



# Mark with Oxyfuel Powder and Cut with XPR with Legacy Part Programs – EDGE<sup>®</sup> Connect CNC

Application Note

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## Introduction

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Although legacy part programs should be reposted with CAM software, there is a manual way to use a legacy part program to mark M09 codes with oxyfuel powder and cut M07 codes with XPR. Follow the guidelines and special sequence of steps below.

## Guidelines

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- Control the CNC in Manual mode.
- Use the **Move to Pierce** function to **complete all oxyfuel powder marking first**.



It is not possible to switch from Plasma mode to Oxyfuel mode.

## Mark with oxyfuel powder and cut with XPR

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To use a legacy part program to mark with oxyfuel powder and cut with XPR:

1. In Phoenix, with the part program in **Oxyfuel** mode, press **Start** and then immediately press **Stop** to pause the program.
2. Choose **Move to Pierce** and select the first M09 code pierce point for oxyfuel powder marking.
3. Choose **Start** to begin oxyfuel powder marking.
4. As soon as all M09 marking codes are complete, immediately choose **Stop** to pause the part program.



If you wait too long to pause the program, then the plasma cutting M07 codes are cut with in Oxyfuel mode instead of in Plasma mode.

5. On the **Main** screen, choose **Change Cut Mode** and then choose **Plasma**.
6. Choose the **Move to Pierce** soft key to skip to the first M07 pierce in the part program.
7. Choose **Start** to resume plasma cutting with XPR.