






WHEN RUNNING ALWAYS KEEP HAND ON E-STOP. CRASHES CAUSE MAJOR DAMAGE



Startup and Zeroing




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- ✓ Turn on wall controller box and PC
- ✓ Ensure E-Stop button is pressed down
- ✓ Launch THS Plasma on PC
- ✓ Reset E-Stop (twist and will pop up)
- ✓ Press Power soft button 
- ✓ Open Homing button List
 - ✓ Home all Axis  → 

(Same icon twice)
- ✓ DRO numbers will change from **red** to **green**

Prepare your material

2



- ✓ Place material to be cut on table
- ✓ Move the plasma cutter to the Lower Left corner of where you want to cut on your material
Toggle  /  to change jogging speed
- ✓ Press ZERO WORK LOCATION 
- ✓ DRO will now show X and Y at zero



X			
G54			-0.0000
Abs	2.1818	DTG	0.0000
Y			
G54			0.0000
Abs	3.3998	DTG	0.0000

Load Your Project G-Code File

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- ✓ Minimize THS Plasma and copy your file from thumb drive to the "G-Code" folder on the PC Desktop
(create a sub-folder with your name)
- ✓ Maximize THS Plasma and Switch to Auto Mode 
- ✓ Open file selector in lower left and locate your project file 
- ✓ You will see your design in the preview window

Verify Cut Parameters

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- Suggested starting values for steel sheet metal:
 - Pierce Height: 0.160
 - Pierce Delay: 0.1
 - Cut Height: 0.040
 - Cut Feed Rate: 160.0
- On Plasma Cutter
 - Torch Height Controller: 085V
 - Plasma Cutter Range: ~60% of Yellow/1



Cut Parameters	
00000: Default	
0.0290	Kerf Width
<input checked="" type="checkbox"/>	THC ENABLED
0.160	Pierce Height
0.1	Pierce Delay
0.040	Cut Height
160.0	Cut Feed Rate
0	Cut Amps
0	P-Jump Height
0.00	P-Jump Delay
0.0	Pause At End
THC	
<input type="radio"/> Disabled <input checked="" type="radio"/> Auto <input type="radio"/> Enabled	
<input checked="" type="checkbox"/> Velocity Anti Dive Enable (VAD)	





Preform a "Cold" Cut

5

- This will validate settings without enabling plasma cutter
- Verify torch is DISABLED 
- Press Run Program  or Green button on pendant




Enable Plasma Cutter and Cut Material

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- Pull safety curtain and wear shaded eye protection
- Open compressed air valve
- Turn plasma cutter to ON
- Toggle Run/Purge to Purge on plasma cutter
 - Verify air pressure (on wall) is 60PSI while purging
- Toggle Run/Purge to Run (air will stop after 20 seconds)
- Set torch to enable on PC   
- Press Run Program  or Green button on pendant

Shutdown

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- Once air purge has STOPPED turn plasma cutter to OFF
- Close compressed air valve
- Press PARK CUTTER  (press PARK CUTTER again if you get mdi error)
- Press down E-Stop
- Exit Linux CNC (Bottom right of plasma app) 
- Shutdown PC (Top left of desktop) 
- Turn Wall Controller Box OFF