Sign Toggle
239	X and Y Swap and Toggle
266	Table 1 Select
267	Table 2 Select
268	Table 3 Select
269	Table 4 Select
276	Internal Variable Load
277	External Variable Load
278	X Axis Home
279	Y Axis Home
280	X Home Return
281	Y Home Return

The unsupported ESSI codes above are ignored when read. Some of these codes may be supported in the future. Any ESSI codes that are not listed above will result in a translator error upon loading the ESSI program.

ESSI Comments

Comments may be placed in to the part program to be displayed on screen and viewed by the operator. The comment line must first be preceded by a program stop command (EIA M00 code or ESSI 0 code).

ESSI Example:

```

0 – Pauses Program
3 – Start Comment
Comment – Text to be displayed
4 – End Comment

```

Unique Feature Codes**Kerf Table**

Code	Description
G59 D1-200Xvalue	Sets kerf table variable from 1-200
G41 D1-200	Enables Left Kerf using a Kerf Table variable
G42 D1-200	Enables Right Kerf using a Kerf Table variable
G43 D1-200	Changes current kerf value via Kerf Table using previously set Left or Right kerf

Tilt / Rotator Part Codes

Code	Description
G00 <i>A value</i>	Sets Tilt angle as a preparatory command – A is the angle value in degrees
M28	Disables Follower
M29	Enables Follower
M90	Preparatory Cmd - Aligns Rotator to Tangent angle of next cut segment
M75	A axis/Tilt Goto Home Cmd - Rapid Index

Automatic Torch Spacing Program Codes

Code	Description
M32	Unclamp / Unlock All Stations
M33	Unclamp / Lock All Stations
M34	Clamp / Unlock All Stations
M34T <i>value</i>	Clamp / Unlock "T" Station, where T = 1 through 19
M35	Clamp / Unlock All Stations Mirror
M35T <i>value</i>	Clamp / Unlock Mirror "T" Station, where T = 1 through 19
M77	Go to Home position Y Axis
M78	Go to Home position X Axis

Station Selects

Stations (Lifter / THCs) may be selected / de-selected using a EIA-274D program code with the following format.

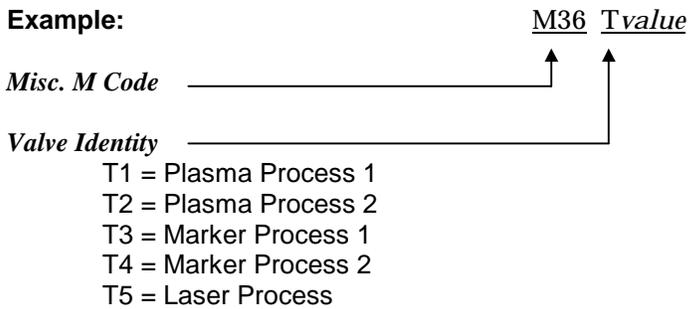
Code	Description
M19 Tvalue	Cancel All Station Selections
M37 Tvalue	Select Station 1-20 (Tvalue)
M38 Tvalue	De-Select Station 1-20 (Tvalue)

Additionally, these Station Select program codes may be overridden using the user selected THC inputs to the control. The feature to override the part program must be enabled at the Cutting Setup screen.

Process Selects

Process Selections may be selected using a EIA-274D program code with the following format.

Example:



Station Configuration Variables

The following options are available for the station configuration

Lifter

- None
- Sensor THC
- Command THC (w/ Serial Link)
- HD4070 Integrated THC 1 or 2 (used only with the HD4070® power supply)
- Other (any stand alone Lifter Station)

Power Supplies

- None
- Max100/ 100D
- Max200
- HT2000
- HD3070
- HD4070 Torch 1or 2
- HT4001
- HT4100
- HT4400
- Other (any other Plasma system)

Marker

- None
- HD4070 Torch 1or 2
- ArcWriter
- Other (any stand alone Marker)

HD3070[®] Auto Gas Overview

The Interface to the HD3070[®] Auto Gas console is made through of Single Ended and BCD (Binary Coded Decimal) inputs. The BCD style of interface allows for exact settings by use of multiple inputs being active at any time. The active BCD input values are summed together to obtain the exact set point.

These I/O points are wired in the same fashion as our other Single Ended I/O points. The following I/O points are supplied for use of the HD3070[®] Auto Gas Console

Inputs

Gas Control Read Complete
Gas Control Error

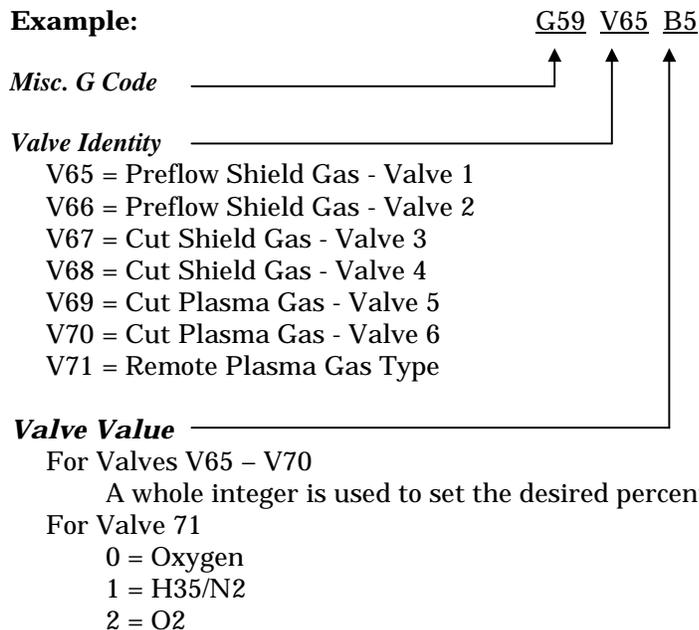
Outputs

Gas Control Write	Remote Test Operate
Remote Test Preflow	Remote Air Plasma
Remote H35/ N2 Plasma	Remote O2 Plasma
Gas Flow Set 1-100 (BCD)	Valve Select 1-8 (BCD)

HD3070[®] Part Program Support

The same valve setting data which is used at the Auto Gas setup screen may also be used within a part program to configure the HD3070[®] for use. This code is used to select the valve and indicate the valve set point.

Using a EIA-274D G59 code with the following format.



For the example given, the part program code (G59 V65 B5) would set the Autogas Preflow Shield Gas valve to 5%. Multiple G59 codes can be used to set and adjust the all desired valves.

HD4070[®] Part Program Support

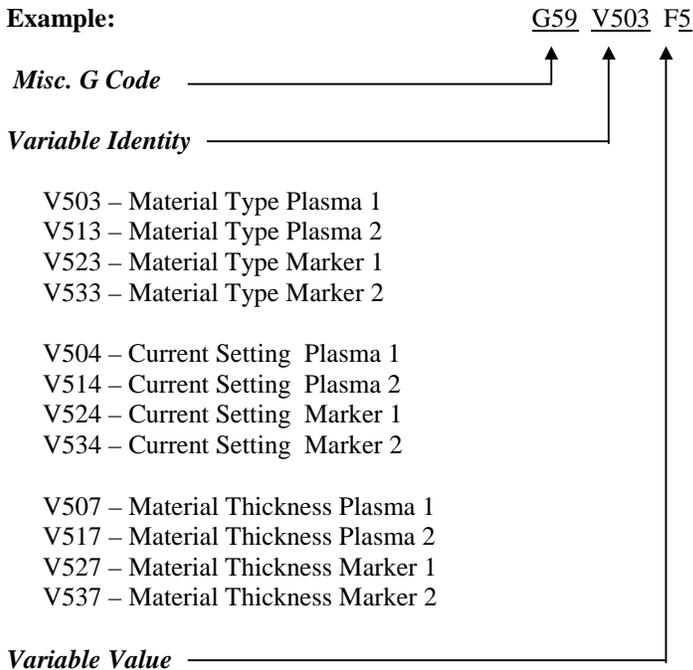
The same Cut Chart data which is used at the Cut Chart setup screen may also be used within a part program to configure the HD4070[®] for use. This code is used to select the set point for each variable.

It is not necessary to have a line of code for each Cut Chart variable within a part program. Only those variables which are changing need be inserted into the part program (e.g. Material Thickness or Material Type).

Part program codes for the HD4070[®] should be grouped together at the beginning of the program. The three variables which may be set through the part program are Material Type, Current Setting and Material Thickness.

Cut parameters for the HD4070[®] may be configured using a EIA-274D G59 code with the following format.

Example:



- V503 – Material Type Plasma 1
- V513 – Material Type Plasma 2
- V523 – Material Type Marker 1
- V533 – Material Type Marker 2

- V504 – Current Setting Plasma 1
- V514 – Current Setting Plasma 2
- V524 – Current Setting Marker 1
- V534 – Current Setting Marker 2

- V507 – Material Thickness Plasma 1
- V517 – Material Thickness Plasma 2
- V527 – Material Thickness Marker 1
- V537 – Material Thickness Marker 2

Variable Value

V503, V513, V523, V533 – Material Type

- 1 = Mild Steel
- 2 = Stainless Steel
- 3 = Aluminum

V504, V514, V524, 534 – Current Setting

- 7 = 7A
- 10 = 10A
- 30 = 30A
- 45 = 45A
- 70 = 70A
- 100 = 100A
- 200 = 200A

Variable Value (continued)

V507, 517, 527, 537 – Material Thickness

1 = None	12 = 10GA	23 = 9/16" & 14mm
2 = 28GA	13 = 1/16" & 1.5mm	24 = 5/8" & 15mm
3 = 27GA	14 = .075" & 2mm	25 = 3/4" & 20mm
4 = 26GA	15 = 3/32" & 2.5mm	26 = 7/8" & 22mm
5 = 24GA	16 = 1/8" & 3mm	27 = 1" & 25mm
6 = 22GA	17 = 3/16" & 5mm	28 = 1 1/8" & 29mm
7 = 20GA	18 = 1/4" & 6mm	29 = 1 1/4" & 32mm
8 = 18GA	19 = 5/16" & 8mm	30 = 1 3/8" & 35mm
9 = 16GA	20 = 3/8" & 10mm	31 = 1 1/2" & 38mm
10 = 14GA	21 = 7/16" & 11mm	32 = 1 3/4" & 44mm
11 = 12GA	22 = 1/2" & 12mm	33 = 2" & 50mm

FineLine Part Program Support

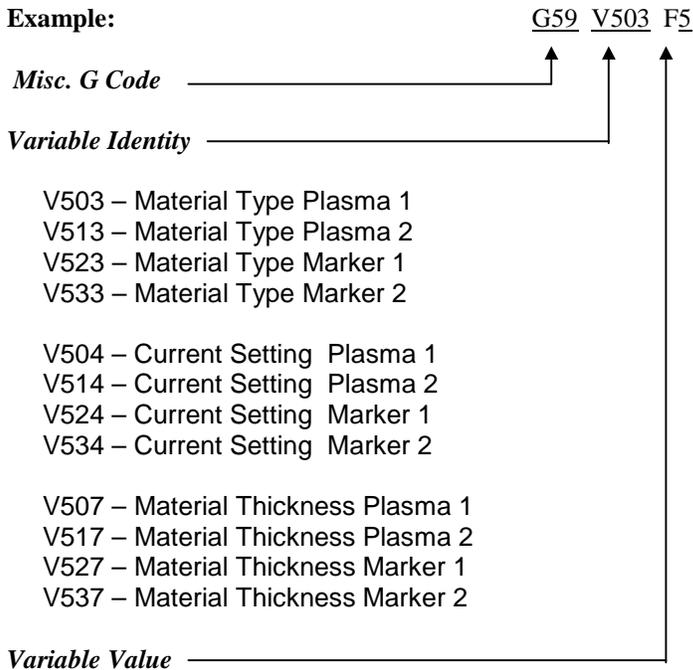
The same Cut Chart data which is used at the Cut Chart setup screen may also be used within a part program to configure the FineLine for use. This code is used to select the set point for each variable.

It is not necessary to have a line of code for each Cut Chart variable within a part program. Only those variables which are changing need be inserted into the part program (e.g. Material Thickness or Material Type).

Part program codes for the FineLine should be grouped together at the beginning of the program. The three variables which may be set through the part program are Material Type, Current Setting and Material Thickness.

Cut parameters for the FineLine may be configured using a EIA-274D G59 code with the following format.

Example:



- V503 – Material Type Plasma 1
- V513 – Material Type Plasma 2
- V523 – Material Type Marker 1
- V533 – Material Type Marker 2

- V504 – Current Setting Plasma 1
- V514 – Current Setting Plasma 2
- V524 – Current Setting Marker 1
- V534 – Current Setting Marker 2

- V507 – Material Thickness Plasma 1
- V517 – Material Thickness Plasma 2
- V527 – Material Thickness Marker 1
- V537 – Material Thickness Marker 2

V503, V513, V523, V533 – Material Type

- 1 = Mild Steel
- 2 = Stainless Steel
- 3 = Aluminum

V504, V514, V524, 534 – Current Setting

- | | |
|----------|------------|
| 8 = 8A | 50 = 50A |
| 9 = 9A | 70 = 70A |
| 10 = 10A | 100 = 100A |
| 30 = 30A | 200 = 200A |

Variable Value (continued)

V506 – Cutting Surface

- 1 = Above Water
- 2 = 3" Below Water
- 3 = Mild Steel Cold Rolled (50 AMP)

V507 – Material Thickness

- | | | |
|-----------|--------------------|--------------------|
| 1 = None | 12 = 10GA | 23 = 9/16" & 14mm |
| 2 = 28GA | 13 = 1/16" & 1.5mm | 24 = 5/8" & 15mm |
| 3 = 27GA | 14 = .075" & 2mm | 25 = 3/4" & 20mm |
| 4 = 26GA | 15 = 3/32" & 2.5mm | 26 = 7/8" & 22mm |
| 5 = 24GA | 16 = 1/8" & 3mm | 27 = 1" & 25mm |
| 6 = 22GA | 17 = 3/16" & 5mm | 28 = 1 1/8" & 29mm |
| 7 = 20GA | 18 = 1/4" & 6mm | 29 = 1 1/4" & 32mm |
| 8 = 18GA | 19 = 5/16" & 8mm | 30 = 1 3/8" & 35mm |
| 9 = 16GA | 20 = 3/8" & 10mm | 31 = 1 1/2" & 38mm |
| 10 = 14GA | 21 = 7/16" & 11mm | 32 = 1 3/4" & 44mm |
| 11 = 12GA | 22 = 1/2" & 12mm | 33 = 2" & 50mm |

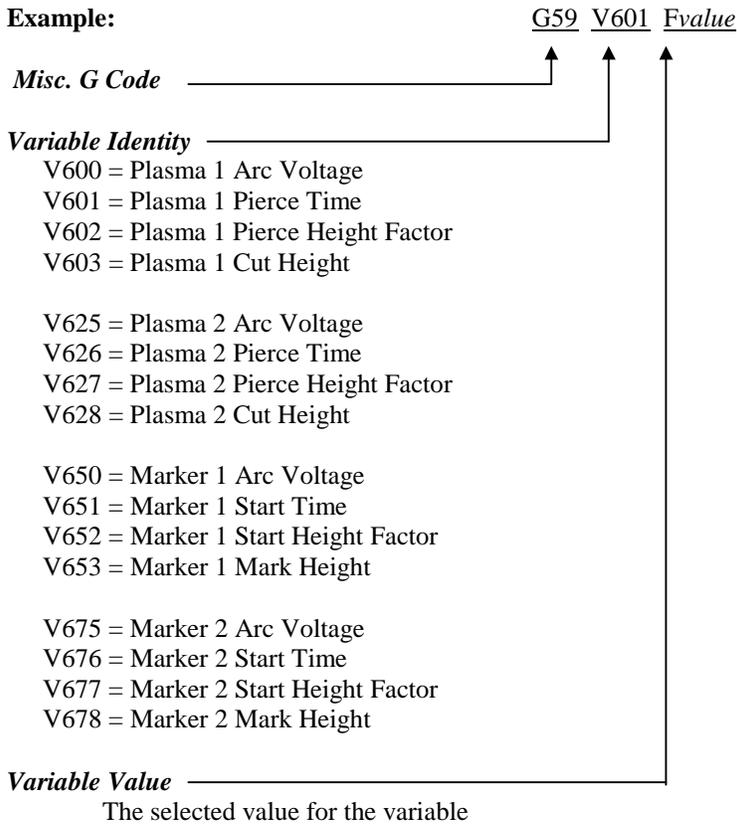
Sensor™ THC Part Program Support

Sensor™ THC offers the ability to configure THC setup parameters through part program codes.

The following parameters are available for use using EIA-274D G59 codes:

- Arc Voltage
- Pierce / Start Time
- Pierce/ Start Height Factor
- Cut / Mark Height

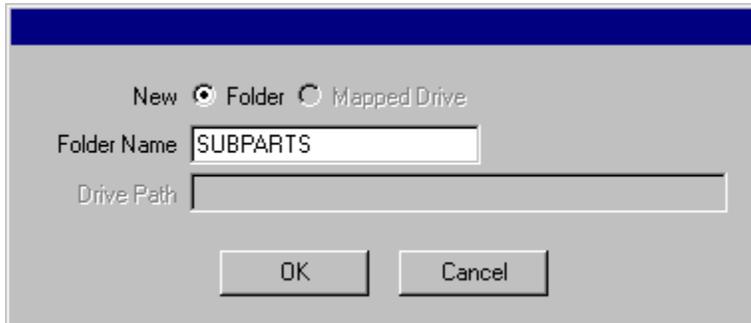
Setup is obtained using the following format.



Sub Parts

The Sub Parts feature allows the user to call and execute a separate part file within a part program using a simple line of text.

To configure a subroutine part for use, the user must first create a folder on the control hard drive named "SUBPARTS". To create a folder on the hard drive, select to Load From Disk". With the folder location highlighted, press the "+" key to create a new folder.



Save the desired part program in the SUBPARTS folder.

To execute the part, insert a line of code at the desired location within the part with the following format.

`PFILENAME`

Start the line of code with the letter P to indicate that a Sub Part is to be executed, followed by the filename for the desired part program.

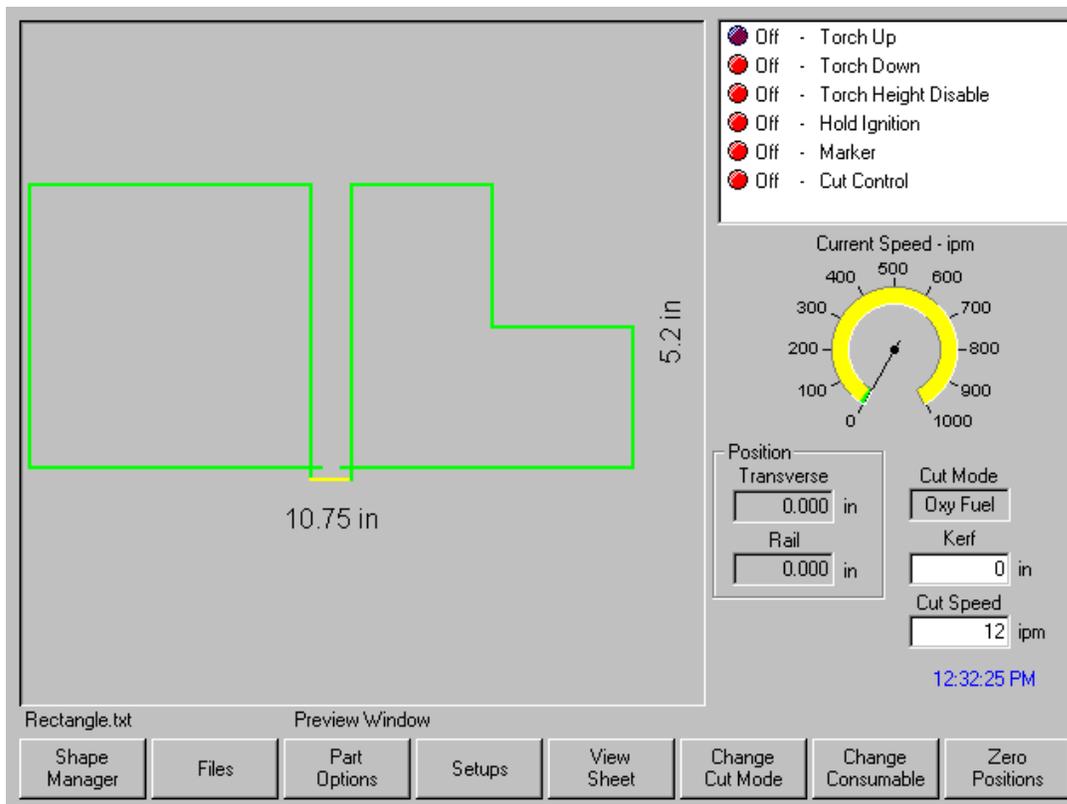
Example:

If the user were to add the Sub Part "L-Bracket" to be executed after completing a simple 5" x 5" square with a commanded traverse, the part program would appear similar to this example.

(Rectangle - Piece)

```
G20
G91
G99 X1 Y0 I0 J0
G41
M07
G01 X-5.2 Y0
G01 X0 Y5
G01 X5 Y0
G01 X0 Y-5.2
M08
G00 X.75 Y0
PL-BRACKET
G40
M02
```

When executed, the example program provided above would be represented as the original part plus the additional Sub Part, including the programmed traverse.



Note: Sub Parts may also contain other Sub Parts. After being translated by the control, the final text of the part will contain the complete text of the original part and Sub Part.

Marker Font Generator

The Marker Font Generator feature may be used to label or identify parts with a marking device prior to cutting. This is accomplished by use of a simple command string within the part program code to call existing text characters (fonts) and execute marking of the selected text.

The program code uses a specific format and is structured to provide information to be used when marking. Information on the Font source location, Scale Factor, Angle, Marker Tool, Tool Offset and Text are entered as information blocks in the command string. Each section or information block in the command string is separated by a space. The format of this command code is outlined as follows:

Note: If a value is not present for a specific information block, the default values will be used. The default values are:

Font (F):	Internal	Angle (A):	0°	Offset (O):	#1
Scale (S):	One	Marker (M):	#1		

Example of a simple command string: **<F2 S1 A45 M2 O2 <TEST 123>**

- < The program command must begin with the "<" symbol to indicate the Marker Font Generator feature is being used.

- F The first block of information is the Font Source location. The "F" indicates "Font" and is followed by a digit to indicate the location. Number 1 indicates the internal font in the control software, number 2 indicates to use a font located on the control hard drive, and number 3 indicates to source the font to be used from diskette. If no font is found at the selected location, the default internal font will be used. For the example given, the font location would be from the hard drive.

- S The second information block determines the scale of the text. The "S" is used to indicate "Scale" and is followed by a digit to indicate a numeric scale factor. For the example given, the Scale factor would be two or twice as large as the original font dimensions.

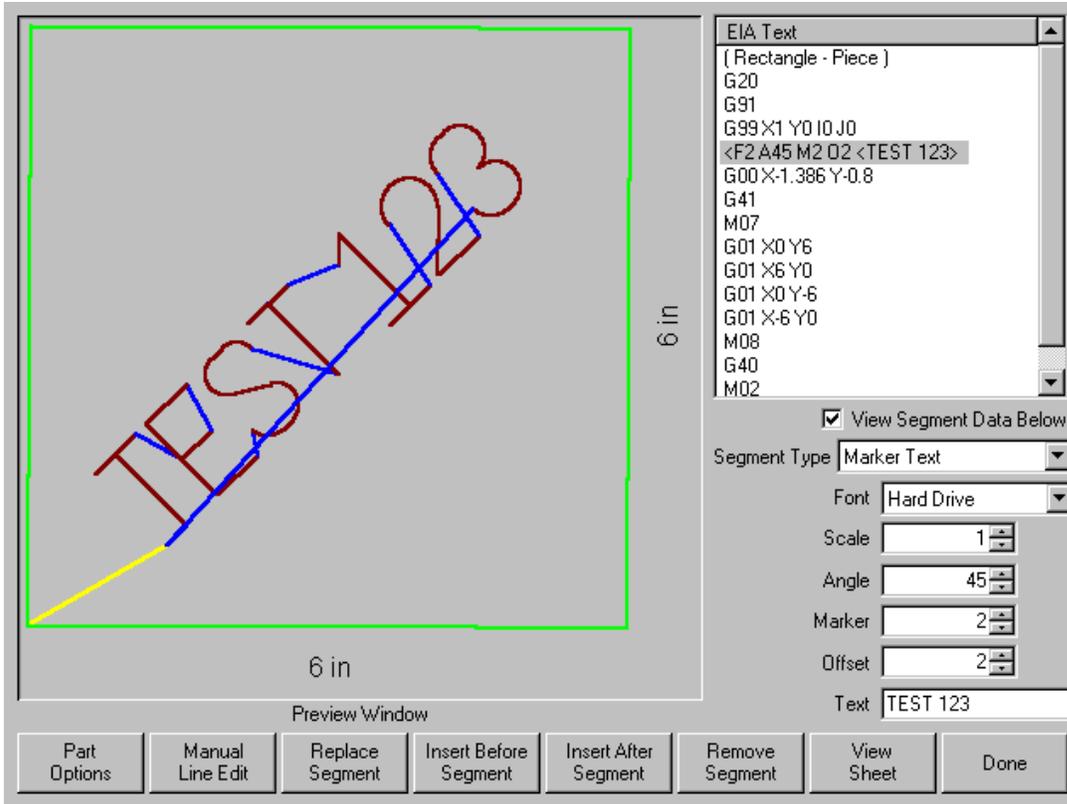
- A The third information block determines the angle of the text. The "A" is used to indicate "Angle" and is followed by a numeric value for the degree of angle. For the example given, the angle would be 45°.

- M The fourth information block determines the Marker Tool to be used. The "M" is used to indicate "Marker" followed by the number of the Marker Tool (Marker Enable Output) to be used. Up to two marker enables are supported.

- O The fifth information block determines which tool Offset to be used. The "O" indicates offset followed by a number indicating one of the nine different tool offsets previously configured in control setups is to be used. The example shown indicates that tool offset number two should be used.

- < > The final information block is used to specify the marker text to be executed. The text must be enclosed in the "<" and ">" marks to be valid and understood as the selected text. For the example given, the marker text executed would be "TEST 123"

Translated by the control, the example command string given above would generate the Marker Text "TEST 123" onto the plate as shown here in Shape Wizard.



To improve the ease of use for the part program designer and control operator, the Marker Font Generator feature will always insert a traverse segment to return to the original start point at the beginning of the marking text.

Internal Fonts

The internal fonts located within the control software are 1” high and are limited to characters available on the control keypad. Alphabetical characters are limited to upper case letters only.

External Fonts

External Fonts may be loaded from a floppy disk or from the control hard drive. When generating the text, the control searches for part files to correspond to the selected character. The part file names must be based on their ASCII numeric equivalent and have a .txt file extension.

Example: For the marker text “Ab 12”, the control will search for the following files to generate the text.

<u>Text</u>	<u>ASCII No.</u>	<u>File Name</u>
Capital A	65	Ascii65.txt
Lower Case b	98	Ascii98.txt
Space	32	Ascii32.txt
No 1	49	Ascii49.txt
No 2	50	Ascii50.txt

Please refer to the ASCII Codes section of this guide for additional ASCII code information. Font programs may be saved on the control hard drive by creating a folder labeled “Fonts” through the “Save to Disk” feature and saving the font programs within this folder. Remember, if a corresponding part file to text requested is not found at the selected source location, the internal font file will be used.

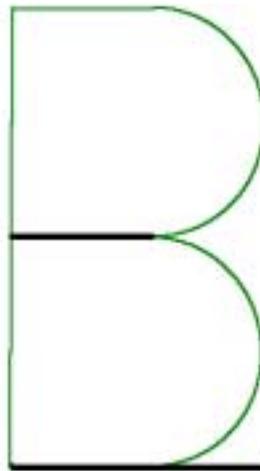
Custom Fonts

As previously noted, customer selected custom fonts may be used when using the Marker Font Generator feature. To construct these font files, certain guidelines should be adhered to.

- 1) Programming format must be EIA
- 2) Only M09 and M10 maybe used to enable and disable the marker.
- 3) Only G00, G01, G02 and G03 codes may be used.
- 4) The program must end in an M02.
- 5) The proper file name must be assigned to the font program.
- 6) The font program must begin in the lower left and end in the lower right.
- 7) Font programs should have the consistent dimensional limits (i.e. 1' high, etc.).

Example: The letter "B" – File Name Ascii66.txt

```
M09
G01 X0 Y1
G01 X0.321429 Y0
G02 X0 Y-0.5 I0 J-0.25
G01 X-0.321429 Y0
M10
G00 X0.321429 Y0
M09
G02 X0 Y-0.5 I0 J-0.25
G01 X-0.321429 Y0
M10
G00 X0.571 Y0
M02
```



The darker lines in the drawing represent the Traverse segment and the lighter lines represent the Marking lines. You can see by this illustration that at the end of the font program, a traverse is used to continue motion to the bottom right corner.

Note: The Burny 3/5 style of programming for the Marker Font Generator feature is also supported for the default internal font source.

Serial Messaging

The Serial Messaging feature may be used to pass commands embedded within a part program through a selected serial port to an external device. Both RS-232 and RS-422 are supported. TCP/IP protocol is not supported at this time.

Overview

Serial Messaging has a fairly basic communication protocol that has three simple formats to send ASCII codes as command strings. During the messaging function, a status indicator for “Message Transmit”, “Message Delay” or “Message Verify” will be displayed in the Watch window.

Options

- 1) While the selected message is sent to the external device, the part program will be temporarily suspended. After completion of the transmission, the part program will then automatically resume. No acknowledgement from the external device is required. An additional Time Delay may also be added.
- 2) A message is sent concurrent to execution of the part program and no delay is encountered. No acknowledge is required. No Delay Time is allowed.
- 3) The message is sent with a suspension of the program during transmission as in option one, but an Acknowledge from the external device (ACK) is required before the part program can continue. A Non-Acknowledge (NAK) response from the external device will prompt a retransmit of the message from the control. An optional Time Out value may be added to the program code. If no Time Out code is used in the program code the Default time out value at the Ports setup screen will be used. Additionally, an optional automatic retry feature may be enabled at the Ports setup screen.

To enable use of this feature, assign Messaging to the select port at the Ports setup screen.

The screenshot displays the Serial Messaging configuration interface. At the top, there are two dropdown menus: 'Messaging' and 'Serial 2'. Below these are several radio button options for Baud Rate (1200, 2400, 4800, 9600, 19200, 38400, 57600, 115200), Parity (None, Odd, Even), Data Bits (7, 8), and Flow Control (None, Xon/Xoff, Hardware). There are also radio buttons for 'During Jog on Path' (None, Forward Only, Forward and Backward). A series of input fields are provided for 'Retry on Time Out' (3 times), 'Time Out' (5 sec), 'Transmit Delay' (5 sec), 'Rewind' (8), 'Dialog Start' (33), 'Dialog Done' (42), 'Dialog Prompt' (3), 'Dialog Pause' (126), 'Dialog Acknowledge' (62), and 'End of Transmission' (26). On the right side, there are several more radio button options: 'Using Phoenix Link' (No, Yes), 'Show Host File Names' (No, Yes), 'File Dump Mode' (Off, On), 'Allow M65 Auto Reload' (No, Yes), 'Essi Program Termination' (0, 63, 64, 99, /, =), 'Download Updates' (No, Yes), 'Use Multidrop' (No, Yes), and 'Control Monitoring' (Off, On). At the bottom, there is a 'Done' button and a set of navigation buttons: 'Machine', 'Speeds', 'Ports', 'I / O', and 'Axes'.

After enabling Messaging, the flow control parameters to communicate with the external device will then need to be selected. The user may also select how messaging is handled for the Jogging Forward/Backward on Path. Additionally, the Retry on Time Out and Time Out parameters are available .

The following parameters must be configured for use. Hardware and flow control configuration information must match the external device.

Baud Rate

Select a communication speed from 1200 Baud to 115200 Baud

Parity

Select None, Odd or Even.

Data Bits

Select 7 or 8 Data Bits.

Flow Control

Select to use None, Xon/Xoff or Hardware.

During Jog on Path

The user may select whether messages will be sent when jogging Forward or Backward on Path while at the Pause screen. Note: All messaging will stop when the Stop Key has been pressed or the Remote Pause input becomes active.

Note: The Message Type 21 will transmit the message concurrent to the associated motion segment during "Backup on Path".

Retry on Time Out

For the Message Type 22 (which requires an acknowledgement from the external device after the message) an automatic retransmit of the message may be sent. The user may select the number of retries allowed before faulting from a lack of response from the external device. The fault prompt "Message Error" will be displayed when in a Time Out condition.

Time Out

The Time Out value may be used for the Message Type 22 (which requires an acknowledgement from the external device after the message) if there is no Time Out value used in the command string of the program code. Refer to the Delay Time / Time Out information for more information.

Programming Code

The ASCII message string follows a unique program message format. Each command begins with a “>” character and ends with a “<” character. These characters are used as delimiters to frame the command (Message Type, Optional Format and Optional Delay Time/ Time Out) instructions for the message.

Message Information

The format of this command code is outlined as follows:

EIA Example:

(>20+Format+Delay Time/Time Out<Message)

Message Command Type

- >20< Direct message with Delay
- >21< Direct message without Delay
- >22< Message that requires Acknowledge
(see Message Command Type below)

Optional Format Value

This optional format value allows the user to add Line Feed and Carriage Return commands, etc., message string. 0,1,16,17,32,33,48,49,64,65,80,81, 96,97,112,113 are supported (see Format Value below).

Optional Delay Time/Time Out Value

Time in seconds (see Time Out Value below)

Message Text

The message content (see Message Text below)

Note: Message format is always within comment characters and the Command portion of the program code is between the “>” Character and the “<” Character.

ESSI Example:

3
>20,1,1<Message
4

EIA Example:

(>20,1,1<Message)

See below for format and delay Code information.

Note: For the example provided, the plus sign (+) character was used as delimiter between fields for the command instruction. In addition to the plus sign (+), the hyphen (-), comma (,) or space may be used as delimiters.

Example:

Using spaces, the EIA command would look like this: (>20 Format Timeout<Message Text)

Message Command Type

- >20< This command delays the part program until all bytes have been transmitted, then optionally waits the Delay Time, if specified.
- >21< A message is sent concurrent to execution of the part program and no delay is encountered. No acknowledge is required.
- >22< The message is sent with a suspension of the program during transmission as in option one, but an Acknowledge from the external device (ACK = Hexadecimal 06) is required before the part program can continue. A Non-Acknowledge (NAK = Hexadecimal 15) response from the external device will prompt a retransmit of the message from the control.

An optional Time Out value may be added to the program code. If no Time Out code is used in the program code the Default time out value at the Ports setup screen will be used. Additionally, an optional automatic retry feature may be enabled at the Ports setup screen.

With the automatic retry feature the message will automatically be retransmitted if no response is detected. The retry is executed after the Time Out value has elapsed. The number of retries can be defined on the Ports configuration screen.

Optional Format Value

Specialty characters for the format may be sent in addition to command string.

Specialty Characters Supported

<u>HEX</u>	<u>Name</u>	<u>Description</u>
01	SOH	Start of Header
02	STX	Start of Text
03	ETX	End of Text
04	EOT	End of Transmission
0A	LF	Line Feed
0D	CR	Carriage Return
	BCC	"Exclusive Or" Check Byte

Note: Checksum is always an 'Exclusive OR' of the Data ONLY as it does not include any of the 'Format' chars including the CR/LF option.

Optional Format Character Assignments

<u>Value</u>	<u>Assignment</u>
0	No Special Assignment (Must be used in the format location is a Delay is required but no Format options are required).
1	Append a Carriage Return (<CR> = Hex value 0D) and a Line Feed (<LF> = Hex Value0A)
16	Append an "Exclusive OR" (<BCC>) to the end of the message.
17	Appends a combination of 16 and 1.
32	Encloses the message with Start of Text (<STX> = Hex Value 02) and End of Text (<ETX> = Hex Value 03). The <ETX> follows the message and the optional <CR><LF>> append codes but precedes the Check Byte <BCC>.
33	Appends a combination of 1 and 32.
48	Appends a combination of 16 and 32.
49	Appends a combination of 1, 16 and 32.
64	Append a Start of Header(<SOH> = Hex value 01) and a End of Transmission (<EOT> = Hex Value04) to the Message.
65	Appends a combination of 1and 64.
80	Appends a combination of 16 and 64.
81	Appends a combination of 1, 16 and 64.
96	Appends a combination of 32 and 64.
97	Appends a combination of 1, 32, and 64.
112	Appends a combination of 16, 32 and 64.
113	Appends a combination of 1, 16, 32 and 64.

Optional Delay Time/Time Out Value

The Delay Value will issue a delay in seconds at the end of the message for Message Type 20.

No delay is supported for Message Type 21.

This value also works as a Time Out value for Message Type 22. An error will be displayed if the message is not Acknowledged (ACK Hexadecimal 06) with in the specified time. If no Time Out Delay is defined in the command, the Time Out parameter on the Ports screen will be used.

The value is in a 3.2 format where a value of 5 is equal to 5.00 seconds. Accepted limits for the value is range of 0.00 to 999.99 seconds.

Message Text Content

Up to 300 data characters in each command string may be sent. The Command characters (information between and including the ">" and "<" signs) are included in this maximum.

Printable and Non- Printing ASCII codes can be used in the message string. Refer to the ASCII Code appendix of this manual for more information on ASCII codes and the Hexidecimal value.

Non-printing characters are supported by use of a two-character command and can send a Binary Code in the Range from 0-255. Double byte character to support combinations will affect the maximum length count with each pair reducing the maximum data characters by 1. Refer to the Non-printing Character information later in this section for information on these values.

Non – Printing Characters

Non Printing Characters are supported through use of a pair of two printing codes to equal the non-printing code. This pair of characters is retained in the program code but sent as single 8-bit code when transmitted.

There are three types of character pairs and each performs a different operation based on the first character of the pair. This produces a single modified character for transmission.

Character Options

- 1) The “&” two-character pair clears the 0x40 bit from the 2nd character code value.
- 2) The “!” two-character pair clears the 0x40 bit and sets the 0x80 bit set in the 2nd character code.
- 3) The “\$” two-character pair clears the 0xC0 bit in the 2nd character.

To transmit the single character with a value 0x01, use the two character sequence “&A”. This converts the “A” value of 0x41 to 0x01 by clearing the 0x40 bit. To transmit 0x81, use “!A” or to transmit 0xC1 use “\$A”.

Exceptions / Additions

As the “&”, “!” and “\$” are used as key indicators for the Non-print characters, there is a special format used when these characters are used as a print character in the message text. Simply use the character twice. “&&” = “&”

The ESSI style part program uses several unique characters which requires special two character codes to be used. For example, the message code “&K” in the part program will transmit the code value of 0x2B which is the ASCII code for the plus sign (+). In order to send the + character the code “&K” must be used.

The following are unique codes used in WORD ADDRESS and ESSI programs

<u>Code</u>	<u>Code Value</u>	<u>Description</u>
&'	0x20=space	At end of ESSI program
&h	0x28 = “(“	To transmit “(” from WORD ADDRESS program
&i	0x29 = “)”	To transmit “)” from WORD ADDRESS program
&?	0x7F = DEL	Non-printable DELETE code
&K	0x2B = “+”	To transmit “+” from ESSI program

Non Printing Character Table**ASCII codes less than Hexidecimal 20**

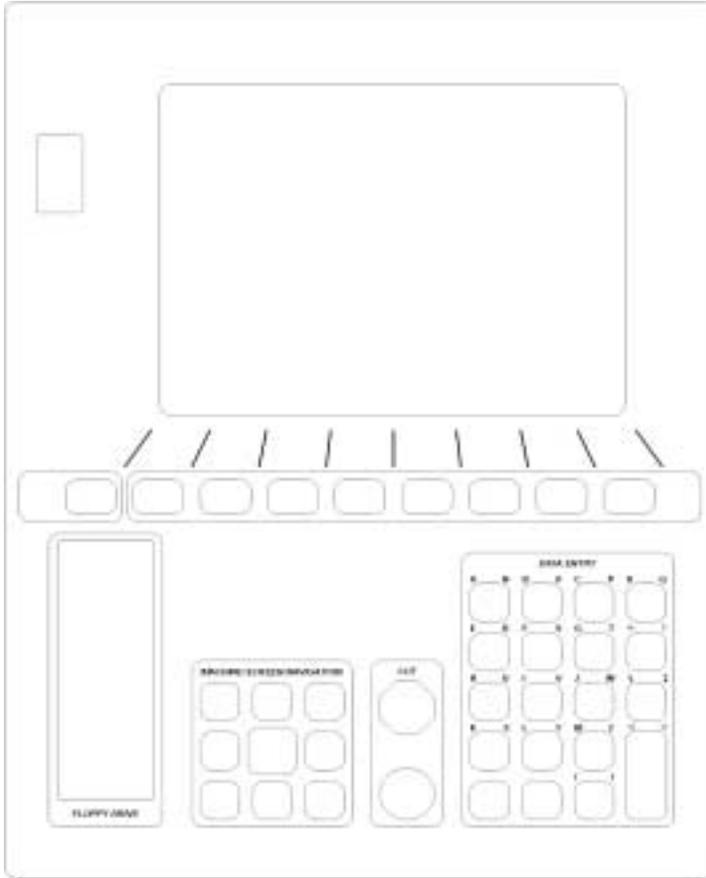
<u>Code</u>	<u>Hex</u>	<u>Code</u>	<u>Hex</u>	<u>Code</u>	<u>Hex</u>	<u>Code</u>	<u>Hex</u>
&A	00	&H	08	&P	10	&X	18
&A	01	&I	09	&Q	11	&Y	19
&B	02	&J	0A	&R	12	&Z	1A
&C	03	&K	0B	&S	13	&[1B
&D	04	&L	0C	&T	14	&\	1C
&E	05	&M	0D	&U	15	&]	1D
&F	06	&N	0E	&V	16	&^	1E
&G	07	&O	0F	&W	17	&_	1F

8 bit character codes greater than Hexidecimal 80

<u>Code</u>	<u>Hex</u>	<u>Code</u>	<u>Hex</u>	<u>Code</u>	<u>Hex</u>	<u>Code</u>	<u>Hex</u>
!@	80	!H	88	!P	90	!X	98
!A	81	!I	89	!Q	91	!Y	99
!B	82	!J	8A	!R	92	!Z	9A
!C	83	!K	8B	!S	93	![9B
!D	84	!L	8C	!T	94	!\	9C
!E	85	!M	8D	!U	95	!]	9D
!F	86	!N	8E	!V	96	!^	9E
!G	87	!O	8F	!W	97	!_	9D
!`	A0	!h	A8	!p	B0	!x	B8
!a	A1	!i	A9	!q	B1	!y	B9
!b	A2	!j	AA	!r	B2	!z	BA
!c	A3	!k	AB	!s	B3	!;	BB
!d	A4	!l	AC	!t	B4	!<	BC
!e	A5	!m	AD	!u	B5	!=	BD
!f	A6	!n	AE	!v	B6	!>	BE
!g	A7	!o	AF	!w	B7	!?	BF
\$@	C0	\$H	C8	\$P	D0	\$X	D8
\$A	C1	\$I	C9	\$Q	D1	\$Y	DD
\$B	C2	\$J	CA	\$R	D2	\$Z	DA
\$C	C3	\$K	CB	\$S	D3	\$[DB
\$D	C4	\$L	CC	\$T	D4	\$_	DC
\$E	C5	\$M	CD	\$U	D5	\$]	DD
\$F	C6	\$N	CE	\$V	D6	\$^	DE
\$G	C7	\$O	CF	\$W	D7	\$_	DF
\$`	E0	\$h	E8	\$p	F0	\$x	F8
\$a	E1	\$i	E9	\$q	F1	\$y	F9
\$b	E2	\$j	EA	\$r	F2	\$z	FA
\$c	E3	\$k	EB	\$s	F3	\$;	FB
\$d	E4	\$l	EC	\$t	F4	\$<	FC
\$e	E5	\$m	ED	\$u	F5	\$=	FD
\$f	E6	\$n	EE	\$v	F6	\$>	FE
\$g	E7	\$o	EF	\$w	F7	\$?	FF

Appendix C: Edge II™ Machine Interface

The Edge II™ shape cutting control is an extremely versatile product, offering up to four configurable axes of motion, configurable I/O locations and three different styles of external table interface for ease of installation. The control features may also be expanded through use of optional analog and network interface cards.



Rear Panel Layout

The rear panel of the control has several cable connectors to connect the control to power, I/O and communication ports. These connectors are clearly labeled as to their function, as shown below.

The AC power cable is inserted into the AC power connector and plugged into a standard 3-way 110 or 220 volt outlet. The control has a universal AC input power module that allows the user to plug into either voltage without changing additional jumpers. In addition, the AC Power connector contains an integral fuse receptacle and line filter.

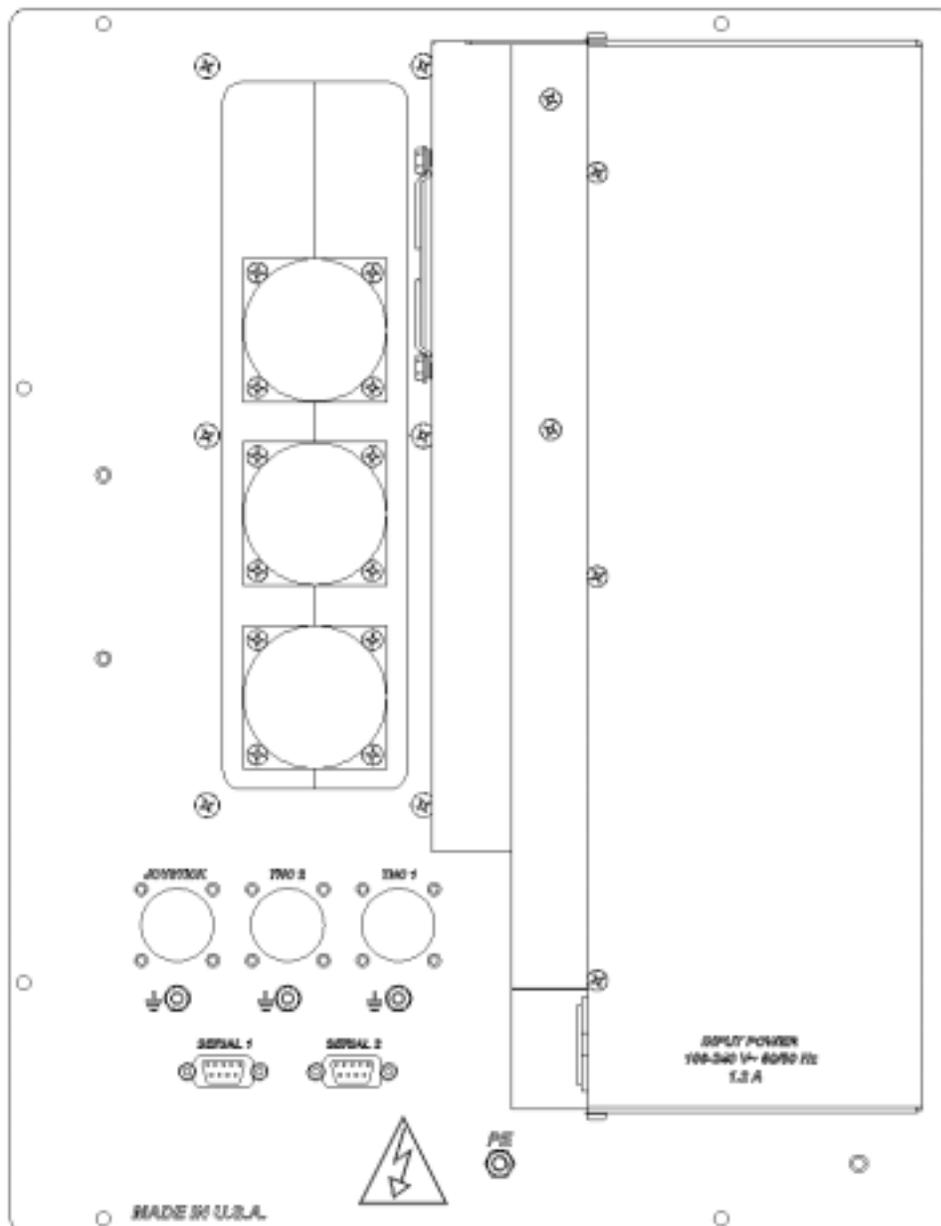
The rear panel has an integrated hinged door to assist in servicing the unit. A remote communications link can be connected to one of the two serial ports and an external ground (PE) lug is also provided.

Single Ended or Double Ended I/O Configuration

The following illustration shows the back panel for the single ended/doubled ended I/O configuration. The cables that connect the control to the cutting machine are attached to the I/O (Input/Output), and the DRIVE/ENCODER connectors.

For the purposes of this guide, Double Ended I/O is referred to as Type "M" configuration and Single Ended I/O is referred to as Type "P" configuration.

Rear Panel



Machine Interface

The information contained in the Machine Interface Appendix is intended to provide the basic information for connection of the shape cutting control to the cutting table. Each machine interface will vary slightly based on the cutting table configuration and features. Additionally, I/O pinout information may vary slightly based on the configuration of the selected I/O and their locations. Changes to the I/O configuration may be made in the password protected I/O screen. All controls are shipped with the default selection of Inputs and interface locations for the selected control Interface (I/O) configuration. Installation and service should only be performed by a qualified service technician.

I/O Configuration Type “P” and “M”

I/O Connector

The I/O connector is a standard sex circular CPC connector from AMP. This connector was specifically chosen for its rugged industrial design and its metal insulation characteristics for EMI/RFI noise immunity. The control can ship with two different versions of I/O in this one connector style. One style is single ended I/O (Type “P” configuration) and the other is double-ended I/O (Type “M” configuration).

In the single ended I/O scheme, a ground is provided on the I/O pin. In the double-ended approach, both the positive and negative pins for the I/O point are provided to the user. The advantage to single ended I/O is that it takes one pin for each point versus two for the double-ended I/O scheme increasing the total number of I/O points available to the user.

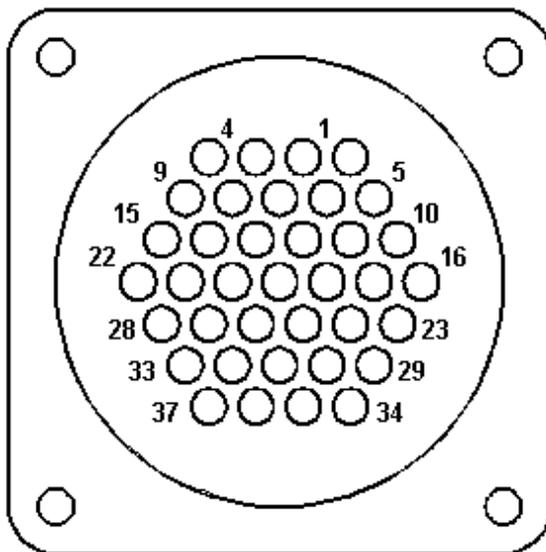
I/O Mating Connector

Connector AMP #208470-1

Backshell AMP #208945-8

Sockets (16-18 ga) AMP #66101-3

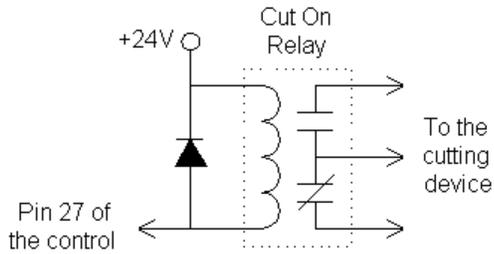
Sockets (20-24 ga) AMP #66105-3



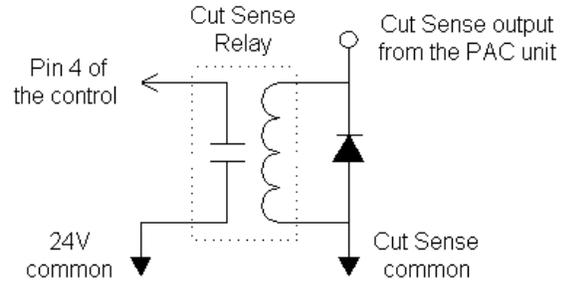
I/O Configuration Type “P” (Single Ended I/O)

Connecting single ended I/O to the control. These examples assume a +24V power supply has been connected across pins 34 and 36 of the control, or that the optional internal +24V power supply has been installed.

Output tied to external Cut On

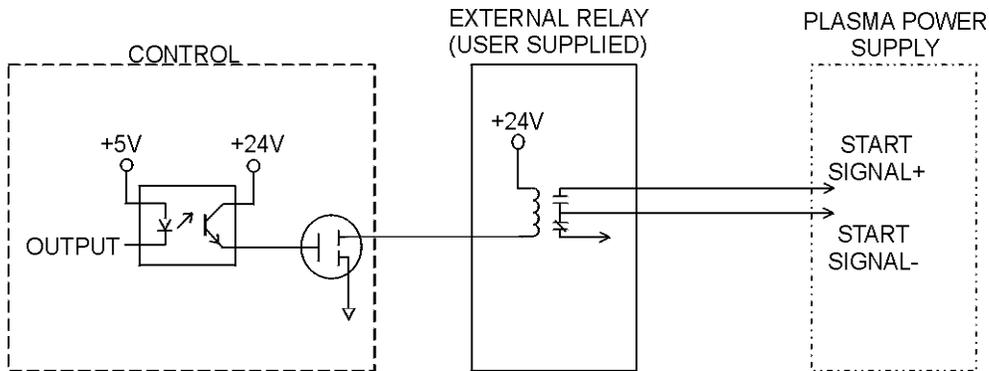


Input tied to Cut Sense Relay

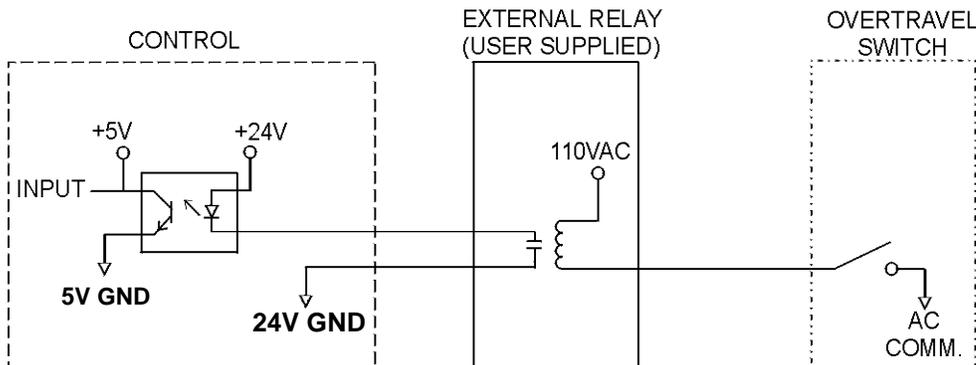


Examples of possible circuits

Output



Input



Single Ended I/O Pinout

The Single Ended I/O offers 12 outputs which are rated at 24VDC for up to 1-amp loads and 12 inputs rated for 24VDC.

Pin	I/O	Description
1	Input 1	Torch Up Sense
2	Input 2	Torch Down Sense
3	Input 3	Preheat Sense or X -Overtravel Switch
4	Input 4	Cut Sense
5	Input 5	Tracer on Path or Z Home Switch
6	Input 6	Spare or Y -Overtravel Switch
7	Input 7	Spare
8	Input 8	Spare or Remote Pause
9	Input 9	X Home Switch
10	Input 10	X Overtravel Switch or X +Overtravel Switch
11	Input 11	Y Home Switch
12	Input 12	Y Overtravel Switch or Y +Overtravel Switch
13	N/C	No Connection
14	+24 VDC	+ I/O Power Supply
15	+24 VDC	+ I/O Power Supply
16	N/C	No Connection
17	24V Common	I/O Power Supply Common
18	24V Common	I/O Power Supply Common
19	N/C	No Connection
20	N/C	No Connection
21	Output 1	Torch Up
22	Output 2	Torch Down
23	Output 3	Ignition Control
24	Output 4	Torch Height Disable/Dual Grid Control
25	Output 5	CNC/Tracer
26	Output 6	Marker Enable
27	Output 7	Cut Control
28	Output 8	Spare
29	Output 9	Spare or Low Preheat
30	Output 10	Preheat Control
31	Output 11	Key Press Indicator or Motion Indicator
32	Output 12	Spare or Plasma Select
33	I/O Shield	Chassis Ground
34	+24 VDC	+I/O Power Supply
35	+24 VDC	+I/O Power Supply
36	24 V Common	I/O Power Supply Common
37	24 V Common	I/O Power Supply Common

Drive/Encoder Connector

The Drive/Encoder connector is a reverse sex circular CPC connector from AMP. This connector was specifically chosen for its rugged industrial design and its metal insulation characteristics for EMI/RFI noise immunity.

NOTE: For optimum noise immunity, cable shields may be tied externally to the control enclosure or to the metal AMP connectors.

Drive/Encoder Mating Connector and Cable

Connector AMP #208472-1

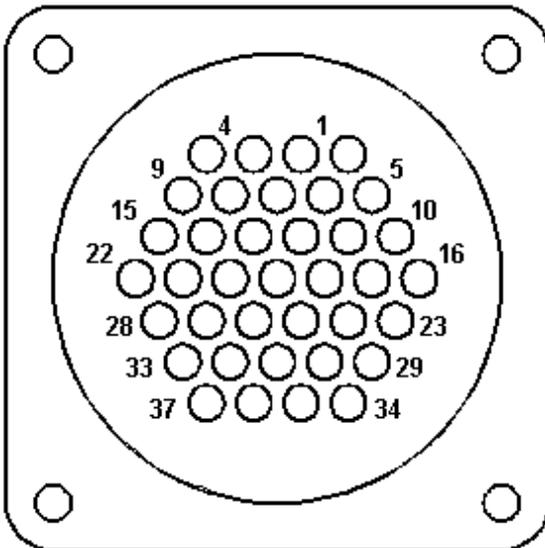
Backshell AMP #208945-8

Pins (16-18 ga) AMP #66099-3

Pins (20-24 ga) AMP #66103-3

Cabling: Use Belden # 9504 or equivalent for encoder signals

Cabling: Use Belden # 9501 or equivalent for drive signals

**Axes Assignments**

Axes	Axes Assignment
1 (X)	Transverse or Rail
2 (Y)	Transverse or Rail
3 (Z)	Dual Gantry, CBH or THC
4 (W)	CBH or THC

Drive/Encoder Pinout

Pin	Description
2	Encoder Power Supply Input (+5V or +12V*)
3	Encoder Power Supply Common
7	Encoder Power Supply Shield
8	

*NOTE: For Rev A + B MCC's +12V Encoders require a switch to be set on the interface board.

X Axis	Y Axis	Description
4	1	Encoder Power Output
8	6	Encoder Power Common
9	5	Encoder Channel A input
14	11	Encoder Channel /A Input
15	10	Encoder Channel B Input
21	17	Encoder Channel /B Input
22	16	Encoder Channel Z Input
28	23	Encoder Channel /Z Input
13	12	Encoder Shields
24	26	Drive Enable In (relay contact)
25	27	Drive Enable Out (relay contact)
37	34	Drive Power Input (+12 or +15)
33	29	Servo Output ($\pm 10V$)
32	30	Drive Power Common
36	35	Drive Power Input (-12 or -15)
20	18	Servo Output Common
19	31	Drive/Servo Shield

Drive/Encoder Pinout (For 3 and 4 Axes units)

Pin	Description
2	Encoder Power Supply Input (+5V or +12V)
3	Encoder Power Supply Common
7	Encoder Power Supply Shield

Z Axis	W Axis	Description
4	1	Encoder Power Output
8	6	Encoder Power Common
9	5	Encoder Channel A input
14	11	Encoder Channel /A Input
15	10	Encoder Channel B Input
21	17	Encoder Channel /B Input
22	16	Encoder Channel Z Input
28	23	Encoder Channel /Z Input
13	12	Encoder Shields
24	26	Drive Enable In (relay contact)
25	27	Drive Enable Out (relay contact)
37	34	Drive Power Input (+12 or +15)
33	29	Servo Output ($\pm 10V$)
32	30	Drive Power Common
36	35	Drive Power Input (-12 or -15)
20	18	Servo Output Common
19	31	Drive/Servo Shield

I/O Configuration Type “M” (Double Ended I/O)

The double ended I/O configuration of the control provides additional flexibility in connecting to external devices. These I/O points allow the user to separate the control voltages for each I/O point. Meaning, there is no common tie between each point as with the single ended I/O scheme. No power is required to be brought into the control. Pins 34-37 are provided for the optional internal +24V supply should the user want the power supply integrated into the control.

Double Ended I/O Pinout

The Single Ended I/O offers eight outputs which are rated at 24VDC for up to 1-amp loads and eight inputs rated for 24VDC.

Pin	I/O	Description
1	Input 1 +	Torch Up Sense
2	Input 1 -	Torch Up Sense
3	Input 2 +	Spare
4	Input 2 -	Spare
5	Input 3 +	Preheat Sense
6	Input 3 -	Preheat Sense
7	Input 4 +	Cut Sense
8	Input 4 -	Cut Sense
9	Input 5 +	Spare
10	Input 5 -	Spare
11	Input 6 +	Limit Switch
12	Input 6 -	Limit Switch
13	Input 7 +	Torch Down Sense
14	Input 7 -	Torch Down Sense
15	Input 8 +	Spare or Remote Pause
16	Input 8 -	Spare or Remote Pause
17	Output 1 +	Torch Up
18	Output 1 -	Torch Up
19	Output 2 +	Torch Down
20	Output 2 -	Torch Down
21	Output 3 +	Ignition Control
22	Output 3 -	Ignition Control
23	Output 4 +	Torch Height Disable/Dual Grid Control
24	Output 4 -	Torch Height Disable/Dual Grid Control
25	Output 5 +	CNC
26	Output 5 -	CNC
27	Output 6 +	Marker Enable or Beeper or Motion Indicator
28	Output 6 -	Marker Enable or Beeper or Motion Indicator
29	Output 7 +	Preheat Control
30	Output 7 -	Preheat Control
31	Output 8 +	Cut Control
32	Output 8 -	Cut Control
33	I/O Shield	Chassis Ground
34	+24 VDC	+I/O Power Supply
35	+24 VDC	+I/O Power Supply
36	24 V Common	I/O Power Supply Common
37	24 V Common	I/O Power Supply Common

Drive/Encoder Connector

The Drive/Encoder connector is a reverse sex circular CPC connector from AMP. This connector was specifically chosen for its rugged industrial design and its metal insulation characteristics for EMI/RFI noise immunity.

NOTE: For optimum noise immunity, cable shields may be tied externally to the control enclosure or to the metal AMP connectors.

Drive/Encoder Mating Connector and Cable

Connector AMP #208472-1

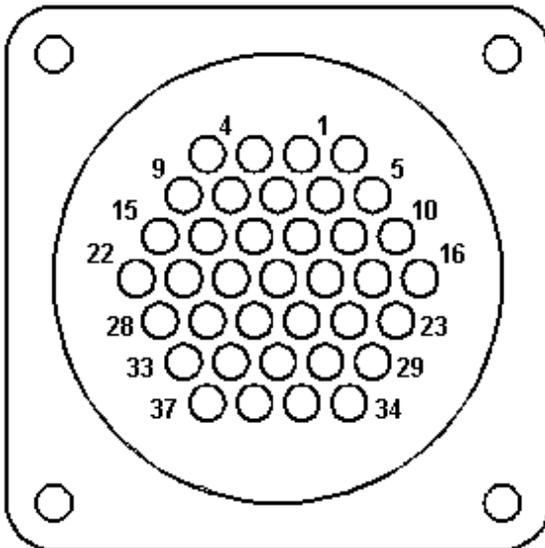
Backshell AMP #208945-8

Pins (16-18 ga) AMP #66099-3

Pins (20-24 ga) AMP #66103-3

Cabling: Use Belden # 9504 or equivalent for encoder signals

Cabling: Use Belden # 9501 or equivalent for drive signals

**Axes Assignments**

Axes	Axes Assignment
1 (X)	Transverse or Rail
2 (Y)	Transverse or Rail

Drive/Encoder Pinout

Pin	Description
2	Encoder Power Supply Input (+5V or +12V*)
3	Encoder Power Supply Common
7	Encoder Power Supply Shield
24	Watchdog Normally Open Contacts
25	Watchdog Common

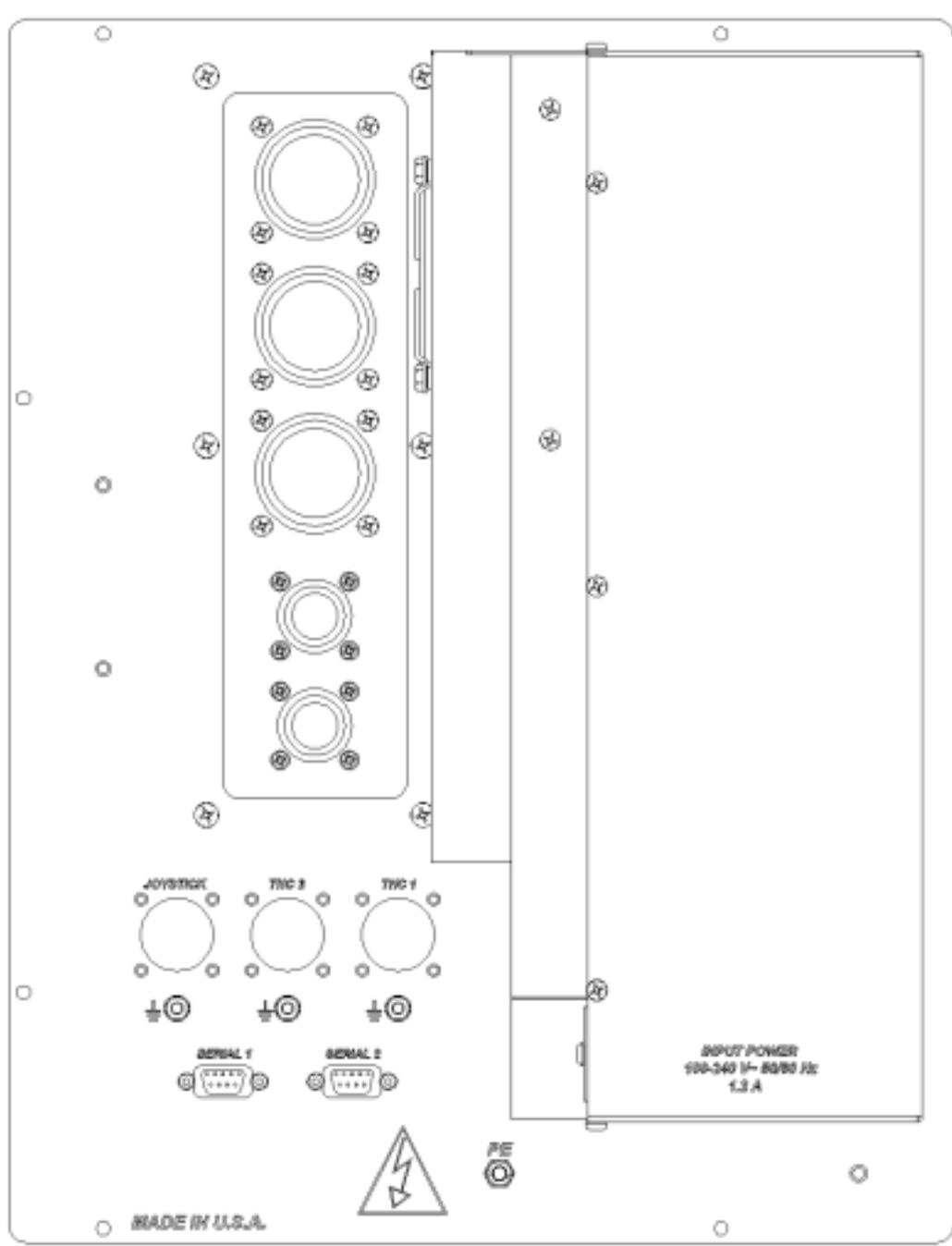
***NOTE:** For Rev A + B MCC's +12V Encoders require a switch to be set on the interface board.

X Axis	Y Axis	Description
4	1	Encoder Power Output
8	6	Encoder Power Common
9	5	Encoder Channel A input
14	11	Encoder Channel /A Input
15	10	Encoder Channel B Input
21	17	Encoder Channel /B Input
22	16	Encoder Channel Z Input
28	23	Encoder Channel /Z Input
13	12	Encoder Shields
37	34	Drive Power Input (+12 or +15)
33	29	Servo Output ($\pm 10V$)
32	30	Drive Power Common
36	35	Drive Power Input (-12 or -15)
20	18	Servo Output Common
19	31	Drive/Servo Shield

I/O Configuration Type “B”

The illustration below shows the control back panel in a Type “B” I/O configuration. The cables that connect the control to the cutting machine are attached to the OXY FUEL and PLASMA (Input/Output), DRIVE connector, X ENCODER and Y ENCODER interface connectors.

Back Panel

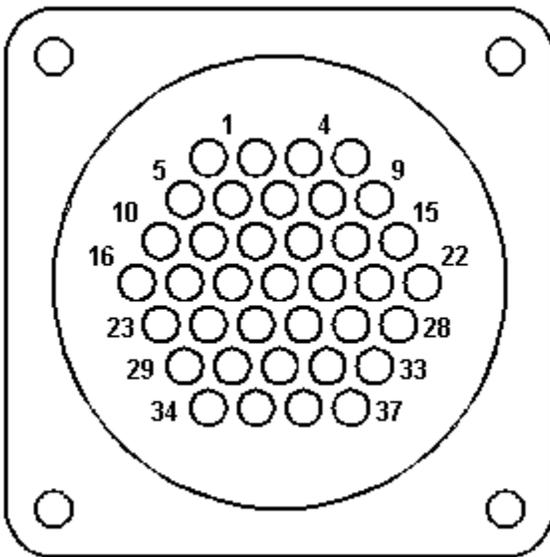


I/O Configuration Type “B”

This shape cutting control has been specifically designed and configured to connect to a Burny 3 or Burny 5 style wire harness system without modification. Outputs are relay contact rated at 1 amp at 120 VAC. Inputs are optically isolated and can operate at 24 – 120 VAC/DC.

Oxy Fuel and Plasma Connectors

The Oxy Fuel and Plasma connectors are standard sex circular CPC connectors from AMP.



I/O Mating Connectors

Connector AMP #206150-1

BackShell AMP #206138-1

Sockets (16-18 ga) AMP #66101-3

Sockets (20-24 ga) AMP #66105-3

Oxy Fuel Pinout

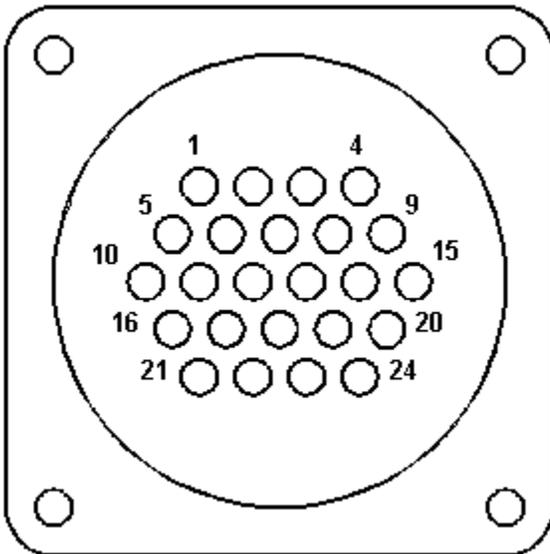
Pin	I/O	Description
10	Input	Oxygen Cut Sense
23	Input	Oxygen Cut Sense
11	Input	Program Inhibit
24	Input	Program Inhibit
3	Output NO	Oxygen Enable
4	Output COM	Oxygen Enable
8	Output NC	Oxygen Enable
32	Output NO	Oxygen Start
37	Output COM	Oxygen Start
36	Output NC	Oxygen Start
21	Output NO	Preheat
22	Output COM	Preheat
28	Output NC	Preheat
9	Output NO	Plate Marker No. 1
15	Output COM	Plate Marker No. 1
14	Output NC	Plate Marker No. 1
1	115 V Hot	I/O Power Supply
18	I/O Shield	Chassis Ground
19	I/O Shield	Chassis Ground
34	115V Neutral	I/O Power Supply Common

Plasma Pinout

Pin	I/O	Description
5	Input	Plasma Select
18	Input	Plasma Select
16	Input	Arc On Sense
29	Input	Arc On Sense
2	Output NO	Plasma Enable
3	Output COM	Plasma Enable
4	Output NC	Plasma Enable
22	Output NO	Plasma Start
21	Output COM	Plasma Start
15	Output NC	Plasma Start
37	Output NO	Plasma Height
36	Output COM	Plasma Height
35	Output NC	Plasma Height
26	Output NO	Plate Marker No. 2 or CNC Tracer
20	Output COM	Plate Marker No. 2 or CNC Tracer
13	Output NC	Plate Marker No. 2 or CNC Tracer

Drive Connector

The Drive connector is a standard sex circular CPC connector from AMP.



NOTE: For optimum noise immunity, cable shields may be tied externally to the control enclosure.

Drive Mating Connector and Cable

Connector AMP #206837-1

Backshell AMP #206138-1

Sockets (16-18 ga) AMP #66101-3

Cabling: Use Belden # 9501 or equivalent for drive signals

Axes Assignments

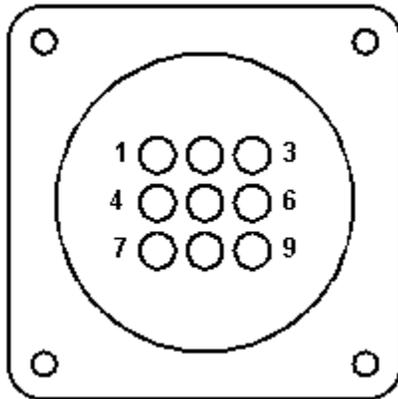
Axes	Axes Assignment
1 (X)	Transverse or Rail
2 (Y)	Transverse or Rail

Drive Pinout

Pin	Description
7	X Reference +
6	Y Reference +
9	Reference Common
12	Reference Shield
20	Remote Pause
8	Watchdog Normally Open Contacts
13	Watchdog Common

Encoder Connectors

The Encoder connectors are a standard sex circular CPC connector from AMP.



NOTE: For optimum noise immunity, cable shields may be tied externally to the control enclosure.

Encoder Mating Connectors and Cables

Connector AMP #206708-1

Backshell AMP #206966-1

Sockets (20-24 ga) AMP #66105-3

Cabling: Use Belden # 9504 or equivalent for encoder signals

Encoder Pinout

Pin	Description
7	Power Output
1	Power Common
8	Channel A input
3	Channel /A Input
9	Channel B Input
5	Channel /B Input
6	Channel Z Input
2	Channel /Z Input
4	Shields

THC and Joystick Interface

I/O Configuration Type “P” controls have dedicated connectors for THC 1, THC and Joystick / Speedpots.

Series 1 PCI Analog Card

Note: The Analog Card will be designated as PCI-AIC Rev A in the Control Information Diagnostic screen.

Board Marking PCI Analog 1 Part # PCBS-0074

THC 1

Pin #	Designation	Description
1	Common	Common
2	Input 5 +	Nozzle Contact Sense + (Relay Contact)
3	Input 5 –	Nozzle Contact Sense - (Relay Contact)
4	Output 1 +	Nozzle Contact Enable + (Relay Contact)
5	Output 1 –	Nozzle Contact Enable - (Relay Contact)
6	Analog Input 1 +	THC +
7	Analog Input 1 –	THC –
8	Output 2 +	Hold Ignition (Relay Contact)
9	Output 2 –	Hold Ignition (Relay Contact)
	Ground Stud	Shield

Mating Connector

Connector AMP #206708-1

Backshell AMP #206966-1

Sockets (20-24 ga) AMP #66105-3

Cabling: Use Belden # 9504 or equivalent

THC 2

Pin #	Designation	Description
1	Common	Common
2	Input 6 +	Nozzle Contact Sense + (Relay Contact)
3	Input 6 –	Nozzle Contact Sense – (Relay Contact)
4	Output 3 +	Nozzle Contact Enable + (Relay Contact)
5	Output 3 –	Nozzle Contact Enable – (Relay Contact)
6	Analog Input 2 +	THC +
7	Analog Input 2 –	THC –
8	Output 4 +	Hold Ignition (Relay Contact)
9	Output 4 –	Hold Ignition (Relay Contact)
	Ground Stud	Shield

Mating Connector

Connector AMP #206708-1

Backshell AMP #206966-1

Sockets (20-24 ga) AMP #66105-3

Cabling: Use Belden # 9504 or equivalent

Joystick

Pin #	Designation	Description
1	Input 1	Joystick UP
2	Input 2	Joystick DWN
3	Input 3	Joystick LT
4	Input 4	Joystick RT
5	Common	Common
6	Analog Input 3 +	Speed Pot 1
7	Analog Input 3 –	Speed Pot 1
8	Analog Input 4 +	Speed Pot 2
9	Analog Input 4 –	Speed Pot 2
	Ground Stud	Shield

Note: Joystick inputs are activated by passing the Common signal (pin 5) to the desired input. Analog inputs for the speedpots are rated at 0 - +10VDC

Mating Connector

Connector AMP #206708-1

Backshell AMP #206966-1

Sockets (20-24 ga) AMP #66105-3

Cabling: Use Belden # 9504 or equivalent

THC and Joystick Cable Grounding

Cable shields should be tied to the external PE studs for optimum noise immunity.

Appendix D: Voyager II™ Machine Interface

The Voyager II™ Shape Cutting Control is designed with all machine interface connections internal to the enclosure. No external machine interface is provided. All Interface cabling enters and exits through an opening in the bottom of the enclosure. Extreme caution should be taken to ensure that the opening at the base of this unit is appropriately sealed so that no contamination enters the unit.

The information contained in this section is intended to provide the basic information for connection of the Voyager II™ Shape Cutting Control to the cutting table. Each machine interface will vary slightly based on the cutting table configuration and features. Additionally, I/O pinout information may vary slightly based on the configuration of the selected I/O and their locations. Changes to the I/O configuration may be made in the password protected I/O screen. All controls are shipped with the default selection of Inputs and interface locations for the selected control Interface (I/O) configuration. Installation and service should only be performed by a qualified service technician. For more information regarding the I/O process definitions please refer to the Setups section of this guide.

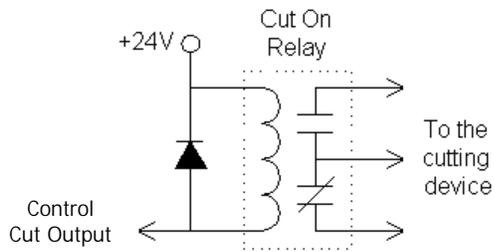


Operation and maintenance of automated equipment involves potential hazards. Personnel should take precautions to avoid injury. This equipment should only be opened by trained service personnel.

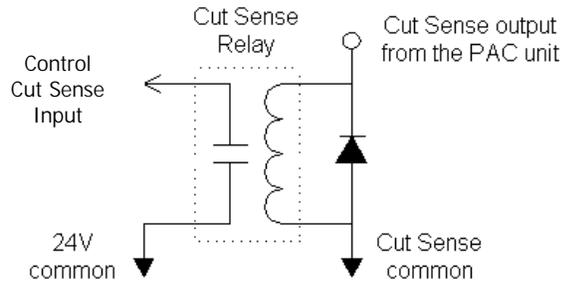
I/O Configuration Type “V” (Single Ended I/O)

Connecting single ended I/O to the control. The control provides +24V power on pins 17 & 18 (+24 VDC) and pins 36 & 37 (24 VDC Common).

Output tied to external Cut On

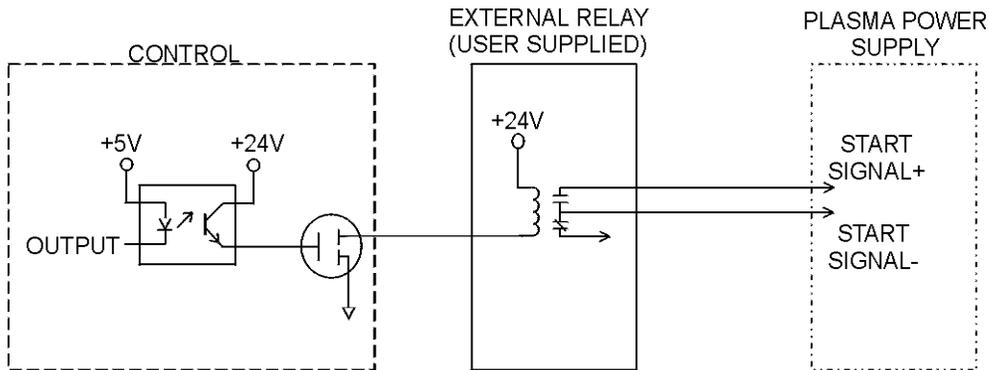


Input tied to Cut Sense Relay

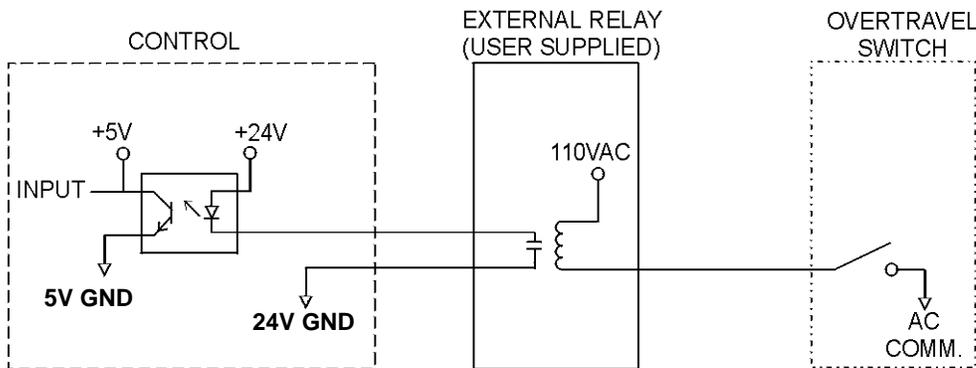


Examples of possible circuits

Output



Input



Single Ended I/O Pinout

The Single Ended I/O offers 32 outputs which are rated at 24VDC for up to 1-amp loads and 32 inputs rated for 24VDC as standard

I/O Connector J5

Pin	Description	Default I/O Description
1	Input 1	Spare
2	Input 2	Z Home Switch
3	Input 3	Program Inhibit
4	Input 4	Cut/ Mark Sense 1
5	Input 5	Cut/ Mark Sense 2
6	Input 6	Remote Pause
7	Input 7	Drive Disabled
8	Input 8	Spare
9	Input 9	X Home Switch
10	Input 10	X+ Overtravel
11	Input 11	Y Home Switch
12	Input 12	Y+ Overtravel
13	Input 13	Plasma 1 Select
14	Input 14	Plasma 2 Select
15	Input 15	Marker 1 Select
16	Input 16	Marker 2 Select
17	+24 VDC	N/A
18	+24 VDC	N/A
19	Chassis Ground	N/A
20	Output 1	Torch Up
21	Output 2	Torch Down
22	Output 3	Ignition
23	Output 4	Torch Height Disable
24	Output 5	Hold Ignition
25	Output 6	Marker
26	Output 7	Cut Control
27	Output 8	Plasma 1 Enable
28	Output 9	Plasma 2 Enable
29	Output 10	High Preheat Control
30	Output 11	Low Preheat Control
31	Output 12	Marker 1 Enable
32	Output 13	Marker 2 Enable
33	Output 14	Gas Control Write
34	Output 15	Remote Test Operate
35	Output 16	Remote Test Preflow
36	+24 VDC Common	N/A
37	+24 VDC Common	N/A

Mating Connector

Connector: 37C D-Sub Amp # 205210-3 or equivalent

Backshell: Amp #748676-4 or equivalent

Pins: Amp #5-66507-9 (24-28 AWG) or equivalent

I/O Connector J6

Pin	Description	Default I/O Description
1	Input 17	Gas Control Read Complete
2	Input 18	Gas Control Error
3	Input 19	Raise Torch 1
4	Input 20	Lower Torch 1
5	Input 21	Enable THC 1
6	Input 22	Raise Torch 2
7	Input 23	Lower Torch 2
8	Input 24	Enable THC 2
9	Input 25	Spare
10	Input 26	Spare
11	Input 27	Spare
12	Input 28	Spare
13	Input 29	Spare
14	Input 30	Spare
15	Input 31	Spare
16	Input 32	Spare
17	+24 VDC	N/A
18	+24 VDC	N/A
19	Chassis Ground	N/A
20	Output 17	Remote Air Plasma
21	Output 18	Remote H35/N2 Plasma
22	Output 19	Remote O2 Plasma
23	Output 20	Gas Flow Set 1
24	Output 21	Gas Flow Set 2
25	Output 22	Gas Flow Set 4
26	Output 23	Gas Flow Set 8
27	Output 24	Gas Flow Set 10
28	Output 25	Gas Flow Set 20
29	Output 26	Gas Flow Set 40
30	Output 27	Gas Flow Set 80
31	Output 28	Gas Flow Set 100
32	Output 29	Valve Select 1
33	Output 30	Valve Select 2
34	Output 31	Valve Select 4
35	Output 32	Valve Select 8
36	+24 VDC Common	
37	+24 VDC Common	

Mating Connector

Connector: 37C D-Sub Amp # 205210-3 or equivalent

Backshell: Amp #748676-4 or equivalent

Pins: Amp #5-66507-9 (24-28 AWG) or equivalent

Note: Additional I/O for the Voyager II™ will be available through use of optional Analog Input cards. Additional information on the Optional Analog Input Cards is available in the Sensor™ THC section of this guide.

Please contact your control vendor for more information on how the Analog Input Card may be configured in your control.

AC Input Pinout

Pin	Description
1	110VAC or 220VAC Input (Hot)
2	110VAC or 220VAC Input (Neutral)
6	AC Power Ground
7	Watchdog (relay contact)
8	+24 VDC common
11	Watchdog (relay contact)
14	+24 VDC Output

AC Input Mating Connector

Connector: 16CAmp # 206037-1 or equivalent

Backshell: Amp #206070-1 or equivalent

Sockets: Amp #66101-3 (16-18 AWG) or equivalent

Axes	Conn. Location	Axes Assignment
1	J5	Transverse or Rail
2	J6	Transverse or Rail
3	J7	Dual Gantry, CBH or THC
4	J8	CBH or THC
5	J9	Rotate or THC
6	J10	Tilt or THC

Drive/ Encoder Pinout (J5- J10)

Pin	Description
1	Channel A Input
2	Channel B Input
3	Channel Z Input
4	Encoder Power Output (5 VDC supplied as standard)
5	Chassis Ground / E Ground
6	Servo Output ($\pm 10V$)
7	Drive Enable In (relay contact)
8	Encoder Shield
9	Channel /A Input
10	Channel /B Input
11	Channel /Z Input
12	E Ground
13	Drive/ Servo Shield
14	Servo Output Common
15	Drive Enable Out (relay contact)

Drive/ Encoder Input Mating Connector

Connector: 15C D-Sub Amp # 25206-3 or equivalent

Backshell: Amp #748676-2 or equivalent

Pins: Amp #5-66506-9 (20-24 AWG) or equivalent



Warning! This control is equipped with an internal power supply for providing analog, encoder and I/O voltage. A wiring modification to bring the proper voltage to the Drive Encoder Connector for the use of 12 Volt encoders may be required.

Optional Analog / PWM Interface

Analog Card Options

The Analog Card Interface option provides connection for operation of the Joystick, Speed Pot and Sensor™ THC features

Series 1 ISA Analog Card

Note: The Analog Card will be designated as Rev 0 in the Control Information Diagnostic screen.

Board Marking PC-012-1098 Rev. B Part # PCBS-0010-B

J1 - Power

Pin #	Designation	Description
1	VA+	+ 12VDC
2	A Ground	Common
3	VA-	- 12VDC
4	VE+	+5VDC
5	E Ground	Ground

TB1 - I/O

Pin #	Designation	Description
1	Analog 3 +	Speed Pot 1 +
2	Analog 3 -	Speed Pot 1 -
3	Analog 4 +	Speed Pot 2 +
4	Analog 4 -	Speed Pot 2 -
5	Input 1	Joystick Up (single ended – active by E-ground)
6	Input 2	Joystick Down (single ended – active by E-ground)
7	Input 3	Joystick Left (single ended – active by E-ground)
8	Input 4	Joystick Right (single ended – active by E-ground)

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

TB2 - I/O

Pin #	Designation	Description
1	Analog 2 +	THC +
2	Analog 2 -	THC -
3	Input 6 +	Nozzle Contact Sense + (Relay Contact)
4	Input 6 -	Nozzle Contact Sense - (Relay Contact)
5	Output 3 +	Nozzle Contact Enable + (Relay Contact)
6	Output 3 -	Nozzle Contact Enable - (Relay Contact)
7	Output 4 +	Hold Ignition + (Relay Contact)
8	Output 4 -	Hold Ignition - (Relay Contact)

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

TB3 - I/O

Pin #	Designation	Description
1	Analog 1 +	THC +
2	Analog 1 -	THC -
3	Input 5 +	Nozzle Contact Sense + (Relay Contact)
4	Input 5 -	Nozzle Contact Sense - (Relay Contact)
5	Output 1+	Nozzle Contact Enable + (Relay Contact)
6	Output 1-	Nozzle Contact Enable - (Relay Contact)
7	Output 2+	Hold Ignition + (Relay Contact)
8	Output 2-	Hold Ignition - (Relay Contact)

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

Series 2 Analog/ PWM Interface Card

Note: The Analog Card will be designated as Rev A in the Control Information Diagnostic screen.

Board Marking PC-026-500 Rev.

Part # PCBS-0040

J5 - I/O

Pin #	Designation	Description
1	Joystick IN1	Joystick Up (single ended – active by E-ground)
2	Joystick IN2	Joystick Down (single ended – active by E-ground)
3	Joystick IN3	Joystick Left (single ended – active by E-ground)
4	Joystick IN4	Joystick Right (single ended – active by E-ground)
5	E Ground	Joystick Common
6	Chassis Ground	Shield
7	Analog In 6 +	Speed Pot 1 +
8	Analog In 6 -	Speed Pot 1 -
9	Chassis ground	Shield
10	Analog In 12 +	Speed Pot 2 +
11	Analog In 12 -	Speed Pot 2 -
12	Chassis Ground	Shield

Mating Connector

12C Phoenix Connector – Phoenix Part # 1803675

J6 - APC 2

Pin #	Description
1	Analog In 8 +
2	Analog In 8 -
3	Shield
4	Analog In 9 +
5	Analog In 9 -
6	Shield
7	+24VDC
8	Analog In 10 +
9	Analog In 10 -
10	Shield
11	Analog In 11 +
12	Analog In 11 -
13	Shield
14	+24VDC
15	Output 16
16	+24VDC
17	PWM 4 +
18	PWM 4 -
19	Shield
20	PWM 5 +
21	PWM 5 -
22	Shield
23	PWM 6 +
24	PWM 6 -
25	Shield

J7 - Plasma 2

Pin #	Description
1	Analog 7 In +
2	Analog 7 In -
3	Shield
4	Output 41
5	No Connection
6	Input 9
7	+24VDC
8	No Connection
9	Analog Out 2 +
10	Analog Out 2 -
11	Chassis Ground
12	Output 42
13	Output 43
14	Output 44
15	Output 45
16	Output 46
17	Output 47
18	Input 41
19	Input 42
20	Input 43
21	Input 44
22	+24 VDC
23	+24 VDC
24	+24 V Common
25	+24 V Common

J8 - APC 1

Pin #	Description
1	Analog In 2 +
2	Analog In 2 -
3	Shield
4	Analog In 3 +
5	Analog In 3 -
6	Shield
7	+24VDC
8	Analog In 4 +
9	Analog In 4 -
10	Shield
11	Analog In 5 +
12	Analog In 5 -
13	Shield
14	+24VDC
15	Output 8
16	+24VDC
17	PWM 1 +
18	PWM 1 -
19	Shield
20	PWM 2 +
21	PWM 2 -
22	Shield
23	PWM 3 +
24	PWM 3 -
25	Shield

J9 - Plasma 1

Pin #	Description
1	Analog 1 +
2	Analog 1 -
3	Shield
4	Output 1
5	No Connection
6	Input 33
7	+24VDC
8	No Connection
9	Analog Out 1 +
10	Analog Out 1 -
11	Chassis Ground
12	Output 34
13	Output 35
14	Output 36
15	Output 37
16	Output 38
17	Output 39
18	Input 34
19	Input 35
20	Input 36
21	Input 37
22	+24 VDC
23	+24 VDC
24	+24 V Common
25	+24 V Common

APC Mating Connector (J6 & J8)

Connector: 25C D-Sub Amp # 207464-2 or equivalent

Backshell: Amp #748676-3 or equivalent

Pins: Amp #5-66506-9 (20-24 AWG) or equivalent

Plasma Mating Connector (J7 & J9)

Connector: 37C D-Sub Amp # 205207-1 or equivalent

Backshell: Amp #748676-3 or equivalent

Pins: Amp #5-66504-7 (20-24 AWG) or equivalent

Appendix E: Serial Ports

Both serial ports provided are shipped in the RS-232C wiring configuration. To change either port to an RS-422 configuration requires changing a jumper setting on the Serial Isolation Board located inside the control on the back panel. Simply locate the appropriate jumper for the desired port at the bottom of the board and move the jumper from the RS-232C position to the RS-422 position, which is clearly marked on the board.



Warning! Configure the port for RS-422 Operation before connecting RS-422 compatible devices.

The serial ports in the control are specifically designed to operate with a standard nine pin serial port connector. Specifications for these ports are as follows:

Channel Type	Optically Isolated RS-232C or RS-422.
Information Code	ASCII (American Standard Code for Information Interchange).
Baud Rate	User selectable up to 115.2K baud.
Number of Start Bits	1
Number of Stop Bits	1
Word Length	User selectable 7 or 8 bits.
Parity	User selectable None, Even or Odd.
Data Synchronization	XON (Control-Q) / XOFF (Control-S).
Time Out	User selectable in one-second increments.
Transmit Delay	User selectable in one one/hundredths of a second increments.
Rear Panel Connector	IBM-PC/AT compatible 9-pin D-type female.

Control RS-232C DB-9 Pinout

Pin	Signal Name	Description
1	Shield	Chassis Ground
2	TxD	Transmit Data to External Device
3	RxD	Receive data from External Device
4		No Connection
5	Common	Ground
6		No Connection
7		No Connection
8		No Connection
9		No Connection

RS-232C Connections to Host PC with 9-pin D-type connector

Host PC		Control	
Signal Name	DB-9 Pin	Signal Name	DB-9 Pin
Shield	1	Shield	1
RxD	2	TxD	2
TxD	3	RxD	3
Common	5	Common	5

RS-232C Connections to Host PC with 25-pin D-type connector

Host PC		Control	
Signal Name	DB-25 Pin	Signal Name	DB-9 Pin
Shield	1	Shield	N/C
RxD	3	TxD	2
TxD	2	RxD	3
Common	7	Common	5

Control RS-422 DB-9 Pinout

Pin	Signal Name	Description
1	Shield	Chassis Ground
2	TxD-	Transmit Data - to External Device
3	RxD-	Receive Data - from External Device
4	TxD+	Transmit Data + to External Device
5	Common	Ground
6		No Connection
7	RxD+	Receive Data + from External Device
8		No Connection
9		No Connection

RS-422C Connections to Host PC with 9-pin D-type connector

Host PC		Control	
Signal Name	DB-9 Pin	Signal Name	DB-9 Pin
Shield	1	Shield	N/C
RxD-	3	TxD-	2
TxD-	2	RxD-	3
RxD+	7	TxD+	4
TxD+	4	RxD+	7
Common	5	Common	5

RS-422 Connections to Host PC with 25-pin D-type connector

Host PC		Control	
Signal Name	DB-25 Pin	Signal Name	DB-9 Pin
Shield	1	Shield	N/C
RxD -	3	TxD -	2
TxD -	2	RxD -	3
RxD +	14	TxD +	4
TxD +	16	RxD +	7
Common	7	Common	5

Serial Port Jumpers

The following Jumper selections for proper operation of the Rev D serial communication card.

Jumper Settings

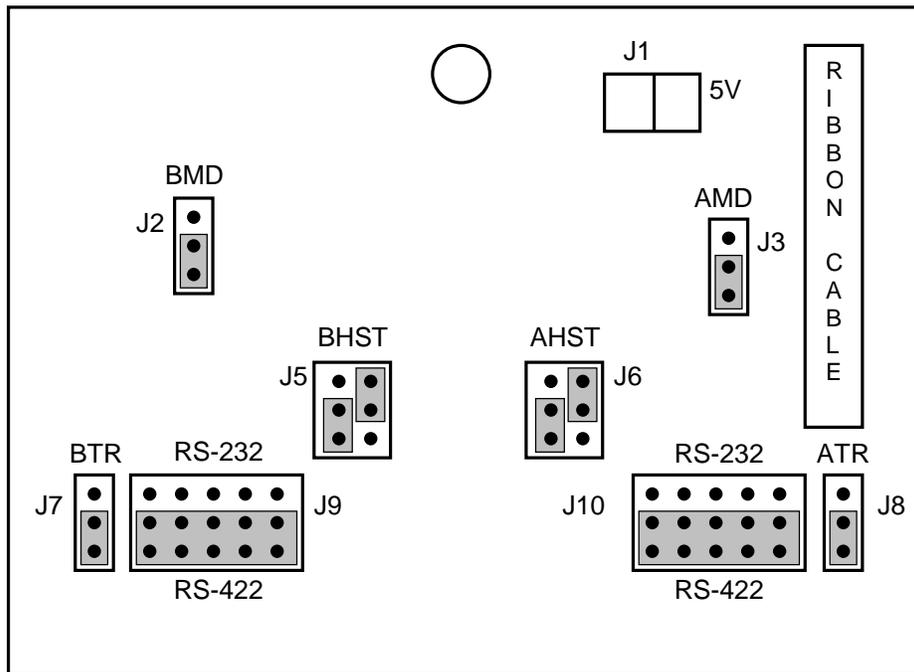
Location	Designation	Description
J3	AMD	Port A Multidrop .
J2	BMD	Port B Multidrop
J6	AHST	Port A Host
J5	BHST	Port B Host
J8	ATR	Port A Termination Resistor
J7	BTR	Port B Termination Resistor
J9	RS-232 / RS-422	RS-232 / RS-422 selection jumper
J10	RS-232 / RS-422	RS-232 / RS-422 selection jumper

Definitions

- Multi-drop** Used to enable / disable the multi-drop feature for communication to multiple controls through one link program..
- Host** Used to configure the card as a host serial card for multi-drop. Requires additional Hardware.
- Termination Resistor** The Termination Resistor is used to add resistance to the communications system for the end controls in a multi-drop system.

RS- 232 / 422 Configuration

The jumpers on J9 and J10 would be placed in position for RS-232 or RS-422 for operation on the appropriate port. Selection may vary slightly depending on control type.



Appendix F: ASCII Codes

This appendix provides the 128 ASCII codes (American Standard Code for Information Interchange) as defined by ANSI (American National Standards Institute) Standard X3.4-1977.

Control Codes

Hex	Dec	Character	Name	Description
00	0	^ @	NUL	Null
01	1	^A	SOH	Start of Header
02	2	^B	STX	Start of Text
03	3	^C	ETX	End of Text
04	4	^D	EOT	End of Transmission
05	5	^E	ENQ	Enquiry
06	6	^F	ACK	Acknowledge
07	7	^G	BEL	Bell
08	8	^H	BS	Backspace
09	9	^I	HT	Horizontal Tab
0A	10	^J	LF	Line Feed
0B	11	^K	VT	Vertical Tab
0C	12	^L	FF	Form Feed
0D	13	^M	CR	Carriage Return
0E	14	^N	SO	Shift Out
0F	15	^O	SI	Shift In
10	16	^P	DLE	Data Link Escape
11	17	^Q	DC1	Device Control 1
12	18	^R	DC2	Device Control 2
13	19	^S	DC3	Device Control 3
14	20	^T	DC4	Device Control 4
15	21	^U	NAK	Negative Acknowledge
16	22	^V	SYN	Synchronous Idle
17	23	^W	ETB	End Transmission Block
18	24	^X	CAN	Cancel
19	25	^Y	EM	End of Medium
1A	26	^Z	Sub	Substitute
1B	27	^[ESC	Escape
1C	28	^\ ^	FS	File Separator
1D	29	^] ^	GS	Group Separator
1E	30	^^ ^	RS	Record Separator
1F	31	^_ ^	US	Unit Separator
20	32		SP	Space

All Codes

Hex	Dec	Symbol	Hex	Dec	Symbol	Hex	Dec	Symbol
00	0	^ @	2B	43	+	56	86	V
01	1	^A	2C	44	,	57	87	W
02	2	^B	2D	45	-	58	88	X
03	3	^C	2E	46	.	59	89	Y
04	4	^D	2F	47	/	5A	90	Z
05	5	^E	30	48	0	5B	91	[
06	6	^F	31	49	1	5C	92	\
07	7	^G	32	50	2	5D	93]
08	8	^H	33	51	3	5E	94	^
09	9	^I	34	52	4	5F	95	´
0A	10	^J	35	53	5	60	96	a
0B	11	^K	36	54	6	61	97	b
0C	12	^L	37	55	7	62	98	c
0D	13	^M	38	56	8	63	99	d
0E	14	^N	39	57	9	64	100	e
0F	15	^O	3A	58	:	65	101	f
10	16	^P	3B	59	;	66	102	g
11	17	^Q	3C	60	<	67	103	h
12	18	^R	3D	61	=	68	104	i
13	19	^S	3E	62	>	69	105	j
14	20	^T	3F	63	?	6A	106	k
15	21	^U	40	64	@	6B	107	l
16	22	^V	41	65	A	6C	108	m
17	23	^W	42	66	B	6D	109	n
18	24	^X	43	67	C	6E	110	o
19	25	^Y	44	68	D	6D	111	p
1A	26	^Z	45	69	E	70	112	q
1B	27	^[46	70	F	71	113	r
1C	28	^\	47	71	G	72	114	s
1D	29	^]	48	72	H	73	115	t
1E	30	^^	49	73	I	74	116	u
1F	31	^_	4A	74	J	75	117	v
20	32		4B	75	K	76	118	w
21	33	!	4C	76	L	77	119	x
22	34	"	4D	77	M	78	120	y
23	35	#	4E	78	N	79	121	z
24	36	\$	4F	79	O	7A	122	{
25	37	%	50	80	P	7B	123	
26	38	&	51	81	Q	7C	124	}
27	39	'	52	82	R	7D	125	~
28	40	(53	83	S	7E	126	←
29	41)	54	84	T	7F	127	
2A	42	,	55	85	U			

Appendix G: Networking

Overview

The optional Network feature allows the control to be incorporated directly into an office PC Network for part allocation. This feature is available on controls with both Windows 98[®] Window NT[®] or Windows XP[®] operating systems and requires a factory supplied Network card to be installed. Please see your control vendor for additional details on adding this feature.

Network System Requirements:

The Optional Networking feature is approved to work with

Window NT[®] Servers
Window NT[®] Workgroups
Window 98[®] Workgroups

Windows 98[®] and Windows NT[®] Controls

Setup Instructions:

- 1) System Administrator for the network must set up both a Computer Account and a User Account on the Server matching the items below to use on the network. The password for the account must be numeric and have administrator level access.
- 2) Physically connect to network. Fiber to 10/100 BaseT.
- 3) At the control, go to the Special Password Screen. Access the System Screen. Enter the items below on the System Setup Screen:

Computer Name "CNC"

Workgroup - Leave Blank for NT Server. Set Workgoup Name for workgroup networking.

Computer Description - Leave Blank

Username "Operator"

Password "1396" - Note that password is only shown in NT version

Domain - "AccountDomainName"

The screenshot shows a dialog box for network configuration. At the top, there is a section for 'Automated Backup' with four radio buttons: 'None', 'Daily', 'Weekly', and 'Monthly'. Below this are five text input fields: 'Computer Name', 'Workgroup', 'Computer Description', 'User Name', and 'Domain'. At the bottom of the dialog, there is a row of eight buttons: 'Backup Hard Drive', 'Scan Hard Disk', 'Defragment Hard Disk', 'Format Floppy Disk', 'Reset Setups', 'VirusScan Tools', 'NJWin Tools', and 'Done'.

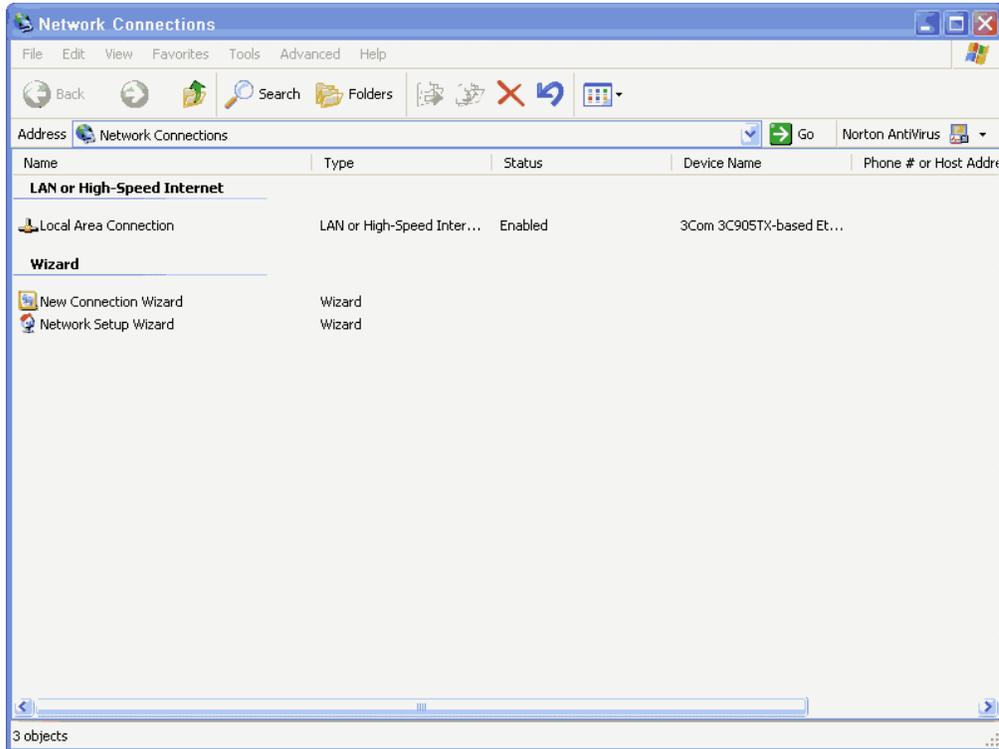
- 1) Once that is complete, Press DONE to exit and save. The user can cycle power on the control, and it should auto logon (i.e. no logon prompt).

Note: It may take as long as 20 –30 minutes for the Server to recognize the control.

Windows XP® Controls

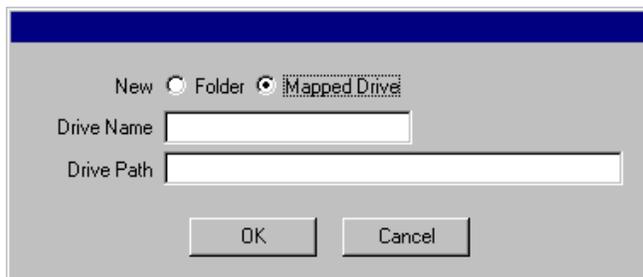
Network Tools

Pressing the Network Tools softkey accesses the Windows® XP Network Connection Utility. Network configuration and Network maintenance should only be performed by authorized personnel or system administrator.



To Map the control for loading files

- 1) Enable the Mapped Network Drive feature at the Special Password Screen.
- 2) At the files Screen, press the + Key. Enter the desired mapped drive location.



The control will automatically log on to the system at boot up.

Appendix H: Sensor™ THC

Diagnostics

Analog Input

The Sensor™ THC requires that additional inputs, outputs and analog voltage be brought in to the control to monitor the process. These signals are communicated to the control through an analog input card that has been installed into the control. In addition to THC operations, this analog input card may also be used for operation of an optional Joystick feature and external speed pots.

Note: View screens will vary depending upon the Analog Input Card being used.

Analog Input Series 1

<input type="radio"/> Off	-	Joystick Up	Analog Input 1	<input type="text" value="0.0"/>	volts
<input type="radio"/> Off	-	Joystick Down	Analog Input 2	<input type="text" value="0.0"/>	volts
<input type="radio"/> Off	-	Joystick Left	Analog Input 3	<input type="text" value="0.0"/>	volts
<input type="radio"/> Off	-	Joystick Right	Analog Input 4	<input type="text" value="0.0"/>	volts
<input type="radio"/> Off	-	Nozzle Contact Sense 1			
<input type="radio"/> Off	-	Nozzle Contact Sense 2			
	<input type="radio"/> Off	Nozzle Contact Enable 1			
	<input type="radio"/> Off	Hold Ignition 1			
	<input type="radio"/> Off	Nozzle Contact Enable 2			
	<input type="radio"/> Off	Hold Ignition 2			

Press SPACE to Change Output State

Inputs	Outputs	Analog Input	Done
--------	---------	--------------	------

Analog Input Series 2

<input type="radio"/> Off - Joystick Up	Analog Input 1	<input type="text" value="0.0"/>	volts		
<input type="radio"/> Off - Joystick Down	Analog Input 2	<input type="text" value="0.0"/>	volts		
<input type="radio"/> Off - Joystick Left	Analog Input 3	<input type="text" value="0.0"/>	volts		
<input type="radio"/> Off - Joystick Right	Analog Input 4	<input type="text" value="0.0"/>	volts		
PWM Output 1	<input type="text" value="0"/>	%	Analog Input 5	<input type="text" value="0.0"/>	volts
PWM Output 2	<input type="text" value="0"/>	%	Analog Input 6	<input type="text" value="0.0"/>	volts
PWM Output 3	<input type="text" value="0"/>	%	Analog Input 7	<input type="text" value="0.0"/>	volts
PWM Output 4	<input type="text" value="0"/>	%	Analog Input 8	<input type="text" value="0.0"/>	volts
PWM Output 5	<input type="text" value="0"/>	%	Analog Input 9	<input type="text" value="0.0"/>	volts
PWM Output 6	<input type="text" value="0"/>	%	Analog Input 10	<input type="text" value="0.0"/>	volts
Analog Output 1	<input type="text" value="0"/>	volts	Analog Input 11	<input type="text" value="0.0"/>	volts
Analog Output 2	<input type="text" value="0"/>	volts	Analog Input 12	<input type="text" value="0.0"/>	volts

Inputs Outputs Analog Input Done

Inputs / Outputs

Single Ended inputs and outputs located on the Analog Input Card are displayed.

Analog Inputs

The Analog Input values shown in the upper right hand of the screen are the actual voltages coming into the analog card. Analog inputs are assigned to the THC Axis and the Analog input for the appropriate THC may be viewed here.

Sensor™ THC Axis Setups

The THC Axis screen is designed specifically for use with the Sensor™ THC.

The screenshot shows the following configuration options:

- Proportional Gain:
- Integral Gain:
- Derivative Gain:
- Feedforward Gain:
- Velocity Gain:
- Voltage Gain:
- Servo Error Tolerance: in
- Stall Force Tolerance: in
- Encoder Counts per in:
- Drive Type: Velocity Current
- DAC Polarity: Positive Negative
- Encoder Polarity: Positive Negative
- Encoder Decode Mode: 1X 2X 4X
- Slide Length: in
- Home:

At the bottom, there are three tabs: Transverse, Rail, and **THC**. A **Done** button is located in the bottom right corner.

Stall Force

The Stall Force Parameter allows the user to select the amount of Following Error (inches / mm) to be used as the motion limit when Homing or performing manual IHS / plate sensing. Example: If the value is set to .1 inches, the THC Axis will continue to move the axis until .1 inches of following error has been reached. The will indicate the Plate location during IHS and will indicate the top of the slide during homing.

Slide Length

This parameter is used to specify the overall motion length of the Slide mechanism being used for the THC. This information is used to set the travel limits of the slide after homing.

Home

The Home parameter is used to activate use of the Home feature for the THC Axis. Depending on the Slide mechanism used, the THC may be Homed to Hard Stop, Hard Stop w/ Current Limit or Home Switch.

Note:

The THC Enable Input used during Sensor™ THC Homing as for Current Limit input if the “Home to Hard Stop Current Limited” option is selected.

The Nozzle contact Sense Input used during Sensor™ THC Homing as the Home Switch input if the “Home to Switch” option is selected.

THC Speeds

Speed 0 to	<input type="text" value="500"/>	to	<input type="text" value="1000"/>	ipm
Acceleration Rate	<input type="text" value="10"/>		<input type="text" value="10"/>	mG
Fast Stop Deceleration Rate	<input type="text" value="100"/>			mG
Maximum Machine Speed	<input type="text" value="1000"/>			ipm
High Jog Speed	<input type="text" value="10"/>			ipm
Medium Jog Speed	<input type="text" value="10"/>			ipm
Low Jog Speed	<input type="text" value="10"/>			ipm
Minimum Corner Speed	<input type="text" value="10"/>			ipm
Marker Speed	<input type="text" value="10"/>			ipm
Fast Home Speed	<input type="text" value="20"/>			ipm
Slow Home Speed	<input type="text" value="10"/>			ipm
Creep Speed	<input type="text" value="25"/>			% of Cut Speed
Plasma Hi/Lo Speed	<input type="text" value="90"/>			% of Cut Speed
Plasma Distance to Corner	<input type="text" value="0"/>			in
Plasma Distance from Corner	<input type="text" value="0"/>			in
THC Acceleration Rate	<input type="text" value="50"/>			mG
Maximum THC Speed	<input type="text" value="600"/>			ipm
THC Jog Speed	<input type="text" value="200"/>			ipm
THC Home / Fast IHS Speed	<input type="text" value="50"/>			ipm
THC Slow IHS Speed	<input type="text" value="5"/>			ipm

Machine Speeds Link I / O Axes Done

THC Acceleration Rate

This parameter allows the operator to set the acceleration rate for smooth and stable movement of the Sensor™ Torch Height Control. The higher the acceleration rate, the quicker the THC will get up to speed. The lower the acceleration rate, the smoother the machine will position the cutting device. Values are entered in Milligees.

Maximum THC Speed

Enter the maximum speed for the Sensor™ THC movement in inches/millimeters per minute.

THC Jog Speed

Enter a value for the desired THC jog speed.

THC Home/Fast IHS Speed

The THC Home/Fast IHS Speed entered here is used to home the torch at the top of the slide and to quickly maneuver the torch from the selected IHS height to the plate.

THC Slow IHS Speed

The THC IHS Speed is used to retract the torch after the plate has been sensed. The torch will retract at this speed until the contact sense is lost. This determines the exact distance to the plate, regardless of any flexing of the plate. A very small speed is recommended for optimal accuracy.

Note: Due to the quick response time of the Sensor™ THC, generally there is no need for a value to be entered at the “Distance to Corner” parameter to lock or “freeze” the position of the torch. It is, however, suggested that a value be entered for the “Distance from Corner” to stabilize the torch during acceleration.

THC I/O

Input Logic <input type="text" value="0"/>		Joystick Installed <input checked="" type="radio"/> No <input type="radio"/> Yes										
<table border="1"> <thead> <tr> <th>Normally</th> <th>Input</th> </tr> </thead> <tbody> <tr> <td>Open</td> <td>- Torch Up Sense</td> </tr> <tr> <td>Open</td> <td>- Torch Down Sense</td> </tr> <tr> <td>Open</td> <td>- X-Overtravel Switch</td> </tr> <tr> <td>Open</td> <td>- Cut Sense</td> </tr> </tbody> </table>		Normally	Input	Open	- Torch Up Sense	Open	- Torch Down Sense	Open	- X-Overtravel Switch	Open	- Cut Sense	Speed Pot. Installed <input type="radio"/> No <input checked="" type="radio"/> Yes
Normally	Input											
Open	- Torch Up Sense											
Open	- Torch Down Sense											
Open	- X-Overtravel Switch											
Open	- Cut Sense											
Input 1 <input type="text" value="Input 1"/> - Torch Up Sense <input type="text" value="Torch Up Sense"/>		Plasma Override <input type="text" value="70"/> to <input type="text" value="130"/> %										
		Oxy Fuel Override <input type="text" value="0"/> to <input type="text" value="120"/> %										
		Speed Pot. 1 <input type="text" value="Speed Pot. 1"/> Installed on <input type="text" value="Analog 2"/>										
		Analog Offset 1 <input type="text" value="Analog Offset 1"/> <input type="text" value="0.1"/> volts										
Output Logic <input type="text" value="0"/>												
<table border="1"> <thead> <tr> <th>Normally</th> <th>Output</th> </tr> </thead> <tbody> <tr> <td>Open</td> <td>- Torch Up</td> </tr> <tr> <td>Open</td> <td>- Torch Down</td> </tr> <tr> <td>Open</td> <td>- Ignition</td> </tr> <tr> <td>Open</td> <td>- Torch Height Disable</td> </tr> </tbody> </table>		Normally	Output	Open	- Torch Up	Open	- Torch Down	Open	- Ignition	Open	- Torch Height Disable	
Normally	Output											
Open	- Torch Up											
Open	- Torch Down											
Open	- Ignition											
Open	- Torch Height Disable											
Output 1 <input type="text" value="Output 1"/> - Torch Up <input type="text" value="Torch Up"/>												
Drive Enables <input checked="" type="radio"/> Independent <input type="radio"/> Series												
<table border="1"> <tr> <td>Machine</td> <td>Speeds</td> <td>Link</td> <td>I/O</td> <td>Axes</td> <td>Done</td> </tr> </table>			Machine	Speeds	Link	I/O	Axes	Done				
Machine	Speeds	Link	I/O	Axes	Done							

Analog Offset 1 - 12

The Analog Offsets 1 through 12 are used to correct for any imbalance or “zero” the incoming analog voltage to the Analog Input Card. Analog inputs are assigned to the THC Axis and the Analog Offsets for the appropriate THC Analog input may be adjusted here.

To calibrate the Analog Inputs, jumper the two pins specific to the input together and view the incoming voltage at the Diagnostics Analog I/O screen. The incoming voltage should be zero. If any voltage is displayed at the diagnostic screen, an Offset Voltage equal to the incoming voltage being read can be entered here to “zero” the incoming voltage. Please refer to the installation instructions later in this section for more details.

Sensor™ THC Part Program Support

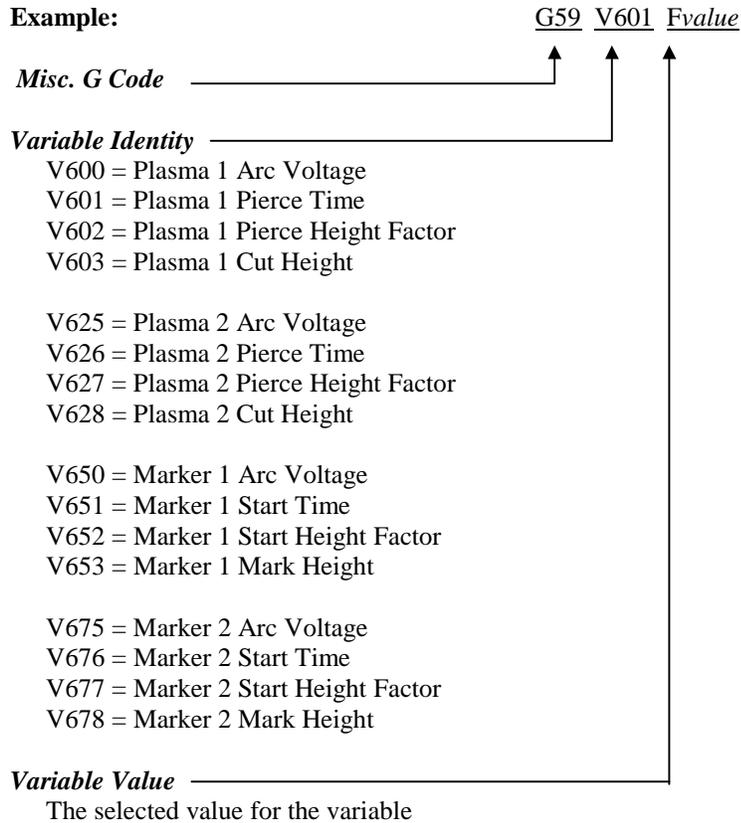
Sensor™ THC offers the ability to configure THC setup parameters through part program codes.

The following parameters are available for use using EIA-274D G59 codes:

Arc Voltage
Pierce / Start Time
Pierce/ Start Height Factor
Cut / Mark Height

Setup is obtained using the following format.

Example:



Installation and THC Interface

The Sensor™ THC is supported through various hardware configurations to offer single and multiple Sensor™ THC operation. Please refer to your exact hardware configuration when installing the Sensor™ THC.



Warning! Due to potentially high voltages, extreme care should be taken when working inside the plasma power supply. Work should only be performed by trained service personnel. Please refer to Power Supply manufacturer instructions.

Sensor™ THC w/ Series 1 ISA Analog Card and Series 2 Voltage Divider Card

This section refers to the following hardware configuration. *Note:* The Analog Card will be designated as Rev 0 in the Control Information Diagnostic screen.

Series 1 ISA Analog Card (Board Marking PC-012-1098 Rev. B)	Part # PCBS-0010-B
Series 2 Voltage Divider Card (Board Marking PC-026-500 Rev.)	Part # PCBS-0047

Instructions

If the voltage divider card has not been installed in the plasma power supply, mount the card in an accessible location away from high electrical noise areas. Wire the VDC to the appropriate signal inside the power supply as outlined in the following pinout information

Voltage Divider Card Pinout (Series 2)

Divider PCB - 2C Connector J1

(**Note:** +24VDC supply to be provided from inside the power supply)

Pin #	Description
1	+24 VDC Power Input
2	+24 VDC Common Input

Mating Connector

2C Phoenix Connector – Phoenix Part # 1840366

Divider PCB - 6C Connector J2 To Control

Pin #	Description
1	Nozzle Contact Sense
2	+24 Common
3	Nozzle Contact Enable
4	Analog In 1+
5	Analog In 1–
6	E Ground

Mating Connector

6C Phoenix Connector – Phoenix Part # 1840405

Divider PCB - 5C Connector J3 to Power Supply / Table

Pin Number	Description
1	Ground (Chassis Ground)
2	Electrode (Plasma DC –)
3	Work (Plasma DC +)
4	NC
5	Shield (Nozzle Contact)

Mating Connector

Terminal Connections

Control & Cable Pinout for Sensor™ THC**I/O Configuration Type “V”**

Control 8C		Divider J2
Analog Pin #	Description	Pin #
1	Analog +	J2 - 4
2	Analog –	J2 - 5
3	Nozzle Contact Sense +	J1 - 1
4	Nozzle Contact Sense –	J2 - 1
5	Nozzle Contact Enable +	J2 - 3
6	Nozzle Contact Enable –	J2 - 2
7	Hold Ignition +	N/A (direct to power supply)*
8	Hold Ignition –	N/A (direct to power supply)*

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

* **Note:** It is recommended that the Hold ignition input be wired to the Power Supply through an external relay for noise immunity. Please refer to Instructions from supply manufacturer for details on connection to the Hold Ignition Input.

Sensor™ THC w/ Series 1 ISA Analog Card and Series 3 Voltage Divider Card

This section refers to the following hardware configuration. *Note:* The Analog Card will be designated as Rev 0 in the Control Information Diagnostic screen.

Series 1 ISA Analog Card (Board Marking PC-012-1098 Rev. B)
Series 3 Voltage Divider Card

Part # PCBS-0010-B
Part # PCBS-0061

Instructions

If the voltage divider card has not been installed in the plasma power supply, mount the card in an accessible location away from high electrical noise areas. Wire the VDC to the appropriate signal inside the power supply as outlined in the following pinout information

Voltage Divider Card Pinout (Series 3)**Divider PCB - 2C Connector J1**

Pin #	Description
1	85 -265 VAC Power Input (47-63Hz)
2	85 -265 VAC Neutral Input

Mating Connector

2C Phoenix Connector – Phoenix Part # 1840366

Divider PCB - 8C Connector J2 To Control

Pin #	Description
1	+24 VDC Common
2	+24 VDC
3	Nozzle Contact Sense
4	Nozzle Contact Enable
5	+24 VDC Common
6	Analog Out +
7	Analog Out –
8	E Ground

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

Divider PCB - 5C Connector J3 to Power Supply / Table

Pin Number	Description
1	Ground (Chassis Ground)
2	Electrode (Plasma DC –)
3	Work (Plasma DC +)
4	NC
5	Shield (Nozzle Contact)

Mating Connector

Terminal Connections

Control & Cable Pinout for Sensor™ THC**I/O Configuration Type “V”**

Control 8C		Divider J2
Analog Pin #	Description	Pin #
1	Analog +	J2 - 6
2	Analog –	J2 - 7
3	Nozzle Contact Sense +	J2 - 2
4	Nozzle Contact Sense –	J2 - 3
5	Nozzle Contact Enable +	J2 - 4
6	Nozzle Contact Enable –	J2 - 5
7	Hold Ignition +	N/A (direct to power supply)*
8	Hold Ignition –	N/A (direct to power supply)*
N/C	Shield	J2 - 8

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

* **Note:** It is recommended that the Hold ignition input be wired to the Power Supply through an external relay for noise immunity. Please refer to Instructions from supply manufacturer for details on connection to the Hold Ignition Input.

Sensor™ THC w/ Series 2 Analog Card and Series 2 Voltage Divider Card

This section refers to following hardware configuration. *Note:* The Analog Card will be designated as Rev A in the Control Information Diagnostic screen.

Series 2 Analog Card / PWM Interface (Board Marking PC-023-0100 Rev.)	Part # PCBS-0040
Series 2 Voltage Divider Card (Board Marking PC-026-500 Rev.)	Part # PCBS-0047

Instructions

If the voltage divider card has not been installed in the plasma power supply, mount the card in an accessible location away from high electrical noise areas. Wire the VDC to the appropriate signal inside the power supply as outlined in the following pinout information

Voltage Divider Card Pinout**Divider PCB - 2C Connector J1**

(**Note:** +24VDC supply to be provided from inside the power supply)

Pin #	Description
1	+24 VDC Power Input
2	+24 VDC Common Input

Mating Connector

2C Phoenix Connector – Phoenix Part # 1840366

Divider PCB - 6C Connector J2 To Control

Pin #	Description
1	Nozzle Contact Sense
2	+24 Common
3	Nozzle Contact Enable
4	Analog In 1+
5	Analog In 1–
6	E Ground

Mating Connector

6C Phoenix Connector – Phoenix Part # 1840405

Divider PCB - 5C Connector J3 to Power Supply / Table

Pin Number	Description
1	Ground (Chassis Ground)
2	Electrode (Plasma DC –)
3	Work (Plasma DC +)
4	NC
5	Shield (Nozzle Contact)

Mating Connector

Terminal Connections

Sensor™ THC w/ Series 2 Analog Card and Series 3 Voltage Divider Card

Series 2 Analog Card / PWM Interface (Board Marking PC-023-0100 Rev.)
 Series 3 Voltage Divider Card

Part # PCBS-0040
 Part # PCBS-0061

Instructions

If the voltage divider card has not been installed in the plasma power supply, mount the card in an accessible location away from high electrical noise areas. Wire the VDC to the appropriate signal inside the power supply as outlined in the following pinout information

Voltage Divider Card Pinout (Series 3)**Divider PCB - 2C Connector J1**

Pin #	Description
1	85 -265 VAC Power Input (47-63Hz)
2	85 -265 VAC Neutral Input

Mating Connector

2C Phoenix Connector – Phoenix Part # 1840366

Divider PCB - 8C Connector J2 To Control

Pin #	Description
1	+24 VDC Common
2	+24 VDC
3	Nozzle Contact Sense
4	Nozzle Contact Enable
5	+24 VDC Common
6	Analog Out +
7	Analog Out –
8	E Ground

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

Divider PCB - 5C Connector J3 to Power Supply / Table

Pin Number	Description
1	Ground (Chassis Ground)
2	Electrode (Plasma DC –)
3	Work (Plasma DC +)
4	NC
5	Shield (Nozzle Contact)

Mating Connector

Terminal Connections

I/O Configuration Type “V”

Due to the ability to select the Analog Input being used for a selected THC and the ability to configure the Input and Output locations, no exact or standard Pinout for the THC connections is available. Connections would be made by selecting the Analog Input for the desired THC and connecting the Analog signals from the Voltage Divider Card. In much the same manner, the required Nozzle Contact Sense, Nozzle Contact Enable and Hold Ignition I/O points would be selected and connected to the corresponding appropriate pins on the Voltage Divider Card.

Description	Divider J2 Pin #
Analog +	J2 - 6
Analog –	J2 - 7
Nozzle Contact Sense +	J2 - 2
Nozzle Contact Sense –	J2 - 3
Nozzle Contact Enable +	J2 - 4
Nozzle Contact Enable –	J2 - 5
Hold Ignition +	N/A (direct to power supply)*
Hold Ignition –	N/A (direct to power supply)*
Shield	J2 - 8

* **Note:** It is recommended that the Hold Ignition input be wired to the Power Supply through an external relay for noise immunity. Please refer to Instructions from the supply manufacturer for details on connection to the Hold Ignition Input.

Sensor™ THC w/ Series 1 PCI Analog Card and Series 2 Voltage Divider Card

This section refers to following hardware configuration. *Note:* The Analog Card will be designated as Rev 0 in the Control Information Diagnostic screen.

Series 1 PCI Analog Card (Board Marking PCBS-0073)
Series 2 Voltage Divider Card (Board Marking PC-026-500 Rev.)

Part # PCBS-0074
Part # PCBS-0047

Instructions

If the voltage divider card has not been installed in the plasma power supply, mount the card in an accessible location away from high electrical noise areas. Wire the VDC to the appropriate signal inside the power supply as outlined in the following pinout information

Voltage Divider Card Pinout (Series 2)

Divider PCB - 2C Connector J1

(**Note:** +24VDC supply to be provided from inside the power supply)

Pin #	Description
1	+24 VDC Power Input
2	+24 VDC Common Input

Mating Connector

2C Phoenix Connector – Phoenix Part # 1840366

Divider PCB - 6C Connector J2 To Control

Pin #	Description
1	Nozzle Contact Sense
2	+24 Common
3	Nozzle Contact Enable
4	Analog In 1+
5	Analog In 1–
6	E Ground

Mating Connector

6C Phoenix Connector – Phoenix Part # 1840405

Divider PCB - 5C Connector J3 to Power Supply / Table

Pin Number	Description
1	Ground (Chassis Ground)
2	Electrode (Plasma DC –)
3	Work (Plasma DC +)
4	NC
5	Shield (Nozzle Contact)

Mating Connector

Terminal Connections

Control & Cable Pinout for Sensor™ THC**I/O Configuration Type “P”**

Note: A 9C Amp connector is provided on the back of the control (I/O Type “P”) for interfacing.

Control 9C Analog Pin #	Description	Divider Pin #
1	24V Common	J2-2
2	Nozzle Contact Sense +	J1-1
3	Nozzle Contact Sense –	J2-1
4	Nozzle Contact Enable +	J2-3
5	Nozzle Contact Enable –	J2-2
6	Analog +	J2-4
7	Analog –	J2-5
8	Hold Ignition +	N/A (direct to power supply)*
9	Hold Ignition –	N/A (direct to power supply)*
Ground Stud	Shield	No Connection

Analog Mating Connector

Connector AMP # 206708-1

Backshell AMP #206966-1

Sockets #66105-3 (20-24 ga)

VDC Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

Cable

Belden #9505 or equivalent

Note: It is recommended that the Hold Ignition input be wired to the Power Supply through an external relay for noise immunity. Please refer to instructions from supply manufacturer for details on connection to the Hold Ignition Input.

Sensor™ THC w/ Series 1 Analog Card and Series 3 Voltage Divider Card

This section refers to following hardware configuration. *Note:* The Analog Card will be designated as Rev 0 in the Control Information Diagnostic screen.

Series 1 PCI Analog Card (Board Marking PCBS-0073)
Series 3 Voltage Divider Card

Part # PCBS-0074
Part # PCBS-0061

Instructions

If the voltage divider card has not been installed in the plasma power supply, mount the card in an accessible location away from high electrical noise areas. Wire the VDC to the appropriate signal inside the power supply as outlined in the following pinout information

Voltage Divider Card Pinout (Series 3)

Divider PCB - 2C Connector J1

Pin #	Description
1	85 -265 VAC Power Input (47-63Hz)
2	285 -265 VAC Neutral Input

Mating Connector

2C Phoenix Connector – Phoenix Part # 1840366

Divider PCB - 8C Connector J2 To Control

Pin #	Description
1	+24 VDC Common
2	+24 VDC
3	Nozzle Contact Sense
4	Nozzle Contact Enable
5	+24 VDC Common
6	Analog Out +
7	Analog Out –
8	E Ground

Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

Divider PCB - 5C Connector J3 to Power Supply / Table

Pin Number	Description
1	Ground (Chassis Ground)
2	Electrode (Plasma DC –)
3	Work (Plasma DC +)
4	NC
5	Shield (Nozzle Contact)

Mating Connector

Terminal Connections

Control & Cable Pinout for Sensor™ THC**I/O Configuration Type “P”**

Note: A 9C Amp connector is provided on the back of the control (I/O Type “P”) for interfacing.

Control 9C		Divider J2
Analog Pin #	Description	Pin #
1	24V Common	1
2	Nozzle Contact Sense +	2
3	Nozzle Contact Sense –	3
4	Nozzle Contact Enable +	4
5	Nozzle Contact Enable –	5
6	Analog +	6
7	Analog –	7
8	Hold Ignition +	N/A (direct to power supply)*
9	Hold Ignition –	N/A (direct to power supply)*
Ground Stud	Shield	No Connection

Analog Mating Connector

Connector AMP # 206708-1

Backshell AMP #206966-1

Sockets #66105-3 (20-24 ga)

VDC Mating Connector

8C Phoenix Connector – Phoenix Part # 1803633

Cable

Belden #9505 or equivalent

* **Note:** It is recommended that the Hold Ignition input be wired to the Power Supply through an external relay for noise immunity. Please refer to Instructions from the supply manufacturer for details on connection to the Hold Ignition Input.

Calibration

Series 1 Analog Card

Note: The Series 1 Analog Card will be designated as Rev 0 in the Control Information Diagnostic screen.

Board Marking PC-012-1098 Rev. B Part # PCBS-0010-B

After the voltage divider card and control cabling have been connected, the system is ready to be calibrated for use.

Analog Offset: To adjust the Analog Offset, place a jumper on the Analog In signals on the Analog input card or at the 9C connection for the Analog Input Card located at the back of the control. The analog input voltage would then be viewed at the I/O Diagnostics screen to read any incoming voltage for the THC. If any voltage is displayed at the diagnostic screen, an Offset Voltage equal to the incoming voltage being read can be entered at the Password protected Analog I/O screen to correct for any imbalance and “zero” the incoming voltage

Example: If an incoming Analog Input Voltage is reading .1 volts, simply enter .1 at the Analog Offset and correct the imbalance.

Series 2 Analog Card

Note: The Analog Card will be designated as Rev A in the Control Information Diagnostic screen.

Board Marking PC-023-0100 Rev. Part # PCBS-0040

After the voltage divider card and control cabling have been connected, the system is ready to be calibrated for use.

Analog Offset: To adjust the Analog Offset, place a jumper on the Analog In signals on the Analog Input Card. The analog input voltage would then be viewed at the I/O Diagnostics screen to read any incoming voltage for the THC. If any voltage is displayed at the diagnostic screen, an Offset Voltage equal to the incoming voltage being read can be entered at the Password protected Analog I/O screen to correct for any imbalance and “zero” the incoming voltage

Example: If an incoming Analog Input Voltage is reading .1 volts, simply enter .1 at the Analog Offset and correct the imbalance.

Series 2 and 3 Voltage Divider Card

Note: No Calibration is required for the Series 2 or 3 Voltage Divider Card.



Warning! The Series 2 Analog card is not compatible with the Series 1 Voltage divider card.

Appendix I: Command® THC

Machine Interface



Warning! Configure the port for RS-422 operation before connecting to the Command® THC. The Command THC Link must first be enabled in Machine Setups for Type “P” controls and at the Station configuration for type “V” controls. Refer to the Serial Port section of this guide for additional information on configuring the serial port for RS-422 communication.

Port Designation

Serial communications for the Command® THC would automatically be set to the serial port which is not selected for serial communications. Example: If Serial Port 1 is designated for use as the link to the Host PC for Downloading of part programs, the HD4070® communications would be established on Serial Port 2.

Type “V” control may select the serial port designation at the Ports configuration screen.

RS-422 Connections to Command® THC with 25-pin D-type connector

Command® THC		Control	
Signal Name	DB-9 Pin	Signal Name	DB-9 Pin
RxD -	1	TxD -	2
TxD -	2	RxD -	3
RxD +	20	TxD +	4
TxD +	21	RxD +	7

For improved noise immunity, it is recommended that the cable shields for communication be tied to ground. Ferrite bead with several wraps on the cable may also be used.

Appendix J: Speed Pot and Joystick

Speed Pot and Joystick Overview

Through the use of Single Ended Inputs to an optional Analog Input Card installed in the control, your shape cutting control may be configured to support an external Joystick or Two Speed Potentiometers. Note: These features are not available for all control types and optional control hardware is required.

The external Joystick is used as a directional command signal when in manual motion.

The optional Speed Pot may be used to adjust the current motion speed.

These features must first be enabled at the password protected I/O screen for use.

Analog Card I/O

Input Logic

Normally	Input
Open	Torch Up Sense
Open	Torch Down Sense
Open	X-Overtravel Switch
Open	Cut Sense

Input 1

Output Logic

Normally	Output
Open	Torch Up
Open	Torch Down
Open	Ignition
Open	Torch Height Disable

Output 1

Joystick Installed No Yes

Speed Pot. Installed No Yes

Plasma Override to %

Oxy Fuel Override to %

Speed Pot. 1 Installed on

Analog Offset 1 volts

Drive Enables Independent Series

Machine Speeds Link I/O Axes Done

Joystick Installed

Select "Yes" to enable the optional external Joystick.

Speed Pot Installed

Select "Yes" to enable the optional external Speed Potentiometer.

Plasma Override %

The Plasma Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the plasma Speed Pot based on a percentage of the set cut speed. The Speed Pot feature must be enabled for use.

Oxy Fuel Override %

The Oxy Fuel Override feature is used in conjunction with the Speed Pot feature to set the minimum and maximum range of adjustment of the oxy fuel Speed Pot based on a percentage of the set cut speed. The Speed Pot feature must be enabled for use.

Speed Pot Installed On

The Speed Pot Installed On Parameter is used to assign Speed Pot inputs to a desired the Analog Input, if a dedicated Speed Pot input is not available on the Analog Input Card being used.

Analog Offset 1- 12

The Analog Offsets 1 through 12 are used to correct for any imbalance or "Zero" the incoming analog voltage to the Analog Input Card. Analog Offsets 1 and 2 are used for the THC 1 and THC 2 feature. Analog Offsets 3 & 4 are used for Speed Pot 1 and Speed Pot 2.

To calibrate the Analog Inputs, jumper the two pins specific to the input together and view the incoming voltage at the Diagnostics Analog I/O screen. The incoming voltage should be zero. If any voltage is displayed at the diagnostic screen, an Offset Voltage equal to the incoming voltage being read can be entered here to "Zero" the incoming voltage. Please refer to the installation instructions later in this section for more details.

Analog Input Diagnostics

The screenshot displays the 'Analog Input Diagnostics' interface. It features several sections:

- Joystick Status:** Four rows, each with a red indicator light, the text 'Off', and a label: 'Joystick Up', 'Joystick Down', 'Joystick Left', and 'Joystick Right'.
- PWM Outputs:** Six rows labeled 'PWM Output 1' through '6', each with a numerical input field set to '0' and a '%' symbol.
- Analog Outputs:** Two rows labeled 'Analog Output 1' and '2', each with a numerical input field set to '0' and the text 'volts'.
- Analog Inputs:** Twelve rows labeled 'Analog Input 1' through '12', each with a numerical input field set to '0.0' and the text 'volts'.
- Navigation:** At the bottom, there are three buttons: 'Inputs', 'Outputs', and 'Analog Input' (which is currently selected). A 'Done' button is located in the bottom right corner.

Note: View screen may vary depending on the Analog Input Card installed.

Inputs

The Analog Input Card required to operate the optional Joy Stick and Speed Pots is equipped with six low voltage Inputs that are optically isolated and can operate at 24 – 120 VAC/DC. The first four inputs are used for the optional Joystick feature and inputs five and six are used to support THC One and THC Two Nozzle Contact Sense respectively. The Input Logic for these inputs is normally open.

Analog Inputs

The Analog Input values shown in the upper right hand of the screen are the actual voltages coming into the analog card. Analog Inputs one and two are used for THC One and Two. Analog inputs three and four are used for optional external speed pot referencing.

I/O Interface

Series 1 ISA Analog Card

Pin # Description

1	Joystick Up
2	Joystick Down
3	Joystick Left
4	Joystick Right
5	E-Ground
6	No Connection
7	No Connection
8	No Connection
9	No Connection

Note: Joystick inputs are activated by passing the Common signal (pin 5) to the desired input. Analog inputs for the speedpots are rated at 0 - +10VDC

Joystick Mating Connectors

Connector AMP #206708-1

Backshell AMP #206966-1

Sockets (20-24 ga) AMP #66105-3

Cabling: Use CAROL #C0603 or equivalent

Series 1 PCI Analog Card

Pin #	Designation	Description
1	Input 1	Joystick UP
2	Input 2	Joystick DWN
3	Input 3	Joystick LT
4	Input 4	Joystick RT
5	Common	Common
6	Analog Input 3 +	Speed Pot 1
7	Analog Input 3 -	Speed Pot 1
8	Analog Input 4 +	Speed Pot 2
9	Analog Input 4 -	Speed Pot 2
	Ground Stud	Shield

Note: Joystick inputs are activated by passing the Common signal (pin 5) to the desired input. Analog inputs for the speedpots are rated at 0 - +10VDC

Mating Connector

Connector AMP #206708-1

Backshell AMP #206966-1

Sockets (20-24 ga) AMP #66105-3

Cabling: Use Belden # 9504 or equivalent

THC and Joystick Cable Grounding

Cable shields should be tied to the external PE studs for optimum noise immunity.

Series 2 Analog Interface Card**J5 - I/O**

Pin #	Designation	Description
1	Joystick IN1	Joystick Up (single ended – active by E-ground)
2	Joystick IN2	Joystick Down (single ended – active by E-ground)
3	Joystick IN3	Joystick Left (single ended – active by E-ground)
4	Joystick IN4	Joystick Right (single ended – active by E-ground)
5	E Ground	Joystick Common
6	Chassis Ground	Shield
7	Analog In 6 +	Speed Pot 1 +
8	Analog In 6 -	Speed Pot 1 -
9	Chassis ground	Shield
10	Analog In 12 +	Speed Pot 2 +
11	Analog In 12 -	Speed Pot 2 -
12	Chassis Ground	Shield

Mating Connector

12C Phoenix Connector – Phoenix Part # 1803675

