



Welcome to ArcStar

Version 8.27

Congratulations on the purchase of your plasma table! You've purchased the best, and we're here to help. This article is meant to give you a recommended course of action on getting familiar with your new plasma table.

VERY IMPORTANT – MUST READ

**DO NOT PLUG IN the control stand or the plasma table.
DO NOT APPLY POWER until you've accomplished the following:**

You must do a very thorough internal and external inspection of the table and control stand. Check and fix any electrical components or wires that may have vibrated loose during transit.

The smoke exhaust fan ships separately from the table. It's power supply cord **MUST NOT BE PLUGGED IN until the fan wires have been properly connected to the fan relay block. You must do this BEFORE ANY CORD IS PLUGGED INTO POWER.**

The table and control stand ship as separate pieces, and are therefore not connected. The individual cables in the wire bundle between them must be connected properly. **BE VERY DILIGENT** when connecting the aviation style plugs to the connector plate of the control stand. The cables and ports are individually labeled, and must match. Make **CERTAIN** you positively match the cable identification to the connector plate identification. Because some of the ports have the same pin configuration, it's possible (if you're not paying attention) to plug them into the wrong port. Doing so **will damage** the electronics. **Be attentive, and be careful.**

We're including a number of helpful articles from our Library page. We'd recommend reading them all. Make sure to check back often for new and updated articles.

We're also including the latest copy of our Operator's Manual. We recommend reading it cover to cover. As to the CC-M4D controller - it's very powerful, and there are a *lot* of settings. We definitely recommend changing the cut speeds and heights as necessary to match the cut parameters listed in the back of your Hypertherm Operators Manual. The procedure to do this is listed in the CC-M4D manual, and is also outlined in the Library article titled 'Programming Cut Parameters for Different Metals'. While you can extensively fine-tune the other parameter settings as you wish, we wouldn't recommend changing them too far from the default settings, if at all.

We **highly recommend** the Hypertherm 45XP plasma cutter with the CPC port option. It's Hypertherm part number HYP088121. The CPC port is required to communicate with the plasma controller. Under no circumstances should you use a Chinese or cheap eBay 'high frequency start' plasma cutter. They do not work well with electronics, and void the warranty of your CC-M4D controller.

The design software is Vectric Cut2D PRO. For the best cut quality, make sure when you design your part, that you choose 'Circular Arcs' as your drawing format. In the ArcStar Library page, the worksheet titled 'Getting the Best Cut Quality in Cut2D' shows exactly how to do this.

Make sure to use the simulate mode before you cut a new part so you can listen to your table as the torch transitions between cuts and reverses directions. This allows you to fine tune the parameters which control acceleration, deceleration, etc. The art of cutting is balancing the speed we want to cut at, against the wear and tear of your machine as it reverses directions in tight corners, runs through transitions, etc.

Remember that Vectric also has a plethora of tutorials on their website, plus there are many Cut2D tutorials on YouTube. We have several written software tutorials in our library page, and we have several video tutorials we've produced. Again, make sure to bookmark and check our website for the latest and greatest!

Perhaps the most important thing we can stress is this - if you get stuck and can't figure it out - call us and let us help you. Finally, we truly value your opinion. If you notice something we've missed or have a suggestion, please email us at arcstar@mail.com. Thank you!

