

RAMS Plasma Setup and Operation

08/16/2012

- Make sure power is turned on the machine by pulling up on the E-Stop button located on the gantry.





- Double click the Machine3 Loader icon on the desktop.
- Mouse click the  on the lower right of the Screen.

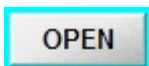


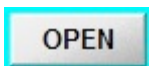
- Jog X,Y,Z  axis close to home position.




- Mouse click the  button. Repeat until all axes have homed to “Machine Zero”. Indicated by steady green on the axis reference  LED.

- Load the file to be cut by mouse clicking the



-  button and selecting the file.
- Place sheet to be cut on the table and align the edge parallel to the aluminum angle on the front of the machine at the desired distance.





- Jog the X, Y, Z axes to the lower left corner of the sheet. Mouse click  to set “Part Zero”.

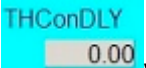
- Jog the Z axis so that the tip of the torch is just touching the surface of the sheet to be cut the mouse click

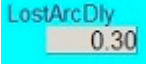


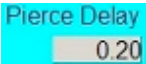
Button.

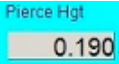

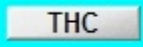

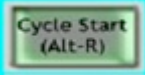
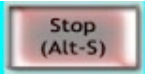
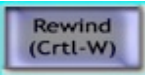

- Mouse click on the  window and set the desired positive height above the plate that the torch will retract to between cuts.

- Mouse click the  button and the z will retract to the above Z Ret Height.

- Mouse click on the  window and set to the desired delay before the THC will start controlling the torch height. .75 is the minimum setting.

- Mouse click on the  window and set to the desired delay before an arc error will be detected. Set to 3.0 normally.

- Mouse click on the  window and set to the desired pierce delay in seconds.

- Mouse click on the  window and set to the desired pierce height in inches.
- Mouse click on the  window and set to the desired Arc voltage that will equal your cut height.
- Turn on Torch Height control by mouse clicking .
- Mouse click on the  button to run the program without the torch firing. Mouse click a second time to turn off “Dry Run” mode.
- Mouse click on the  button to run the program Cycle.
- Mouse click on the  button to Stop the program Cycle.
- Mouse click on the  button to rewind the program after a stop.
- Mouse click on the  button to send the gantry to “Part Zero” after program completes or is stopped.

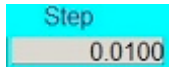
Miscellaneous Controls



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The axes can be jogged in continuous or step mode. In continuous mode the axis will move as long as the jog+ or jog- is commanded.

In Step mode the axis will move only the amount set .



Mouse click on set the value desired then press enter on the keyboard.

Mouse clicking the button will scroll through pre-selected step values.

- The led will light when the z makes contact with the cutting surface.
- Jog Speed can be controlled by adjusting the percentage of maximum jog speed using



the control. Mouse click on the window to set the desired percentage the press enter on the keyboard. Small changes can be easily made by mouse clicking the + or – arrows.

- After a cut error or after a consumable change scroll the



to the start line desired then

Run From Here

press **Run From Here**. The program will index to the desired line. Always try to start on the M05 before the section of the program you desire to run. If you do not start at an M05 the torch will not light automatically you will have to jog to pierce height and manually turn on the torch by mouse clicking

Torch On/Off F5

and cycle start. The first time you press



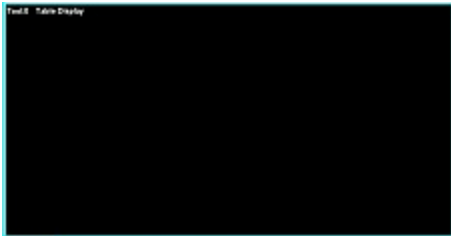
cycle start the machine will open mouse click okay and press Cycle Start. Machine will move to start position. Press Cycle Start once more and machine will start cut at the desired location.

Reverse Run

- **Reverse Run** should not be used.



- Dragging the green FRO% scroller will allow you to change feedrate while the program is running. Not recommended if using torch height control.
- The tool path



screen can be manipulated with the mouse controls by positioning the Mouse pointer over the window. Left button to rotate and reset. Right button to drag. Roller to zoom in and out .