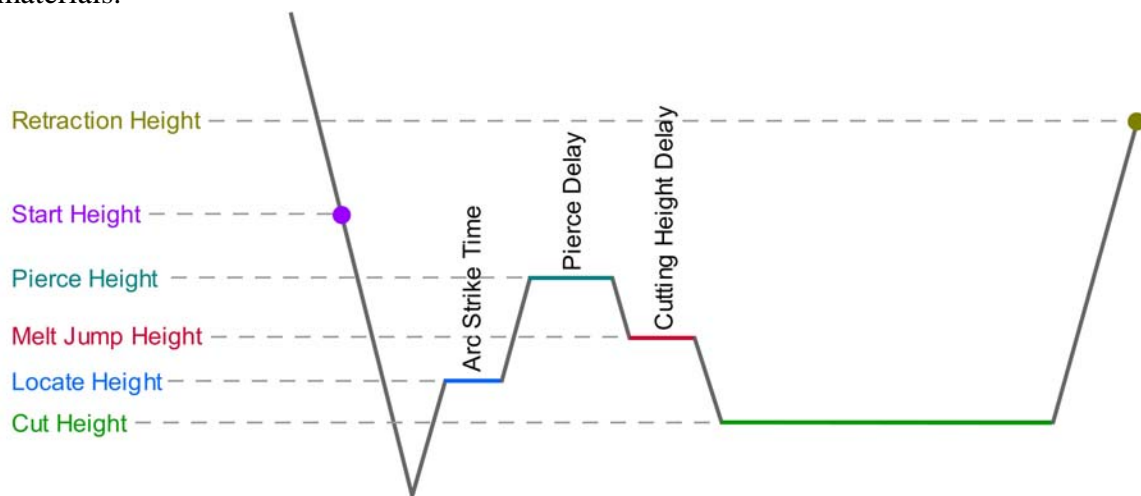




Plasma Table Heights

Version 8.26

Pressing K1 causes the torch to lift upwards at the fastest speed and touch the upper limit switch, stopping the movement. This is the highest position the torch can retract to, and is also known as 'Zero Height' (page 32). This option will only appear if '485 THC' has been selected in the 'Machine' tab under the 'Para' menu (page 28). Good to use when loading materials.



Start Height - manually entered value on the 'Machine' menu. Pressing K2 causes the torch to move downwards at it's fastest speed to the 'Start Height', slow to IHS speed, and then continue moving downward until it senses the material. It then raises up to 'Locate Height' (this option will only appear if '485 THC' has been selected on the 'Machine' tab, p 28).

Locate Height (page 32) = (Cutting Height) x (Arc Transfer H). Initial height of the arc strike, before the torch raises up to pierce the material. Pressing K key on the 'Auto' menu allows you to manually enter a value (be aware this will change the 'Cutting Height' value).

Pierce Height (page 25): Manually entered value via the 'Plasma' menu. Height at which the torch pierces the material.

Melt Jump Height - Set via the 'Plasma' menu (page 25). Percentage of Cutting Height. Used to skip over and avoid getting excess material blown back into the torch.

Cutting Height (page 25). Manually entered value via the 'Plasma' menu. Height at which the torch cuts the material.

Retraction Height (page 25): Manually entered value via the 'Plasma' menu. Height to which the torch retracts to when the cut is complete.

