



## ArcStar CAD CAM and CNC Workflow

Version 8.26

Start Cut2D PRO software program.

Click 'Create a New File'.

Job type - select 'single sided'.

Job Size - set larger than project.

Z Zero Position - n/a.

XY Datum Position = center.

### CAD

Import or design part using CAD tools on left margin.

Recommend turning on grid points - F4 opens snap options box.

When finished, group objects as one - Ctrl+A to highlight, then Ctrl+G to group.

Click right arrow at top of CAD menu to switch to CAM menu.

### CAM

Click 'Profile Toolpath' button under 'Toolpath Operations'.

Ensure 'Show advanced toolpath options' box is checked.

Tool - n/a.

Machine Vectors - Choose 'On'.

If desired, click 'Leads' tab - add lead ins, lead outs as desired.

Click 'Calculate' button, then 'Close' button.

Click 'Save Toolpath' button - Select inches or mm under 'Post Processor'.

Click 'Save Toolpath(s)' button to save file to USB stick

## ArcStar Plasma Table Workflow

### Pre-Cut Preparation

Select and load material onto ArcStar table.

Obtain height and speed values from plasma cutter cut charts.

Ensure plasma cutter ground lead properly attached to material.

Check plasma torch consumables.

Ensure ohmic lead attached to torch.

Ensure torch on/off kill switch set to 'On'.

Ensure appropriate air supply to plasma cutter.

Turn plasma cutter on. Set appropriate amps value from cut charts.

### ArcStar Table Preparation

Insert USB stick.

Turn ArcStar controller on.

Click 'File' / 'USB Disk', arrow down to filename, then push 'Select' / 'Run'.

In the main 'Auto' menu, press 'Z', then enter half the Kerf Width.

In the main 'Auto' menu, press '0' to open the 'Spd Set' menu.

Program the Cut Speed, then press F8 to save the value.

In the main 'Auto' menu, press 'Para' / 'Plasma'.

Set Arc Voltage - Program Arc Voltage.

Cutting Height - Program Cut Height.

Pierce Height - Program Pierce Height.

Pierce Delay - Program Pierce Delay.

Jog torch to material start position

Press K2 to detect material height

Press K1 to raise torch to upper limit

#### Cutting

Ensure operator is wearing appropriate eye and ear protection

Turn exhaust fan on

Press green 'Start' button to begin cutting

