

# **FangLing Shape Cutting Controller Operation and Installation Manual(Ver.2.6)**

(Apply to F2000 series: F2100B/T、F2300(A/B)、F2300T(A/B)、  
F2500(A/B)、F2500T(A/B)、F2600T、and Tube/plate All-in-one  
module)

**Shanghai FangLing Computer Software Co., LTD.**

**2017-9**

## REVISION HISTORY

Version	Date	Page	Description
Spec.01	2011/8/10	All	New manual creation
Spec.02	2012/2/28		Add Section 8.7.4, 8.7.5, 8.7.6, and Chapter 14
Spec.03	2012/4/12		Add Section 8.7.6.1-8.7.6.3 and 3.11, modify Section 1.3
Spec.04	2012/8/8		Modify Section 4.1 and Chapter 14, add Section 6.7 and Appendix 2
Spec.05	2013/5/20		Perfect chart and catalog, integrate F2000 series specification
Spec.06	2014/2/20		Add the section of arc THC module usage illustration, interface instruction. In appendix 3, add the interpretation of wiring with F1620/F1630 THC.
Spec.07	2014/4/15		Merge the F2000T into the F2000 series manual. In appendix 3, add the interpretation of wiring with PTHC-2.
Spec.08	2014/12/11		1. Modify the operation manual for new remote controller F1510-T. 2. Add Fangcheng technology THC and F2000 series wiring instructions.
Spec.09	2016/1/5		3. Increase the laser offset function. 4. Increase cutting statistics information display function 5. Increase some common problems
Spec.10	2016/6/16		1. Add the Tube/plate All-in-one module.
Spec.11	2016/11/5		1. Increase the operation manual for dynamic pierce and crawl function. 2. Increase the operation manual for the backing to zero parameters. 3. Increase the operation manual for the serial port RS232 and remote controller F1520. 4. Delete remote controller F1510-T.
Spec.12	2017/3/14		1. Increase the operation manual for remote controller F1510
Spec.13	2017/6/8		1. Increase isolation instructions by arc port plus relay. t2. Modify instruction of Small Arc Limit and Limited Speed below Radius.

## User Guide

### Read this Manual

This manual is used to the numerical control cutting controller (F2000 series) produced by Shanghai Fangling Computer Software Co., Ltd.. Read and understand this instructional manual, the cutting machine manuals and local security regulation before using it carefully.

Note: Due to the continuous improvement of this product, the technical parameters and hardware parameters mentioned in this manual are subject to change without notice. If you have any questions or comments on this product and the contents of this manual is not detailed, please contact us promptly, and we will be happy to answer your questions, suggestions and criticisms. Thanks again for your choice and your trust.

**Note:** This product is not designed to be field serviceable. Please return back to the after-sales (service) center for any required service.

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### Work Condition

- Working Temperature, 0°C~50°C. Relative Humidity, 5~95%.
- Operation Voltage: DC +24V.
- The controller should be installed in a cab which can provide protection from powder.
- The controller would be better used in the situation without high voltage radiation.

### Maintenance

- KEEP HANDS CLEAR of dangerous moving machinery. All control action, including manual action, can be executed using the front panel keys or remote interface.
- Loose fitting clothing or ties may become entangled in the machinery. These items should not be worn while operating the machine.
- This controller should only be operated by trained service person.
- Do not open the controller unless obtaining the authorization.
- Do not let any acid, alkaline, corrosive and other items to corrode the controller.

## High Voltages

- Electric shock can kill. Be sure this equipment is safely installed in accordance with enclosed procedures and specifications.
- Avoid contact with electrical wires and cabling while power is on.
- Only trained person can operate this controller.

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# Chapter 1 F2000 Series CNC Controller Introduction

## 1.1 Brief Introduction

F2000 series CNC controller is a new product, absorbing the advantages of many CNC controller, combined with our own F2100B, F2300, F2500 and F2600, F3100, F5100 series CNC controller, which is more user-friendly, more convenient and more cost-effective. The controller can control the motion of two axes, which is apt to the application of flame, plasma or laser cutting. This series is suitable for all two axis CNC machines which support position control mode.

This controller is very light and handy and it is very easy to operate. The controller provides menu or illustration for all the operations for the convenience of users. All key switches are human oriented designed, and they are very convenient and comfortable.

The controller high performance ARM chip and ultra large scale programmable device FPGA, runs multi task real-time operating system and adopts the method of combining software interpolation with hardware interpolation, making high-speed operation more stable and reliable. Reflect speed is very fast. Based on Fangling's research of CNC system for many years, the machines control is more stable and the protection mechanism is quite good.

The numerical control controller of F2000 series consists of F2100B/T, F2300A/B、F2300T A、F2300T B、F2500A/B、F2500T A、F2500T B and F2600/T controller.

### 1.1.1 F2100B/T controller



Fig 1.1 F2100B



Fig 1.2 F2100T

### 1.1.2 F2300A/B/T (A)/(B) controller



Fig 1.3 F2300A



Fig 1.4 F2300T(A)



Fig 1.5 F2300B

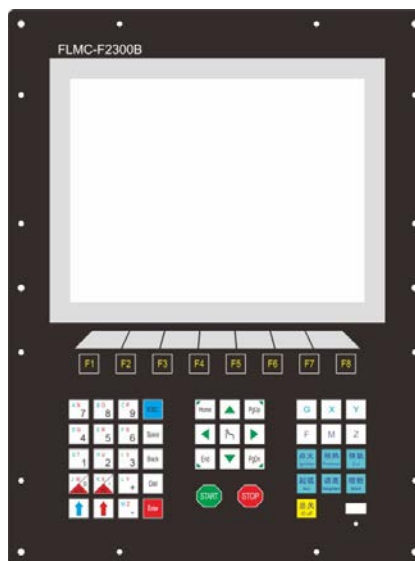


Fig 1.6 F2300T (B)

### 1.1.3 F2500A/B/T (A)/ (B) controller

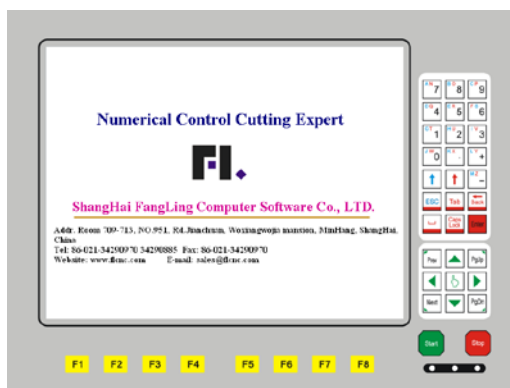


Fig 1.7 F2500 A/T (A)



Fig 1.8 F2500 B/T (B)

### 1.1.4 F2600/T controller



Fig 1.9 F2600/T

## 1.2 Characteristics

- 1) Chinese/English/French/Portuguese/Russian/Denmark/Korean language are supported, the language can be switched easily. In addition to Chinese and English, it need customer to provide language translation documents. In addition to Arabic, other languages are all available.
- 2) 49 categories different graphics (including grid pattern), chip part and hole part are alternative.
- 3) Support the EIA code (G code) and various CAM software , such as FastCAM、FreeNest 、 SmartNest 、 IBE. Support G code with suffix such as TXT,CNC,NC,MPG,B3.
- 4) Compact keyboard design and easy to input files.
- 5) Shape have some operations such as Proportion, Rotate, and Mirror.
- 6) Shape can be arrayed in matrix, interaction, stacked modes.
- 7) Steel plate can be adjusted according to any steel side.
- 8) Coordinate system can be customized to support the two dimensional coordinates of all eight kinds.
- 9) All input and output port type and the number can be customized (normally open or normally closed).
- 10) Self-diagnostic function, to diagnose the key status and all the IO status, facilitate inspection and debug.
- 11) Provide a front USB interface for copying files.
- 12) System can be upgraded by USB interface easily, and we provide lifetime

- upgrade service.
- 13) All functions and techniques can upgrade online and don't worry about the after sale service.
  - 14) Import and export files by single or all files.
  - 15) Display time, week and clock.
  - 16) Parameters backup and parameter restore.
  - 17) Support the Flame, Plasma, Marker and Demonstration four kinds of mode.
  - 18) Including various types of processing parameters to meet the needs of different processes.
  - 19) Flame and Plasma are separated in the control IO ports.
  - 20) Support THC(Torch Height Control), two-level preheat, three-level pierce in flame mode.
  - 21) Plasma arc feedback, positioning feedback, automatically shut down the arc at the corner.
  - 22) Built-in plasma arc auto/manual turn high function: display actual arc pressure and set arc pressure, set THC parameter, check for collision/position successful signal, control arcing signal, check for location.
  - 23) Plasma arc controlling supports two close arc THC ways of speed and distance to make the machine more stable and safer.
  - 24) Support edge cutting. It can save the preheat time for the thick steel plate.
  - 25) Movement speed can be real-time acceleration, deceleration.
  - 26) According to plate thickness, the cutting speed is automatically restricted by a speed limit in the corner, effectively preventing over burn.
  - 27) Select row and column manually.
  - 28) Dynamic/static illustration of the process, graphics zoom in / out, dynamically tracking cut-off point under zooming state.
  - 29) DSP as core can control the machine move in high speed accurately, stability and in low noise.
  - 29) Starting speed and acceleration can be set by your convenience.
  - 30) Automatically memorize the working situation and the last cutting point when power off.
  - 31) "Cutting offset" function can avoid waste the steel plate when the nesting of the plate is calculated wrong.
  - 32) Set up different administration authority and the corresponding password to safeguard the interests of equipment manufacturers.

- 33) Support P2P mode ,BCD (8421) mode remote controller and serial RS232 remote control.
- 34) The original size of the workpiece and size with kerf can simultaneously display, intuitive and convenient
- 35) Support system backup and system restore function, system restore can be restored not only to operating system but also to factory condition.
- 36) Support ESSI code commonly used instructions
- 37) Controller models with suffix “T” have integrated THC module
- 38) Support laser point function
- 39) Support plasma dynamic perforation function
- 40) Information statistics such as processing piece, operation time, perforation number and so on.

### 1.3 Technical Indicator

- 1) Control Axis: 2 axis linkage(3 axis customizable)
- 2) Control accuracy: +/-0.001mm
- 3) Coordinate range: +/- 99999.99mm
- 4) Max pulses: 200 kHz. Max speed: 15,000 mm/m
- 5) Max lines of code: 80,000lines
- 6) Max size of single code file: 4M
- 7) Time resolution: 10ms
- 8) Working Voltage: DC +24V direct-current power input, power > 80W。
- 9) Working Temperature: -10°C~+60°C. Relative Humidity, 0~95%.
- 10) Max power of drive arc THC motor: 45W (suitable for models with “T”). if need more power, can select maximum value: 200W.

### 1.4 Controller Interface

- a) DB15 pins SMA Male interface of 2 axes of motor drive.
- b) DB25 pins SMA Female interface of 16 channels optoelectronic isolation output ports max back flow current 300mA.
- c) DB25 pins SMA Male interface of 16 channels optoelectronic isolation input ports, max output current 300mA.
- d) USB interface on the front panel, for the convenience of transmitting cutting code.
- e) Extend IO input/output ports, PWM input ports, analog input ports.
- f) Optional standard DB9 core male serial port RS232 interface.

**The following three interfaces are only suitable for controller models with “T”:**

- g) Selection of partial pressure proportion of arc input: 1:50 or 1:100
- h) 5 pins connector for THC motor output and limit input ports.
- i) 7 pins connector for arc voltage and IHS port, arcing start output port.

## **1.5 Hardware Configuration**

### **1.5.1 F2100 B/T Hardware Configuration**

1. Monitor: 7 inch, 800\*480, high definition 16 million colors and high brightness LCD
2. Memory: 64M SDRAM
3. Program space available for user: 256M electronic hard disk
4. CPU frequency: 400MHz
5. USB: USB 1.1 front interface, at least 16GB U disk supportable
6. Keyboard: PCB keyboard
7. Chassis: full-steel structure completely shielded which defends electromagnetic radiation, interference and static electricity

### **1.5.2 F2300 A/B/T Hardware Configuration**

1. Monitor: 10.4 inch 800\*600, high definition 16 million colors and high brightness LCD
2. Memory: 64M SDRAM
3. Program space available for user: 256M electronic hard disk
4. CPU frequency: 400MHz
5. USB: USB 1.1 front interface, at least 16GB U disk supportable
6. Keyboard: PCB keyboard
7. Chassis: full-steel structure completely shielded which defends electromagnetic radiation, interference and static electricity

### **1.5.3 F2500 A/B/T Hardware Configuration**

1. Monitor : 15 or 17 inch high brightness LCD with industrial VGA interface
2. Memory: 64M SDRAM
3. Program space available for user: 256M
4. CPU frequency: 400MHz
5. USB: USB 1.1 front interface, at least 16GB U disk supportable
6. Keyboard: PCB keyboard



7. Chassis: full-steel structure completely shielded which defends electromagnetic radiation, interference and static electricity

#### **1.5.4 F2600/T Hardware Configuration**

1. Monitor : No, but standard monitor with VGA interface supportable
2. Memory: 64M SDRAM
3. Program space available for user: 256M
4. CPU frequency: 400MHz
5. USB: USB 1.1 front interface, at least 16GB U disk supportable
6. Keyboard: no, but standard keyboard with PS2 interface supportable
7. Chassis: full-steel structure completely shielded which defends electromagnetic radiation, interference and static electricity

## Chapter 2 Starting up

### 2.1 Operation Panel



Fig 2.1 F2100 B



Fig 2.2 F2100 T

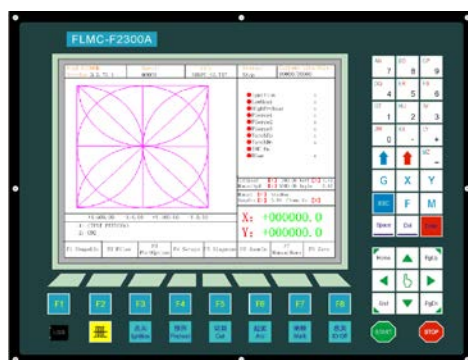


Fig 2.3 F2300A/T(A)

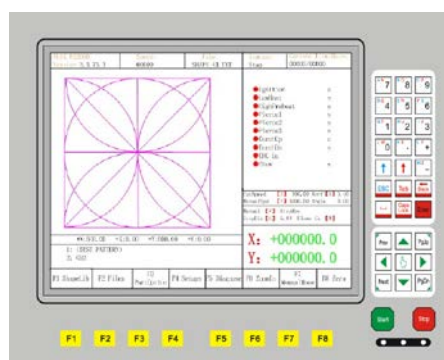


Fig 2.4 F2500A/T(A)

**【F1】 - 【F8】** Function key in different interface

**【S↑/PgUp】** page-up key of edit interface or Torch up in other interface

**【S↓/PgDn】** page-down key of edit interface or Torch down in other interface

**【F+ / HOME】** Accelerate or skip to the head of code line

**【F- / END】** Decelerate or skip to the tail of code line

**【1】 - 【9】** During the cutting process, change the cutting speed to ratio of the speed limit you have set, for example press **【1】**, change the cutting speed to 10% of the speed limit you have set, press **【2】**, change the cutting speed to 20% of the speed limit you have set

Only [1], [4], [7] can only adjust the speed with the T controller.

The following shortcuts only support the F2000 series of CNC controller with 'T':

**【2/3】** :Adjust piercing time quickly.

**【5/6】** :Adjust the HIS time quickly.

- 【0】 : Disable or Enable THC.
- 【8/9】: Set the arc voltage quickly.
- 【.】 : IHS test.

## 2.2 Power on Processing and Main Interface

When just power on, the controller will first go into BIOS starting up interface:

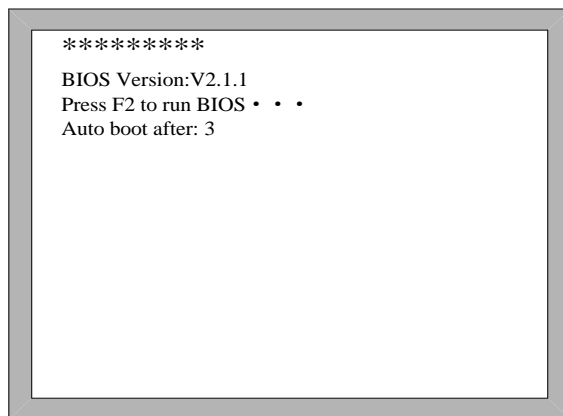


Fig 2.5 Controller self-check interface

In the starting process, there is 3 seconds to countdown, before the countdown is over, if pressing 【F2】 , it will enter the BIOS (please take the reference of the chapter 12 to run bios). If pressing any other key, it will jump over the countdown and directly enter the welcome interface. If pressing no key, it will countdown to 0 and then enter the welcome interface shown as Fig 2.6. In the welcome interface, press any key to enter the main interface automatically shown as Fig2.7.

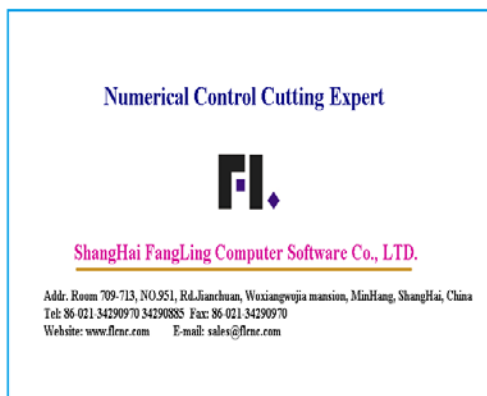


Fig 2.6 welcome interface

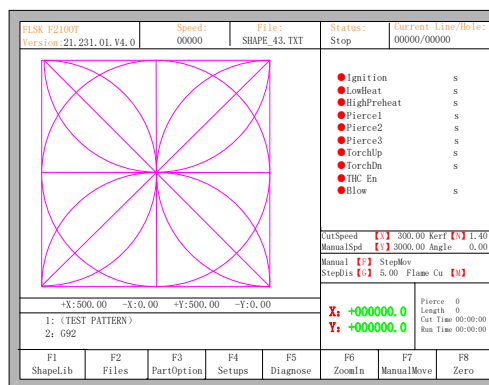


Fig 2.7 the main interface

**Note:** the controller model “F2100T” shown in “FLSK F2100T” at the left and up corner of above figure shows different contexts, the following is the same, it will not be interpreted repeatedly. For example, it will show “FLSK F2300T” in the controller of F2300T.

In the main interface, press 【F1】 - 【F8】 for the following functions:

- **【F1】 ShapeLib:** Pressing F1 to enter the Shape Library including 48 common shape, and most of them have plate size and hole size.
- **【F2】 Files:** You can load local files, U disk files or edit, import, export and delete codes.
- **【F3】 PartOption:** Make actions of mirroring, rotation, plate adjusting, plate arraying, selecting row and hole or code edition etc.
- **【F4】 Setups:** Setting all parameters.
- **【F5】 Diagnose:** Including input ports diagnosis, output ports diagnosis, keyboard diagnosis, controller self check, date setting and ports definition.
- **【F6】 ZoomIn:** Zoom in the shape in full screen.
- **【F7】 ManualMove:** Manually move the machine.
- **【F8】 Zero:** Clear the coordinate of X and Y before starting cut or after cutting over.
- **【X】 CutSpeed:** Setting the cutting speed.
- **【Y】 ManualSpeed:** Setting the manual moving speed.
- **【F】 Manual:** Setting the mode of manual movement including keepMov(keep movement), StepMov(step movement), ContiMov(continue movement).
- **【G】 StepDis:** Setting the distance of the StepMov .
- **【N/Z】** Before the cut running starts, set kerf compensation value.
- **【M】** Selecting the cutting mode including Flame Cut(flame cutting), Plasma Cu(plasma cutting), Demo run.
- **【START】** Begin to cut.
- **【SPACE】** Enter cutting interface.

## 2.3 Function Index

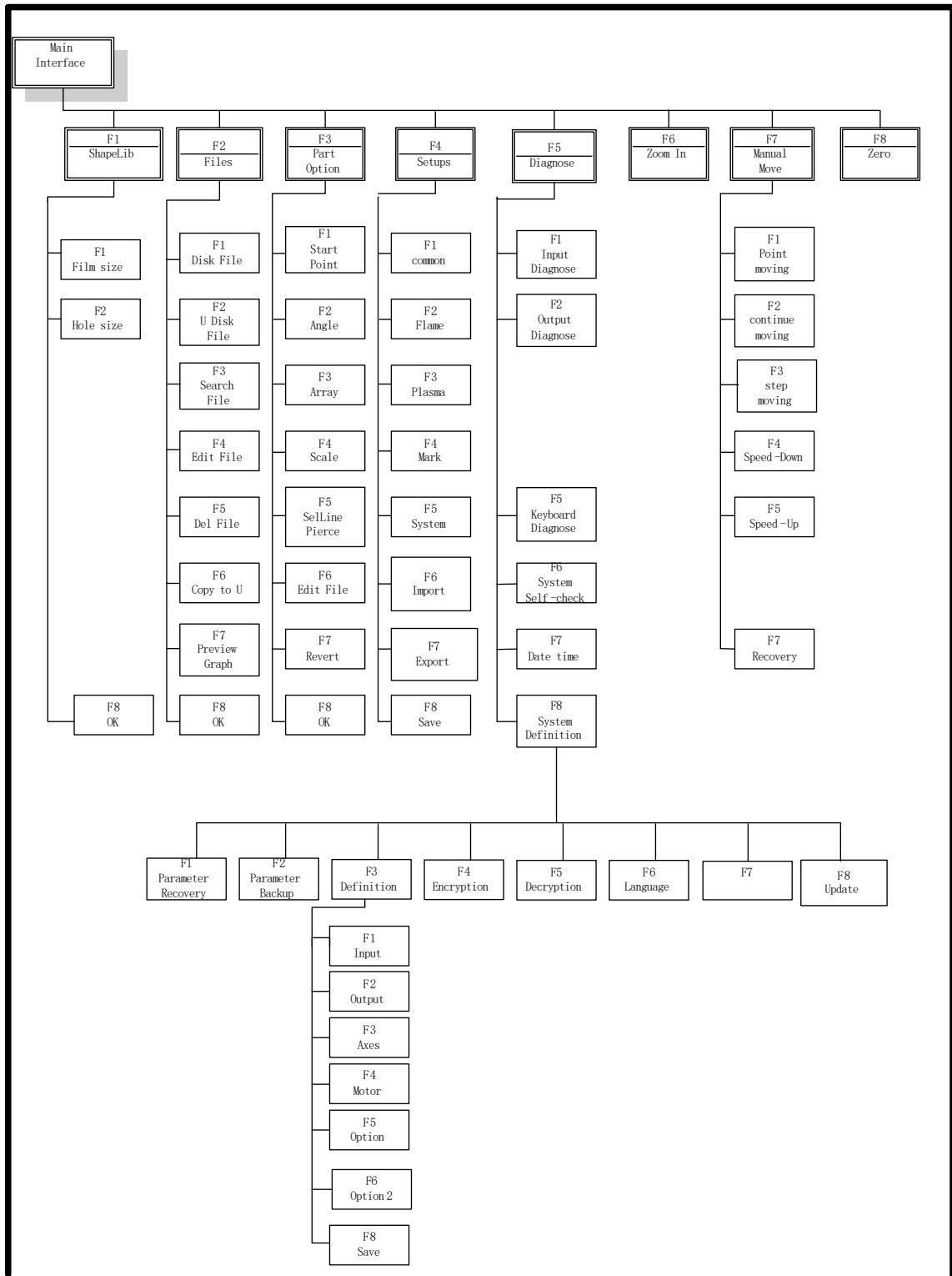


Fig 2.8 Function index of main interface

## Chapter 3 Cutting Function

In the main interface, press the **【SPACE】** to enter the cutting interface, shown as follows:

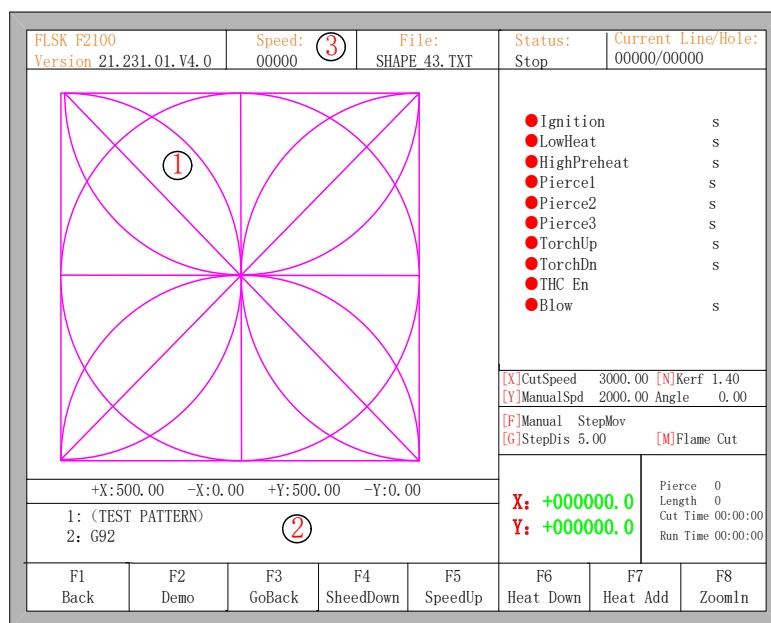


Fig 3.1 cutting interface

①Shows the current workpiece's cutting path.

②Shows the G-file being processed, shows the current and next line.

③Shows the current cutting speed. during cutting or paused, you can press the keyboard's number keys **【1】** - **【9】** to achieve quick speed regulation. For example, press the number **【3】**, the speed is automatically adjusted to 30%; press the number **【8】** the speed is automatically adjusted to 80%.

**Only Key 【1】、【4】、【7】 can achieve rapid speed control with T controller.**

X shows the absolute coordinate of the torch in X direction.

Y shows the absolute coordinate of the torch in Y direction.

In the cutting interface:

- Press **【X】** : Modify the cutting speed.
- Press **【Y】** : Modify the manual move speed.
- Press **【F】** : Change the current manual move mode.
- Press **【G】** : Modify the distance of step move in manual move
- **【START】** (or **【F9】**) : Start cutting.
- **【STOP】** (or **【F10】**) : Pause, the controller can suspend all ongoing actions.
- **【F1】** :Move back along the cutting path(I / O closed)
- **【F2】** : Move forward along the path (I / O closed).
- **【F3】** : Return to the starting point, i.e. the starting point of the current work piece.
- **【F4】** : It is same to key End. Decrease the cutting speed, each decrease of 3% click rate. Decrease the rate of manual moving machine in manual mode.
- **【F5】** : It is same to key Home. Increase the cutting speed, each 3% increase in click rate. Increase the rate of manual moving machine in manual mode.

- **【F6】** : Reduce the preheat time, skip the remaining preheat time, and the controller automatically records preheat time and the time is used until the workpiece is over.
- **【F7】** : Increase the preheat time once 15 seconds.
- **【F8】** : When the controller move is suspended, for selecting piercing point; when in moving, the trace display is zoom in over the full screen.
- Four direction keys (Up, down, left and right): manually move.

### 3.1 Cutting Index

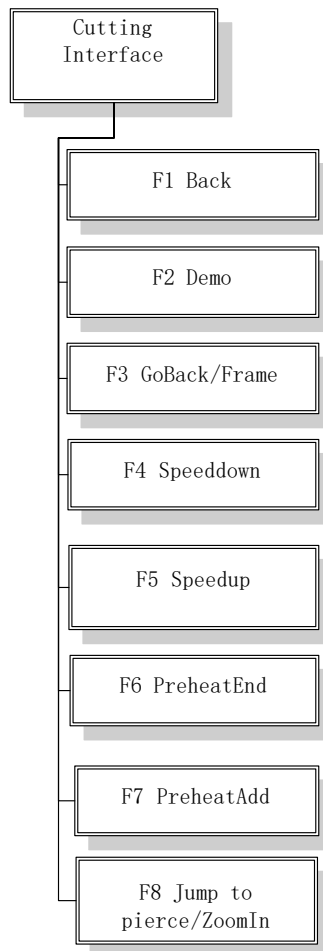


Fig 3.2 Cutting operation index

## 3.2 Speed Regulation

### 3.2.1 Normal Speed Regulation

In the operation panel, press **【F5】**, **【PRE】** or **【HOME】**, increasing 3% of current rate with per click. Hold the **【F5】**, **【PRE】** or **【HOME】**, then the rate will continuously increase to the maximal cutting rate.

In the operation panel, press **【F4】**, **【NEXT】** or **【END】**, decreasing 3% of current rate with per click. Hold the **【F4】**, **【NEXT】** or **【END】**, then the rate will be continuously reduced to 0.5% of

maximal cutting rate.

### 3.2.2 Quick Speed Regulation

In automatic operation, or when the system is suspended, in the cutting interface the system can carry out quick speed regulation.

In the cutting interface, on the operation panel, press the number keys **【1】** - **【9】**, the speed will quickly adjust to the corresponding percentage figures 10 times, for example press **【3】**, adjust to 30% of the speed limit you have set, press **【8】**, adjust to 80% of the speed limit you have set.

### 3.3 Forward

In the automatic function interface, press key **【F2】**, the machine start to move without cutting. The process does not excute any ignition, piercing and any other I/O working. The machine just moves along with the shape trace. Press **【F2】** again, stop running.

The function can be used to check the trace or code before you start the cutting process, or can also be used when the process needs shift piercing. Press the red “STOP” key to stop the forward process as you want.

Forward speed and cutting speed are provided separately. Forward speed is defined by the "Demo/Back speed" in the common parameters.

### 3.4 Backward

During the running process, if you want to go backward along with the shape trace (maybe the iron board was not cut through), you can follow the following direction:

- First, press “STOP” key to set the machine at pause status.
- In the automatic function interface, press key **【F1】**(Back) to make the machine go backward along with the shape trace. When the torch reaches the position you need, press “STOP” key to stop it. You may press key **【F2】** to go forward if the machine just went back too much.

**Notice:** Go backward or forward function can be used repeatedly to make the machine reach an ideal position.

- In the backward process, press **【F1】** again, the system stops running.
- When the torch reaches the position you need, press “START” key again, if the current cutting code is G01, G02 or G03, system will automatically piercing before performing these procedures, and then continue the current program, if the current row is not G01, G02 or G03, the system will directly continue the current line program.

Same as the forward speed, backward speed and cutting speed are also provided separately. Backward speed is also defined by the "empty / backward speed" in the common parameters.



### 3.5 Edge Cutting / Offset Cutting / Return

When the torch is not on the trace of the current work piece, it will prompt as follows:

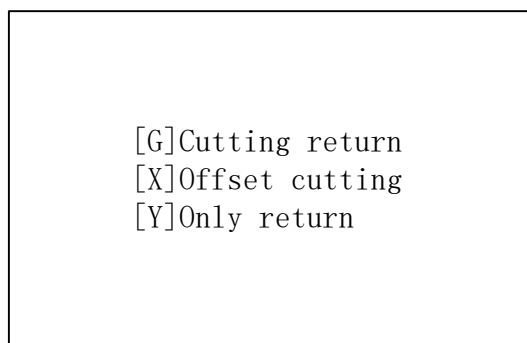


Fig. 3.3 edge perforation

There are two reasons led to this situation:

- 1) When the common parameter "Edge Cutting Enable" is checked and if G-file of the next processing line is M07, the system will be automatically suspended. At this time, the torch can be manually moved to any edge of the plate, press the "start" button, the system will prompt as above
  - 2) When the processing is paused, due to some reasons, it needs to move the torch out of the actual path of the work piece, the above prompt will appear.
- If press **【G】**, the system cutting returns back to the paused point, continue to cut. This feature is particularly useful for thick steel plate, it can reduce the preheat time and increase cutting efficiency.
  - If press **【X】**, the controller offset current point to paused point, it will continue cutting. That is, the controller offsets the cutting point. When the cutting machine paused or a power outage or any other reason, if the torch is not on the right trace of shape, the function can be used to offset the torch to the shape trace.
  - If press **【Y】**, The controller moves to the paused point quickly, and then pause. During the cutting process, if discovering cutting torch malfunction or other issues, system needs to move the cutting tip out of cutting region to overhaul. When return to breakpoint after the maintenance, this key can be pressed. Then return to the paused point, press the **【start】** button, the system automatically continues to cutting.

### 3.6 Back to Reference Function

Pause in the processing, if press the **【F3】**, then the system will prompt:

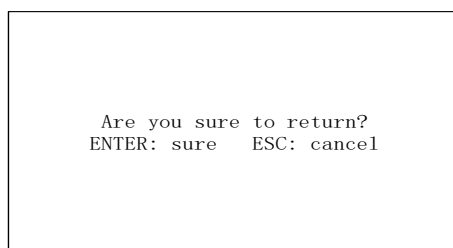


Fig. 3.4 Return reference prompt

Press the Enter key, the system will automatically return to the starting point of the work piece, and then the system automatically switches to processing the main interface, and waits for further user action.

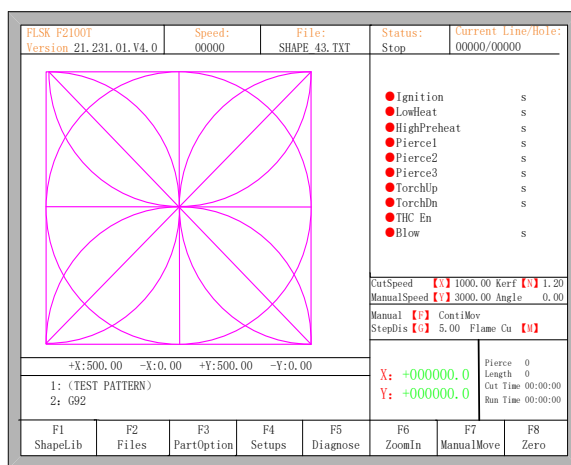


Fig. 3.5 main process interface

During the return process, the user can press the "Stop" button to stop the operation, and can continue to return operation after pressing of **【F3】**. Number of back to reference and stop has no limit.

### 3.7 Preheat Time Regulation

- In the preheat process, press the START (F9) key to skip the process of preheat or piercing delay.
- In the preheat process, press the STOP (F10) key to prolong preheat until START(F9) key is pressed again.
- In the preheat process, press the **【F6】** key then the preheat time will be reduced to the current preheat time spent, and skip the process of preheat. The total preheat time is remembered until M02 or M30.

For example: the preset preheat time is 60 seconds. In preheat process, the preheat time will count down, under normal circumstances, till 0, the system begins the next step of cutting, but if the system has the remaining 10 seconds of countdown time, press **【F6】**, then the system immediately stops preheat to begin the next step of cutting, and records the preheat time of 50 seconds, the system automatically thinks that users need preheat time of 50 seconds, the next preheat after the null cutting when the preheat time becomes 50 seconds.

- In the preheat process, each press the F7 key, preheat time increases by 15 seconds and the preheat time maintains the increased value till incision ending of this time.

For example: The original system sets the preheat time of 60 seconds after the null cutting, during the system countdown, each press **【F7】**, on the interface the countdown increases by 15 seconds, and the next time you need to preheat, the initial preheat time be 75 seconds.

### 3.8 Jump to pierce

Before you start cutting or cutting is paused, the function key prompt F8 is "Jump to Pierce ", now press F8, the system will prompt:

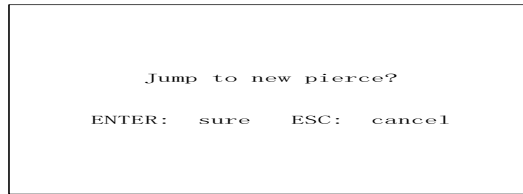


Fig. 3.6 select new pierce

Pressing ESC, the controller will return back to the cutting interface. Pressing ENTER, the controller will prompt again:

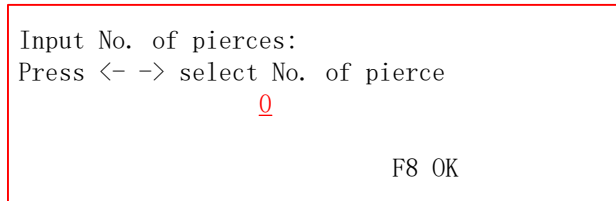


Fig. 3.7 pierce prompt

Pierce point can be input manually here. You can also press ESC to exit without manual input pierce point, and then press the left and right arrow keys to select the pierce point.

### 3.9 Dynamic Amplification

After the start of cutting, the F8 in the cutting interface will become "ZoomIn ", then press the F8 key, full-screen amplify the processing graphic , and dynamically tracking.

F1 Back	F2 Demo	F3 GoBack	F4 Speeddown	F5 Speedup	F6 Preheatdown	F7 Preheatup	F8 ZoomIn
---------	---------	-----------	--------------	------------	----------------	--------------	-----------

Fig 3.8 Function key of cutting interface

- Press the F8 key continuously, the system will progressively amplify graphic.
- Press ESC to exit the amplified display, back to the cutting interface.

### 3.10 Cutting Exit

When the cutting process does not get finished, and the cutting machine also being in the pause condition, if press **【Esc】** , the controller will query whether quit the cutting process. If pressing **【Enter】** , the process will be canceled, and if pressing **【Esc】** the process will be saved, and the controller will start cutting from the paused poing.

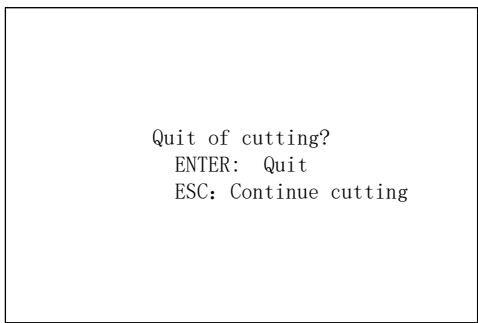


Fig. 3.9 Quit of cutting

### 3.11 Frame

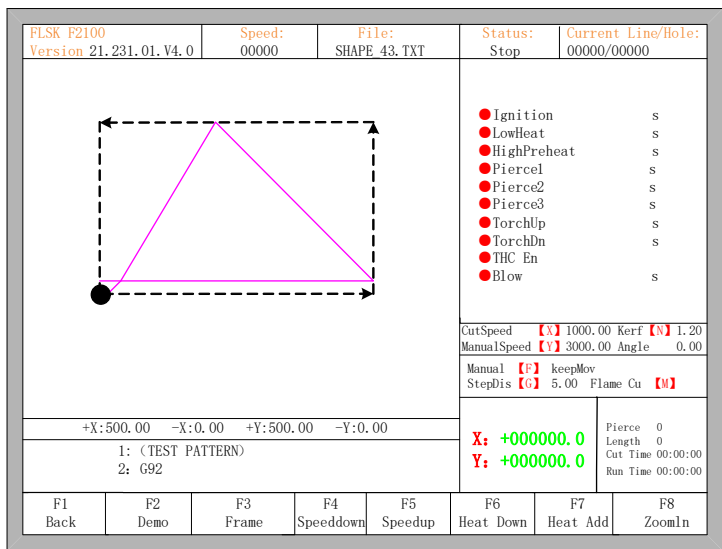
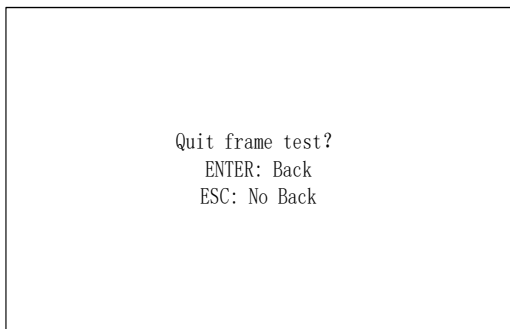


Fig. 3.10 Walk along frame

Before the beginning of the process, Pressing will enter into the interface of auto processing, **【F3】** is the function of walking along frame as figure 3.10 shows at CCW direction, the beginning point is the lower left corner. In the end of the walking, the controller will prompt:



At this time, press **【Enter】**, the controller will automatically go back to start point of parts. If press **【ESC】**, the controller will stop at current point.

In the process of walking along frame, pressing STOP suspends operation, and press START, the controller resumes running. Press **【F3】** again, the controller returns to the starting point.

### 3.12 THC Instruction (only "T" models of F2000 series CNC controller)

#### 3.12.1 Wiring Instruction

F2100T controller links with location proximity switch, arc start of plasma power and arc voltage divider by 7 pins socket, links with lifting motor by 5 pins socket.

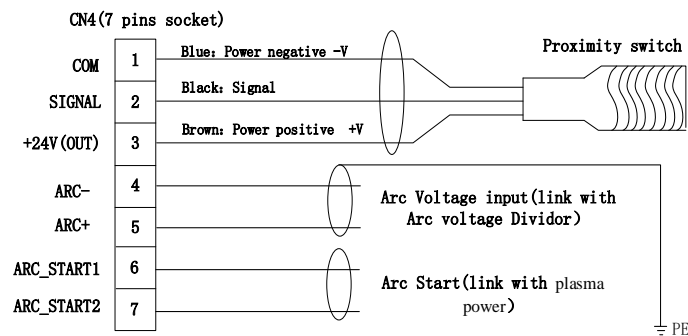


Fig.3.11 Arc and location signal wiring schematic

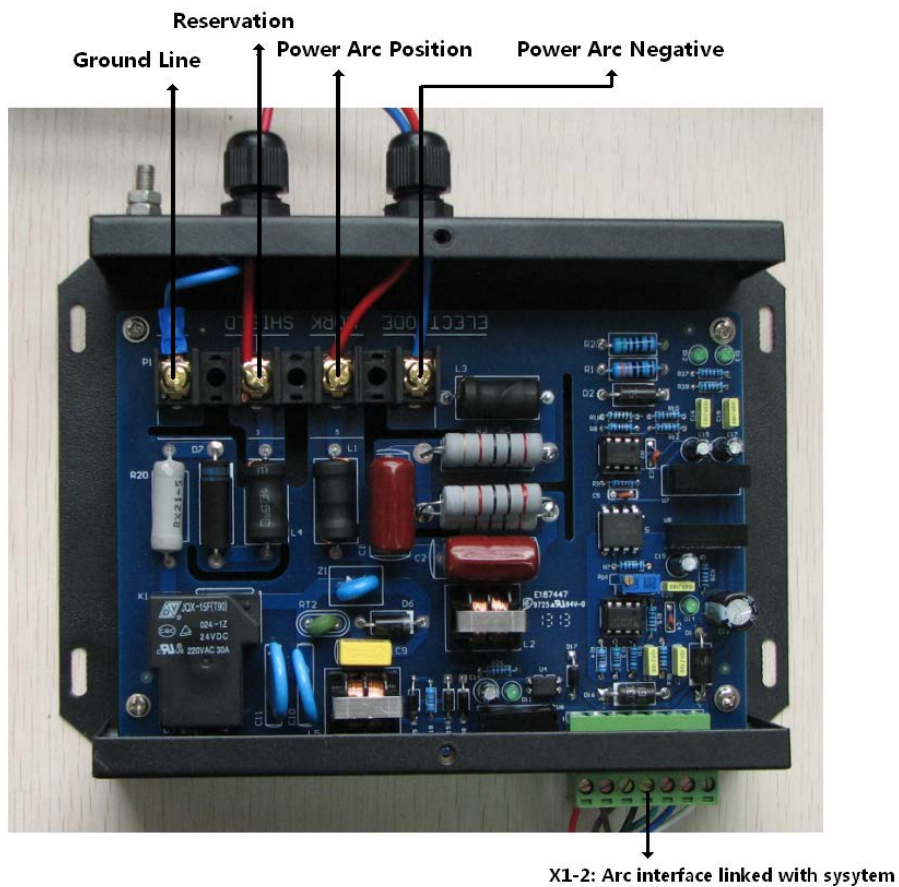


Fig.3.12 Arc Voltage Dividor

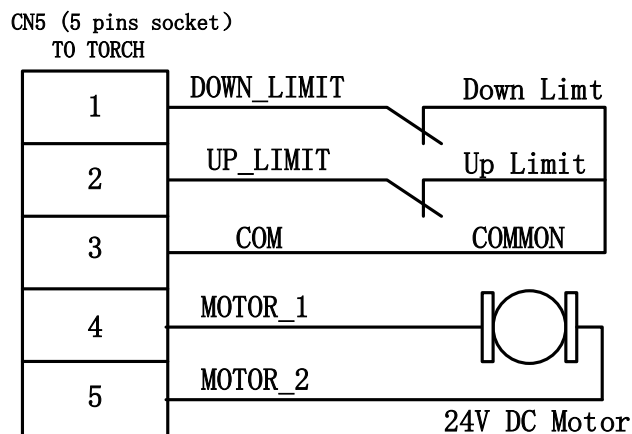


Fig.3.13 Lifting body monitor and limit switch wiring

**Note:** please refer to the section of 11.4.5 to get detail of wiring interpretation with THC module.

### 3.12.2 Arc Setting and Actual Arc Displaying

In the main interface or auto interface, display the arc voltage setting and actual arc voltage.

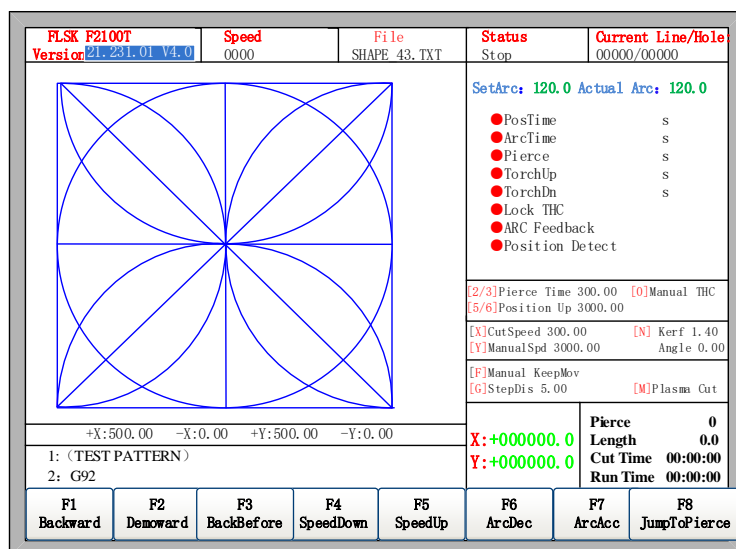


Fig.3.14 Auto interface with arc THC setting

### 3.12.3 IHS(Initial Height Sensor)

Several settings needed to be done before using IHS.

Proximity switch should be connected CN4 (Fig 3.11). (CN4\_SIGNAL)

When torch has not touched with steel panel, in the system diagnosis (Chapter 8 Fig 8.1) , Position detect should be NO. When torch has touched with the steel panel, Position detect signal display NC.

In the figure.7.4, Position Check Time must be more than the time of which torch drops down

from the highest point to the steel panel.

In the figure.7.4,Position Up Time is the time of which torch ascends from steel panel touch point to arc ignition height.

When controller is at stop or pause status, press **【.】** to test IHS.

- Torch descend (the longest time of which is Position Check Time)
- Torch stop then ascend to ignition height (Position Up Time) when torch tip reach the plate and proximity switch is active.
- A warning window will prompt if Torch cannot reach plate and proximity switch is not active after torch descend the whole Position Check Time.

### 1.12.4 Set Arc Voltage

The arc voltage is set in the plasma parameter setting interface, please refer to Section 7.3 for the parameter setting.

### 3.12.5 Increase/Decrease Arc Voltage

In the auto interface with Plasma cutting mode, press **【F6】** to reduce arc voltage, press **【F7】** to increase arc voltage.

In the auto interface and main interface in Plasma cutting mode, press **【8】** to reduce arc voltage, press **【9】** to increase are voltage.

The step of decreasing or increasing is the manual adjusting stride of setting arc, it can be set in the plasma parameter setting.

### 3.12.6 Disable/Enable THC

In the plasma cutting mode, press **【0】** to alternate Disable and Enable THC.

press **【PgUp】**to ascend the torch (full speed) and press **【PgDn】**to descend the torch (full speed).

Whent THC is working, press **【PgUp / PgDn】** also to ascend or descend the torch, but it will enter into the THC working status after **【PgUp / PgDn】** is released.

### 3.12.7 Torch Collision / IHS Signal Check

- In the non plasma cutting mode, If the Torch touch plate, Plasma Collision (Pin06 of CN1) or Position Detect(Pin05 of CN1) signal is active torch automatically ascending time is Position Up Time. Refer to Positon Up Time in the figure 7.4.

- In the plasma cutting mode, If the Torch touch plate, Plasma Collision (Pin06 of CN1) or Position Detect(Pin05 of CN1) signal is active, it will automatically stop and the torch will automatically ascend, the time of which is the Torch Up Time. Refer to Torch Up Time in the figure 7.4.

## 3.13 Statistical Information

The function of statistical information is used to record the number of piercing, the number of the

finished workpiece, the total cutting distance, the cutting time and the running time of the plasma and flame cutting. Plasma and flame are calculated separately.

### 3.13.1 Related Parameters

- Pierce Count: Record the number of pierce during cutting process.
- Workpiece Count: Record the number of finished workpiece.
- Cut Length: Record total cutting length. Unit: metric - meter, Inch - feet.
- Cut Time: Record the whole cutting time.
- Run Time: Record the whole running time, empty state time and M07 state time.

### 3.13.2 Statistical Information Display

In flame cutting interface, the lower right corner will display Pierce Count, cut length(Unit: metric - meter, Inch - feet), the cut time and the run time of flame cutting. As shown in figure 3.15.

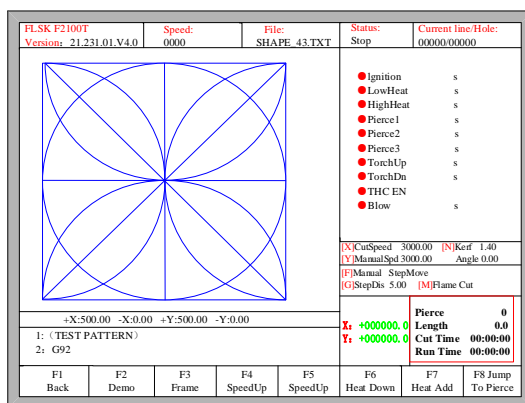


Fig.3.15 Oxygen gas cutting interface

In plasma cutting interface, the lower right corner will display pierce count, workpiece count, cutting length(Unit: metric - meter, Inch - feet), the cut time and the run time of plasma cutting. As shown in figure 3.16.

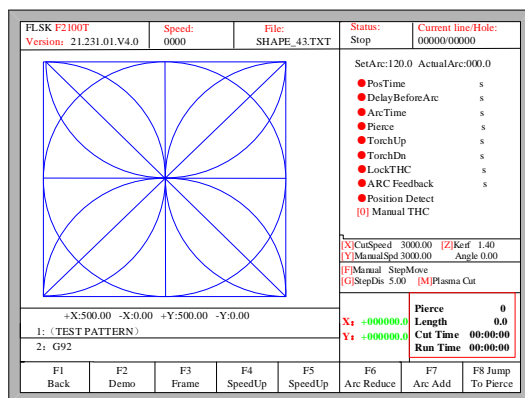


Fig.3.16 Plasma cutting interface

In the non plasma and flame cutting mode, it does not show any statistical parameters. As shown in figure 3.17.



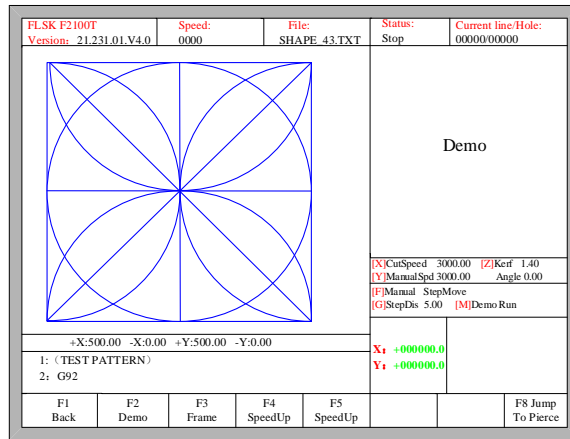


Fig.3.17 Non plasma and oxygen gas cutting interface

## Chapter 4 Part Option

Before starting cutting, you can use “F3 Part Option” in the main interface.

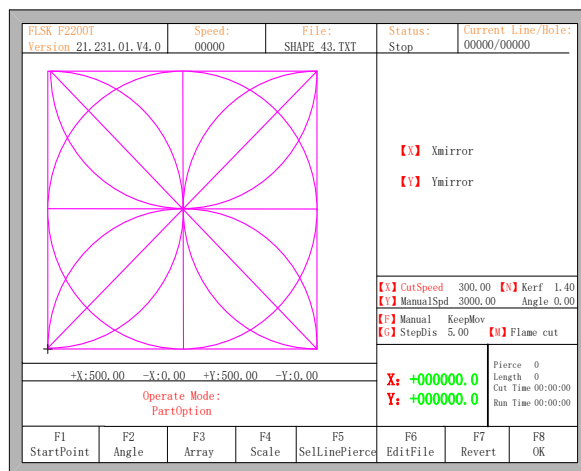
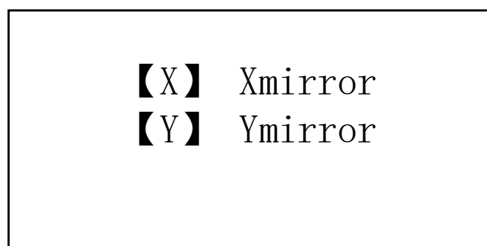


Fig 4.1 Part options

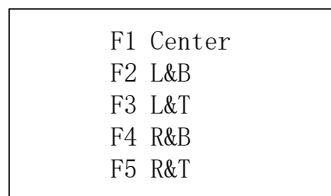
### 4.1 Mirror Function



- Press X to mirror the image of the part along the horizontal axis(X axis)
- Press Y to mirror the image of the part along the vertical axis(Y axis)

### 4.2 Start Point Selection

After press **【F1】** , System will prompt to select start point:



At this time, press **【F1】 - 【F5】** , the starting point of cutting part automatically jump to relevant location. For example, press **【F4】** , the start point will automatically jump to lower right corner. As the following figures 4.2 and 4.3 show:

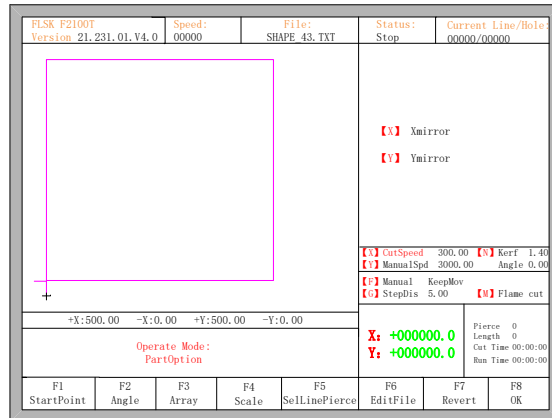


Fig 4.2 before press F4, start point is at original point

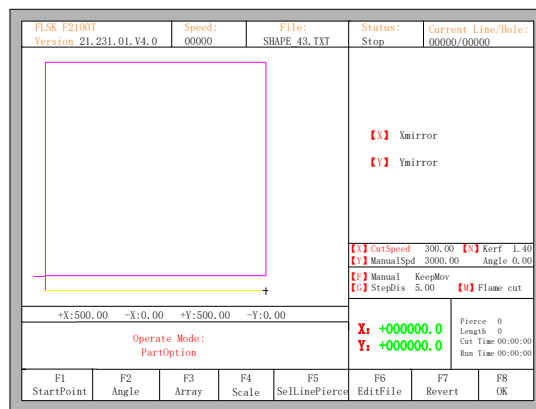


Fig 4.3 after press F4, start point is at lower right corner

## 4.3 Angle Adjustment

Press F2, the system will prompt:

```
F1- steel plate adjust
F2- enter angle
```

- Press F1 to align the part according to steel plate
- Press F2 to input align angle directly
- Press ESC to exit angle adjusting

### 4.3.1 Steel Plate Adjustment

After entering steel plate adjustment menu, the system will prompt:

X-start Y-OK ESC-exit  
 Adjust X: +00000.00  
 Adjust Y: +00000.00  
 Angle +00000.00

Here, you can manually move the cutting torch to any edge of the steel plate or a corner of the plate. Pressing **【X】** to set the current point as the starting point of correction. And then manually move the torch far enough away from the starting point along to the second point at the same edge of the steel plate, Pressing **【Y】** to finish the angle adjust. The controller will automatically calculate the current align angle of plate, and then automatically rotate part image.

**Illustration:** if use the laser gun to make adjustment, the laser point can be aligned to the edge of the plate correction, the specific use of the method can refer to section 5.5 laser offset function.

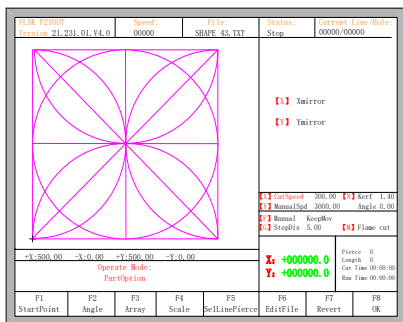


Fig 4.4 before adjusting

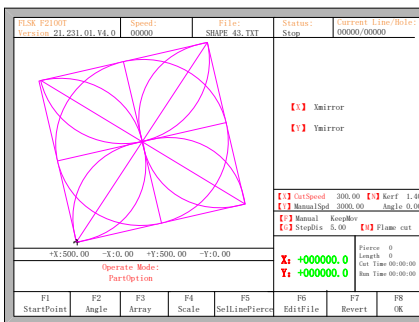


Fig 4.5 after adjusting

After adjusting, the controller will ask whether to return to the start point, if press **【ENTER】**, the controller will run back to the start point of the operation, if press **【ESC】**, the controller will do nothing but go back to the auto interface.

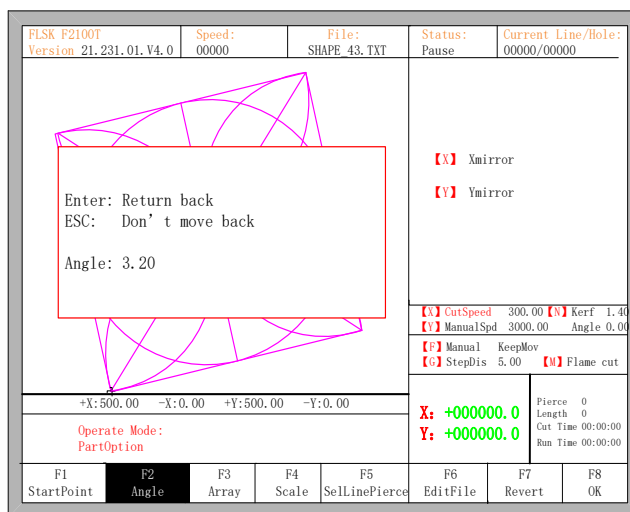


Fig 4.6 Return to the start point after adjusting

### 4.3.2 Steel Plate Adjust Angle Memory Function

About steel plate adjust angle memory, please refer to the section of 8.7.6.6.

### 4.3.3 Enter Angle

When the angle of the current work piece is known, you can input the angle:

```

Please enter angle
min: -360 max: 360
Angle:      0.00
Note:
>0 Rotate CCW on the base of current
<0 Rotate CW on the base of current
=0 Reset the current part to 0 degree
  
```

After manually input the angle, press **【ENTER】** to make sure, the part image will be rotate with the corresponding angle. Positive angle means rotate in counterclockwise, while negative means clockwise. Press **【ESC】** to exit angle adjusting.

**Illustration:** when enter angle 0, the part image will restore to the angel of 0° , at this time, the controller will clear the angle of steel plate adjustment and manual input angle. Generally, the angle entered is not as the angle of steel plate adjusting. If the angle entered here needs to be as the angle of steel plate adjusting, please refer to section 8.7.6.8.

## 4.4 Array

In the part options menu, press **【F3】** , the system will prompt as Fig 4.7. There are three build-in array types: arrange in straight, arrange in stagger, arrange in nest.

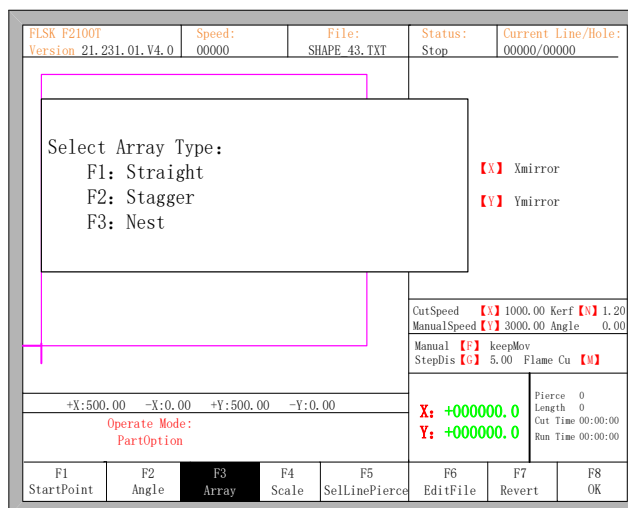


Fig 4.7 Select arrange type

Press **【F1】** to arrange in matrix.

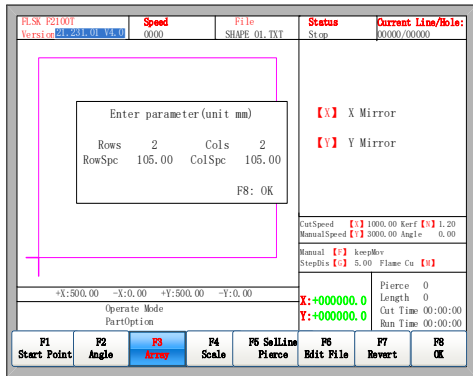


Fig 4.8 Arrange in straight

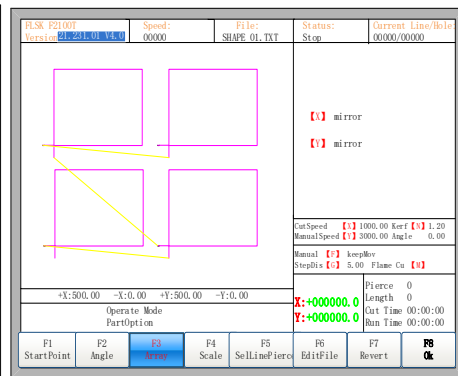


Fig 4.9 Result of arranging in matrix

Press [F2] to enter staggered arrangement.

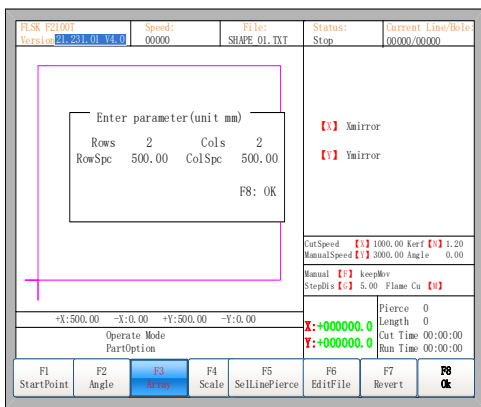


Fig 4.10 Staggered arrange

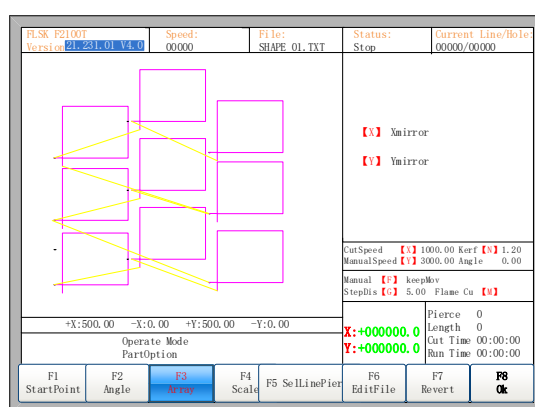


Fig 4.11 Result of staggered arrangement

Press [F3] to enter arrangement in stack.

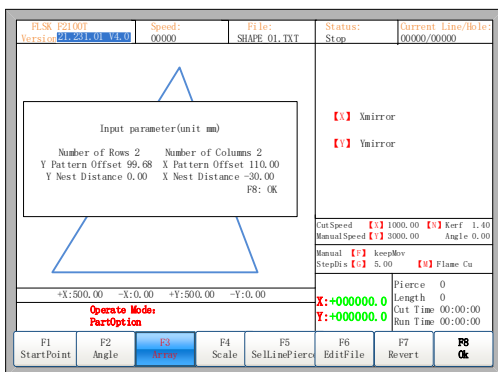


Fig 4.12 Arrange in Nest

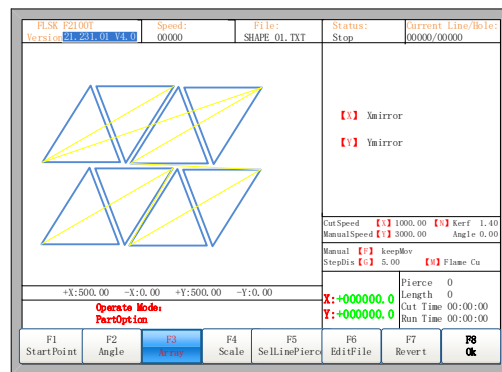


Fig 4.13 Result of arrangement in nest

Note:

The Arrange in Nest is mainly applied to graphics that are suitable for insertion, such as triangles, trapezoids and so on. First, the current graphic is rotated 180 degrees in the center. The original graphics and the rotated graphics are inserted into a new pattern. Then the combination of the new graphics start Staggered arrange. The description of parameters:

**Y Nest Distance:** When two graphs are inserted in centrosymmetric way, the distance between the two graphics center in the Y direction. This parameter can be negative.

**X Nest Distance:** When two graphs are inserted in centrosymmetric way, the distance between the two graphics center in the X direction. This parameter can be negative.

**Number of Rows:** Two graphics in centrosymmetric way combined into a graphic, and the number of rows that the combination of graphics arrange.

**Number of Columns:** Two graphics in centrosymmetric way combined into a graphic, and the number of columns that the combination of graphics arrange.

**Y Pattern Offset:** Two graphics in centrosymmetric way combined into a graphic, and the Y pattern offset that the combination of graphics arrange.

**X Pattern Offset:** Two graphics in centrosymmetric way combined into a graphic, and the X pattern offset that the combination of graphics arrange.

## 4.5 Proportion

In the part options menu, press [F4] (scale), the controller prompt as figure 4.14:

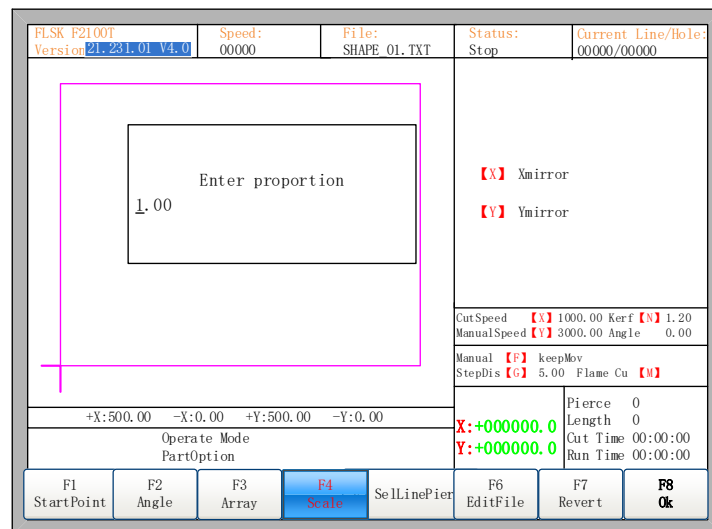


Fig 4.14 Set scales

After entering the scale, press **[Enter]**, then the shape will automatically be scaled if the parameter is legal.

Note: Proportion is also applied to lead in and lead out.

## 4.6 Select Line/Pierce

In part options menu, press **[F5]** to enter selecting line/pierce, the controller will prompt:

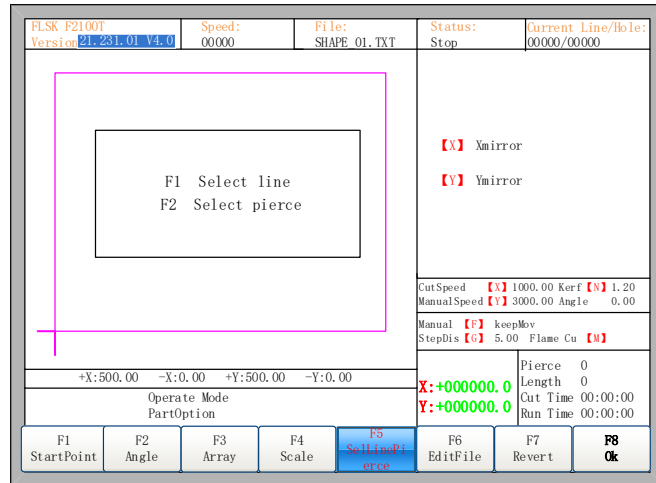


Fig 4.15 Select Line/Pierce

### 4.6.1 Select Line

Press **[F1]** to select the number of G code line to start cutting, the controller prompts:

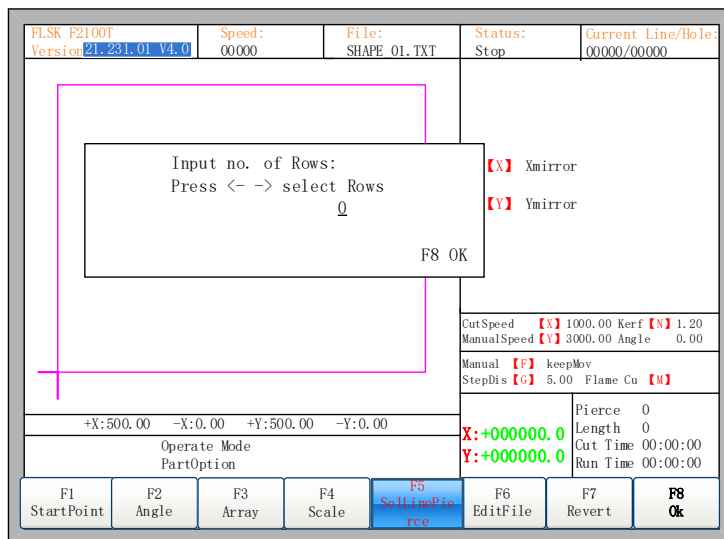


Fig 4.16 Prompt to select row

Here, you can directly enter the row number or press **[ENTER]** to press **[←]** or **[→]** to select row.



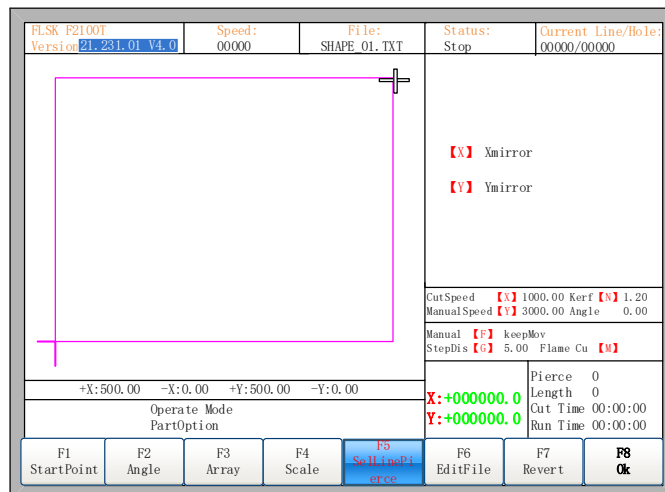


Fig 4.17 Select row

After selecting row, press **【F8】** to confirm.

### 4.6.2 Select Pierce

The operation is similar to 4.6.1.

### 4.6.3 Operation after Select Line/Pierce

After selecting row or pierce, press **【F8】** to exit to the main interface. Press SPACE to enter the auto interface, there are two kind of operation:

1. Move from current position to the selected position and then cutting
- Press **【F1】** in the auto interface, the controller will directly run to the position of the selected line or pierce without cutting, then pause and wait for the next operation.

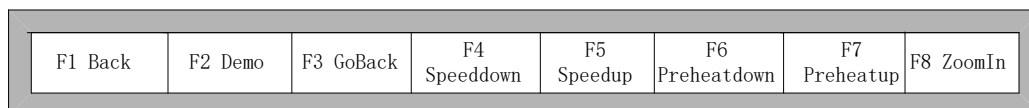


Fig 4.18 Function key of cutting interface

- Press **【START】** in the cutting interface, the controller will prompt:

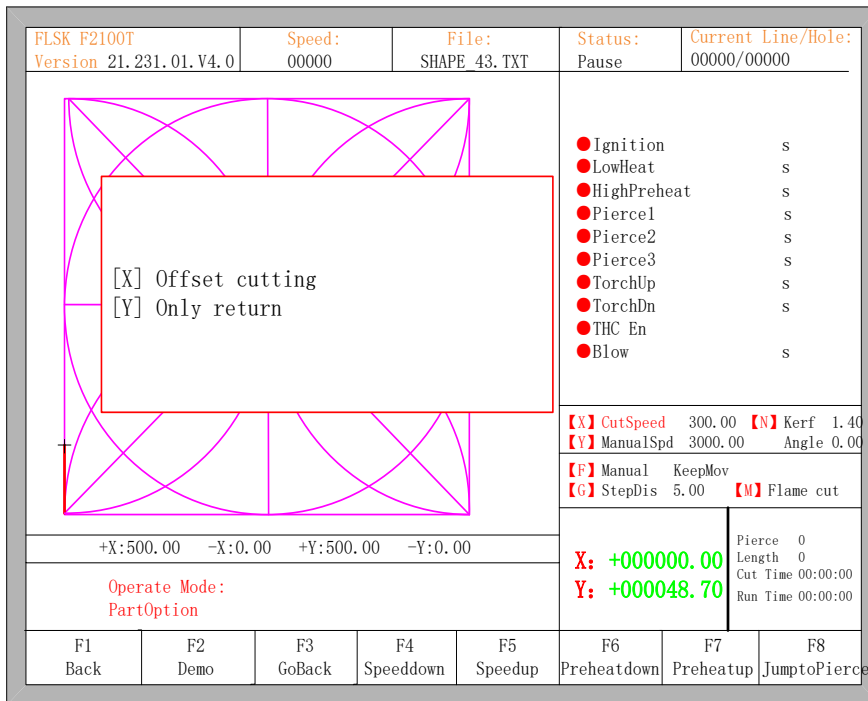


Fig 4.19 Operation after selecting row/number

Press **【Y】**, the controller will also directly move to the selected line or pierce, then pause and wait for the next operation.

2. Cutting from the current position

After the prompt of Fig 4.19, press **【X】**, then the controller will start cutting from current position.

### 4.7 Restore

If you want to cancel all of operations with part option including mirror, angel adjust, scale or/and array, press **【F7】** in the part options menu, the controller automatically revert to original state of the part.

## Chapter 5 Manual Function

In the automatic interface, press **【F7】** (Manual) to enter manual function interface, shown as Fig 5.1:

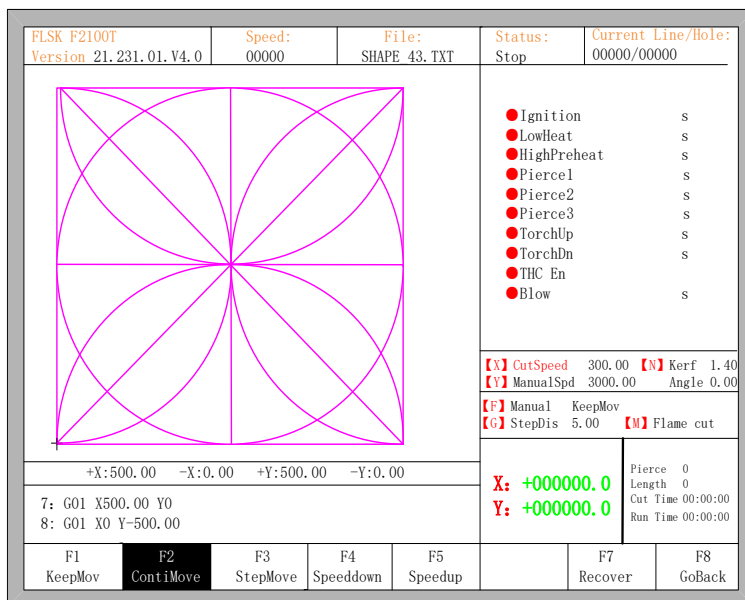


Fig 5.1 Manual function interface

Manual move speed can be increased by pressing **【HOME】** or be decreased by pressing **【END】**. Also, press numeric key, the manual move speed changes to ratio which is 10 times of the corresponding figure of the speed limit you have set, for example press **【3】**, change the cutting speed to 30% of the speed limit you have set, press **【8】**, change the cutting speed to 80% of the speed limit you have set.

### 5.1 Keep Moving Function

When you enter into the manual interface, the default option is continuous moving function. Press key **【F1】** to go for the keep moving function. At this moment, the controller will move toward the specified direction if any directory key is pressed, and when the directory key is released, the system will stop.

### 5.2 Continuous Moving Function

When in the manual interface, press **【F2】** to enter the continuous-moving function interface. At this moment, the controller will move toward the specified direction if any directory key is pressed and then released, and when any directory key or stop key is pressed the controller will stop moving.

### 5.3 Step Moving Function

In the manual interface, press **【F3】** to enter the interface of step moving,. The controller prompts to input the step distance:

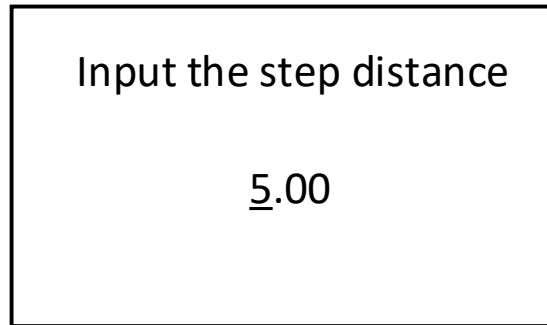


Fig 5.2 Input the fixed length

After inputting the step distance. Press any direction key and then release, the system will move the step distance toward the direction, in the process of moving, when any direction key or stop key is pressed, the controller will stop moving.

## 5.4 Breakpoint Recovery

To guarantee that the breakpoint could work correctly, you need to meet with the following conditions:

- 1) When the controller is paused. the controller will automatically remember the paused point as the breakpoint.
- 2) In the process of cutting, when power is off, the controller will remember the current position as the breakpoint and remember it.

When you need to recover from the breakpoint from the breakpoint. After the controller powers on, don't move the torch, press **【F7】** in the main interface to enter the manual interface, then press **【F7】** to recover from the breakpoint. After recovering, if the torch hadn't been moved and is on the position when the power is off, press **【START】**, the controller will go on from the breakpoint.

After the breakpoint is recovered, if the position is not on the exact position, you need move the torch to the exact point manually, check the exact point by Forward or Backward and Offset cutting operation.

Also you can move the torch to the start point of the part, then select Line or Pierce (refer to chapter 4.6 Select Line/Pierce), Press **【START】** and select only return function. the controller will show in Fig 5.3:

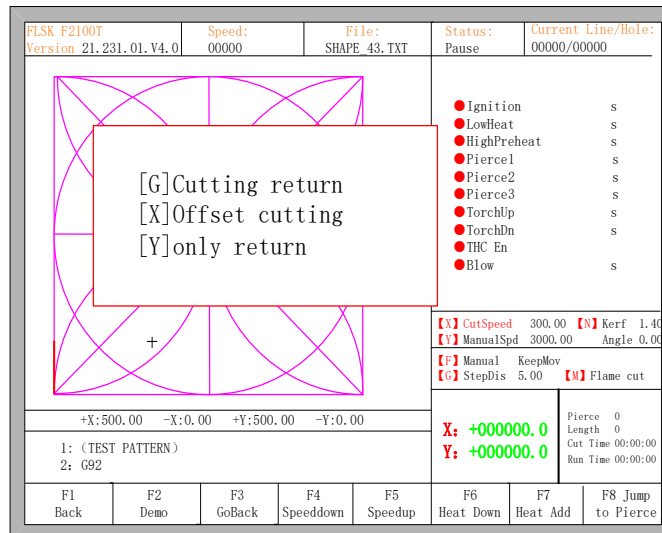


Fig 5.3 Restore breakpoint

- Press **【G】**, the controller will start cutting from current point to the start point of the select Line or Pierce.
- Press **【X】**, the controller will offset current point to the start point of the select Line or Pierce.
- Press **【Y】**, only move from the current point to the start point of the select Line or Pierce.

## 5.5 Laser Offset Function

Laser offset function refers to the user's installation of a laser cross location next to cutting torch. Distance between the cross and the cutting torch is fixed. After setting this offset distance(refers to section 7.4 powder parameters), user can use in **【F7】** Manual Move interface:

- **【F4】** Laser offset: can make the cross cursor move to the original position of the torch
- **【F5】** Laser bias: can make the torch move to the position of the cross cursor

Using this function, the user can conveniently use positioning characteristics of the cross laser cursor. After the completion of the positioning, make the torch move back to the position point of the cross cursor. This function can be mainly used in steel plate correction, steel plate start point search, etc.

If user has customized the laser offset function, the previous acceleration and deceleration buttons in manual move interface will be replaced by buttons [F4] laser offset and [F5] laser bias, shown as fig 5.4:

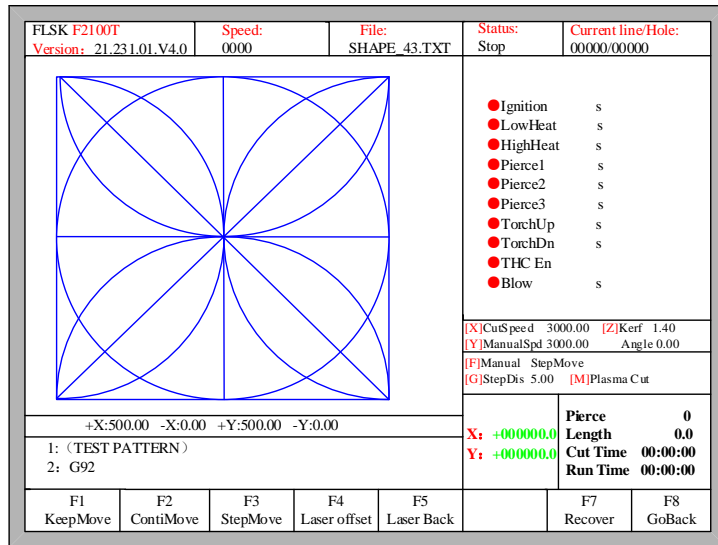


Fig 5.4 Laser offset and laser back function

## Chapter 6 File Operation

The controller supports cutting file which has txt、cnc、nc、B3、MPG postfixes. The maximum file size is 4M and the largest lines is 150000. You can edit, compile, delete, export or import.

Note:

1. The total files in the controller is less than 5000. And only less than 1000 files in a folder.
2. The total length of the file path in the USB disk can not exceed 133 bytes. A Chinese Character is counted by two bytes, and the letters and characters are counted by one byte.
3. The hard disk folder name is 13 bytes.
4. The file name is less than 64 bytes.

In the main interface, press key **【F2】** (edit) to enter file management interface, shown as follows:

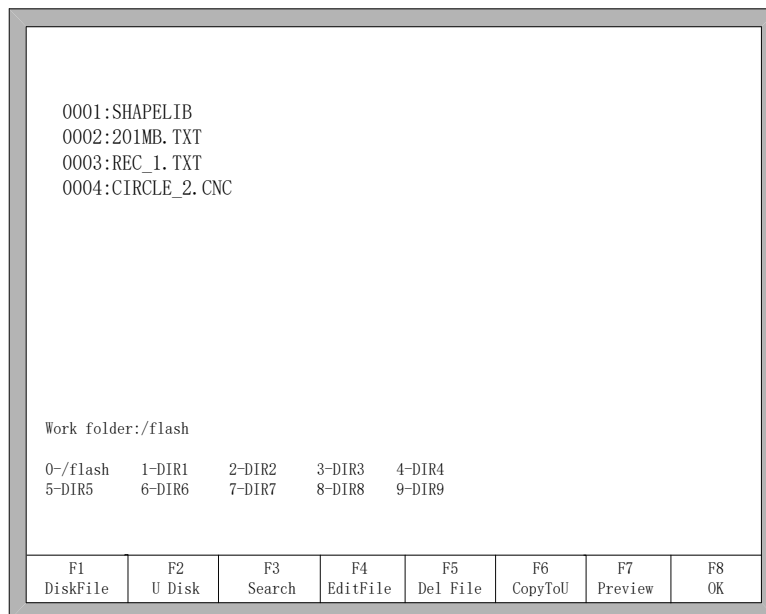


Fig 6.1 file manage interface

### 6.1 Disk Files

In the file management interface, press F1 to enter the Disk File management, as shown in Fig 6.1 . All supported files are listed.

- Press F4, if the file is G file, you could edit them. Please refer to chapter 6.4 on how to edit files.
- Press F5, you could choose to delete the current file or the current folder, as well as all the files.
- Press F6, if the file to USB.
- Press F7, preview the part image if the file is G file.
- Press F8, load the G file to the controller.

### 6.2 U Disk Files

In the file management interface, press key **【F2】** to go for U Disk interface.

In the U Disk interface, choose the corresponding G file stored in USB, press **【F6】**, the controller will save the file into the disk.

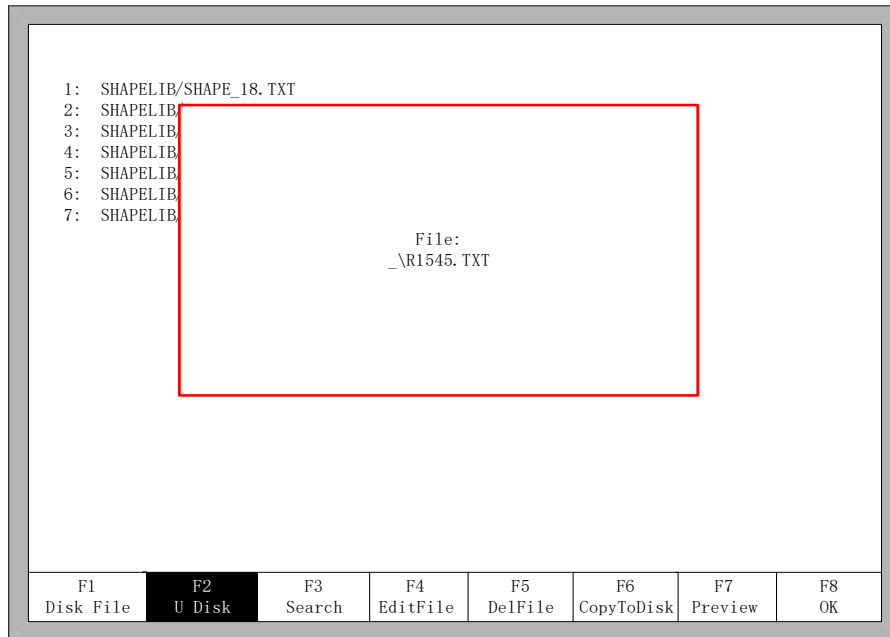


Fig 6.2 save U disk files

**Note:** The file in U disk can be loaded into the controller directly without be copied into the disk. At this time , the file will be saved automatically by name ufile.txt. shown as Fig 6.2:

When input file name, if you do not want to change the file name, you can be directly press **【Enter】** to preserved; or modify the file name and then press **【Enter】** to save. If the same named file has already existed, the system prompts:

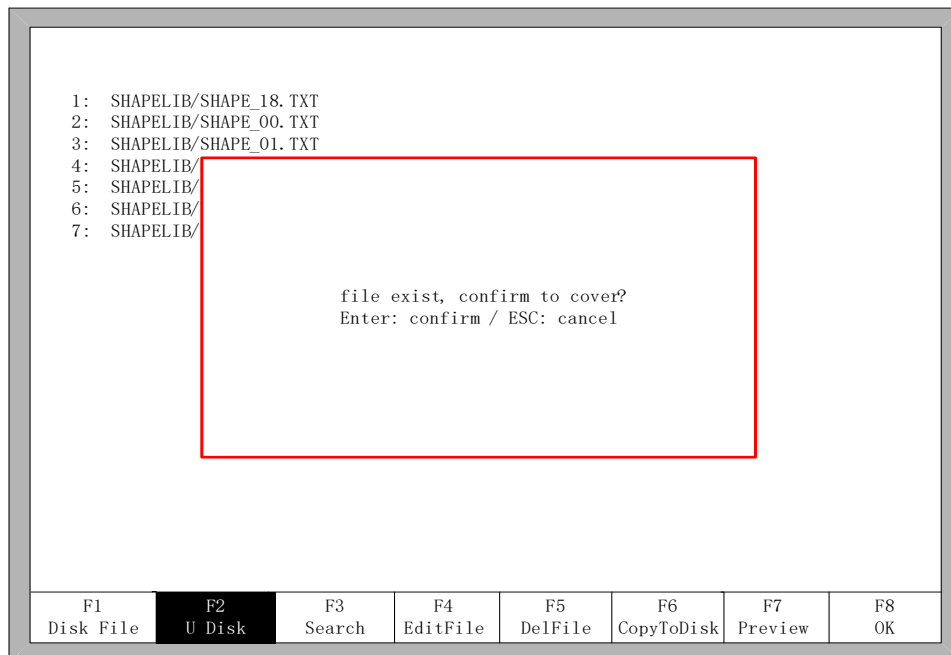


Fig 6.3 Replacement documents



## 6.3 Search File

In the file manage interface, press key **【F3】** to search a file. You can input all or part of the file name, then press **【Enter】**, and the controller will list all the files which name include the input word.

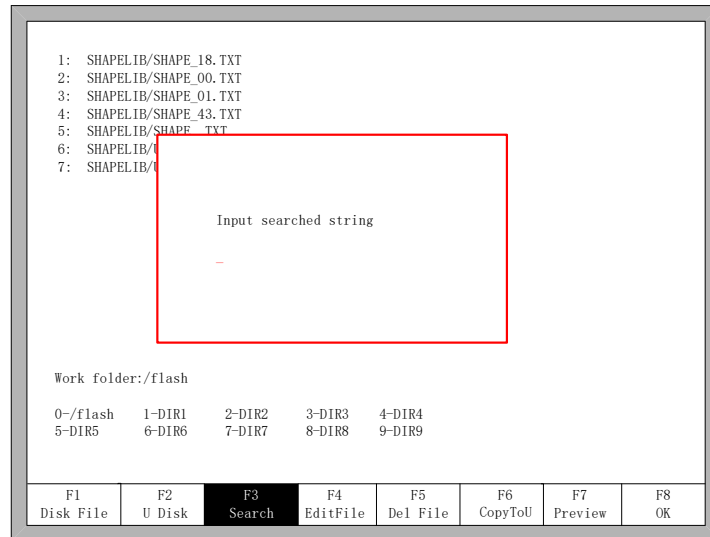


Fig 6.4 search file

## 6.4 Edit File

In the disk file interface, move the cursor to the file that you want to edit, then press **【F4】** to enter the edit interface.

When enter the characters, some keys are multiplexing button. Press these keys directly, enter the characters under the button. If first press **【Shift】** key, release the **【Shift】** key and then press the multiplexing button, then enter characters upper the button. Or press both **【Shift】** and reuse keys, then enter characters upper the button.

When editing the file, press **【F2】** can insert a new line after the current line, and press **【F3】** to delete the current line. Press **【F+/Home】** key, the cursor automatically moves to the first character of the current line, press **【F-/End】**, the cursor automatically moves to last character of the current line.

Each edit line supports 128 characters maximum.

When you open a file on U disk or new a G file, you must save it before using it. Otherwise, you cannot make use of the breakpoint recovery function.

Press **【F8】** to save the file.

## 6.5 Delete File

In the file management interface, press **【F5】** to delete the file, it will pop up the dialog box as shown in Fig 6.5, select the cursor to delete the file or the current selected folder all the files, or empty all the files.

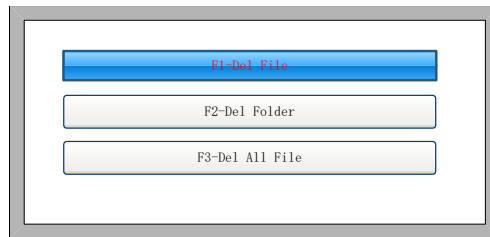


Fig 6.5 Del File

【F1】 Delete file: The G file where the current cursor is located is deleted.

【F2】 Delete folder: all G files in the current folder will be deleted.

【F3】 Empty all files: all G files in the machine will be deleted.

## 6.6 New File

In the editing file interface (refer to 6.4 edit code ), you can press key 【F4】 to create a new file.

## 6.7 Compile Code

After create a new G file or edit G file, if you want to check if file is legal or not , in the edit interface, press 【F1】 ,you can compile the file to check it.

## 6.8 Folder Management

### 6.8.1 Select Work Folder

The controller supports 10 folders, as the figure 6.1 shows.

- Work folder: current work folder path.
  - 0-/flash 1-DIR1 2-DIR2 3-DIR3 4-DIR4 5-DIR5 6-DIR6 7-DIR7 8-DIR8 9-DIR9 。These 10 symbols interpret 10 folder path. The number before '-' is the short key, press the corresponding number, switch current work folder into corresponding folder. For example, press 【1】 , it will show as the figure 6.6.

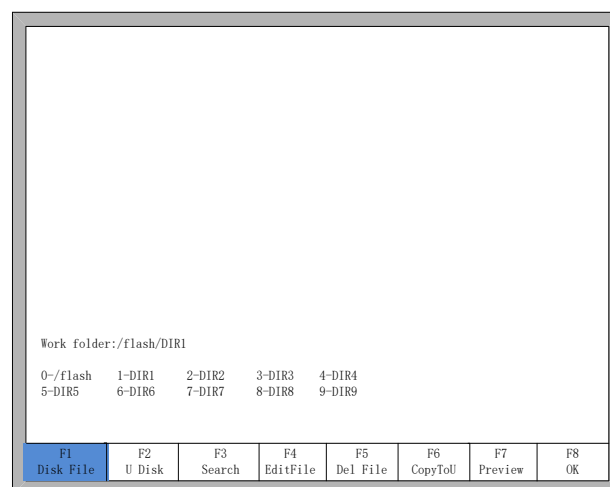


Fig 6.6 Folder 1

## 6.8.2 Create New Folder

As 6.4 edit file. First go to the edit file interface and edit a G file. As the figure 6.7 shows.

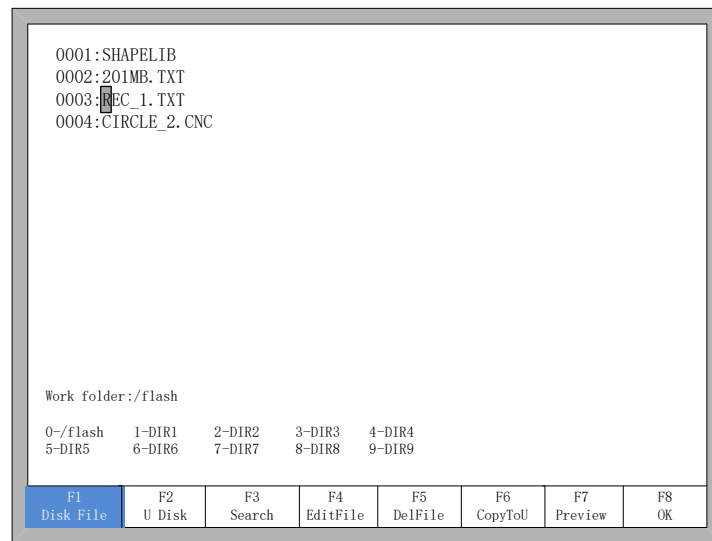


Fig 6.7 cursor moves to G code file name

Then press **【F4】** -- edit file, the function keys under the edit file show as figure 6.8.

F1 Compile	F2 AddRow	F3 Del Row	F4 New File	F5 NewFolder			F8 Save
---------------	--------------	---------------	----------------	-----------------	--	--	------------

Fig 6.8 Edit file interface

At this time, press **【F5】**, input the folder's name in the prompting dialog window and then press **【Enter】**.

**Illustration:** the controller supports only 10 folders. If there already are 10 folder, then the new added folder will replace the second folder, successively the third folder, the forth file and so on. The first folder /flash is reserve folder, this folder can neither be replaced nor be modified.

## Chapter 7 Parameter Setting

In the main interface, you can get the parameter interface by pressing key **【F4】** (Setups). Shown as Fig 7.1

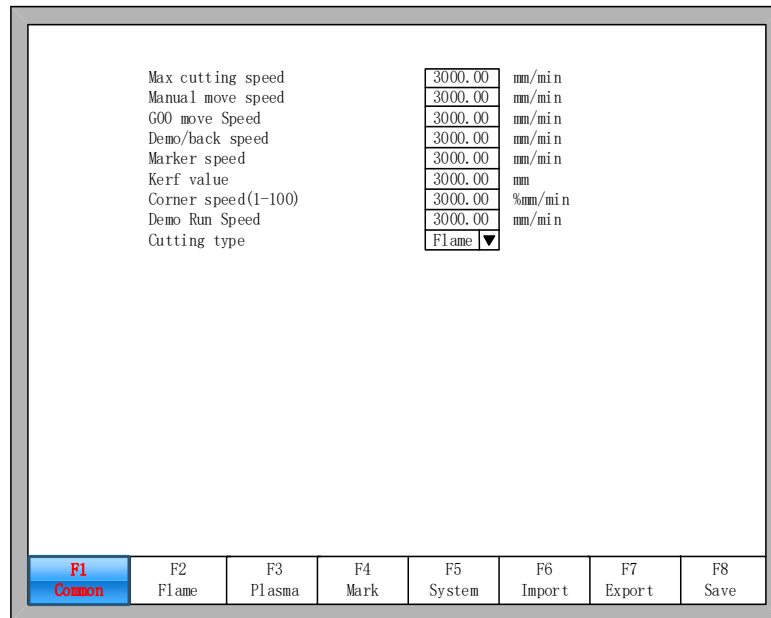


Fig7.1 Parameter Interface

You can set five kinds of parameter in the parameter interface:

- 1) Common parameters: cutting speed, manual move speed, G00 move speed, the size of kerf compensation, corner speed, cutting type.
- 2) Flame parameters: all the parameters used in oxygen gas cutting, edge cut enable.
- 3) Plasma parameters: all the parameters used in plasma cutting
- 4) Marker parameters: ignition, perforation cycle parameters, marker gun offset
- 5) System parameters: you can set system pulses, maximum speed limit, motor parameters and soft limit parameters.

### 7.1 Common Parameters

- **Cutting Speed:** the current cutting speed.
- **Manual Move Speed:** manual move speed.
- **G00 Move Speed:** the move speed at G00. That is the rapid move in cutting.
- **Demo/ back speed:** the speed of forward or backward along the part path.
- **Dust speed:** the speed when executing powder.
- **Kerf:** Specifies the amount of kerf that is applied to the current part program.
- **Corner speed:** Corner speed is speed limited at corner. When the  $\alpha$  is between 10-35 degree, the speed is limited automatically by controller. If the corner is less than 10 degree,

the speed is not limited , if it is more than 35, the speed is limited to start speed.

$$V_x = \begin{cases} V & \alpha < 10 \\ \left(1 - \frac{\alpha}{25\pi} * h\right) * V, & 10 \leq \alpha \leq 35 \\ \text{start speed} & \alpha > 35 \end{cases}$$



Fig 7.2 Corner Illusion

- **Demo run speed:** the speed under demonstration.
- **Cutting Type:** There are three cutting types: flame(Oxygen gas), Plasma and demonstration type.

## 7.2 Flame Parameters

Ignition Time	1.0	s
Low Preheat Time	30.0	s
High Preheat Time	0.00	s
Pierce 1 Time	0.00	s
Pierce 2 Time	0.00	s
Pierce 3 Time	0.00	s
Blow Time	0.00	s
Torch Up Time	0.00	s
Torch Down Time	0.00	s
Pierce Up Time	1.0	s
Pierce Down Time	30.0	s
THCEnable	<input checked="" type="checkbox"/>	
Hold heat	<input checked="" type="checkbox"/>	
Edge Cutting Enable	<input checked="" type="checkbox"/>	
Crawling Speed	600.00	mm/min
Crawling Time	0.40	s
Pierce Count	0	<input type="button" value="Clear"/>
WorkPiece Count	0	<input type="button" value="Clear"/>
Cut Length(m)	0	<input type="button" value="Clear"/>
Cut Time	00:00:00	<input type="button" value="Clear"/>
Run Time	00:00:00	<input type="button" value="Clear"/>

F1 Common	F2 Flame	F3 Plasma	F4 Mark	F5 System	F6 Import	F7 Export	F8 Save
--------------	-------------	--------------	------------	--------------	--------------	--------------	------------

Fig 7.3 Flame Parameters

- **Ignition Time:** the time delay after opening ignition output.
- **Low Preheat Time:** The preheating time before piercing the steel plate. During the low pressure preheating process, you can prolong the preheating time by pressing “stop” key or **【F7】** key. If Key **【stop】** is pressed, the preheating time will delay until **【Start】** is pressed . If **【F7】** is pressed, the preheating time will automatically be increased 15 seconds, and this time will be preserved by controller.
- **High Preheat Time:** Like **Low Preheat Time**. **But** open different IO, high preheat time is before low preheat time.
- **Pierce 1 Time:** Piercing time with low pressure oxygen open.
- **Pierce 2 Time:** Piercing time with middle pressure oxygen open.

- **Pierce 3 Time:** Piercing time with high pressure oxygen open.
- **Blow Time:** The open time of output blow after oxygen output is closed.
- **Torch Up Time:** Specifies the amount of time used for torch lift after completing each cut. This is normally used to provide torch head clearance and return the torch to its predefined rest position.
- **Torch Down Time:** Specifies the amount of time used to lower the torch at the beginning of each new cut. This is usually longer than the Pierce Torch Down Time as it involves lowering the torch from its predefined rest position.
- **Pierce Up Time:** Specifies the amount of time used for torch lift during piercing. This parameter is used to provide distance between the torch tip and metal surface for cutting.
- **Pierce Down Time:** Specifies the amount of time used for torch lowering during piercing.
- **THC Enable:** Torch Height Control is enable or disable. The output of THC enable is active or inactive in flame cutting .
- **Hold Preheat:** If it is checked, Low Heat IO port is on the open status even after completing each cut. It will be closed when all cuts are finished, that is the file is finished. Also, it can be kept open status even all cuts are finished if Hold Preheat after cutting end is YES, refer 8.7.6 option.
- **Edge Cutting Enable:** When it is checked, the controller will automatically stop whenever each pierce point has occurred. When it stops, user can move the torch to the edge of steel panel, then press start button, the controller will prompt:

```
[G]Cutting return
[X]Offset cutting
[Y]Only return
```

Fig.7.4 Edge cutting

When press **【G】**, after the controller will pierce at the current position and cutting to the part path. The current position should be at edge of metal.

This function will be especially useful when cut the thick metal plate. Thick steel plate is hard to be punched holes and the punched hole will be also larger. If directly punch hole in the cutting path, it will maybe affect the final production quality. Using edge cutting can may accelerate the efficiency of punch holes, save cutting time and improve production quality.

Of course, don't use edge cutting, punch hole with lead-in is also a more effective method.

- **Crawling speed:** creep speed when opening the crawling function. See8.7.6.9 for crawling function.

- **Crawling time:** Specifies the amount of time after piercing the part that the torch travels at crawling speed. After the Crawling Time is completed, the control accelerates to full cut speed. This parameter is helpful in allowing the operator to bring the cutting surface up to temperature and completely pierce the metal before cutting at full speed.

**Note:** Depending on the performance of the plasma system, a crawling time may be required to allow for ramp up of the cut voltage after a pierce.

- **Pierce count:** record the number of pierce during flame cutting.
- **Workpiece count:** record the number of workpieces completed by flame cutting.
- **Cut length:** record the total flame cutting distance. Unit: metric-meters, Inch-feet
- **Cut time:** record the time of flame cutting process.
- **Run time:** record the flame cutting time + G00 move time + the time of piercing time.

## 7.3 Plasma Parameters

DelayBeforeArc	0.00	s	Pierce Count	0	Clear
Pierce Time	0.00	s	WorkPiece Count	0	Clear
Torch Up Time	2.00	s	Cut Length(m)	0	Clear
Arcing Check Time	15.00	s	Cut Time	00:00:00	Clear
Position Check Time	10.00	s	Run Time	00:00:00	Clear
Position Up Time	2.00	s			
Speed to Lock THC	95.00	mm/min%			
Distance to Lock THC	5.00	mm			
Time of Disable THC after Piercing	0.00	s			
Lose Arc Delay	0.00	s			
Time to Lock THC before M08	100.00	s			
Pierce Up Time	2.50	s			
Pierce Down Time	2.00	s			
Watch Arc Enable	<input checked="" type="checkbox"/>				
Use Cylinder THC	<input type="checkbox"/>				
Set Arc Voltage	130	V			
Arc Protection Value	50	V			
THC Sensitivity	30.00	%			
Arc Set Step Value	1.0	V			
Fast HIS Time	6.00	s			
Flame Gun Lift Speed	100	%			
Plasma Gun Lift Speed	100	%			

F1 Common	F2 Flame	F3 Plasma	F4 Mark	F5 System	F6 Import	F7 Export	F8 Save
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Fig 7.5 plasma parameters

- **DelayBeforeArc:** Specifies the delay time before starting piercing. That is a wait time before controller starts to cut. All outputs are off.
- **Pierce time:** Specifies the time delay from when the torch completes lowering until motion is initiated at Creep Speed. Used to allow the plasma torch to completely pierce the material before moving.
- **Torch Up Time:** Specifies the length of time to raise the torch at the beginning and end of each cut to provide clearance over the cut pieces. If you are using an automatic height control system,

set Torch Up Time to zero.

- **Arcing Check Time:** The time between the control system start arc on and Arc On Feedback is on. The controller will go on to move and cut if arc on feedback is on with this time. Or it will prompt a warning message and stop running if arc on feedback is off after this time.
- **Position check Time:** The max time of controller start to lower the lifter and Position Detection is on.
- **Position up Time:** In Position Check Time, if the Position Detection is on, then the torch is raised for this time. It is the ignition height of plasma arc.
- **Speed to Lock THC:** The percentage speed of full cut speed. If the speed is less than this, the output of LockTHC is on.
- **Distance to Lock THC:** Within the distance of each cut segment, the output of LockTHC is on.
- **Time of Disable THC after Piercing:** The delay time to enable torch height control after arc on feedback is on.
- **Lose arc delay:** The filter time of lose arc detection.
- **Time to Lock THC before M08:** Plasma is off before the end of part cut.
- **Pierce up time:** When the crawling function is opened, the dynamic pierce parameters are described in detail. 8.7.6.9 Reptile function description.
- **Pierce Down time:** When the crawling function is opened, the dynamic pierce parameters are described in detail. 8.7.6.9 Reptile function description.
- **Watch arc enable:** whether real-time detection of arc on signal in cutting process or not.  
If setting "yes", in the cutting process, the system detects the real-time arc on feedback signal. If arc on is lost, the controller will stop the cutting and prompt alarm message.  
If setting "No", then in the cutting process does not detect arc on feedback signal
- **Use Cylinder THC:** When this parameter is selected, it keeps Torch Down output in cutting.

**(The following is typical for the "T" models in F2000 series CNC controller)**

- **Set Arc Voltage:** reference arc voltage, the range of value is 50.00-300.00。 Unit: V
- **Arc Protection Value:** When actual arc value  $\geq$  (Set Arc Voltage + Arc Protection Value), the controller will prompt an alarm of breaking arc and stop cutting, the range of the value is 5.00-100.00. Unit: V. Default 30V。

**Notice:** if arc value is less than 30 V, the controller will also prompt the alarm of breaking arc.

This 30 V is fixed value and not permitted to be modified.

- **THC Sensitivity:** This is sensitive reflected by THC motor. The more fast of the lifter motor, the more larger of THC Sensitivity. It is advised to set 30-50, the range of which is 1.00-100.00.
- **Arc Set Step Value:** In cutting interface, Increase or decrease the **Set Arc Voltage** value every time by pressing F7 or F6, the range of value is 0.10-10.00. Unit: V。



- **Fast IHS Time:** The lifter motor runs time in full speed when IHS(initial height sensing). Then the lifter motor runs the half speed until the torch contact the steel plate.  
Notice: **Fast IHS Time** cannot be more than **Position Check Time**.
- **Flame gun lift speed:** Flame torch can reach the maximum percentage of lift speed.
- **Plasma gun lift speed:** Plasma gun torch can reach the maximum percentage of lift speed.
- **Pierce Count:** record the number of perforations during the plasma cutting process.
- **WorkPieceCount:** record the number of workpieces completed by plasma cutting.
- **Cut Length (m):** record the total plasma cutting distance. Unit: metric-meters, Inch-feet.
- **Cut time:** record the time of plasma cutting process.
- **Run time:** record the plasma cutting time + empty time + the time of M07 state.

## 7.4 Marker Parameters

Marker Ignition Time	<input type="text" value="0.00"/>	s
Marker Preheat Time	<input type="text" value="0.00"/>	s
Mix Powder Open Time	<input type="text" value="0.00"/>	s
Mix powder Close Time	<input type="text" value="0.00"/>	s
Marker Up Time	<input type="text" value="0.00"/>	s
Marker Down Time	<input type="text" value="0.00"/>	s
Marker Horizontal Offset	<input type="text" value="0.000"/>	mm
Marker Vertical Offset	<input type="text" value="0.000"/>	mm
Laser Torch X offset to Flame Torch	<input type="text" value="0.000"/>	mm
Laser Torch Y offset to Flame Torch	<input type="text" value="0.000"/>	mm
Plasma Torch X offset to Flame Torch	<input type="text" value="0.000"/>	mm
Plasma Torch Y offset to Flame Torch	<input type="text" value="0.000"/>	mm

F1 Common	F2 Flame	F3 Plasma	F4 Mark	F5 System	F6 Import	F7 Export	F8 Save
--------------	-------------	--------------	------------	--------------	--------------	--------------	------------

Fig 7.6 marker parameters

- **Marker Ignition Time:** Ignition time of marker. Note: the output is same to flame ignition output.
- **Marker Preheat Time:** The preheat time of marker from ignition complete to open mix power Open.
- **Mix powder Open/Close Time:** Delay time of scatter powder mouth relative to spurt powder mouth open/close, input  $\geq 0$  arbitrary value, unit: s.
- **Marker Up Time:** The time of marker torch going up. Unit: s.
- **Marker Down Time:** The time of marker torch going down. Unit: s.
- **Marker Horizontal Offset:** Horizontal offset of powder torch gun relative to flame

cutting torch gun. Unit: mm.

- **Marker Vertical Offset:** Vertical offset of powder gun relative to cutting torch. Unit: mm.
- **Laser Troch X offset to Flame Torch:** the horizontal distance of the laser gun relative to the flame torch gun.
- **Laser Troch Y offset to Flame Torch:** the Vertical distance of the laser gun relative to the flame torch.
- **Plasma Torch X offset to Flame Torch:** the horizontal distance of the plasma torch gun relative to the flame torch gun.
- **Plasma Torch Y offset to Flame Torch:** the Vertical distance of the plasma torch relative to the flame torch.

## 7.5 System Parameters

The system parameters, as shown in Fig 7.7, are related with the precision of driver shaft of the cutting machine, coordinate axis, increase/decrease of rate and little arc processing limited parameter.

Horizontal Axis Pulse	<input type="text" value="125"/>	pluse/min
Vertical Axis Pulse	<input type="text" value="125"/>	pluse/min
Max Cutting Speed	<input type="text" value="6000.00"/>	mm/min
Max Goo Speed	<input type="text" value="6000.00"/>	mm/min
Max Manual Speed	<input type="text" value="6000.00"/>	mm/min
Small Arc Limit	<input type="text" value="800.00"/>	mm/min
Limited Speed below Radius	<input type="text" value="0.00"/>	mm
Accerate Time in Flame	<input type="text" value="0.40"/>	s
Accerate Time in Plasma	<input type="text" value="0.30"/>	s
Emergency Stop Time	<input type="text" value="0.080"/>	s
Start Speed	<input type="text" value="250.00"/>	mm/min
Max+X	<input type="text" value="100000.00"/>	mm
Max+Y	<input type="text" value="100000.00"/>	mm
Min-X	<input type="text" value="-100000.00"/>	mm
Min-Y	<input type="text" value="-100000.00"/>	mm/min

F1 Common	F2 Flame	F3 Plasma	F4 Mark	F5 System	F6 Import	F7 Export	F8 Save
--------------	-------------	--------------	------------	--------------	--------------	--------------	------------

Fig 7.7 System Parameters

- **Horizontal Axis Pulse:** The number of pulse that controller needs to generate when the machine move 1mm towards X axis, maintaining 3 digits at most after decimal point.

- **Vertical Axis Pulse:** The number of pulse that system needs to generate when the machine move 1mm towards Y axis , maintaining 3 digits at most after decimal point.
- **Max Cutting Speed:** the maximum cutting speed.
- **Max G00 speed:** the allowable maximum rapid move speed.
- **Max Manual Speed:** the maximum speed of manual move.
- **Small Arc Limit:** Maximum speed at cutting a small arc. Refer to note 1.
- **Small Arc Radius Limit:** If the radius is less than or equal to the value of the circular arc, the running speed should be limited. Refer to note 1.
- **Flame adjusts time:** the accelerate time from start speed to the full speed in flame cutting.
- **Plasma adjust time:** the accelerate time from start speed to the full speed in plasma cutting.
- **Emergency STOP Time:** the deaccelerate time from current speed to stop in emergency.
- **Start Speed:** the system's speed when it began to start.
- **Max Coordinate:** The maximum positive coordinate which the machine can reach horizontally.
- **Min Coordinate:** The minimum negative coordinate which the machine can reach horizontally.

Note 1:

Table 7.1 Small Arc Definition

Cutting Speed(mm/min)	Small Arc Radius(mm)
0-2000	5
2000-4000	10
4000-6000	15
6000-8000	20
8000-10000	25
10000-12000	30
>12000	35

The relationship between cut speed and arc radius:

Small Arc Limit	Small Arc Radius	Cutting Speed
=0	=0	No limit
>0	=0	Follow table 7.1, for arc less than small arc radius, the running speed should be limited.
>0	>0	Cutting speed = small arc limit x (arc radius/ radius of small arc limit). When the result is less than the starting speed, the value is starting speed. When starting speed is less than cutting speed, the value is cutting speed.

Note: the modified small arc limit or radius of small arc limit will become effective only after reloading cutting files.

## 7.6 Parameter Import

In the parameter configuration interface, press F6 to import the parameters from the U disk or the hard disk. As shown in Fig 7.8. The import from the U disk, first of all, insert the U disk into the system USB interface, and the corresponding parameter file in the U disk, which can only be from the same system with the system model derived from the parameters of the file. Then select the parameter file that need to import from the U disk, click Enter.

The import from the hard disk, first of all, determine that the local hard disk has a saved parameter file. Click Enter to select the parameter file saved in the local hard disk, then click enter.

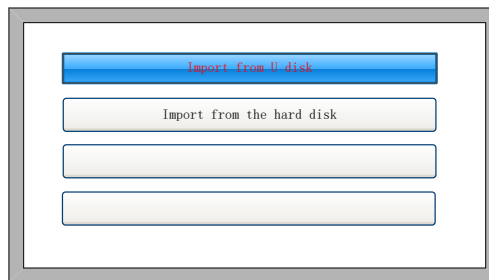


Fig.7.8 Parameter import

## 7.7 Parameter Export

After the parameter configuration is over, press F7 in the parameter configuration interface to export the parameters, you could choose to export to the U disk or hard disk.

The export to the U disk. First of all, Insert the U disk into the USB port of the unit, named the name of the parameter file. Click Enter to complete the parameters saved to the U disk.

Export to the hard disk, and the parameters stored in the hard disk. When needed, restore at any time.

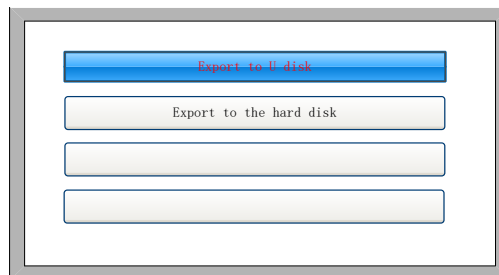


Fig.7.9 Parameter export

This function combines the input parameter function to enable rapid adjustment of the cutting parameters required for different thickness plates. Use the export parameters function to let the cutting parameters of thickness of the plate required to store in the hard disk or the U disk. When cutting the corresponding thickness of the plate, use the import parameters function from the U disk or hard disk to import the corresponding parameters can be.

## 7.8 Save Parameters

After parameter modification, press **【F8】** to save.

**Note:** when any parameter has been modified, you must take preservation operation to keep modification valid, or the system will take the original parameters.

## Chapter 8 Diagnosis Function

Input							
Forward limit		●		Move up input		●	
Back limit		●		Move down input		●	
Right limit		●		Move left input		●	
Left limit		●		Move right input		●	
Emergency stop		●		Acceleration input		●	
Arc Feedback		●		Deacceleration input		●	
IHS Signal		●		Torch up input		●	
Plasma Collision		●		Torch down input		●	
Upper Limit in THC		●					
Lower Limit in THC		●					
F1 Input	F2 Output			F5 KeyBrd	F6 SelfCheck	F7 DateTime	F8 System Def

Fig 8.1 Diagnostic interface

In the main interface, you can press **【F5】** to enter the system diagnosis interface, as shown in Fig 8.1.

You can be diagnosing the I/O and keyboard in this interface. System self-check can be made by this.

## 8.1 Diagnosis Interface Index

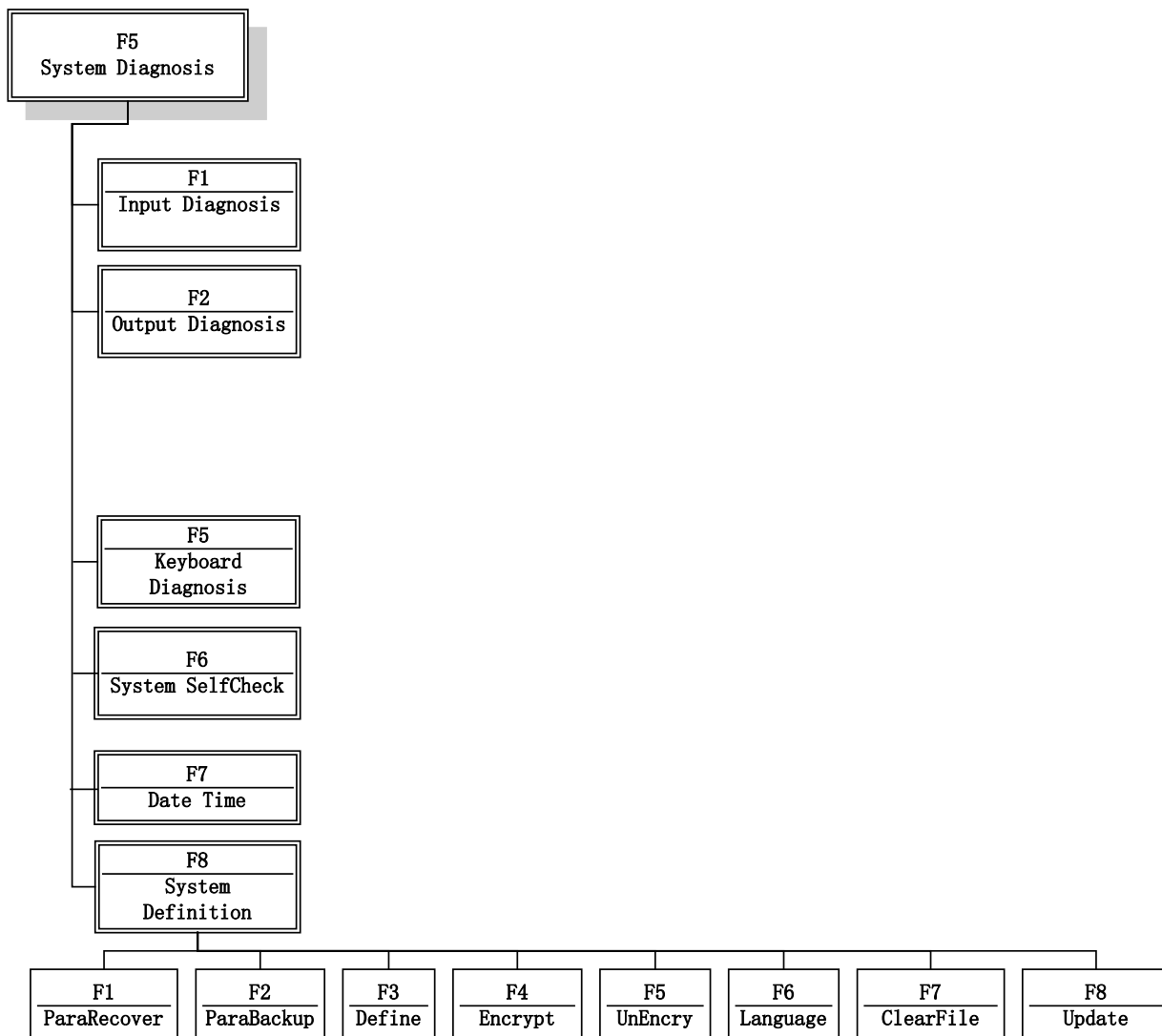


Fig 8.2 Diagnosis interface index

## 8.2 Input Diagnosis

The system will read current IO information when press **【F1】** to refresh the interface, and display all IO's status. The green NC means the input is effective, and the red NO means the input is ineffective.

## 8.3 Output Diagnosis

In diagnosis interface ,press **【F2】** to enter output diagnosis interface, shown as Fig 8.3

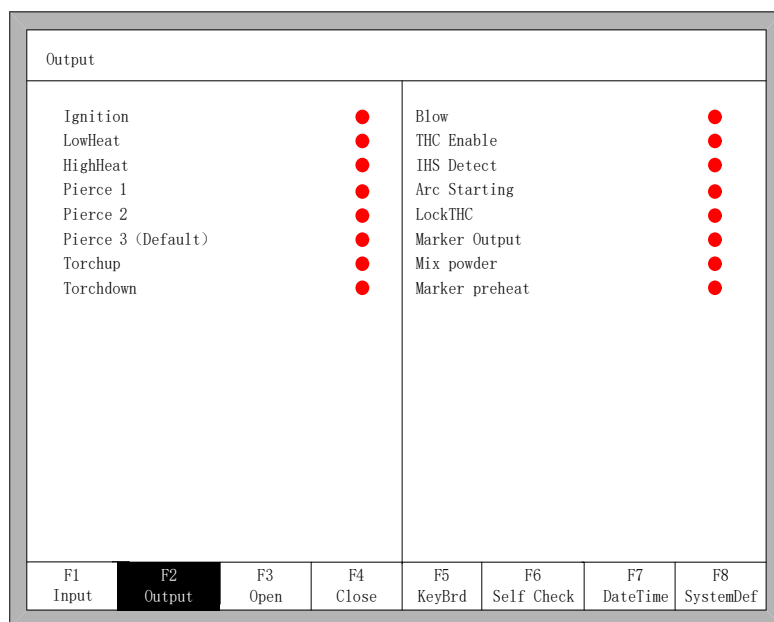


Fig 8.3 Output diagnosis

Press **【↑】**, **【↓】**, **【←】**, **【→】**, you can move the cursor to the corresponding output port, press **【F3】** to open the corresponding output port, press **【F4】** to close the corresponding output. ● represents the output is active, ● represents the output is inactive.

## 8.4 Keyboard Diagnosis

In diagnosis interface ,press **【F5】** to enter okeyboard diagnosis interface, shown as Fig 8.4.

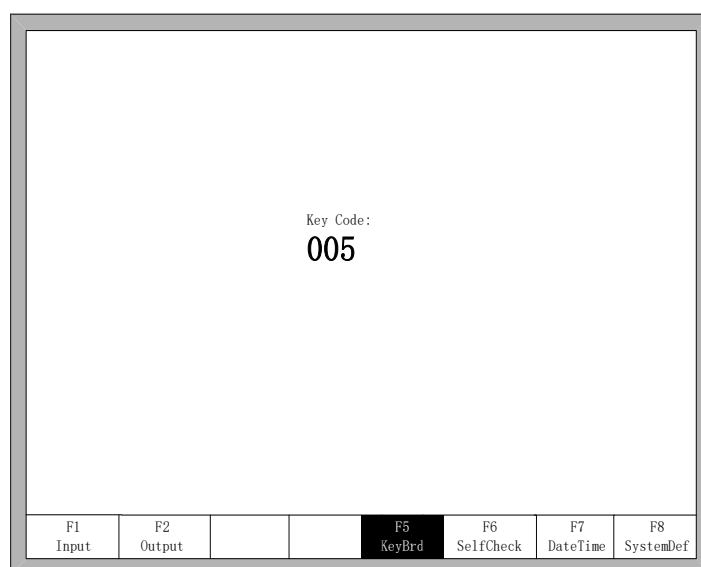


Fig 8.4 Keyboard Diagnosis

In this interface, press any key of the keyboard, there will be a corresponding keyboard encoding shown here. if there is no encoding shown, then this key is out of fault.



## 8.5 System Self-check

In the system diagnosis interface, press **【F6】** to enter the system self-check interface.

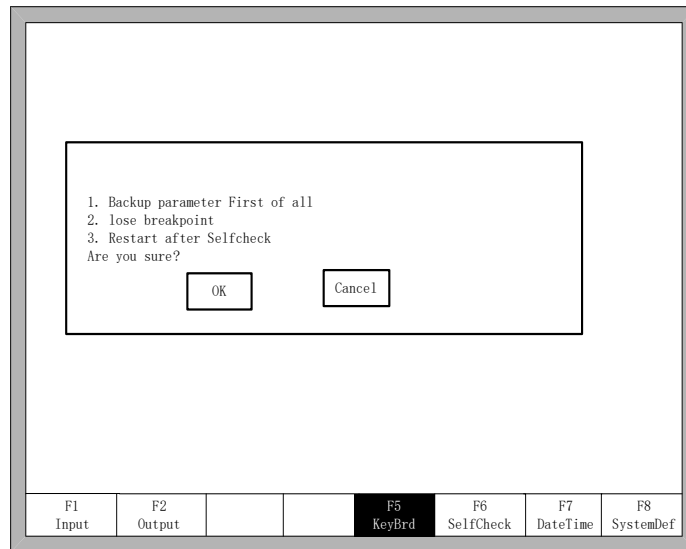


Fig 8.5 System self-check

If the self-check is OK, the system will show:

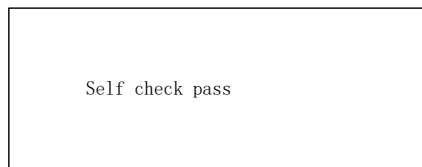


Fig 8.6 Self-check pass

## 8.6 Date and Time

Press F7 in the system diagnosis interface to set the date and time

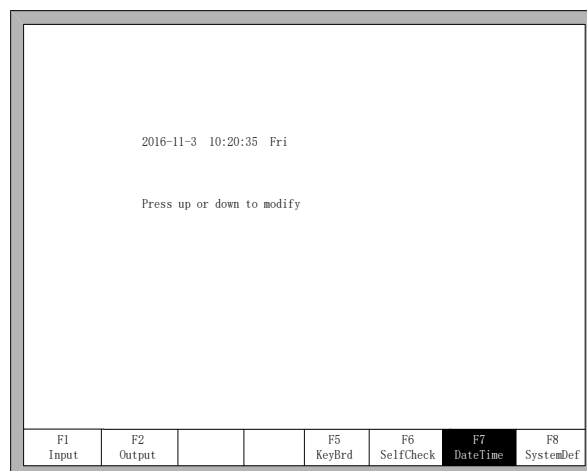


Fig 8.7 System time

Move the cursor to the corresponding date, time or week, press **【↑】** or **【↓】** to adjust the time.

## 8.7 System Definition

In the system diagnosis interface, press F8 to enter the system custom definition interface, in the interface, you could set the input IO, output IO or system coordinate, set back to zero, and also reset or backup the parameters and one key switch between English or Chinese.

### 8.7.1 Parameter Backup and Restore

Parameter Backup: The process of parameter backup is, in the main interface press **【F5】** (System Diagnosis), **【F8】** (System Definition), **【F2】** (Parameter Backup). The system will need code, after inputting the code “1396”, press **【Enter】**, the system will import the default parameters. In the following process, if the parameters are modified or some of them are broken, reset the parameters.

Notice: after installing and debugging the complete equipment, equipment manufacturer please backup the parameters.

Parameter Reset: The process of reset the parameters is, press **【F5】** (System Diagnosis) in the main interface, **【F8】** (System Definition), **【F1】** (Parameter Reset).

Notice: After resetting successfully, please restart the system.

### 8.7.2 Input Definition

The controller could change the IO definition, including changing the order of IO number, the type of IO (normally open or closed) according to the user's need. In the system custom definition interface, press **【F3】** to enter the definition interface, press **【F1】** to enter the input definition interface. As shown in fig 8.8.

Definition of Input																
Function	Port	Type	Function	Port	Type											
Forward Limit	02	NO	Move Up Input	09	NO											
Back limit	15	NO	Move Down Input	10	NO											
Left limit	14	NO	Move Left Input	07	NO											
Right Limit	01	NO	Move Right Input	08	NO											
Emergency Stop	03	NO	Acceleration Input	16	NO											
Arc Feedback	04	NO	Deacceleration Input	17	NO											
IHS Signal	05	NO	Torch Up Input	18	NO											
Plasma Collision	06	NO	Torch Down Input	19	NO											
<table border="1"> <tr> <td>F1 Input</td> <td>F2 Output</td> <td>F3 Axes</td> <td>F4 Motor</td> <td>F5 Option</td> <td>F6 Option2</td> <td></td> <td>F8 Save</td> </tr> </table>									F1 Input	F2 Output	F3 Axes	F4 Motor	F5 Option	F6 Option2		F8 Save
F1 Input	F2 Output	F3 Axes	F4 Motor	F5 Option	F6 Option2		F8 Save									

Fig 8.8 input definition

In the interface press **【↑】**、**【↓】**、**【←】**、**【→】**, move the cursor to the position that needs changing, press **【Enter】** to open the tab of the drop - down box at the location of the cursor, move the cursor by **【↑】**、**【↓】**, press **【Enter】** to change the number of the Input, press **【Enter】** to set the selected parameters.

Serial number: 01~10, 14~22.

Type: NO (normally open), NC (normally closed)

Function: Move forward, move back, move left and move right, ignition input, oxygen cutting input, start input, stop input, gun rising input, gun down input, acceleration input, deceleration input, z axis upper limit position, z axis lower limit position, open drilling rig, drive no alarm situation, forward and backward.

### 8.7.3 Output Definition

The controller could change the IO definition, including changing the order of IO number, the type of IO( normally open or closed) according to the user’s need. In the system custom definition interface, press **【F2】** to enter the definition interface,, as shown in fig 8.9.

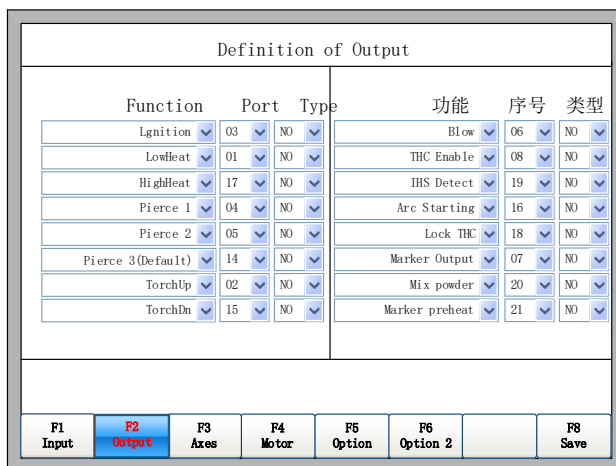


Fig 8.9 output definition

In the interface press **【↑】**、**【↓】**、**【←】**、**【→】**, move the cursor to the position that needs changing, press **【Enter】** to open the tab of the drop-down box where the cursor is located. Press **【↑】**、**【↓】** to move the cursor and press **【Enter】** again to set the selected parameter. The output type is open drain transistor output type.

Type NO means that the output signal is normally open. Type NC means that the output signal is normally closed.

### 8.7.4 Coordinate Definition

The system could provide IO definition for the user. As shown in Fig 8.10

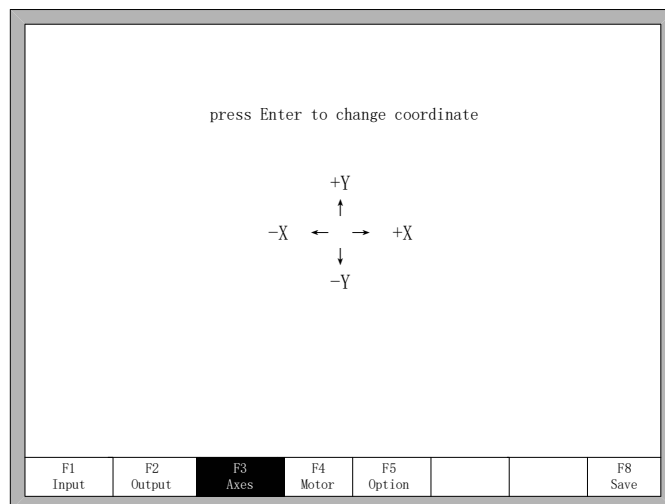


Fig 8.10 Coordinate Definition

In the interface, press Enter repeatedly to change among 8 type of coordinates. Press **【F8】** to save.

### 8.7.5 Motor

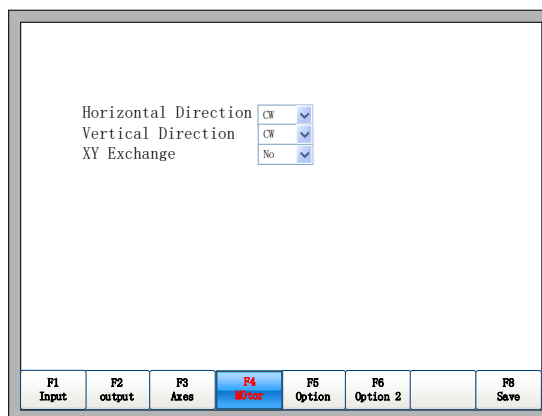


Fig.8.11 Motor Direction

Fig 8.11 Motor direction Press up or down key, move the cursor **■** to the axes of which needs to change motor rotation direction, then press **【Enter】**, the motor direction can switch between positive and reversal.

XY exchange: if this function is “YES”, output pulse of X axis and Y axis exchange each other, in other words, horizontal axis and vertical axis exchange each other.

## 8.7.6 Option

### 8.7.6.1 Remote Controller

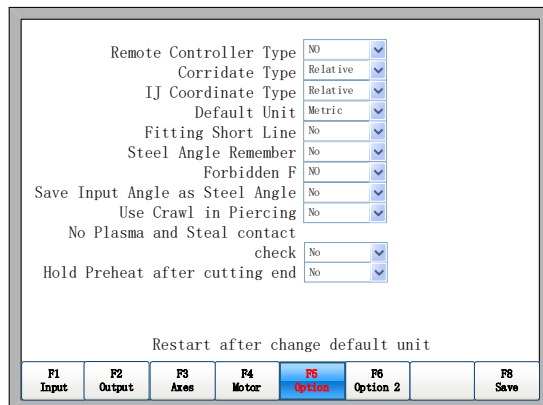


Fig 8.12 Option

Press left or right arrow in this interface, remote controller's type can be set arbitrarily one of the three types which are NO, P2P, 8421.

- NO type: no input of remote controller.
- P2P type: reference the section 11.1.2 Remote input.
- 8421 type: reference the section 11.1.2 Remote input.

### 8.7.6.2 Default Coordinate

As the figure 8.12 shows, the default coordinate can be set default relative coordinate or default absolute coordinate.

### 8.7.6.3 Default IJ Coordinate

As the figure 8.12 shows, in the G code of G02 or G03, I or J parameter after the code is relative coordinate or absolute coordinate. Under the general circumstance, the arc's IJ coordinate is relative coordinate, only minority several G code of arc's IJ coordinate is absolute coordinate.

### 8.7.6.4 Switch between Metric and Inch

As the figure 8.12 shows, default unit can be switched to either the metric or the inches, after switching, the data's units about length are all switched.

### 8.7.6.5 Short Line Fitting

As the figure 8.12 shows, when short line segments in the G code are too many and continuous shake or shock occurs in the process of machine tool runs, set this parameter "Yes", in the general condition this parameter is set "No".

### 8.7.6.6 Steel Plate Angle Memory

In the default condition, the angle after steel plate is adjusted has no memory. After this parameter is set “Yes”, steel plate angle memory will be automatically stored, until the steel plate is adjust again or the angle is cleared.

### 8.7.6.7 F Instruction Forbidden

When this parameter is “Yes”, F instruction after G code which is used for limited rate is ignored.

### 8.7.6.8 Manual Angle Input to Adjust Steel Plate

When this parameter is “Yes”, the manual input angle in the section of 4.3.3 is also steel plate adjusting angle. This angle will be shown in the main interface, if open the function of steel plate angle memory, this angle is also add to the steel plate adjust angle and accordingly saved.

### 8.7.6.9 Use the crawl function

When this parameter is yes, dynamic pierceand crawl are enable. The timing diagram of the dynamic pierce is shown in Fig 8.13.

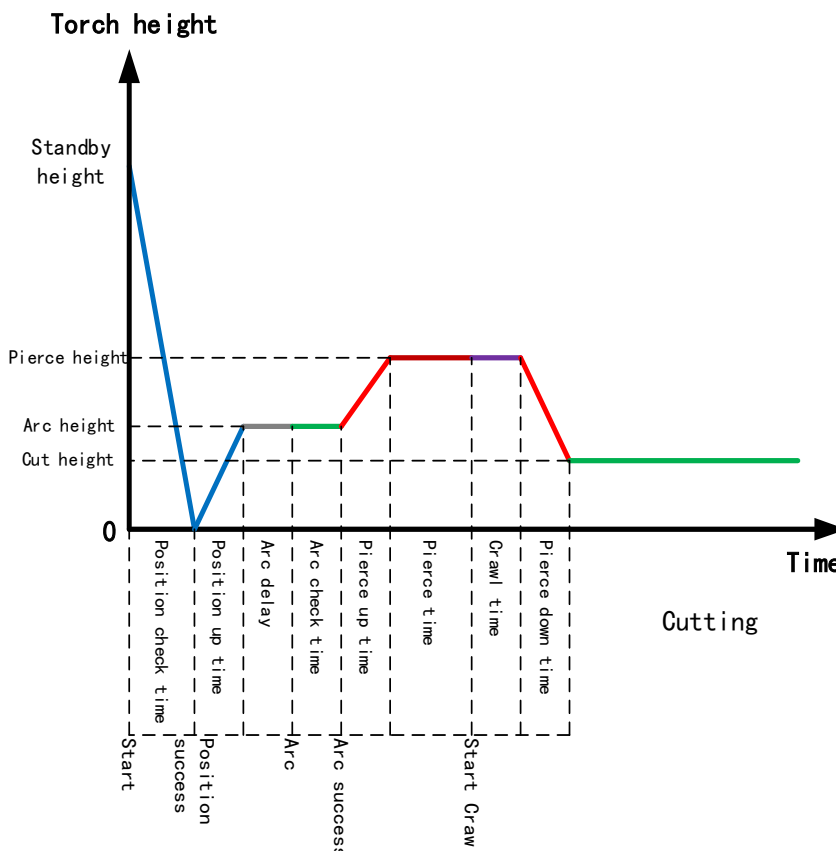


Fig 8.13 Dynamic perforation timing diagram

**Time parameter description:** (For details, see 7.3 Plasma Parameter Settings.)

- Position check time: After the cutting is started, the torch descends, and when the system detects the positioning success signal, the positioning detection time ends in

advance. If the system has not received the positioning success signal after the positioning detection time has ended, the system will alarm. When this parameter is 0, the system will skip the detection of the positioning success signal and the torch will not fall and go directly to the positioning up phase.

- Position up time: After detecting the positioning success signal, the torch is lifted and the ascending time is the positioning rise time. When the parameter is 0, the torch does not lift, the system goes directly into the arc delay phase.
- Arc delay: After the positioning up time is over, the system will delay the arc for a period of time, which is defined as the arc delay. When the parameter is 0, the system goes directly to the arc, instead of delaying.
- Arc check time: After the Arc delay time is over, the system starts to open the Arcing port and detect the successful starting feedback signal. When detecting the successful signal, the arc detection time ends in advance. If the system has not received the successful starting feedback signal after the arc detection time has ended, the system will prompt the error and terminate the cutting of the current workpiece, and exit the program according to the breakpoint memory. When the parameter is 0, the system will directly detect the starting feedback signal. If the signal is not detected, it will report an error. After detecting the signal, the system will enter the next stage.
- Pierce up time: After arc success, the torch at the same time to enhance. This upgrade time is the pierce up time. When the parameter is 0, the torch does not lift and the system goes directly to the next stage.
- Piercing time: After the system detects the successful feedback signal from the arc, the system starts to static perforation, which is called piercing time. When this parameter is 0, the system will skip the time and enter the crawl phase.
- Crawl time: At the end of the static perforation, if there is more perforation at the perforation point, higher slag build-up, the arc will be unstable when cutting in this area. So it is necessary to move forward for a period of time under the condition of no height adjust, the time is the crawl time. When this parameter is 0, the system will skip the time and enter the perforation fall phase.
- Pierce Down time: When the crawl time ends and the torch descends to the normal cutting height, start cutting. And this fall time is the perforation fall time. When the parameter is 0, the torch does not drop, and directly start normal cutting.

#### **8.7.6.10 No Plasma and Steal contact check**

Whether the collision signal is detected during the plasma cutting process. If the election is no, when the collision between the plasma gun and the steel plate is detected during cutting process, cutting will be stopped and the alarm prompt will be given. If it is selected yes, the collision information is not processed during cutting.

#### **8.7.6.11 Hold Preheat after cutting end.**

In oxygen gas cutting, when cutting is completed, choose whether to turn off the preheated oxygen automatically..

### 8.7.7 Option 2

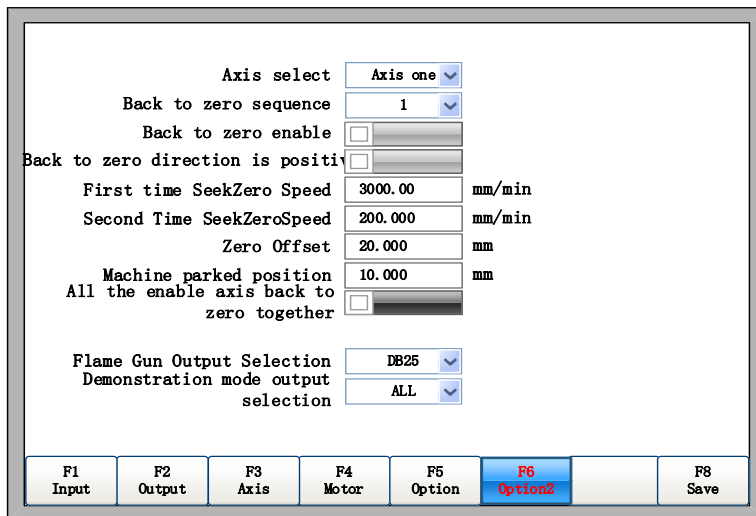


Fig 8.14 Option 2

#### 8.7.7.1 The function of backing to zero.

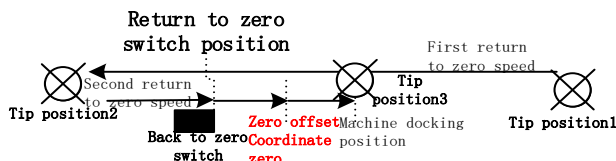


Fig 8.15 Return to zero process diagram

As shown in Fig8.15, backing to zero process is: Before starting to return to zero, the tip is in the right side of the tip position 1, then press the F8 button on the main interface, the machine starts to return to zero, The tip moves to the left in the direction of the first zero return arrow shown in Figure 8.15 at the first zero return. The location of the first time to find the zero switch is just to find the approximate range of zero switch, so the speed can be relatively fast. When the return switch is detected, the system will immediately pause, then the gun will stop at the left side of the zero switch, as shown in the figure Tip position 2. The machine will then move to the right in the direction of the second return arrow as shown in Figure 8.15 at the second return to zero, and the position of the second time to find the zero switch is found, and the range of the zero switch has been determined. Now speed needs to be smaller in order to improve the accuracy of zero. When the tip moves to the zero switch position in the figure, it runs to the zero point of the current axis according to the zero offset parameter, and finally runs to the machine tool position, that is the tip position 3.

The parameter setting interface is shown in Fig 8.14. The parameters are defined as follows

- Axis select: select the need to set the zero axis X, Y, the following parameters are set on the axis.
- Backto zero sequence: 1 ~ 2, the current axis of the return order.
- Back to zero enable: If selected, the current axis will be back to zero, otherwise the current axis will not return to zero.
- Backto zero directionpositive: If selected, the current axis will return to the positive direction,



otherwise it will return to the opposite direction.

- First time seek zero speed: the first time the current axis to find the speed of zero switch, this time just to find the approximate range of zero switch, so the speed can be relatively large.
- Second time seek zero speed: the current axis of the second time to find the speed of zero switch, then return to zero the scope of the switch has been determined, now speed needs to be smaller in order to improve the accuracy of zero.
- Zero Offset: The location of the actual machine zero relative to the zero return switch. If the position of the return switch is not the zero position of the machine, this parameter is required to set as the zero position of the machine.
- Machine parked position: After the completion of back to zero, the coordinate position which current axis required to dock.
- All the enabled axis back to zero together: If this is selected, all enabled axis will back to zero, otherwise they will back to zero in order

**Description: F2000 series CNC system with "T" models are unique.**

Flame gun output selection: flame gun output selection, you can choose to use CN5 or DB25 (CN2) interface to make height control of the flame gun.

Demonstration mode Output selection: In the demonstration mode, you can choose whether making lifter control to CN5 or DB25 (CN2) interface

Note: This option only suffix with T models only, CN5 interface only suffix with T only.

### 8.7.8 Language Switch

In the main interface, press **【F5 Diagnose】**, then press **【F8 System definition】**, then press **【F6 Language】**, it will select needed language interface.

### 8.7.9 Add the Language File

From the company get the language pack file and copy it into the USB. Insert the USB into the system USB port. In the main interface, move the cursor to add language file, press **【Enter】**. There will be an introduction appearing to show the result.

This system can support most of the national language files, can also be customized language file. Please contact the company demand.

### 8.7.10 Clear Files

In the main interface, press **【F5 Diagnose】**, then press **【F8 System definition】**, then press **【↓】** to make cursor above **【Clear File】** button and press **【ENTER】**, the system will clear all G code files of system.

### 8.7.11 System Update

In the main interface, press **【F5 Diagnose】**, then press **【F8 System definition】**, then press **【F8 System update】**, please ensure that you have inserted the U disk into system's USB interface, otherwise it will pop up a prompt box "please insert U disk". If U disk is okay, after press **【F8 System update】**, it will pop up a dialog box as Fig 8.16. Press **【Enter】** and confirm, it will prompt to update as the figure

8.17 shows.

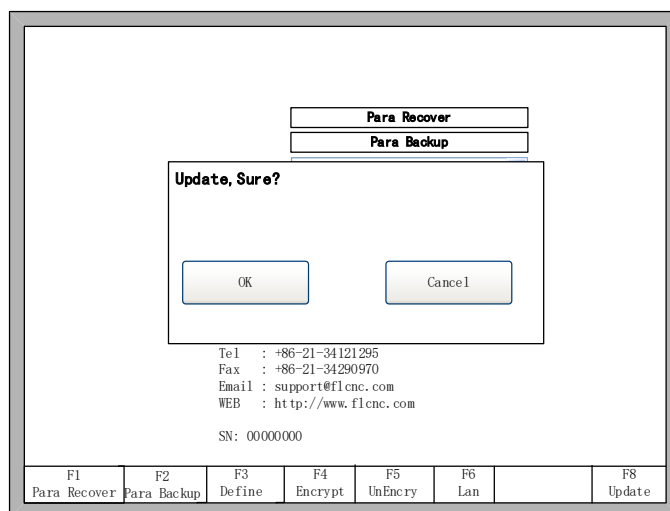


Fig 8.16 the prompt of update confirm

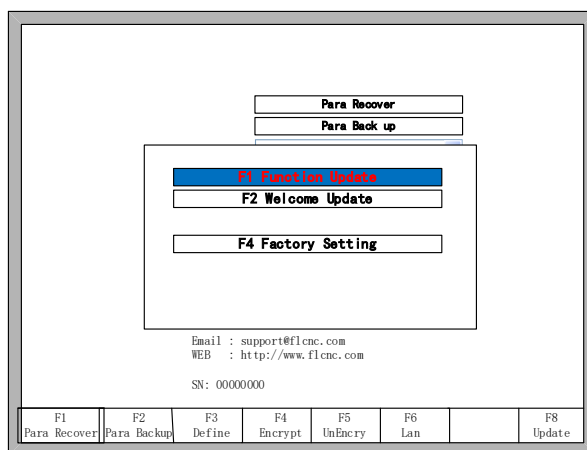


Fig 8.17 the prompt of system update

Function Update: after press **【F1】**, it will update function. The function update file is F2000.exe or corresponding model upgrade file F2100BV4.exe, F2300V4.exe, F2500V4.exe.

Welcome Update: after press **【F2】**, it will update the welcome interface. The interface upgrade file is named WELCOME.bmp, which should be put directly into the U disk but not in any folders. This welcome interface is the first shown interface after power on. If you want to find the method of make new welcome interface, please contact with our after-sale service department.

System recovery: after press **【F4】**, it will recover the system. At this time, the system is exhaustively recovered back to the status before leaving factory, in other words, the parameters, IO ports configuration, coordinate direction definition and so on are all recovered back to the status before leaving factory. In the general condition, please don't use this function to recover system.

## Chapter 9 Graph Management

In the main interface, press **【F1】** (Shape Lib) to enter graph interface, shown as follows:

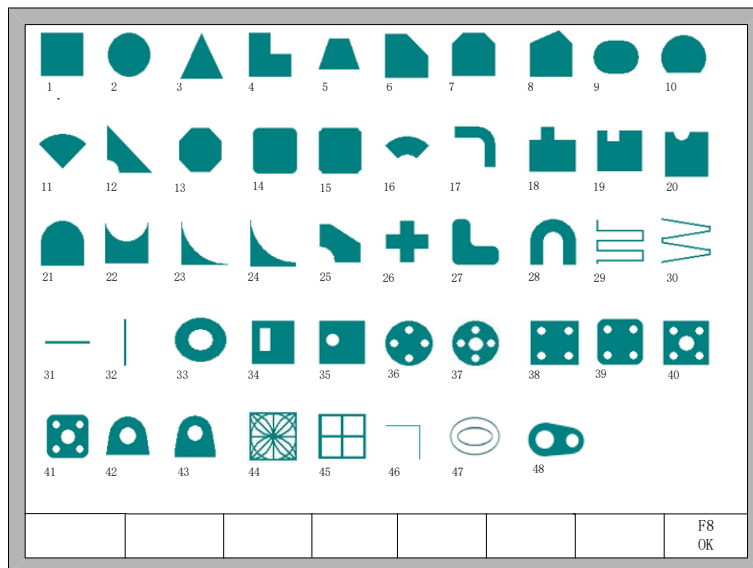


Fig 9.1 Page of graph Library

You can press **【↑】**, **【↓】**, **【←】**, **【→】** to choose different graph.

### 9.1 Choose Graph

In home interface of graph, move the cursor to the required graph, press **【F8】** to confirm, shown as Fig 9.2:

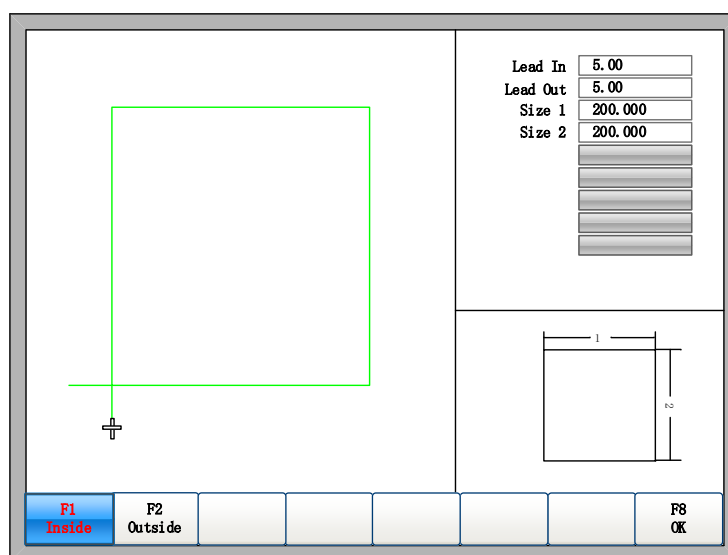


Fig 9.2 Chip size interface

You can press **【↑】**、**【↓】**、**【←】**、**【→】** to modify sizes, after modification , press **【F8】** to confirmed.

Press any key to return to graphics processing interface as shown in Fig3.1.

## 9.2 Chip/Hole Size

In Fig 9.2 in chip size interface, you can press **【F2】** to choose hole size, shown as Fig 9.3:

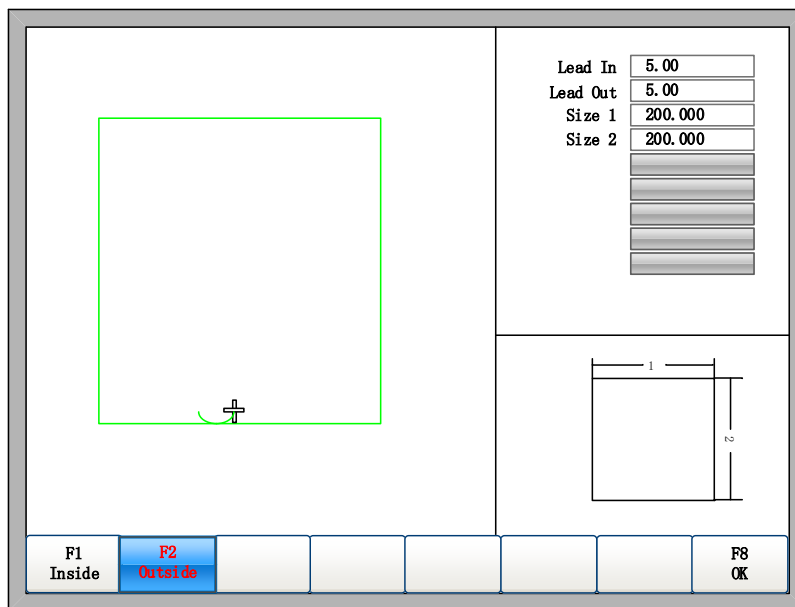


Fig 9.3 Hole size

Modify hole sizes is the same as chip sizes.

After modification , press **【F8】** to confirmed, then enter into the interface of cutting as shown in Fig 3.1.

**Note:** The graphic after No.29 don't have hole size.

## Chapter 10 Code Explanation

### 10.1 Code Symbol and Interpretation

- In the cutting machine programming, the following programming symbols are generally available, with corresponding parameter following it.

Table 10.1 Programming symbols interpretation

programming symbols	Function Interpretation
N	Programming segment number
G	Code for ready
M	Auxiliary function
X	Relative coordinate or absolute coordinate of X axle
Y	Relative coordinate or absolute coordinate of Y axle
U	Relative coordinate of X axle
V	Relative coordinate of Y axle
I	Coordinate d-value of X axle between circle center and arc's start
J	Coordinate d-value of Y axle between circle center and arc's start
R	Arc's radius, when it's positive value, the arc <math><180^\circ</math>; when it's negative value, the arc >math>>180^\circ</math>
F	Cutting rate, used for G01, G02, G03

- In the following context, all the symbol “/” is the relationship of OR. For example, X/U represents that the result is either X or U, both of which cannot simultaneously appear. N represents parameter value, for example, Xn expresses that n is the following parameter. [] means optional context, which can be selected or not.

### 10.2 Coordinate System

This system uses right-hand Descartes coordinate system acquiescently, as the figure 10.1 shows.

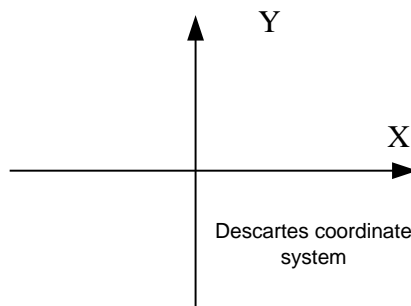


Fig 10.1 Descartes coordinate system

Of course, the system also can be defined coordinate system by user, referencing “8.7.4 Coordinate definition”.

## 10.3 G Code Explanation

The G code which this system supports for is shown as the table 10.2.

Table 10.2 Common G code table

G99	Parameter: X/U Y/V I J	Part option parameter
G92	Parameter: X Y	Reference point setting
G91 / G90	No parameter	Relative/Absolute coordinate
G20 / G21	No parameter	Inches/metric
G41 / G42	No parameter	Left/right Kerf compensation
G40	No parameter	Cancel Kerf compensation
G00	Parameter: X/U Y/V	straight line rapid moving tool
G01	Parameter: X/U Y/V	Straight line cutting
G02	Parameter: X/U Y/V I J	Clockwise arc cutting
G03	Parameter: X/U Y/V I J	Anticlockwise arc cutting
G04	Parameter: P	Time delay

1. G92 Reference point setting

**Format:**

G92 **【Xn】 【Yn】**

**Parameters meaning:**

**【Xn】【Yn】** express absolute coordinate of reference point to be set and is also absolute coordinate of which machine tool goes back to. If no parameter after G92, the default reference point coordinate is (0, 0). Generally, while machine tool is taking (0,0) as reference point, this code can be ignored.

**Note:**

After inputting this code, coordinate of reference point to be set by G92 can be saved automatically. Before new cutting code hasn't been inputted, the coordinate of this reference point is always available, whether system is power off or not. After input a new cutting code, if new code has G92 instruction, the coordinate of this reference point is the context after G92, if no G92, the reference point is default (0, 0). In one code file, G92 only appears once.

**Example:**

- a. G92 X0 Y0

Take (0,0) as reference coordinate, when press "go back" function key, the machine tool goes back to coordinate point (0, 0).

- b. G92 X20 Y0

Take (20,0) as reference coordinate, when press “go back” function key, the machine tool goes back to coordinate point (20,0).

## 2. G90/G91

### Format:

G90/G91

G90: absolute coordinate. X/Y in the code means absolute coordinate value; U and V mean relative coordinate value.

G91: relative coordinate. X/Y in the code means relative coordinate value; U and V also mean relative coordinate value.

### Example:

#### a. G90 usage

```
G92 X0 Y0 // Reference point (0,0)
G90 // Absolute coordinate
G00 X20 Y0 // Rapidly moving tool to (20,0)
M07 // Cutting device on
G01 X120 Y100 //Cutting to (120,100)
M08 //Cutting device off
M02 // End of program
```

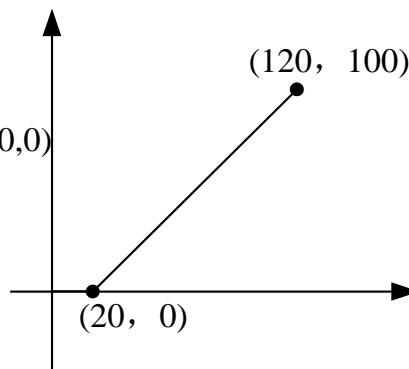


Fig 10.2 G90 usage

#### b. G91 usage

```
G92 X0 Y0 // Reference point (0,0)
G91 // Relative coordinate
G00 X20 Y0 //Rapidly moving gun to (20,0)
M07 //Cutting device on
G01 X120 Y100 //Cutting to(140,100)
M08 //Cutting device off
M02 // End of program
```

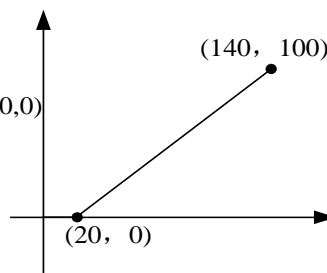


Fig 10.3 G91 usage

## 3. G20/G21

### Format:

G20/G21

G20: inches unit. All of X, Y, I, J, R, U, V after G20 are inches unit.

G21: metric unit. All of X, Y, I, J, R, U, V after G21 are metric unit.

### Note:

If no G20/G21 in the code, take the metric as data's unit.

The conversion formula of inches and metric: 1 inches  $\approx$  25.4mm。

#### 4. G00 Traverse rapidly

This instruction expresses that rapidly traverse to specific location, which the system will rapidly move to at the rate of “G00 move speed\* time ratio” from start point.

##### Format:

G00 X/Un Y/Vn 【Fn】

##### Parameters meaning:

- Fn – rapidly moving to specific location at the limited rate;
- Un – displacement of endpoint's X coordinate relative to start point of current segment, unit(mm);
- Vn – displacement of endpoint's Y coordinate relative to start point of current segment, unit(mm);  
(In the relative coordinate system):
- Xn – displacement of endpoint's X coordinate relative to start point of current segment, unit(mm);
- Yn – displacement of endpoint's Y coordinate relative to start point of current segment, unit(mm);

(In the absolute coordinate system):

- Xn – displacement of endpoint's X coordinate relative to working start point, unit(mm);
- Yn – displacement of endpoint's Y coordinate relative to working start point, unit(mm);

##### Example:

```
G92 X0 Y0 // Reference point (0,0)
G91 // Relative coordinate
G00 X100 Y100 //rapidly moving tool to (100,100)
M02
```

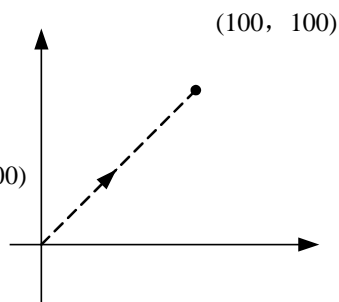


Fig 10.4 G00 usage

#### 5. G01 Linear Interpolation(at cut speed)

This instruction expresses that linearly incise to specific location, which the system will cut to at the rate of “incise speed\* time ratio” from start point of current segment.

##### Format:

G01 X/Un Y/Vn 【Fn】

##### Parameters meaning:

The same to the meaning of G00 code, the difference of them is only that G00 expresses linearly walking(meaning: output ports are all closed), but G01 expresses linearly incising.

#### 6. G02 Clockwise Circular Interpolation



This instruction expresses that incise clockwise arc (clockwise interpolation) to specific location, which the system will cut to at the rate of “incise speed\* time ratio” from start point of current segment.

**Format:**

G02 X/Un Y/Vn In Jn 【Fn】 or G02 X/Un Y/Vn R[-]n 【Fn】

**Parameters meaning:**

- Fn – incise at limited rate;
- Un – displacement of endpoint’s X coordinate relative to start point of current segment, unit(mm);
- Vn – displacement of endpoint’s Y coordinate relative to start point of current segment, unit(mm);
- In – displacement of circle centre’s X coordinate relative to start point of current segment, unit(mm);
- Jn – displacement of circle centre’s Y coordinate relative to start point of current segment, unit(mm);
- R[-]n – the radius of arc, when the angle of arc  $\leq 180^\circ$ , R is positive. Otherwise, it’s negative, unit(mm);

(In the relative coordinate system):

- Xn – displacement of endpoint’s X coordinate relative to start point of current segment, unit(mm);
- Yn – displacement of endpoint’s Y coordinate relative to start point of current segment, unit(mm);

(In the absolute coordinate system):

- Xn – displacement of endpoint’s X coordinate relative to working start point, unit(mm);
- Yn – displacement of endpoint’s Y coordinate relative to working start point, unit(mm);

**Example:**

```

Example 1: B->A
G92 X0 Y0 // Reference point (0,0)
G91 // Relative coordinate
G00 X60 Y100 //Rapidly move tool to B
G02 X-40 Y-40 I0 J-40 //The arc 1
//(G02 X-40 Y-40 R-40)
M02

Example 2: A->B
G92 X0 Y0 // Reference point (0,0)
G91 // Relative coordinate
G00 X20 Y60 //Rapidly move tool to A
G02 X40 Y40 I40 J0 //The arc 2
//(G02 X40 Y40 R40)
M02

```

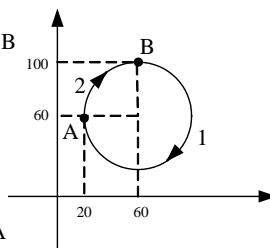


Fig 10.5 G02 usage

### 7. G03 Counterclockwise Circular Interpolation

The same as G02. The difference is that G02 is clockwise circular(clockwise arc), but G03 is counterclockwise circular(counterclockwise arc).

### 8. G40/G41/G42 Kerf Compensation

These functions are used for kerf compensation. Because flame incision and plasma incision both finally have the existence of kerf when incise route expressed by code is only actual size of work piece, the actual incision work piece without regard to the effect

of kerf isn't needed size. After set the kerf compensation, the system will automatically work out the effect of kerf and incise work piece with actual size.

G41/G42 must match with G40 to be used. If G41/G42 is ignored, the default kerf compensation is zero; if G40 is ignored, kerf compensation is available.

**Format:**

```
G41 //Enable Left Kerf Compensation
..... // incision code
G40 //Disable Left Kerf Compensation
G42 // Enable Right Kerf Compensation
..... // incision code
G40 // Disable Right Kerf Compensation
```

**Example:**

( Convex Roof Trapezoid w/Hole )

```
G21                               /* metric unit */
G91                               /* relative coordinate */
G99 X1 Y0 I0 J0   /*proportion factor is 1, rotate angle is 0, no mirror image*/
G00 X44.45 Y41.275                /* Rapidly moving to (44.45, 41.275)*/
G41                               /* Left Kerf Compensation */
M07                               /* Incision beginning*/
G03 X0 Y0 I19.05 J0               /*Counterclockwise Circular Interpolation */
M08                               /* Incision ending */
G40                               /* Disable Left Kerf Compensation */
G00 X-44.45 Y-41.275              /* Rapidly moving to (-44.45, -41.275) */
G41                               /* Right Kerf Compensation */
M07                               /* Incision beginning */
G01 X25.779438 Y58.031634         /*Linear Interpolation */
G02 X75.441125 Y0 I37.720562 J-16.756634 /* Clockwise Circular Incision*/
G01 X25.779438 Y-58.031634       /* Linear Interpolation */
G01 X-127 Y0                      /* Linear Interpolation */
M08                               /* Incision ending */
G40                               /* Disable Right Kerf Compensation */
M02                               /* End of program */
```

**Note:**

The value of Kerf Compensation should be half of actual kerf width.

9. G99 proportion、rotate、mirror (image)

**Format:**

G99 Xn Yn In Jn

**Parameters meaning:**

- X – proportion factor, can be set from 0.001 to 1000.
- Y – rotate angle, can be set from -360° to 360°.
- I – image of X axis, make image along X axis, 1 expresses that there is image, 0 expresses that there is no image.
- J – image of Y axis, make image along Y axis, 1 expresses that there is image, 0 expresses that there is no image.

**Note:**

A code can have G99, also cannot. If there is G99, the parameter X, Y, I, J after code should not be ignored.

Mirror image and rotation will take the origin (0, 0) of Descartes coordinate as reference point.

## 10. G04 Time delay

**Format:**

G04 Pn

**Parameters meaning:**

P- delay time, the following parameters are using 0.01 second as the unit, such as P100 means delay of 1 second.

## 11. Program notice items

- The program must contain the instruction of G92 (reference point setting) and M02(end of program).
- G41/G42 must match with G40 to be used. If G41/G42 is ignored, the default kerf compensation is zero; if G40 is ignored, kerf compensation is available.
- If G20 / G21 is ignored, the system will execute G21 (metric unit).
- If G90 / G91 is ignored, the system will execute G91 (relative coordinate).
- M07 and M08 can't be neglected.
- When there is one parameter in the code of G00、 G01、 G02、 G03 is ignored, if this parameter is absolute coordinate, the system will set it G code coordinate value of last row; If it's relative coordinate, the system will set it 0.
- G00、 G01、 G02、 G03 can be simplified: G0、 G1、 G2、 G3.
- If there is contiguous G00 (or G01、 G02、 G03) around, the following G00 (or G01、 G02、 G03) can be ignored.

## 10.4 M Code Explanation

Table 10.3 Common M code

M07	No parameter	Cutting device on
M08	No parameter	Cutting device off
M11	No parameter	Marker offset on
M12	No parameter	Marker offset off
M09	No parameter	Open the Powder
M10	No parameter	End of Powder
M00	No parameter	Stop of instruction
M02/M30	No parameter	End of program

- M07 Cutting device on  
Please refer to Appendix 2 I/O Timing Sequence Figure of F2000 Series Numerical Control System.
- M08 Cutting device off  
Please refer to Appendix 2 I/O Timing Sequence Figure of F2000 Series Numerical Control System.
- M00 End of instruction  
In the processing of incision, the system will stop the machine tool with the M00 instruction, waiting for the next operation.
- M02/M30 End of program

## Chapter 11 Port Explanation

As shown in Fig 11.1, the back interface of the system. The red box section is unique to the T series. CN1 is the input port, which is the standard DB25 male, CN2 is the output pin, which is the standard DB25 female, CN3 is the motor interface, which is the standard DB15 male. CN4 and CN5 are unique to T-series. Refer to Section 11.4 for details on wiring with T series. The bottom 3-pin green terminal interface is the 24V power interface.

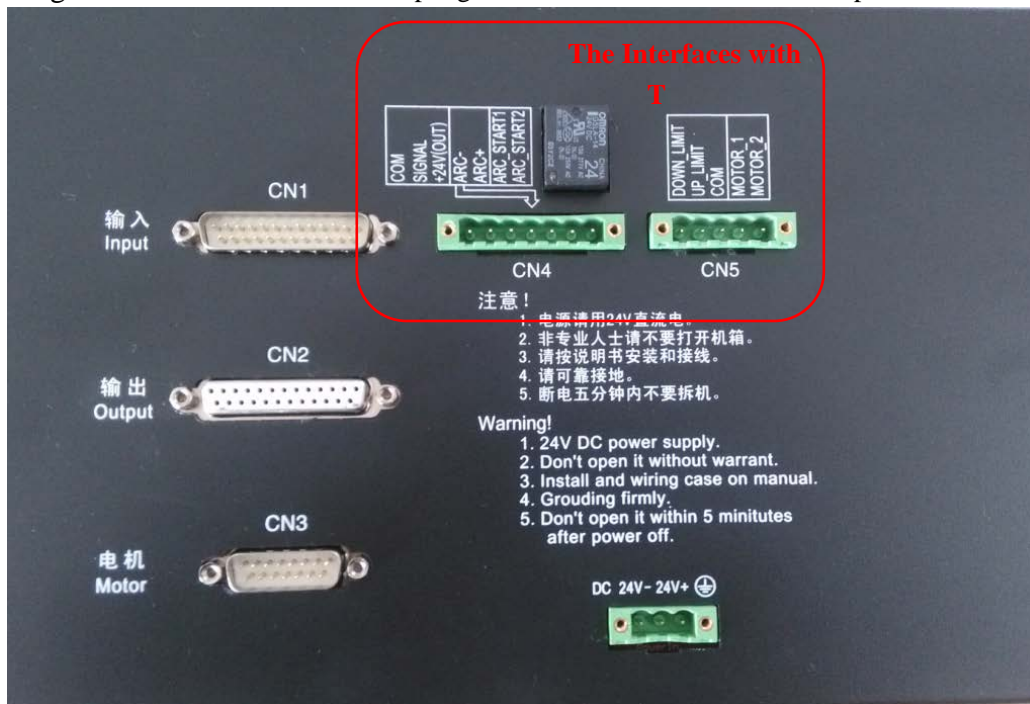


Fig 11.1 Back Interface

### 11.1 Input Port

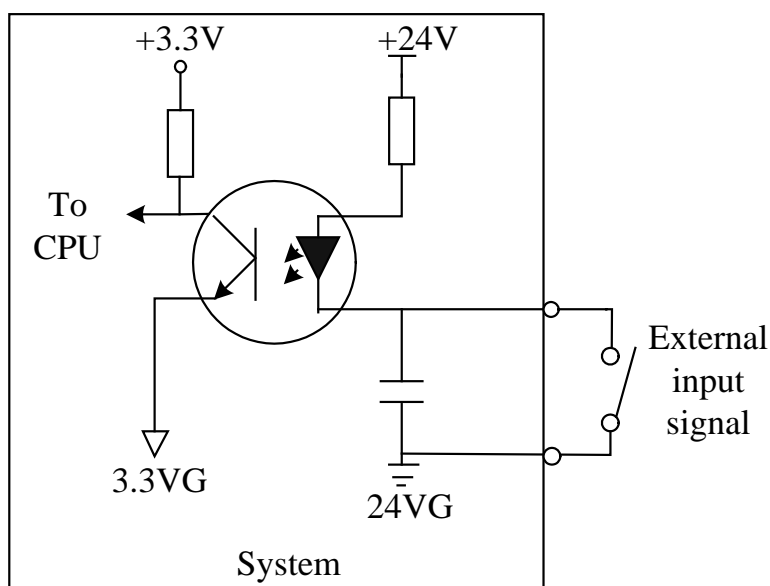


Fig11.2 input port circuit

- Input signal is a mechanical contact switch, normally open type and closed type are all supported, it is effective when it is connected to 24VG, and it is ineffective when it is float or connected to 24V. Com-port of switch outside is connected 24VG. The other port is connected to corresponding IO port.
- 16 channel input ports totally
- Input signal definition

Table 11.1 Input port definition

Pin number	Signal name	remark
2	X+ limit	X+ stop input, float it if not use, this is horizontal
15	X- limit	X- stop input, float it if not use, this is horizontal
14	Y+ limit	Y+ stop input, float it if not use, this is vertical
1	Y- limit	Y- stop input, float it if not use, this is vertical
3	Emergency stop	Emergency stop input, float if not use
4	Arcing successfully	
5	Positioning successfully	
6	Plasma collision	
11,20-23	Spare	
12,24	+24V	+24V/3A Power output
7	Move left/C	Remote control input
8	Move right/D	Remote control input
9	Move forward/A	Remote control input
10	Move backward/B	Remote control input
16	Firing	Remote control input
17	Oxygen cutting	Remote control input
18	Cutting torch up	Remote control input
19	Cutting torch down	Remote control input
13,25	24VG	+24V Ground

### 11.1.1 Input Wiring Instructions

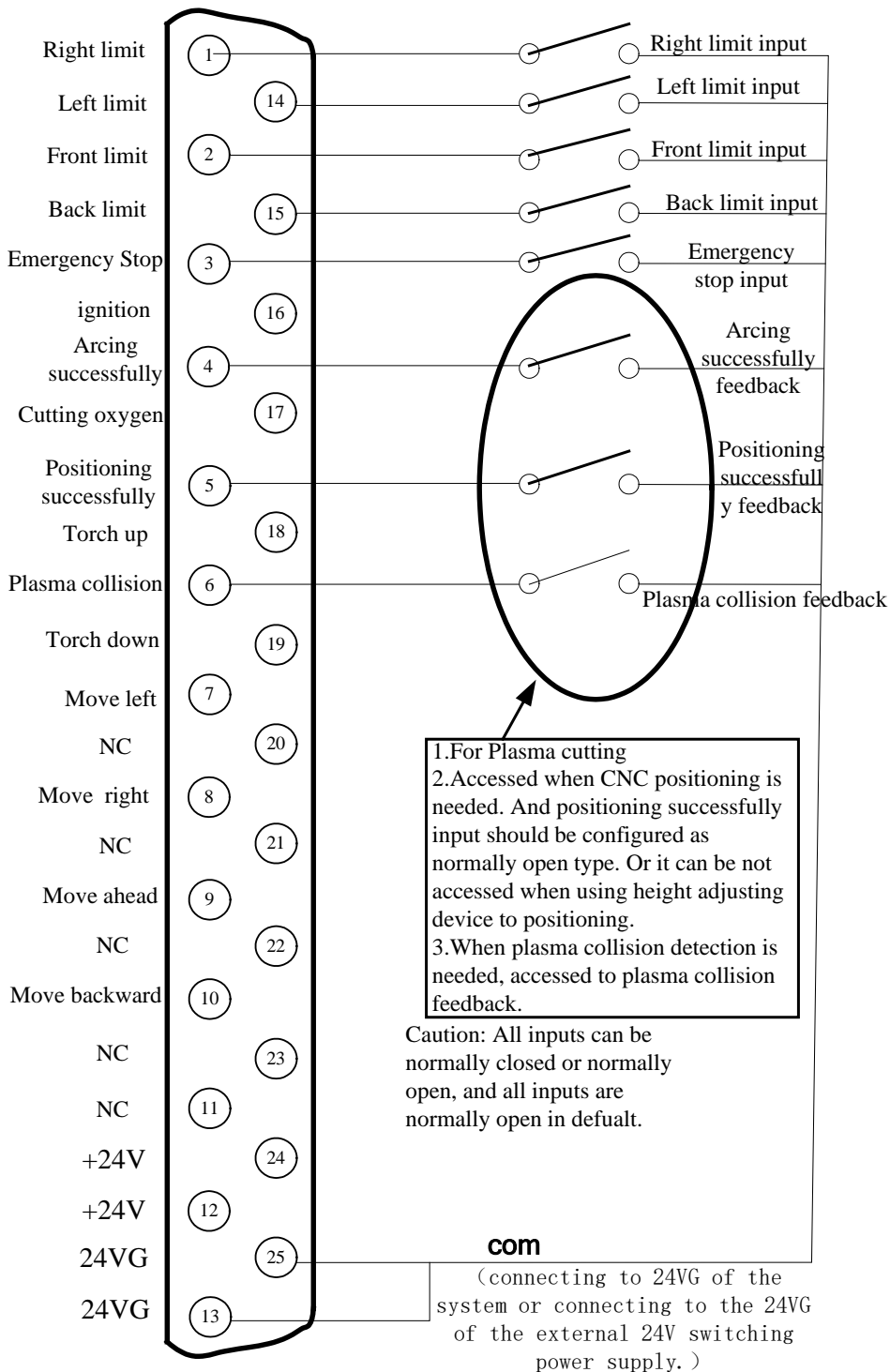


Fig 11.3 External input wiring

## 11.1.2 Remote Controller Input

The system supports three external remote control input, one for line input (P2P) type, one for 8421 (BCD) encoded input type, Another for serial RS232 interface input type.

### ➤ Line Input(P2P) Type

The pin 7, 8,9,10 of input port represents left, right, forward, backward, when inputting valid signal, the machine can move toward the corresponding direction, when the input signal is invalid, the machine stop moving.

When the input signal of pin 16 is valid, the system will ignite the torch, the ignition time is the setting value in system parameters, please take the reference of part of "ignition time" in "7.2 oxygen gas parameters".

When the input signal of pin 17 is valid, the system will turn on or off the cutting oxygen. When the cutting oxygen is on, the system cut off the oxygen, when the cutting oxygen is off, open the cutting oxygen system.

When the input signal of pin 18 is valid, the system will raise the cutting torch, when the signal invalid, the torch stops.

When the input signal of pin 19 is valid, the torch goes down, when the signal invalid, the cutting torch stops.

**Note: The external switches of line input are designed by the user.**

### ➤ 8421(BCD) code input

Input pin 9, 10, 7, 8 is the A, B, C, D bits of the 8421 code. Functions are shown in Table 11.2

Table 11.2 Function of 8421 code input

Decimal	8421 code(DCBA)	Function
0	0000	No Input
1	0001	Turn on or off the cutting oxygen
2	0010	Go back according to the original track
3	0011	Move forward according to the original track
4	0100	Left lateral movement
5	0101	Ignite Input
6	0110	Start
7	0111	Slow down
8	1000	Accelerate
9	1001	Move for the negative direction vertically
10	1010	Move forward vertically
11	1011	Pause
12	1100	cutting torch
13	1101	raise the cutting torch
14	1110	Move toward right horizontally
15	1111	Start

8421-type remote control input is designed by the user

### ➤ Serial RS232 remote control

See Chapter 15, Shanghai Fangling F1520-T remote controller instructions for details.



## 11.2 Output Port

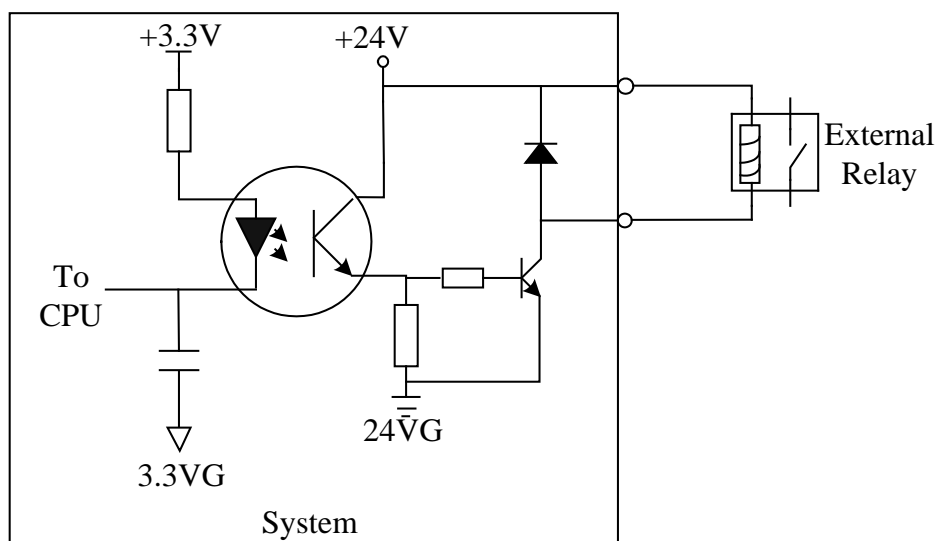


Fig11.4 output port circuit

- Output voltage is 24VDC, low level is effective; The common end of the external relay coil is connected with the 24V +, and the other end of the relay coil is connected with the corresponding IO port.
- Maximum output current  $I_{\max} = 300mA$  ;
- 16 output ports in total
- Output signal definition

Table 11.3 Output port definition

25 interface Pins No.(Main connector)	Signal	Remark
3	Ignite	
1	Low pressure preheat	
17	High pressure preheat	
4	Low pressure cutting oxygen	
5	Medium pressure cutting oxygen	
14	High pressure cutting oxygen	
2	Torch up	
15	Torch down	
6	Exhaust	

8	Enable high adjusting box	
19	Plasma locating	
16	Plasma arc starting	
18	Corner low-speed output Or automatic / manual	
7	Spray powder	
20	Raise powder	
21	Marker Preheat	
9,10,11,22,23	Not used	
12,24	+24V	+24V/3Aoutput
13,25	24VG	+24Vground

Note: the power supply of external relay, please take 24V power supply output from the DB25(CN2) 12/24 feet ,and take 24V power ground from 13/25 feet.

## 11.2.1 Output Wiring Instructions

### 11.2.1.1 Oxygen Gas Typical Connection

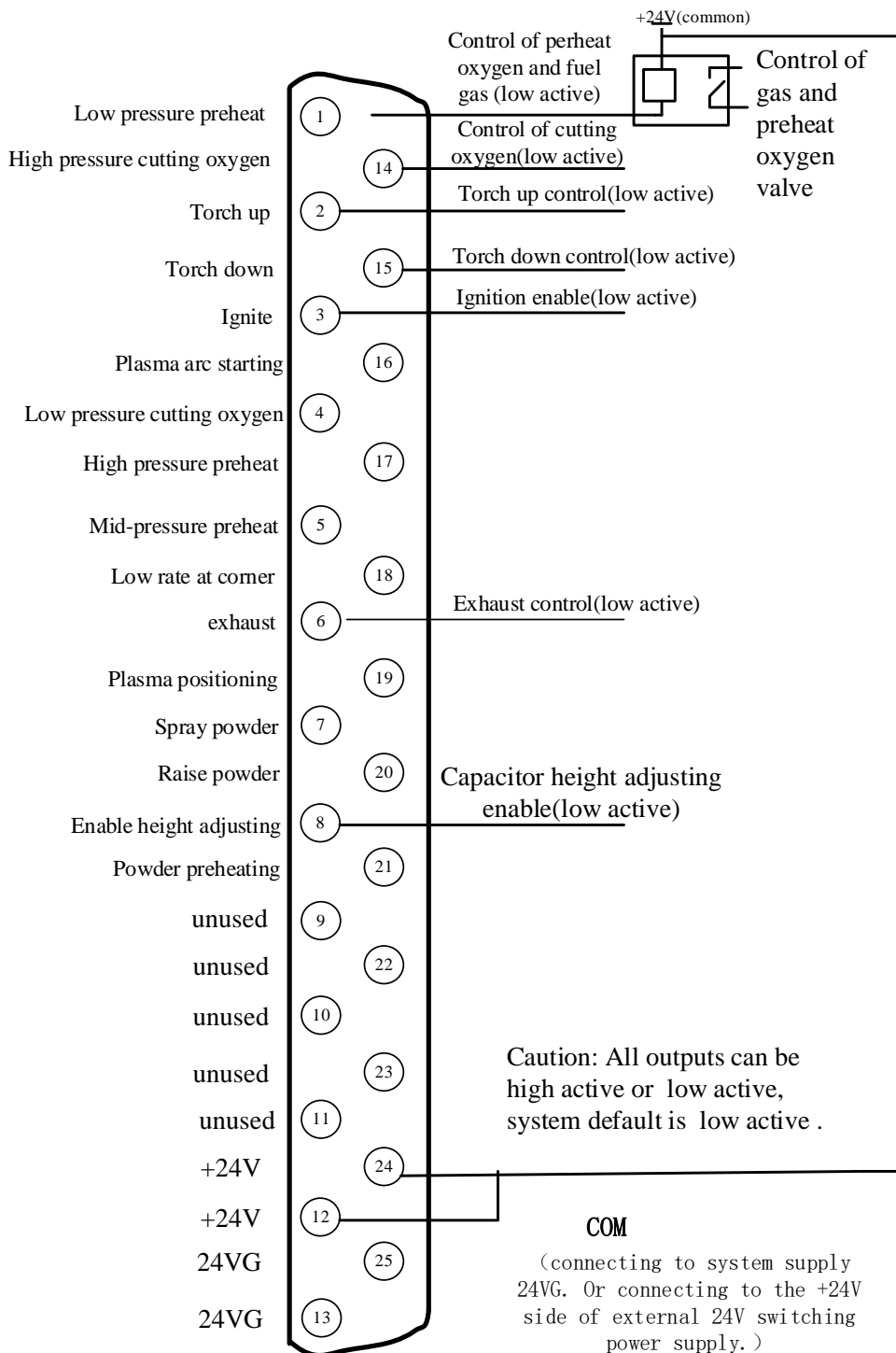


Fig 11.5 Oxygen gas typical connection

### 11.2.1.2 Three Level Perforation Circuit

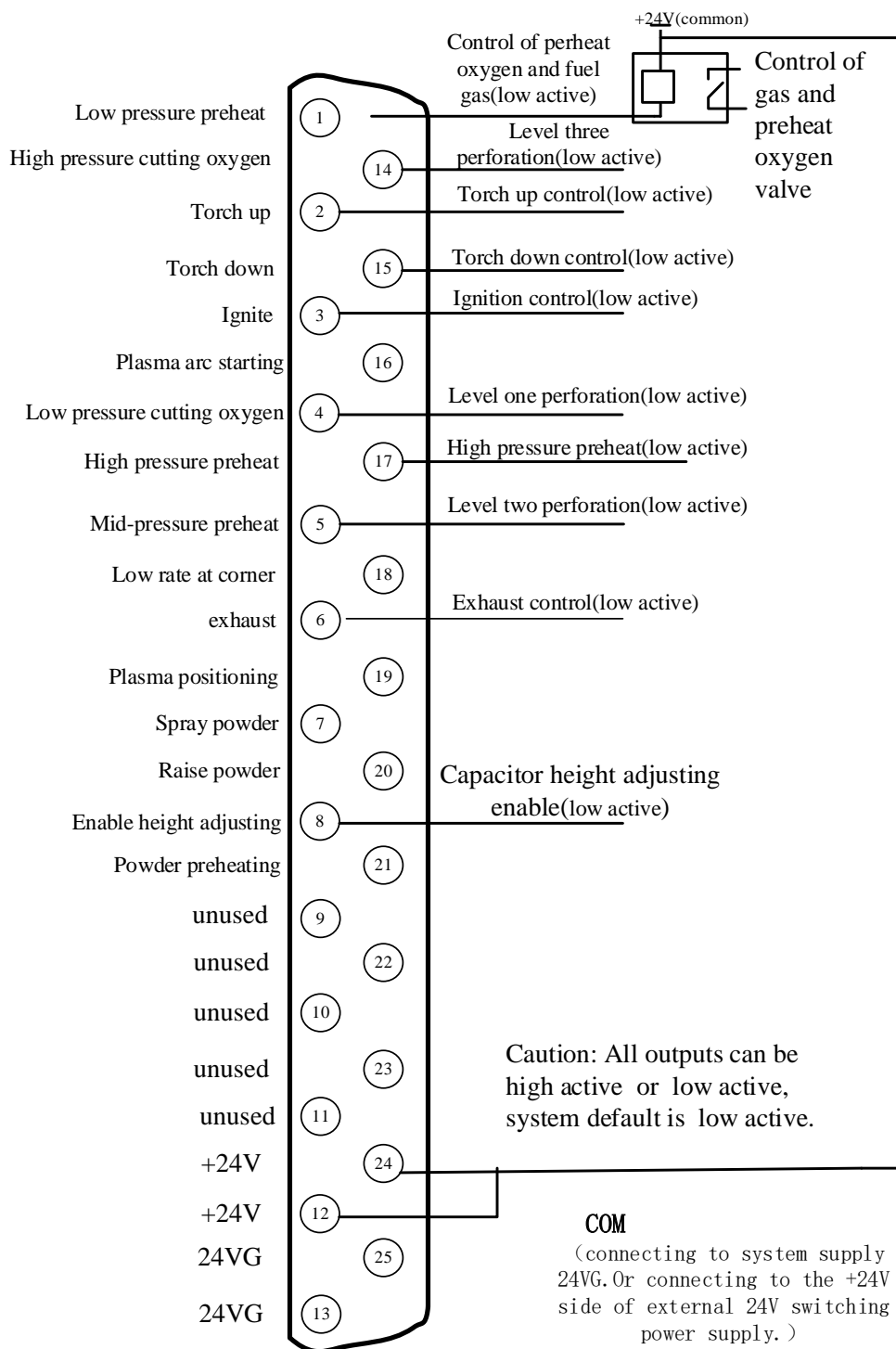


Fig 11.6 Three level perforation circuit

### 11.2.1.3 Typical Circuit of Using Powder

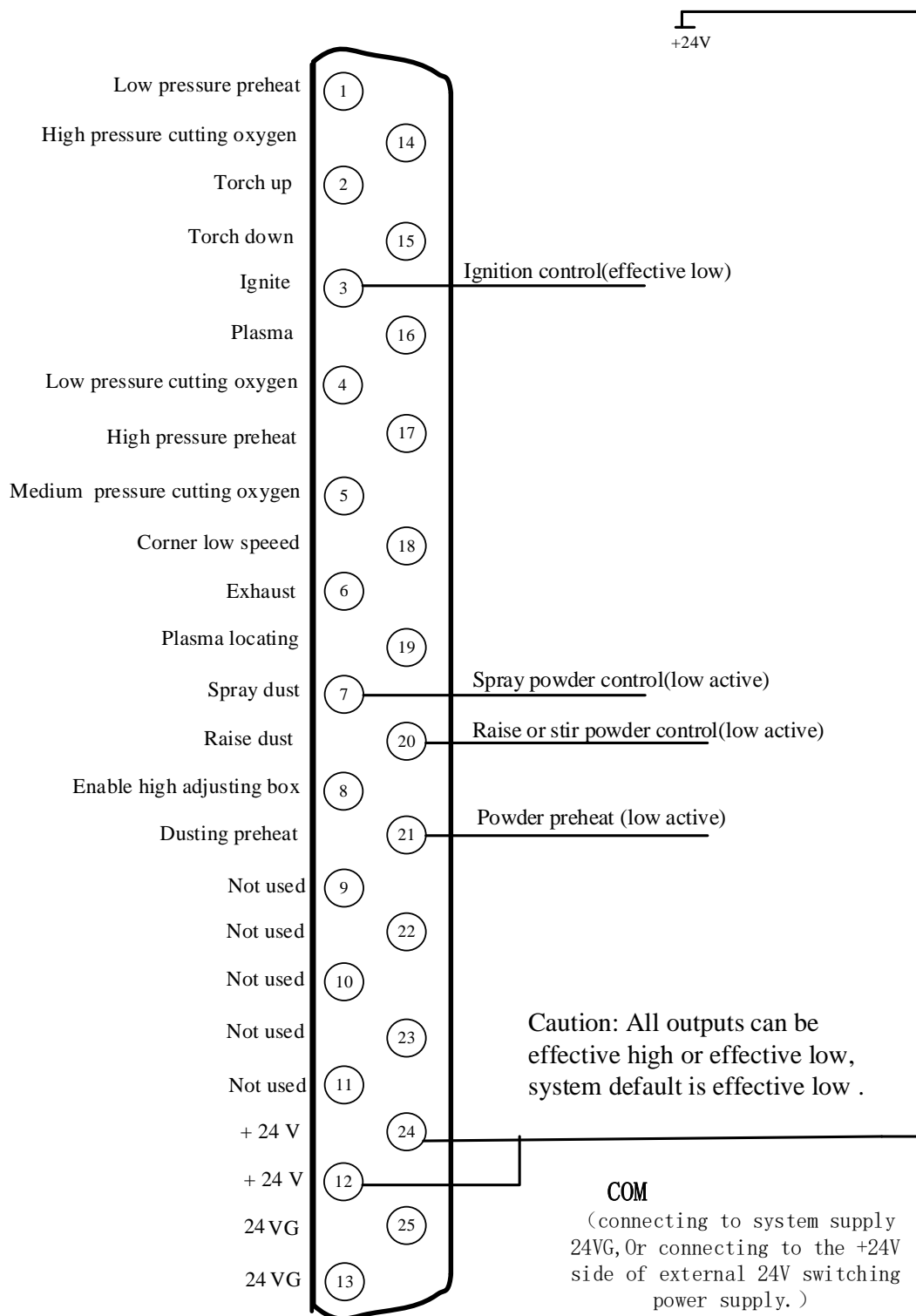


Fig 11.7 powder typical connection

### 11.2.1.4 Typical Circuit of Using Plasma Cutting

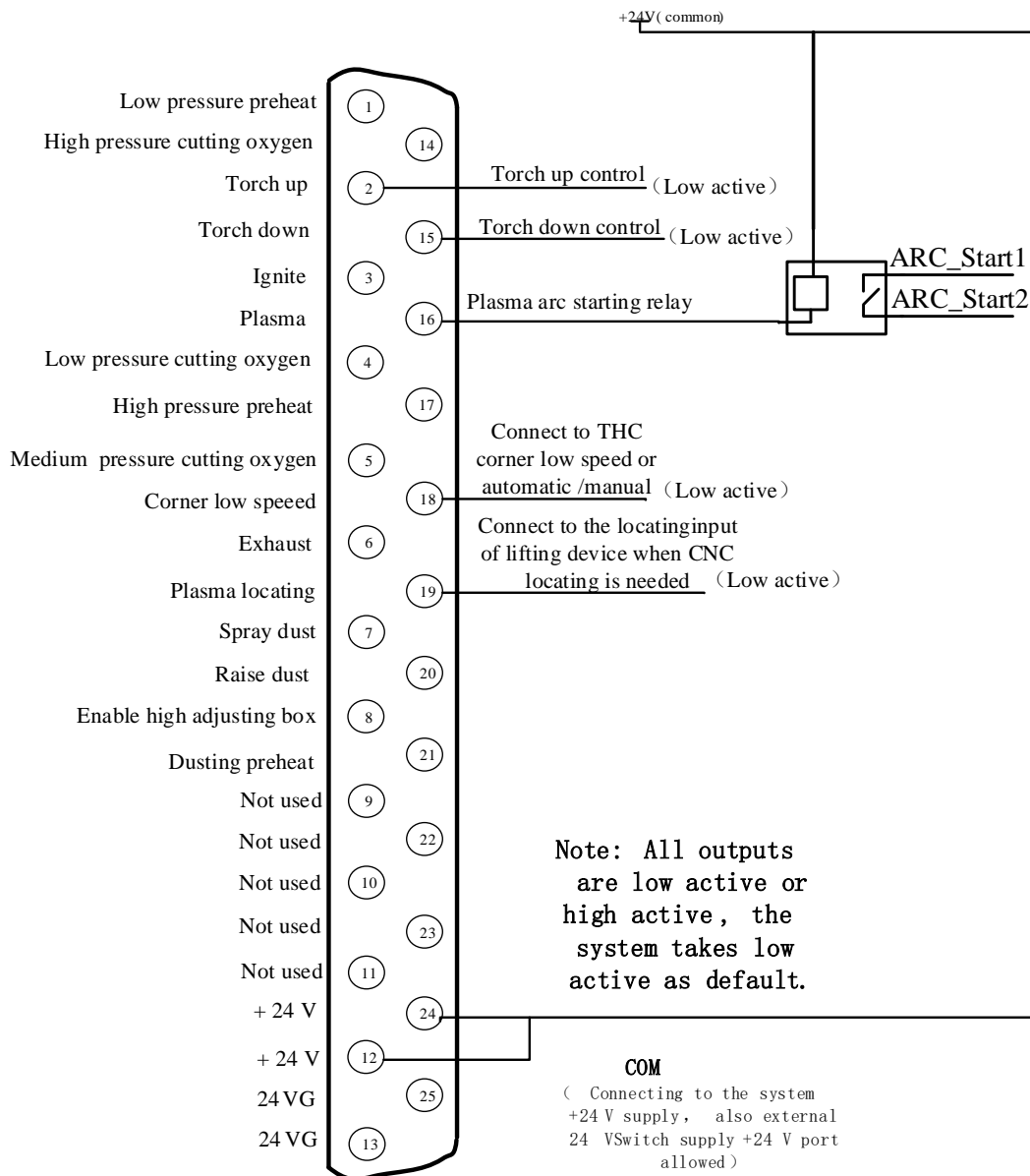


Fig 11.8 Typical wiring diagram of the plasma

#### Instruction:

##### ➤ Height-adjusting device wiring with corner low-speed

When the height-adjusting device takes corner low-speed input control signal, the system's "corner low speed" output signal is used to control the height-adjusting device's corner low-speed input. The system takes an open-collector transistor output, with the default active low signal. Reference section 8.7.3, set the output port type of close THC (corner signal) "NO". CNC system needs to output low electrical lever signal with this THC during decreasing rate and this signal should be broken off at normal cutting time.

##### ➤ Height-adjusting device wiring with automatic / manual

When the height-adjusting device takes automatic / manual control function instead of corner low-speed input, the system needs to use the "corner low-speed" output to control the height-adjusting device's automatic / manual signal. The system takes an open-collector transistor output, with the default active low signal. Meanwhile, it needs to change the type of corner low speed from normally-open to normally-closed in the output port configuration interface (Section 8.7.3), i.e. from "NO" to "NC". CNC system needs to break off this signal with this THC during decreasing rate and this signal should output low electrical level at normal cutting time.

➤ **Using height-adjusting device locating**

When using the locating function of the height-adjusting device, the locating function of numerical control should be closed. The approach is to change the input type of successful locating from normally-open to normally-closed in the input port configuration interface (Section 8.7.2), i.e. from "NO" to "NC". There are two types of locating:

The first: locating controlled by the plasma arc starting. CNC emits the plasma arc starting, the height-adjusting device starts arc after locating, and sends signal of arc starting successful feedback to CNC after starting arc successfully. After CNC system has received signal of arc starting successful feedback, it will begin to incise immediately. Such devices available in the market include Ontime, HYD, Heavth and other brands. Such devices can connect the "plasma arc starting" output of CNC system to the "starting arc with locating" input of the height-adjusting devices, and at the same time in the plasma parameters (refer to section 7.3 plasma parameters) set the arc detecting time to the value that allows for completing the testing and starting arc.

The second: finish position from the decline of the cutting torch . Before issuing the command of starting arc, first issue the command of declining the height adjust device, then issue the command of starting arc. These kind of height adjust devices could be START, HYD in markets. When using these kind of height adjusting device, transfer to the interface of plasma parameters (refer to section 7.3 plasma parameters), set the location detecting time as the time of location of touch.

➤ **Using CNC system locating**

When using the location function of digital control system, firstly enter into the input configuration interface, set the input type of successful location from normally closed to normally open type, i.e. from "NC" to "No". At the same time, return the signal of successful location to the input port of the successful location of the digital controller. In the plasma parameter interface (refer to section 7.3 plasma parameters), set the location detecting time and locating up time to needed values.

## 11.3 Motor Port

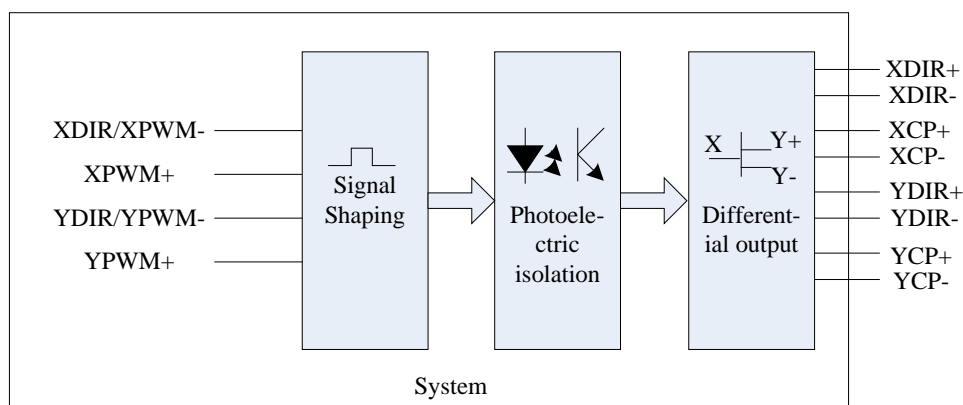


Fig11.9 motor port schematic diagram

- Signal definition table

Number of the 15 pin interface	signal	Remarks
1	XDIR+	Positive at the horizontal axis
9	XDIR-	Negative at the horizontal axis
2	XCP+	Positive pulse at the horizontal axis
10	XCP-	Negative pulse at the horizontal axis
3	YDIR+	Positive at the vertical axis
11	YDIR-	Negative at the vertical axis
4	YCP+	Positive pulse at the vertical axis
12	YCP-	Negative pulse at the vertical axis
5,13,6,14	Not used	
7	+5V	+5V/500mA Power output
15,8	5VG	5V Power Ground



### 11.3.1 Typical Wiring Diagram of the Motor Interfaces

#### 11.3.1.1 Connection Methods for Differential Stepper Driver

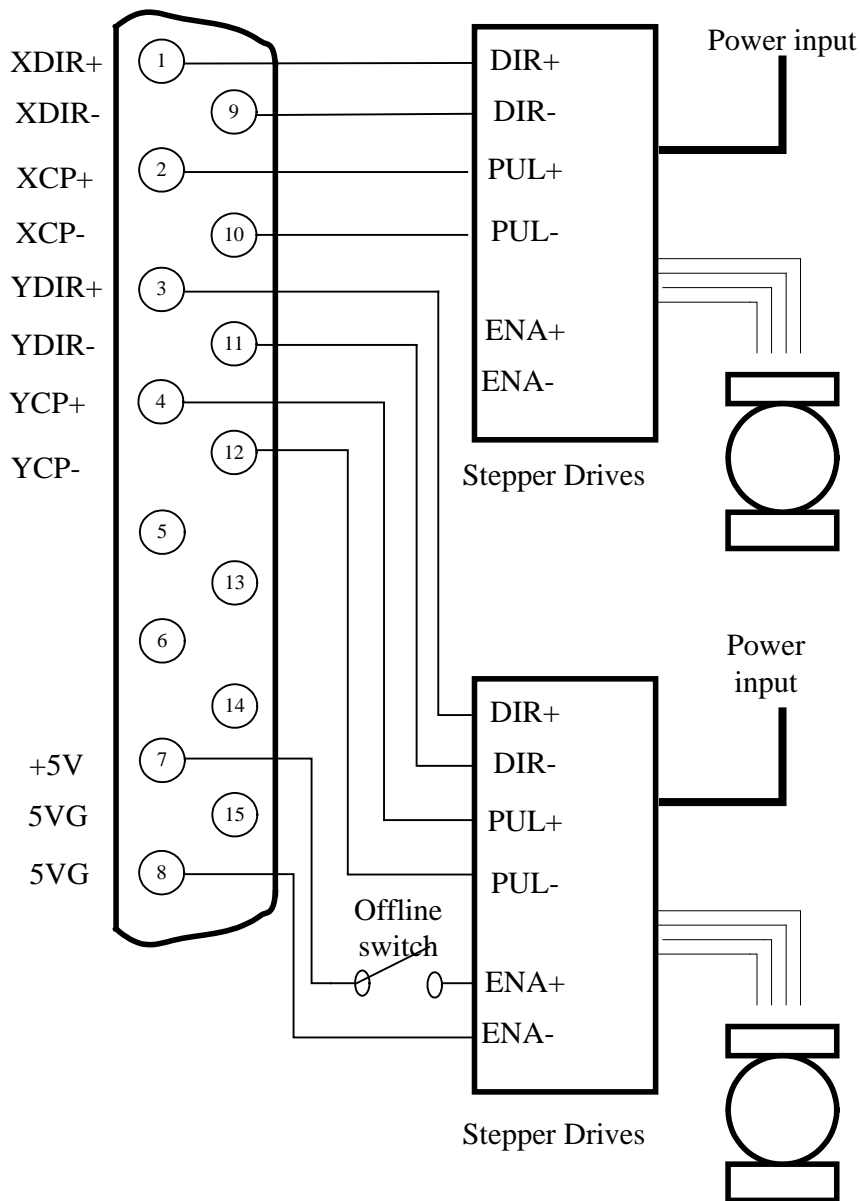


Fig 11.10 connection methods for differential stepper driver

### 11.3.1.2 Com-anode Connection Methods for Stepper Driver

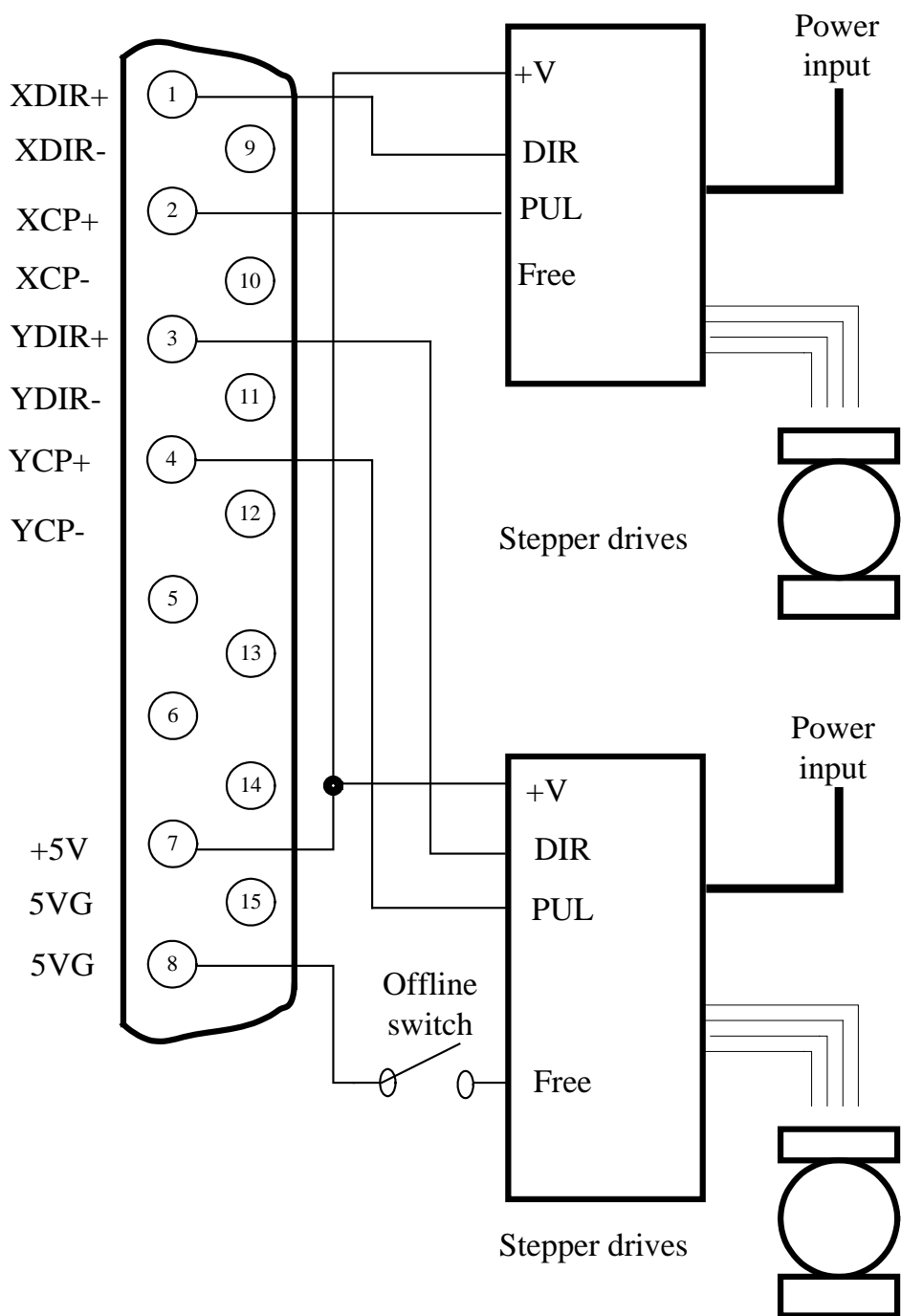


Figure 11.11 com-anode connection methods for stepper driver

### 11.3.1.3 Connection Methods of Servo Driver of Panasonic Company

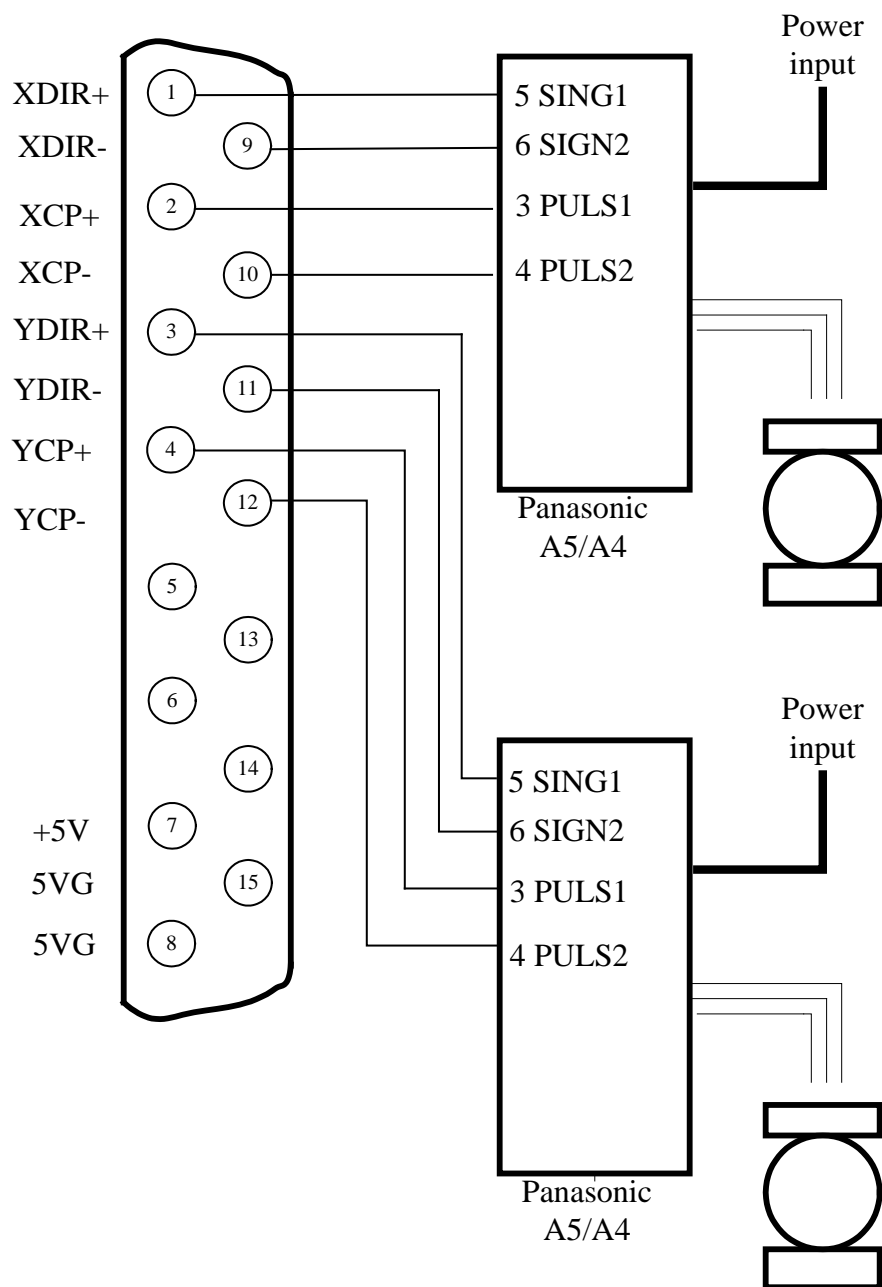


Figure 11.12 Connection methods of Servo driver of Panasonic Company

## 11.4 Arc THC Module Interface (THC) (suffixed with “T” )

Compared to F2000 series CNC system, F2000T CNC system adds the ports of arc THC as the red frame area in following figure based on the original system.

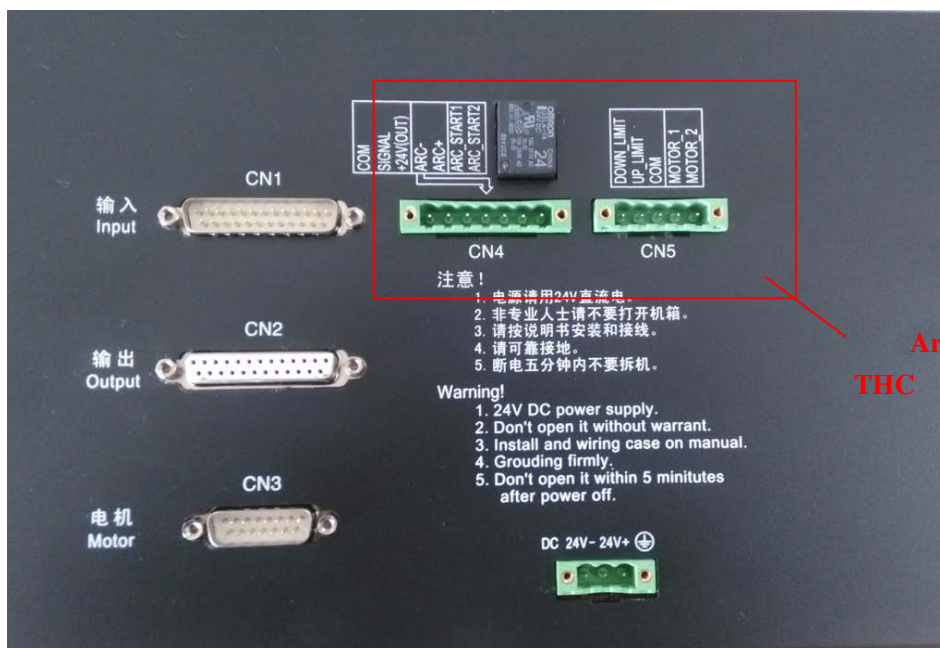


Fig.11.13 F2100T system interface schematic diagram

### 11.4.1 Torch Height DC MOTOR Port ( CN5 )

Motor port CN5 (DC MOTOR) output pin MOTOR\_1, MOTOR\_2, input pin UP\_LIMIT, DOWN\_LIMIT, common ground COM. connect MOTOR\_1, MOTOR\_2 to height adjustment motor, connect UP\_LIMIT, DOWN\_LIMIT to upper limit switch and lower limit switch.

Table 11.4 Torch Height Motor Port

CN5	Signal Name	Comment
1	DOWN_LMT	Lower limit switch input
2	UP_LMT	Upper limit switch input
3	COM	+24V Power Ground
4	MOTOR_1	Height Adjustment Motor
5	MOTOR_2	Height Adjustment Motor

#### Note:

1. Maximum power of DC motor: 45W.
2. Short the DOWN\_LMT and COM by an electrical wire, and short UP\_LMT and COM, When don't use limit switches.

### 11.4.2 Arc Input ( ARCIIn )

Arc input pins are ARC+ and ARC- in port CN4. ARC+ link with positive pole of arc output of arc divider board. ARC- link with negative pole of arc output of arc divider board.

Table 11.5 Arc Input Signal

CN4	Signal Name	Comment
4	ARC-	negative pole of arc output of arc divider board
5	ARC+	positive pole of arc output of arc divider board

**Note:** By default, the controller use arc divider 100: 1. That is, the original arc voltage is divided 100 by divider board.

**If use 50: 1 divider board, open the system box, find the switches showing as the figure 11.13. When this switch is on, divider board is 50: 1, otherwise 100: 1. Default position is OFF, 100:1.**

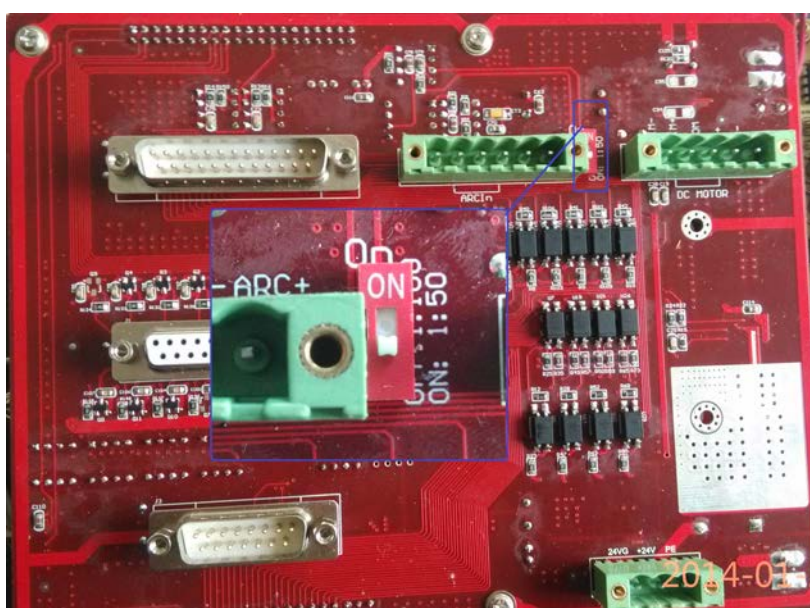


Fig.11.14 Arc input partial pressure proportion

### 11.4.3 IHS Sensing Port

The positioning port (PS) and the arc pressing port are in the same seven pin interface (CN4), the pins are +24V (OUT), SIGNAL, COM. The +24V (OUT) is connected with the positive electrode of the switch, and the SIGNAL is connected with the signal of the proximity switch, and the COM is connected with the negative electrode of the switch.

**Note:** Approach switch is NPN type with DC24V.

Table 11.6 Position Interface Signal Definition of Arc THC Module

CN4	Signal Name	Comment
1	COM	Negative pole of approach switch
2	SIGNAL	NPN approach switch signal
3	+24V(OUT)	Positive pole of approach switch

### 11.4.4 Arc Start (ARC\_START)

The starting arc port (ARC\_START) and the arc input port are in the same seven pin interface (CN4), the output pin is ARC\_START1, ARC\_START2, and connect to the arc port of the plasma power supply.

Table 11.7 Arcing port Signal Definition of Arc THC Module

CN4	Signal Name	Comment
6	ARC_START1	plasma power arcing port+
7	ARC_START2	plasma power arcing port-

Note: It is strongly recommended that the customer use a relay for isolation to avoid interference from the system with the plasma power supply.

### 11.4.5 Wiring Diagram of F2000T CNC System with Arc THC Module

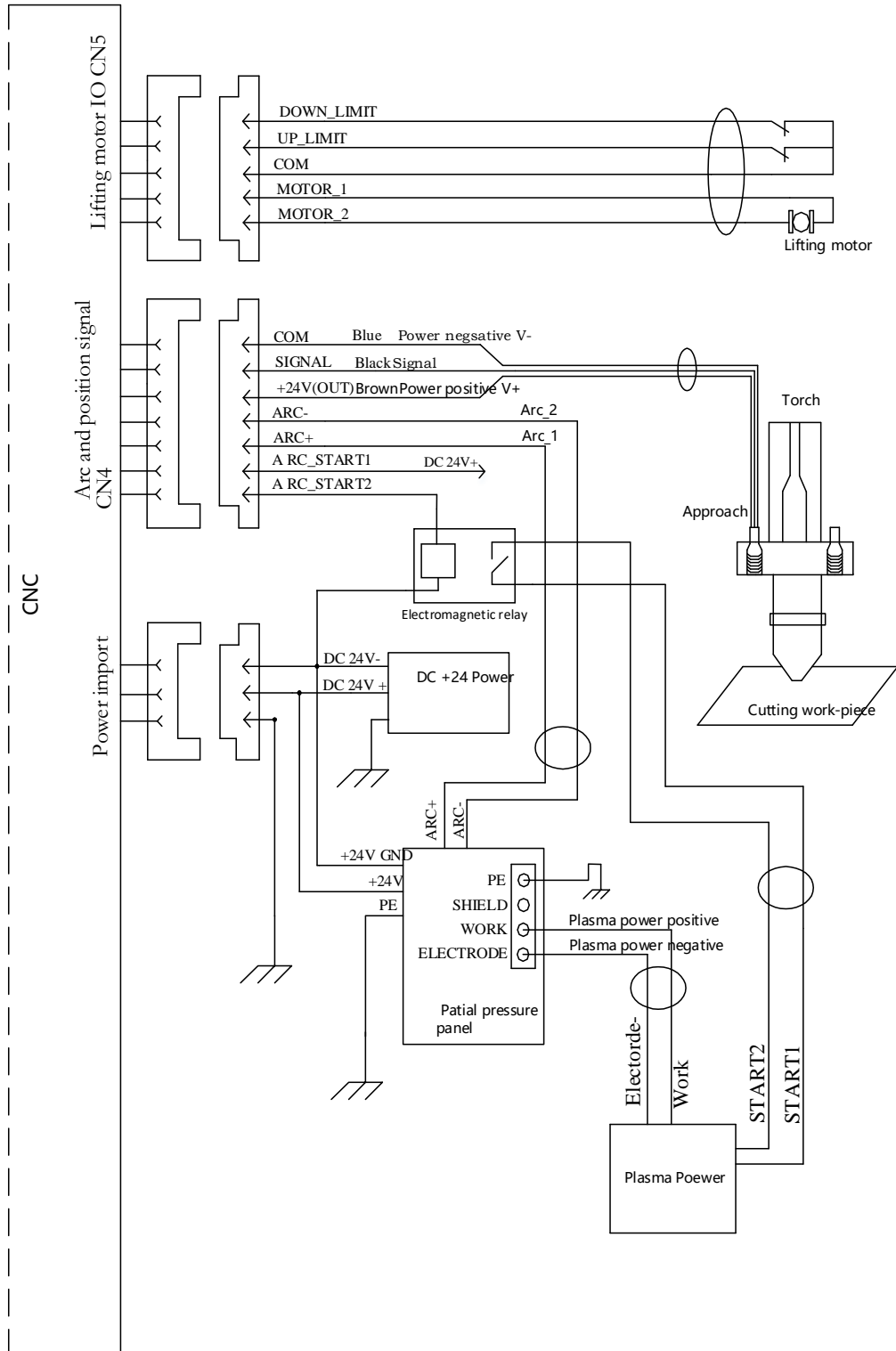


Fig.11.15 Wiring Diagram of F2100T system with Arc THC Module

### 11.4.6 Wiring Diagram of double approach switch

Two NPN-style approach switches are used for location, which can either be linked

with the parallel mode or be linked with series mode. To make the location more accurate and stable, we recommend using series mode to link the two switches. The specific wiring mode is shown as the figure 11.16. With this link-mode, any one action of approach switch can emit the collision signal.

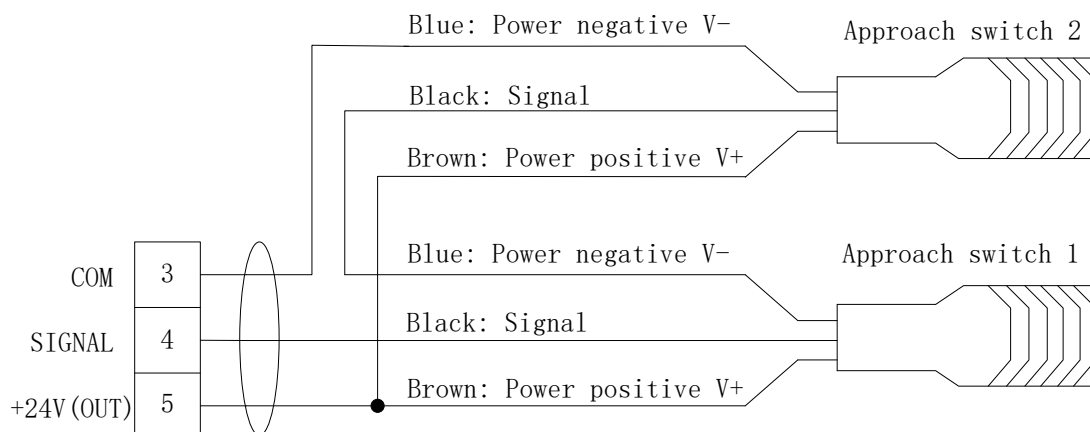


Fig.11.16 Wiring Diagram of double approach switch

## 11.4.7 Separate Control of Flame Cutting Torch and Plasma Cutting

### Torch

This function can achieve the separate control of flame cutting torch and plasma cutting torch. Plasma cutting torch can only be connected to CN5 motor interface, while flame cutting torch can select to be controlled by CN5 interface or DB25(CN2) interface by setting parameter “output port of the flame gun” (Please refer to section 8.7.7).

The connection method of the plasma gun is referenced to 11.4.1 Motor CN5 (MOTOR DC).

The connection method of the flame gun, if controlled by CN5 interface, is also referenced to 11.4.1 Motor CN5 (MOTOR DC). If controlled by DB25 interface, then please refer to section 11.2 output wiring instructions.

## 11.5 Power Input (Power In)

Power input: 24V-, 24V+, PE.

Table 11.8 Power Interface Signal Definition

3 Pins Interface Pin Number	Signal Name	Comment
1	24V-	24V Power -
2	24V+	24V Power +
3	PE	Ground



## Chapter 12 Use of BIOS

About system upgrade and system recovery function, the users can also refer to section 8.7.10, the function here is similar to that section. When the system powers on, it will display as shown in Fig 12.1.

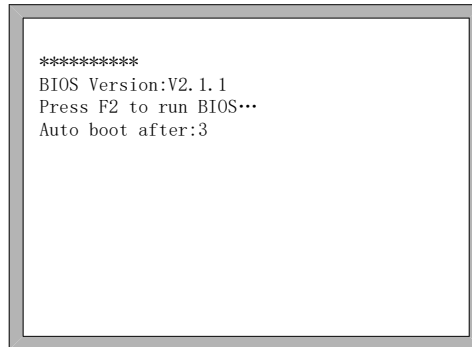


Fig 12.1 Power on

Before the screen number counts down to 0, if you press F2, the system will enter the BIOS interface. If you press other keys, the system will stop counting down and enters the main interface..

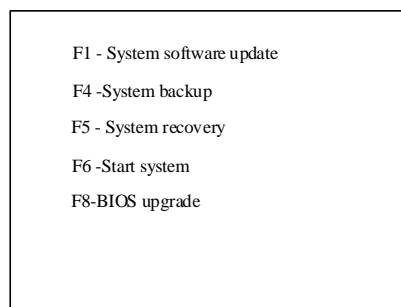


Fig 12.2 BIOS interface

### 12.1 System Upgrade

After entering BIOS, press **【F1】** to upgrade the system, it should satisfy the following conditions:

- U disk has been inserted into USB interface of CNC
- There should be the upgrade file F2000.exe in the root folder of the U disk..

Under the circumstance of above two conditions satisfied, Press **【F1】** to upgrade system, when completing the upgrading, press **【F6】** to reboot.

### 12.2 System Backup

After entering BIOS, press **【F4】** to backup system. It only backup OP (operation system), but not backup parameter, IO ports configuration, coordinate configuration and so on.

## 12.3 System Recovery

After entering BIOS, press **【F5】** to return to the original system that has been backup. System recovery here does not affect the user's parameters, IO port configuration, coordinate configuration, etc., Recommend to use system recovery function here.

## Chapter 13 Installation and Debugging

### 13.1 Horizontal / Vertical Pulses Number Setting

- Horizontal / vertical pulses number setting

Here, horizontal / vertical pulses number is also introduced in the section of 7.5 system parameter. It's easy to set the number of horizontal (vertical) pulses. Before drawing a line, assume one value of horizontal pulses XPIs and one value of vertical pulses YPIs, set these two parameters and then save the settings. Enter the manual interface, choose fixed moving function. Assume the fixed distance is A mm. Move A mm horizontally, and the actual length of the line is B mm (which is generally not equal to A), then we can calculate the horizontal pulses

number. The equation is  $XPIs \cdot \frac{A}{B}$ . After calculating, replace the outcome with the assumptive XPIs (take three decimal places at most). Similarly, move C mm vertically, the actual length is D

mm, then the vertical pulses number is  $YPIs \cdot \frac{C}{D}$ .

- Requirement of pulses number:

The maximum frequency of output pulses from the system is 160 KHz. It is not possible to work properly according to the order if the pulse frequency is higher than 160 KHz. Assume the pulse number is x, the highest speed is  $M_v$  (mm/min), then  $(M_v \cdot x / 60)$  should be less than 160000.

For example, the pulse number is  $x=2000$ , the highest speed is  $M_v=12000$  (mm/min). Because of  $M_v \cdot x / 60 = 12000 \cdot 2000 / 60 = 400000 > 160000$ , the speed of 12000 (mm/min) is not reachable. If we set x to be 500, then  $M_v \cdot x / 60 = 12000 \cdot 500 / 60 = 100000 < 160000$ , at this time it can operate at the maximum rate of 12000 mm/m.

While in principle the number of pulse can be set to a large value, in fact it should be set between 150 and 1200. Because the frequency is too high, some drives can't work very well, the motor sometimes will be out of synchronism. On the other hand, the performance of anti-jamming is of foreign interference is poor and the external interference is strong.

**Note:** The most reasonable number of pulse is between 150 and 1200. The number of pulse exceeds this range, please refer to the interpretation of driver and modify subdivision number of stepper driver and denominator of Servo driver.

## Chapter 14 Shanghai FangLing F1510-T Remote Controller

### 14.1 Wireless Remote Control Module Performance and Characteristic

- 433MHz free ISM frequency channel, free license on trial
- Remote controlling distance > 30m, at least not below 0.5m
- Hardware test error code, software optimizing algorithm, bi-direction communication, insure the communication stable and reliable
- Sending module matches address with receiving module, the address can be set manually, support at most 128 supportable addresses
- Wireless remote controlling send module is supplied power by dry battery, at least working more than 6 months service time
- Receiver module is set into 8421 port mode or IO mode, at most 16 output ports

### 14.2 The Layout of Remote Controller



Fig.14.1 layout of remote controller

#### 14.2.1 Transmitter Description

Keys: English and Chinese control keys, they are “启动(Start)、停止(Stop)、四个方向(↑ ↓ → ←)、1 个小手 (Manual)、T ↑、T ↓、S+、S-、点火(Ignition)、预热(Preheat)、快氧(CutOxy)、起弧(Plasma)、前进(Forward)、后退(Back)、总关(Close)、手动速率(ManualRate)”. 19 keys in total.

Indicator: three manual modulation rate (5%, 50%, 100%) and 3 manual mode lamp (electric, interlock, fixed length). 1 sending signal indicator, 1 electric quantity indicator(or multiplexes

with signal indicator)

Description: boot default rate is 50% manual lights, manual rate for the second state, manual rate in continuous is pressed, the manual speed change state machine manual rate twice (50% light) -> Manual rate three times (100% light) -> Manual rate once (5% light) -> Manual rate twice (50% light). When turned on, the default is inching bright Manual as a state, to move light, Manual changes state machine Manual once (Jog lights) -> Manual secondary (interlock lights) -> Manual three times (fixed length lights) -> Manual once (jog lights).

When all keys are pressed, it will issue OUT1-OUT8 signal as the following table, when the key is released, all outlets closed (OFF).

Transmitter Keys	P2P Output (description: 0 means to determine the high level of output, the 1 means the low level output)	Encoding output OUT1,2,3,4,5,6,7,8 (description: 0 means to determine the high level of output, the 1 means the low level output)	Remarks
<b>S+/Speed</b>	00001000	00001000	Speed up
<b>S-/Speed</b>	00000100	00000111	Speed down
↑	00100000	00001010	Up arrow
↓	00010000	00001001	Down arrow
←	01000000	00000100	Left arrow
→	10000000	00001110	Right arrow
<b>Manual once (Boot default)</b>		00001111	Manual cycles between once, twich and three times
<b>Manual twice</b>		00011111	
<b>Manual three times</b>		00101111	
<b>T ↑</b>		000001101	Torch up
<b>T ↓</b>		00001100	Torch down
<b>Start</b>	00000010	00000110	Start
<b>Stop</b>	00000001	00001011	Stop
<b>Back</b>		00000010	Back
<b>Foward</b>		00000011	Forward
<b>Ignition</b>		00000101	Ignition
<b>CutOxy</b>		00000001	Cutting oxygen
<b>Preheat</b>		00110000	Preheat oxygen
<b>Plasma</b>		01000000	Plasma arc
<b>Manual rate once</b>		01010000	Cycles between three types
<b>Manual rate twice (Boot default)</b>		01100000	
<b>Manual rate three times</b>		01110000	
<b>Clsoe</b>		11110000	

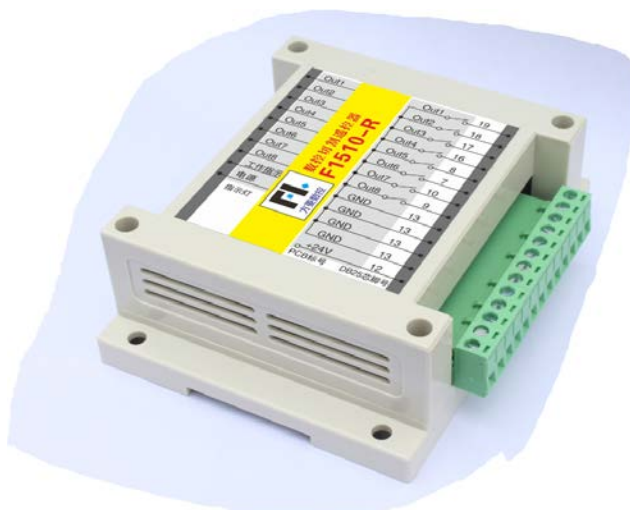
## 14.3 The Output Port of Receiver

Model: F1510-R

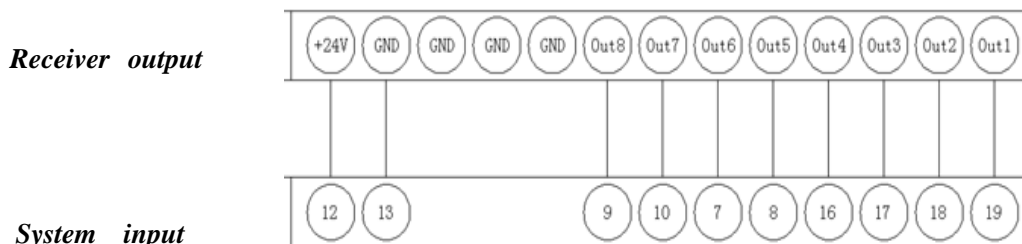
Output ports: 8

Power supply mode: 24VDC.

Each output port corresponds to a LED lamp to display IO port state, when it is ON, lamp lights, when it is OFF, lamp is off.



**Wiring instructions for remote controller and F2000 series:**



Description: all the buttons on the panel can be used. Press F5 diagnose, F8 system definition, F3 definition, F5 option, then set the remote controller type to 8421.

## **Chapter 15 Shanghai FangLing F1520 Remote Controller**

Note: F1520 remote controller needs special instructions when placing orders. If you need to add it after some time, you need to send the system back to our Shanghai after-sales maintenance department. It can be used normally after we add the appropriate hardware circuit to system.

### **15.1 Performance and Characteristics of Wireless Remote Control Module.**

- 1.433MHz free ISM band free license trial;
2. Remote control distance > 30m, at least not less than 0.5m;
3. Hardware detection error, software optimization algorithm, two-way communication ensure stable and reliable communications;
4. Send and receive modules by address match, the address can be set manually, the maximum support 128 addresses;
5. Wireless remote controller uses dry battery power supply, use of time can last more than 6 months.
6. F1520 remote control is divided into hand-held transmitter F1520-R and receiver F1520-T;
7. Receiver module F1520-R uses RS232 connection, user-friendly wiring.

## 15.2 Layout of Remote controlle

### 15.2.1 Transmitter F1520-T Description



Buttons: Start、Stop、Four direction(↑↓→←)、Manual、T↑、T↓、S+、S-、Ignition、Preheat、CutOxy、Plasma、Forward、Back、Close and ManualRat. There is 19 keys.

Indicator: three manual speed lights (5%, 50%, 100%), three manual mode lights (electric, interlock, fixed length) .one send signal indicator, a power indicator (or signal Indicator light multiplexed)

Description: When the manual speed is 50% by default, the manual rate is quadratic. When the manual rate is pressed continuously, the manual rate changes the manual speed twice (50% light) -> Manual rate three times 100% light) -> manual rate once (5% light) -> manual rate twice (50% light). When the power is on, the default is the point of the manual for the state, the jog light is on, the manual changes



the state machine for the manual once (the jog light is on) -> Manual twice (with lights) -> Manual three times (fixed light) >Manual One time (jog light).

### 15.2.2 Receiver F1520-R wiring instructions

Remote controller receiver F1520-R, using the standard serial port connection, directly connects to the system's RS232 serial port nine-pin DB terminal block head, There is serial remote control receiver in Figure 15.2. The standard F2000 series has no such ports, so customer needs special instructions when placing orders.



Fig15.2 Receiver F1520-R

As shown in Fig15.3, it is F1520-T remote control interface that can be connected to the serial port RS232 interface diagram, motor 2 and serial port CN6. You can plug the receiver head directly, or use a male and female DB9 extension line to connect.

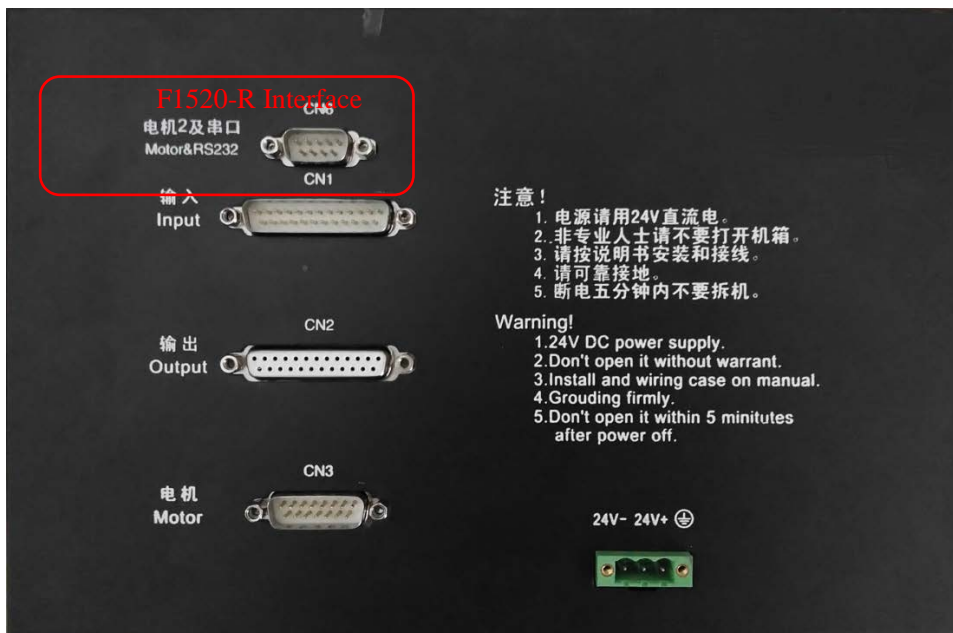


Fig15.3 Back interface

The wiring definition is shown in Fig 15.4.

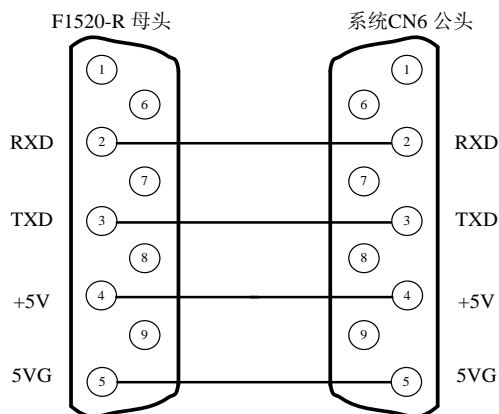


Fig 15.4 F1520-R wiring definition

## Chapter 16 Tube/plate All-in-one module

### 16.1 Summarize

#### 16.1.1 Module Brief Introduction

F2000X module is the pipeline cutting software function module based on the F2000 model digital control system produced by our company. Digital control system with F2000X module function can process various pipe parts. This function is based on the mature F2000 system, so this system is stable and reliable, easy to operate. The user can rapidly cut pipeline based on the initial operation.

This module can be applied to all F2000 series controller from our company, facing to different machine tool, various mating controller selection available.

#### 16.1.2 Module Function

- Supporting 2 axes cutting tube machine with chuck mode
- Supporting 2 axes cutting tube machine with friction disk mode
- Supporting tube and plate all-in-one (chuck mode) cutting machine
- Supporting tube and plate all-in-one (friction disk mode) cutting machine
- Tube /Plate function auto switch
- Any pipe diameter processing By using of Fang Ling pipe nesting software, it support a variety of workpiece cutting such as truncated, saddle head, eccentric saddle head, shrimp tube, bent pipe, etc.
- System comes with graphics library, containing five graphics, support left and right truncation, left and right branch and the mother tube opening, can be free combination.

## 16.2 operation instructions

### 16.2.1 Main interface

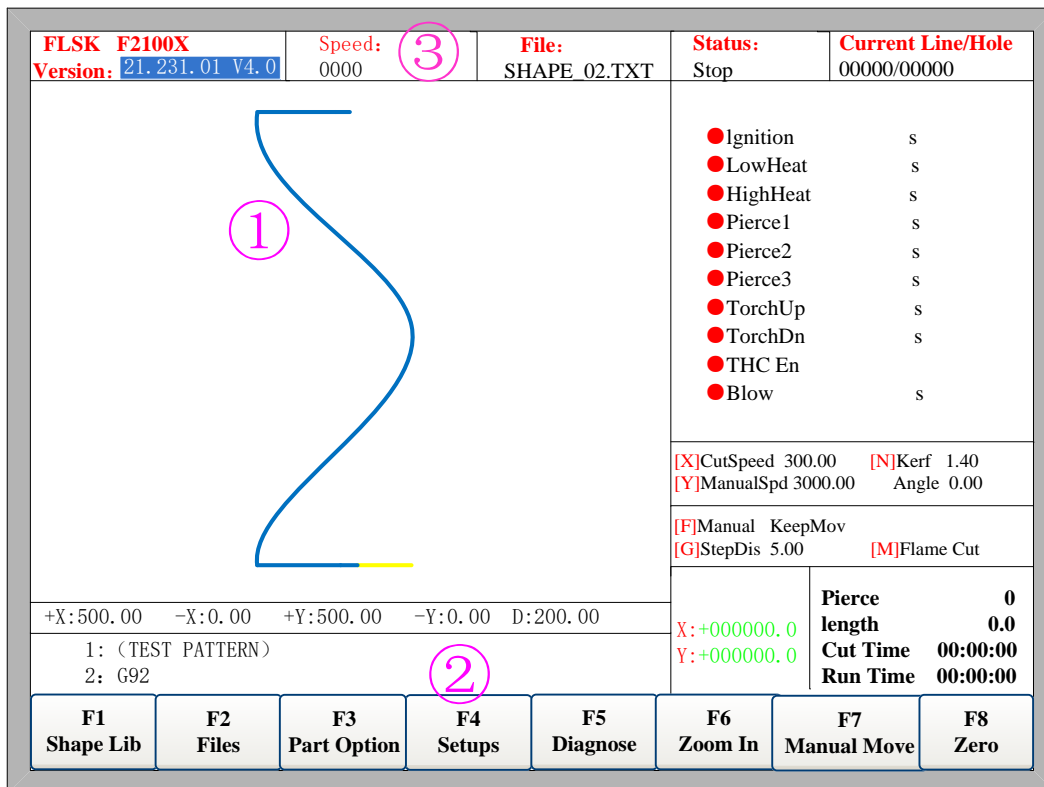


Fig 16.1 Tube/plate cutting main Interface

The Tube/plate All-in-one system shows one more X on the upper corner of main interface than ordinary F2000 series. For example F2100, it will be F2100X.

In the middle section of the display graphics area 1 and area 2, there's one more parameter tube diameter D. for example: "D:200.00". It interprets that current tube diameter is 200 mm.

### 16.2.2 Tube/Plate Cutting Switch

The tube/plate All-in-one system has onemore parameter in common parameter interface, tas shown in Fig16.2

Max Cutting Speed	<input type="text" value="3000.00"/>	mm/min
Manual Move Speed	<input type="text" value="3000.00"/>	mm/min
G00 Move Speed	<input type="text" value="3000.00"/>	mm/min
Demo/Back Speed	<input type="text" value="3000.00"/>	mm/min
Marker Speed	<input type="text" value="3000.00"/>	mm/min
Kerf Value	<input type="text" value="1.5"/>	mm
Corner Speed (1-100)	<input type="text" value="3000.00"/>	%
Demo Run Speed	<input type="text" value="3000.00"/>	mm/min
Cutting Type	<input type="text" value="Flame"/>	
System Mode	<input type="text" value="Pipe Cut"/>	

<b>F1</b> Common	<b>F2</b> Flame	<b>F3</b> Plasma	<b>F4</b> Marker	<b>F5</b> System	<b>F6</b> Import	<b>F7</b> Export	<b>F8</b> Save
---------------------	--------------------	---------------------	---------------------	---------------------	---------------------	---------------------	-------------------

Fig16.2 Tube/Plate Cutting Switch

In the main interface, press **【F4】** to enter into Setups interface. It will show **【F1 Common】** parameter function interface as figure 16.2.

Press down **【↑】** or **【↓】** to select parameter **【System mode】**, press down **【←】** or **【→】** to switch between two modes: **【Tube cutting】** and **【Plate cutting】**.

**Note:** after switch system mode, the user needs to save parameters and power off to restart system, then cutting modeswitches between tube cutting and plate cutting.

### 16.3 Tube graphics library

Under the main interface, press **【F1】** to enter the tube graphics library interface, as shown in Figure 16.3.

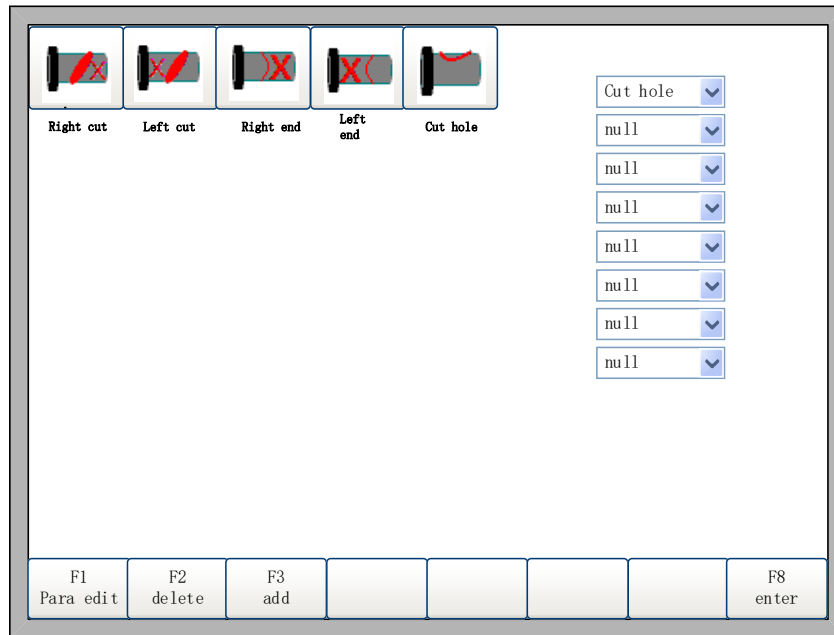


Fig16.3 Graphics library interface

Note: This chapter is only available in the tube cutting system.

- 1) [F1] Parameter editing: the cursor where the drop-down box type of the relevant parameters set. When multiple end combinations are combined, the pipe diameter and pipe wall thickness parameters can only be set in the end type selected in the first drop-down box.
- 2) [F2] Delete: delete the cursor where the drop-down box in the end, the first one can not be deleted.
- 3) [F3] Add: Select the desired end type in the drop down box where the cursor is located.
- 4) [F8] Confirm: confirm the parameters setting is completed, enter the graphical preview interface.

### 16.3.1 Graphic selection and combination

In the Gallery interface shown in Figure 8.1, you can select the type of end to be cut and you can combine the graphics at will. In the drop-down box on the left, select the type of end to be cut in order. Press[↑], [↓] to select the corresponding drop-down box, and then click [Enter] or [F2] to open the drop-down box and select the desired terminal type. To select each end, you must set the parameters. The end of the parameter that is not set is red

## 16.3.2 Parameter editing

In Figure 16.3, undergraphics library interface, press [↑], [↓] to select the end of the parameter to be set, and then press 【F1】 to display the corresponding parameter editing interface.

### 16.3.2.1 Truncate the parameter interface

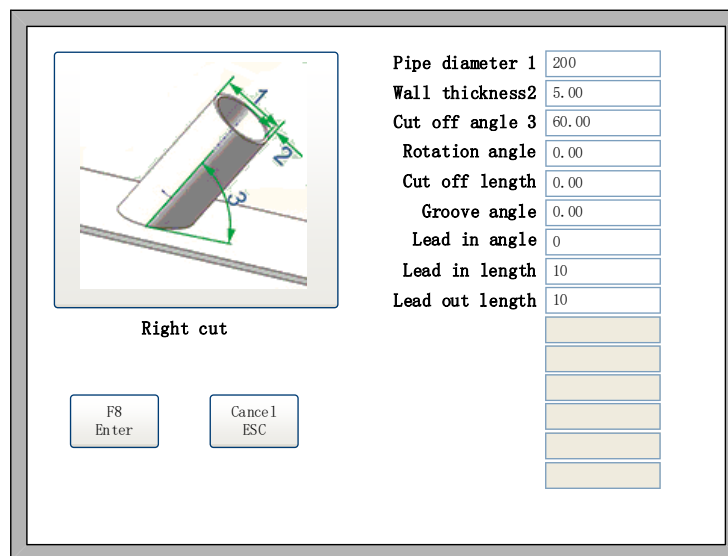


Fig16.4 Truncate the parameter interface

In Fig 16.4 cut off the parameters interface, you can edit the corresponding parameters. The cutoff parameters are described below:

- Pipe Diameter 1: The outer diameter of the cut pipe, 1 on the schematic, which can only be set in the type of terminal selected in the first drop-down box in Figure 16.3. Unit: mm
- Pipe wall thickness 2: The wall thickness of the cut pipe, 2 on the diagram. This parameter can only be set in the type of terminal selected in the first drop-down box in Figure 16.3. Unit: mm
- Cut off angle: the angle between the cut tube and the cut surface, 3 on the schematic. Unit: degrees
- Rotation angle: This is the relative position, relative to the positioning point, chuck shaft rotation set the angle, from the tube head to the chuck direction, counterclockwise positive. Unit: degrees
- Cut off length: the first end of the graphics combination, the parameter refers to the point of contact with the tube to the center line of the intersection of the

distance. The lower end, which refers to the distance between the intersection of the front end of the front end and the intersection of the axis of the current tip. Unit: mm

- Lead in angle: unit: degree
- Lead in length: Unit: mm
- Lead out length: Unit: mm

### 16.3.2.2 Branching parameter interface

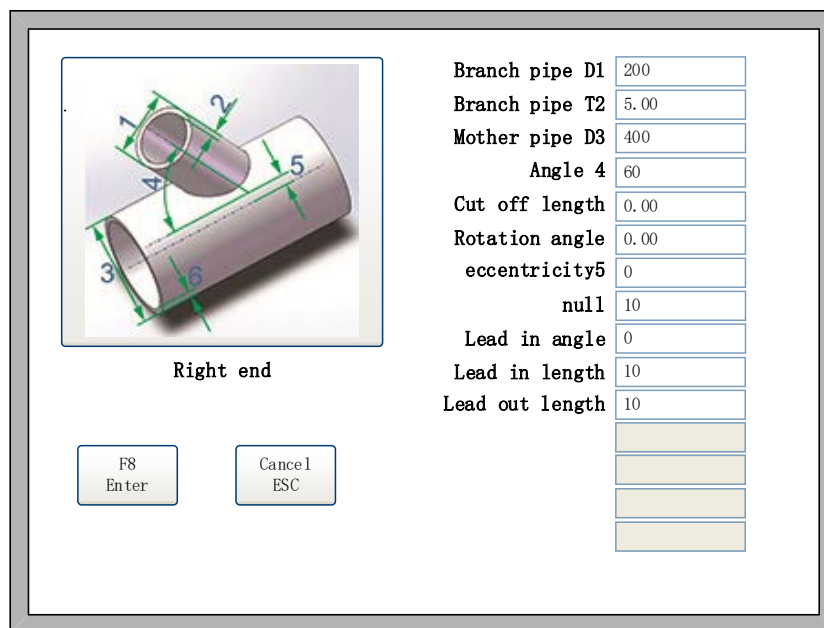


Fig 16.5 Branching parameter interface

The branching parameters are described below:

- Branch pipe1: The outer diameter of the cut pipe, 1 on the diagram. This parameter can only be set in the terminal type selected in the first drop-down box in Figure 16.3. Unit: mm

- Branch pipe2: The wall thickness of the cut pipe, 2 on the diagram, which can only be set in the type of terminal selected in the first drop-down box in Figure 16.3. Unit: mm

- Mother pipe 3: Diameter of the coherent tube of the cut tube, 3 on the schematic. Unit: mm

- Angle 4: branch pipe and the angle of the tube, the figure on the 4, unit: degree

- Cut off length distance: the first end of the pattern combination, this parameter refers to the gun point to the branch pipe and the center line of the intersection of the distance. The lower end of the pipe is the distance between the



branch of the front end and the intersection of the pipe axis and the intersection of the branch of the current end and the axis of the parent pipe. Unit: mm

- Rotation angle: This is the relative position, relative to the positioning point, chuck shaft rotation set the angle, from the tube head to the chuck direction, counterclockwise positive. Unit: degrees

- Eccentricity 5: the vertical distance between the centerline of the branch pipe and the center line of the tube, 5 on the schematic. Unit: mm

### 16.3.2.3 Mother hole opening interface

The manifold opening is divided into a riding-type mother tube and a plug-in pipe, and is set by a drop-down box below the schematic. The interface of the bus opening is shown in Fig 16.6.

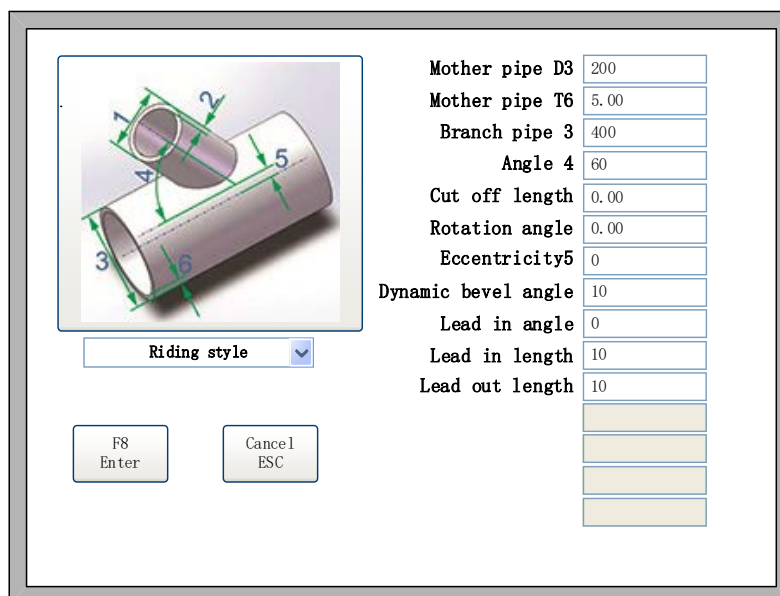


Fig 16.6 Mother hole opening interface

When the combination of graphics, then the branch inside the branch on the parameters of the value, in the main tube inside the hole will become the parameters of the mother tube. The parameters of the parent opening are as follows:

- Mother pipe D3: The outer diameter of the cut pipe, 3 on the schematic. This parameter can only be set in the type of terminal selected in the first drop-down box in Figure 16.3. Unit: mm

- Mother pipeT 6: The wall thickness of the cut pipe, 6 on the diagram. This parameter can only be set in the type of terminal selected in the first drop-down box in Figure 16.3. Unit: mm

- Branch pipe 1: The diameter of the branch pipe to be inserted by the cutting pipe, 1 on the diagram: Unit: mm
- Angle 4: branch pipe and the angle of the tube, the figure on the 4, unit: degrees
- Cut off length: the first end of the pattern combination, this parameter refers to the gun point to the branch pipe and the center line of the intersection of the distance. The lower end of the pipe is the distance between the branch of the front end and the intersection of the pipe axis and the intersection of the branch of the current end and the axis of the parent pipe. Unit: mm
- Rotation angle: This is the relative position, relative to the positioning point, chuck shaft rotation set the angle, from the tube head to the chuck direction, counterclockwise positive. Unit: degrees
- Eccentricity 5: the vertical distance between the centerline of the branch pipe and the center line of the tube, 5 on the schematic. Unit: mm
- Dynamic bevel angle: the dynamic bevel angle of the parent pipe opening. Unit: mm

### 16.3.2.4 Graphic preview

After the parameters of the selected graphic are set, click [F8] to confirm, then enter the graphical preview interface, as shown in Figure 16.7

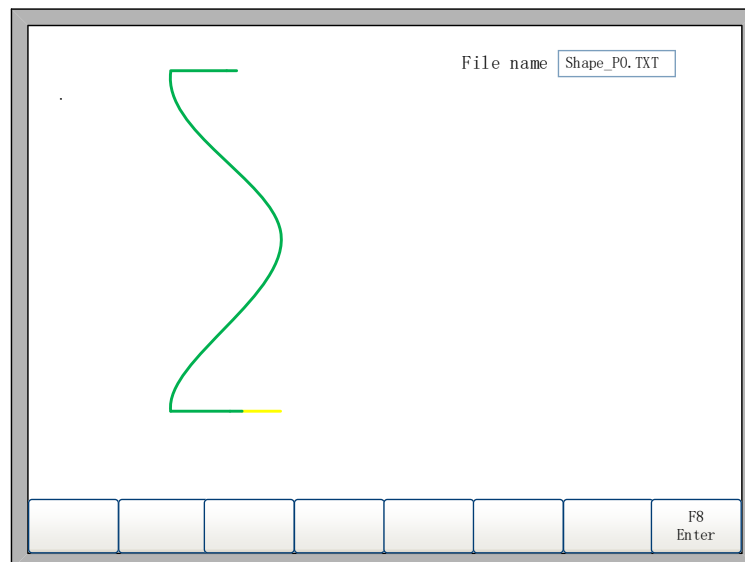


Fig 16.7 Graphic preview

In the graphical preview interface, the user can see the preview code generated according to the type of the selected terminal and the parameter. In the upper right corner there will be an edit box, which is the name of the G code file generated by the parameter, which can be modified by the user. Click **【F8】** to confirm, then this the G

code file can be saved. In the main interface click **【F2】** file management the corresponding G code file can be found ,thus users can find and select in the future production process at any time .

After confirming the graphic preview, click **【F8】**, then enter the main interface, you can start cutting.

### 16.3.3 Tube cutting related parameter settings

#### 16.3.3.1 Number of pulses set

As shown in Figure 16.8, in the [F4] parameter interface under the [F5] system parameters, there shows the number of chuck pulse related settings.

Horizontal Axis Pulse	125	pluse/min
Vertical Axis Pulse	125	pluse/min
Max cutting Speed	6000.00	mm/min
Max G00 Speed	6000.00	mm/min
Max Manual Speed	6000.00	mm/min
Small Arc Limit	800.00	mm/min
Limited Speed below Radius	0.00	mm
Accerate Time in Flame	0.40	s
Accerate Time in Plasma	0.30	s
Emergency Stop Time	0.080	s
Start Speed	250.00	mm/min
Max +X	100000.00	mm
Max +Y	100000.00	mm
Min -X	-100000.00	mm
Min -Y	-100000.00	mm/min
Chuck Pulse	125.000	
Chuck Max Spd	1.0	RPM

F1 Common	F2 Flame	F3 Plasma	F4 Mark	F5 System	F6 Import	F7 Export	F8 Save
--------------	-------------	--------------	------------	--------------	--------------	--------------	------------

Fig 16.8 Chuck pulse

- Chuck pulse : This parameter sets how many pulses to rotate one degree. In the pipe cutting mode, use the number of chuck pulses to calculate the chuck position.
- Chuck Max Speed: the maximum speed of the chuck.

### 16.3.3.2 Chuck selection

Remote controller type	NO
Default corrdiate type	Relative
IJ Coordinate Type	Relative
Default Unit	Metric
Fitting Short Line	No
Steel Angle Remenber	No
Forbidden F	No
Manual angle to do steel correction	No
Use Crawl in Piercing	No
Use Chuck	No
No plasma and Steal contack check	No
Hold Preheat after cutting end	No
PIPE axes output	Y

Restart after change default unit

F1 Input	F2 Output	F3 Axes	F4 Motor	F5 Option	F6 Option2	F8 Save
-------------	--------------	------------	-------------	--------------	---------------	------------

Fig 16.9 Chuck selection

In **【F5】** System Diagnostics - **【F8】** System Definition - **【F3】** Definition - **【F5】** Option Parameter interface is shown in Figure 16.9.

- **【Use chuck】** When the rotating axis uses a chuck, it is set as yes. When rotating axis uses a friction disk, set as no.
- **【PIPE axes output】** set the chuck axis is X or Y.

## 16.4 Tube/plate All-in-one System controller Topology Schematic

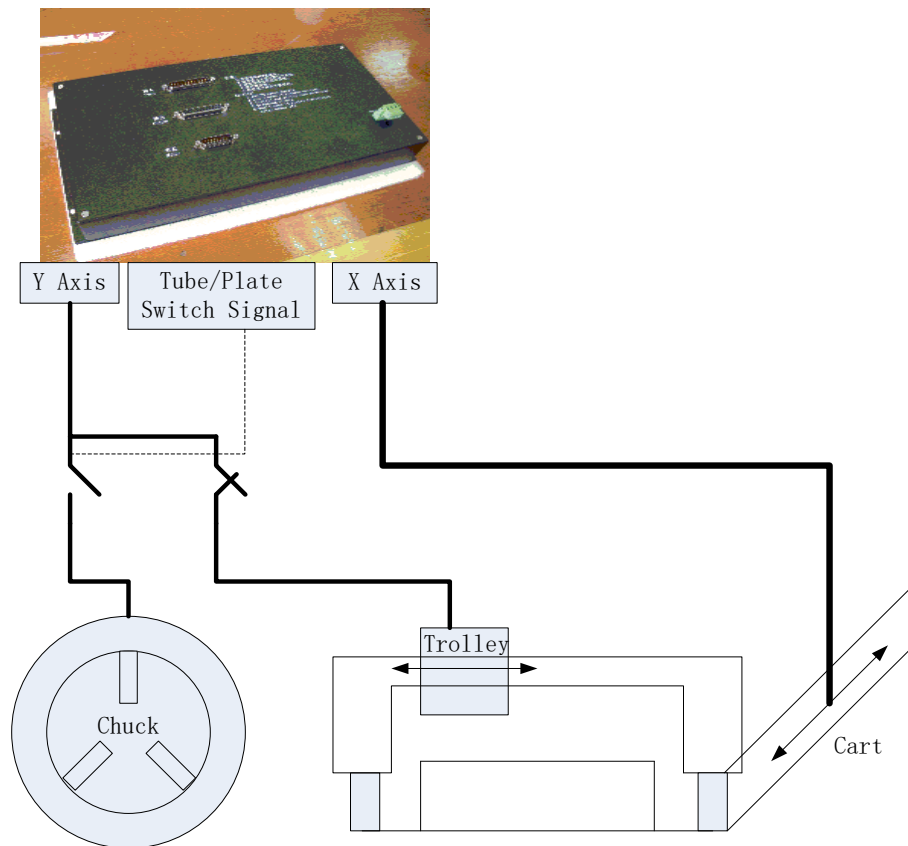


Fig 16.10.1 Tube/plate all-in-one system controller topology Schematic

X axis and Y axis can be changed to control Cart and Trolley motors. The chuck motor can select any one of the two axis to make output control. At the same time, only one of the chuck's or trolley's motor is always enable (Using the tube/plate switch signal by the system outputs).

## 16.5 IO Port

Output Definition											
Function			Port			Type					
Ignition	▼	03	▼	NO	▼	Blow	▼	06	▼	NO	▼
LowHeat	▼	01	▼	NO	▼	THC Enable	▼	08	▼	NO	▼
HighHeat	▼	17	▼	NO	▼	Position Detect	▼	19	▼	NO	▼
Pierce1	▼	04	▼	NO	▼	Arc starting	▼	16	▼	NO	▼
Pierce2	▼	05	▼	NO	▼	LockTHC	▼	18	▼	NO	▼
Pierce3	▼	14	▼	NO	▼	Marker Output	▼	07	▼	NO	▼
TorchUp	▼	02	▼	NO	▼	Pipe Mode	▼	20	▼	NO	▼
TorchDn	▼	15	▼	NO	▼	Marker preheat	▼	21	▼	NO	▼

F1 Input	F2 Output	F3 Axes	F4 Motor	F5 Option	F6 Option2		F8 Save
-------------	--------------	------------	-------------	--------------	---------------	--	------------

Fig 16.11 Output definition

【Pipe Mode】 This port keeps open all the time in the mode of tube cutting, keeps closed in the mode of plate cutting. Using this signal, you can switch between trolley and chuck enable.

## 16.6 Code Explanation

### 16.6.1 Code Symbol

Tube cutting program code is similar to plate cutting program code,, its differences areas following:

- Letters and Units:

X: The cart's axis, unit(mm)

Y: chuck(it's trolley in the mode of cutting plate), unit is degree.

(When don't use chuck, unit is mm)

- Diameter Code

The tube cutting code starts with the following procedures (must) (D=168)

It interprets that the tube's diameter is 168 mm in this cutting program.

- Wall Thickness Code

There is one line code in the cutting tube code as follow(omissible):

(T=8)

It interprets that the tube's wall thickness is 8 mm in this cutting program.

- Annotation

The content contained within parentheses in the tube cutting program are annotation. Besides diameter annotation code, the rest annotations can all be omitted..

### 16.6.2 Typical Code

(D=452)

(T=55)

(M=Q235-A)

(F=1)

G71

G90

G92X0Y0

(Sit,90,-570.787,Sit,1200,50,90,0)

G00 X0 Y-0.634 B0

M07

G01 X4.33 Y0 B0 F500

G01 X4.454 Y4 B0 F1000

G01 X4.822 Y8 B0 F1000

G01 X5.428 Y12 B0 F1000

M08

M02

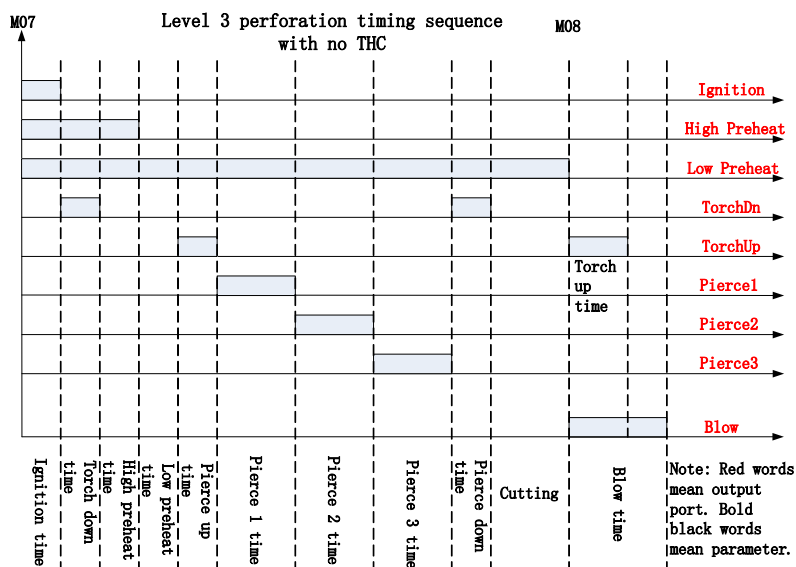
## Appendix 1 G、M Code Rapid Consult

Serial number	Order	Function
1	G99	rotation、proportion、mirror image
2	G92	reference coordinate
3	G91	Relative coordinate system
4	G90	Absolute coordinate system
5	G20	English unit
6	G21	Metric unit
7	G26	X axis quick return reference point
8	G27	Y axis quick return reference point
9	G28	X, Y axis quick return reference point
10	G41	Left kerf gap compensation
11	G42	Right kerf gap compensation
12	G40	Cancel kerf gap compensation
13	G00	Quickly move
14	G01	Liner cutting
15	G02	Clockwise arc cutting
16	G03	Anticlockwise arc cutting
17	G04	Program delay
18	M07	Start cutting cycle
19	M08	Stop cutting cycle
20	M11	Marker offset open
21	M12	Marker offset off
22	M09	Open the powder
23	M10	Stop of the powder
24	M00	Pause
25	M02	Program end

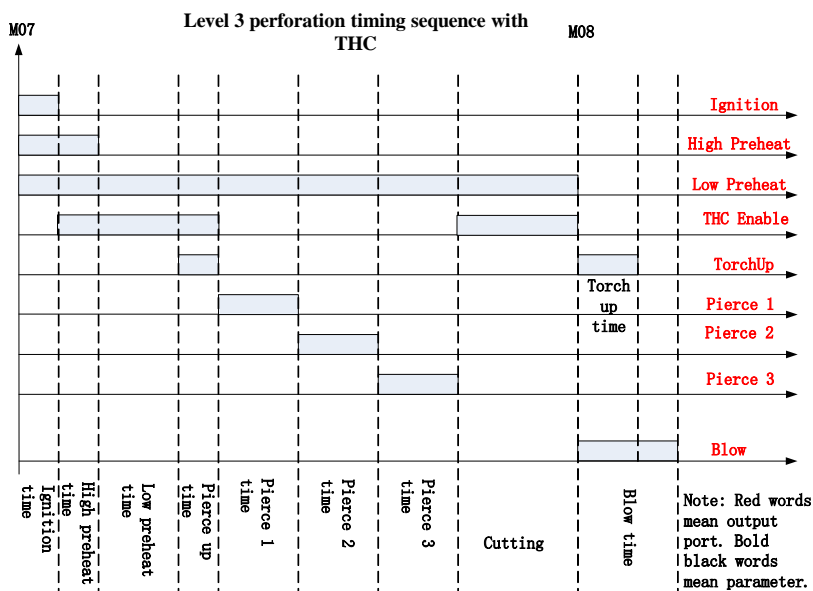


## Appendix 2 IO Timing Sequence Figure of F2000 Series Numerical Control System

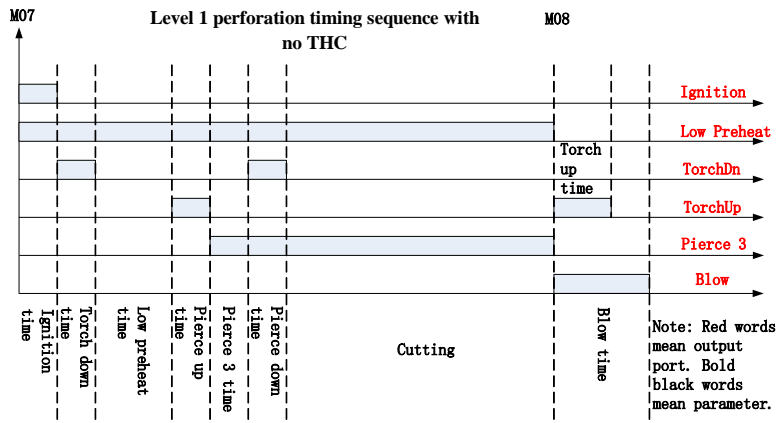
### A2.1 Flame Cutting Timing Sequence



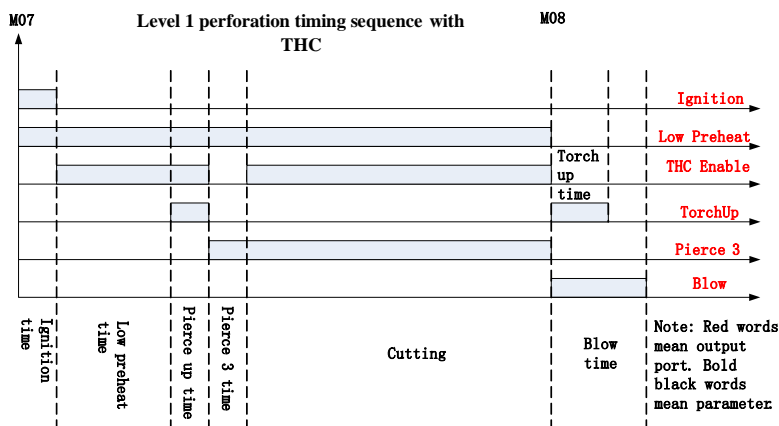
Appendix fig 2.1 Flame cutting timing sequence (Level 3 perforation with no THC)



Appendix fig 2.2 Flame cutting timing sequence (Level 3 perforation with THC)

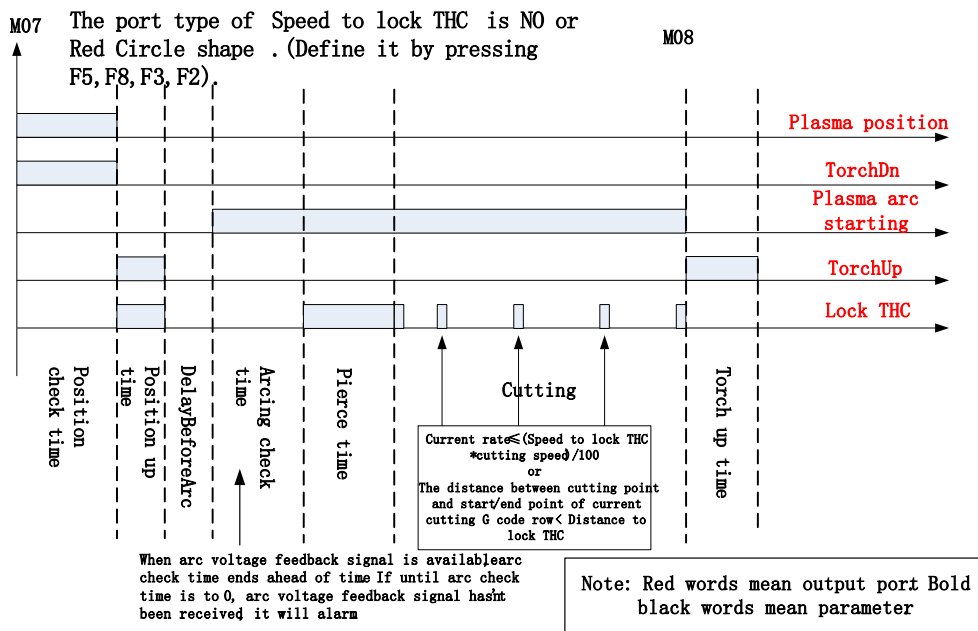


Appendix fig 2.3 Flame cutting timing sequence (Level 1 perforation with no THC)

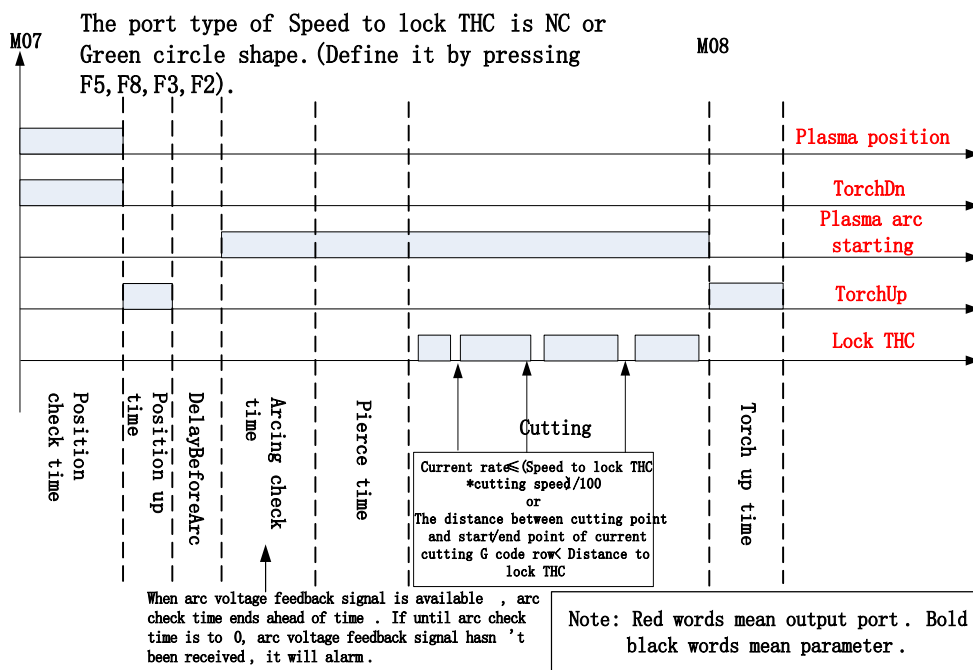


Appendix fig 2.4 Flame cutting timing sequence (Level 1 perforation with THC)

## A2.2 Plasma IO Timing Sequence



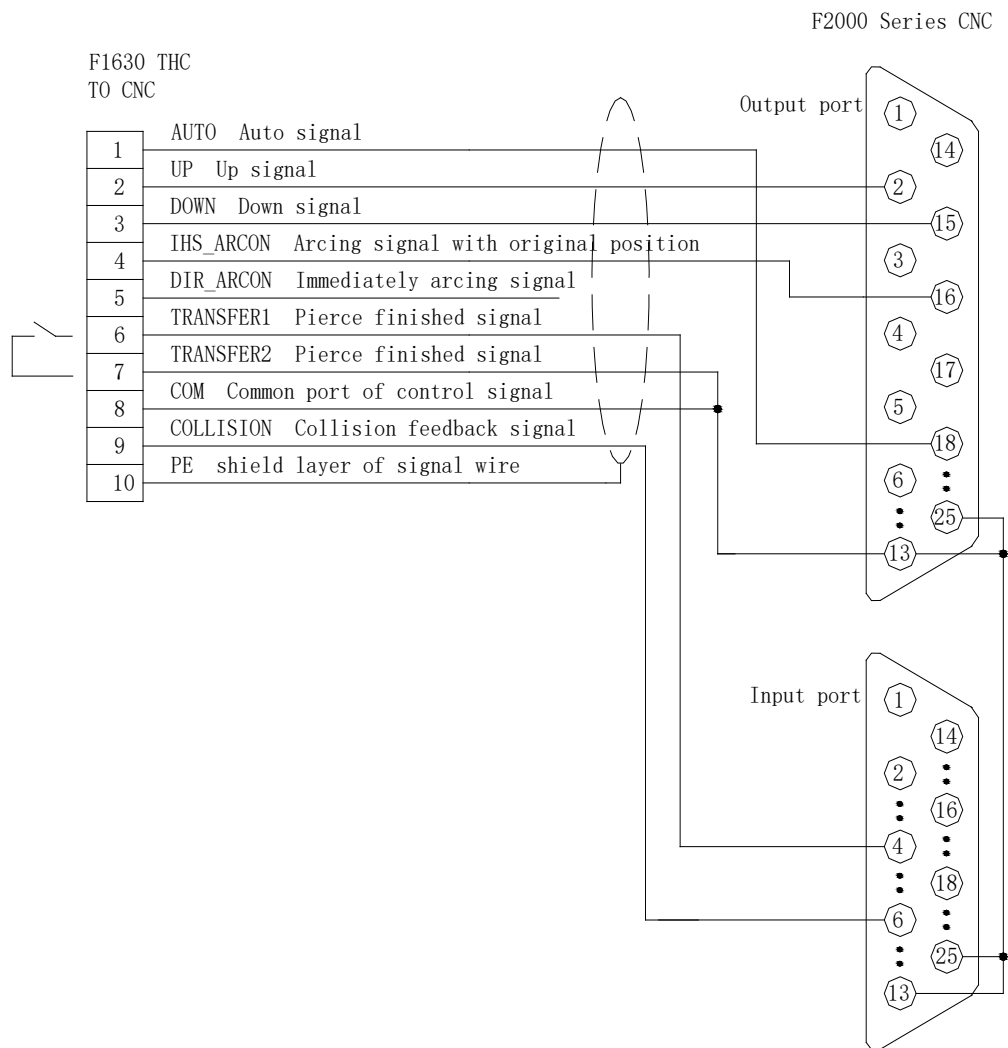
Appendix fig 2.5 Plasma IO timing sequence



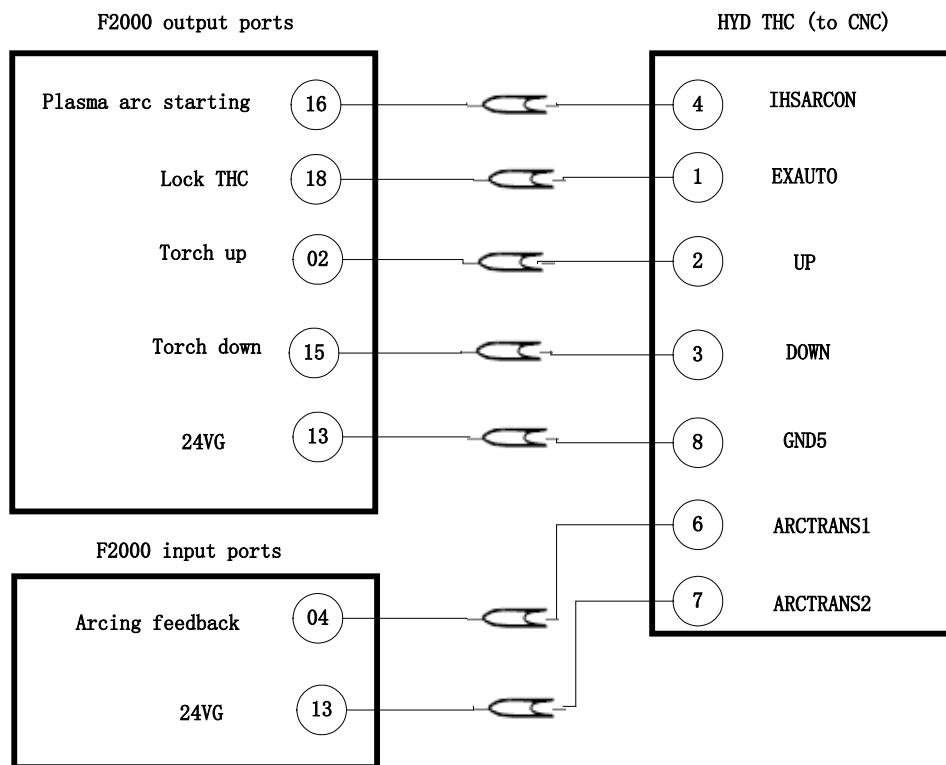
Appendix fig 2.6 Plasma IO timing sequence 2

## Appendix 3 Interpretation of Wiring Connection between F2000 Series and Common THC

### A3.1 Connection with F1620/F1630 THC



## A3.2 Connection with HYD THC



Plasma parameter	Range of value	Recommended value
Delay Before Arc	0	0
Pierce time	0	0
Torch up time	0-3	3
Arcing Check Time:	5-30	30
Position check Time:	0	0
Speed to lock THC	90-100	95
Distance to lock THC	0-15	10
Lose arc delay	0-1	0.5
Watch arc enable	Yes	Yes

The method of setting parameter:

F2100T, F2300T (A/B), F2500T (A/B), F2600T:

F4 (Setups), F3 (Plasma).

### Input definition

	Port	Type
Position detect	05	●

### Output definition

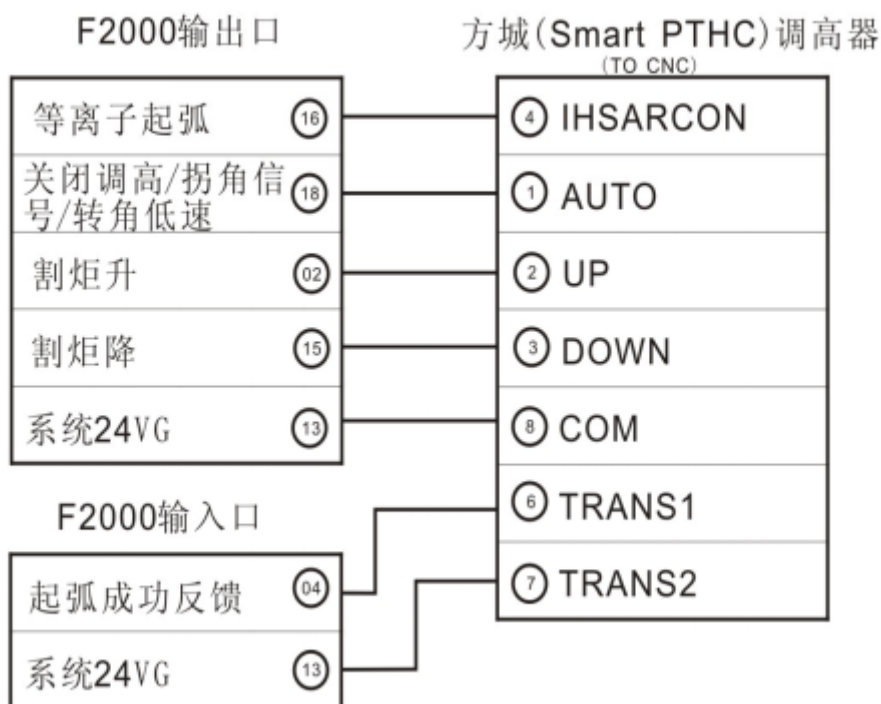
	Port	Type
Lock THC	18	●

The method of definition:

F2100T, F2300T (A/B), F2500 T (A/B), F2600T:

F5(Diagnose), F8(System Def), F3(define), input password: 1396.

### A3.3 Connection with Fangcheng Technology THC



Plasma parameter	Range of value	Recommended value
Delay Before Arc	0	0
Pierce time	0	0
Torch up time	0-3	3
Arcing Check Time:	5-30	30
Position check Time:	0	0
Speed to lock THC	90-100	95
Distance to lock THC	0-15	5
Lose arc delay	0-1	1
Watch arc enable	Yes	Yes

The method of setting parameter:

F2100T, F2300T (A/B), F2500T (A/B), F2600T:

F4 (Setups), F3 (Plasma).

Input definition

	<b>Port</b>	<b>Type</b>
Position detect	05	NC

Output definition

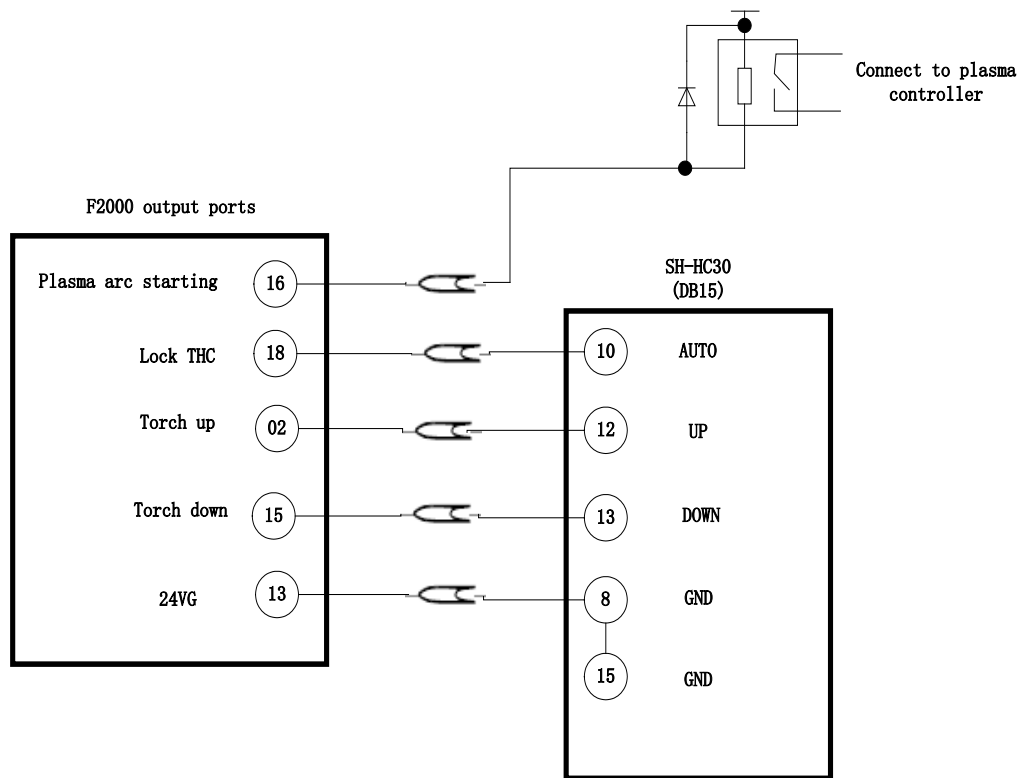
	<b>Port</b>	<b>Type</b>
Lock THC	18	NO

The method of definition:

F2100T, F2300T (A/B), F2500 T (A/B), F2600T:

F5(Diagnose), F8(System Def), F3(define), input password: 1396.

### A3.4 Connection with START THC SH-HC30



Plasma parameter	Range of value	Recommended value
Delay Before Arc	0	0
Pierce time	0-3	According to thickness of plating
Torch up time	0-3	3
Arcing Check Time:	0	0
Position check Time:	3-30	15
Speed to lock THC	90-100	95
Distance to lock THC	0-15	10
Lose arc delay	0-1	0.5
Watch arc enable	No	No

The method of setting parameter:

F2100T, F2300 T (A/B), F2500 T (A/B), F2600T:

F4 (Setups), F3 (Plasma).

Input definition

	Port	Type
Position detect	05	NC

Output definition

	Port	Type
Lock THC	18	NC

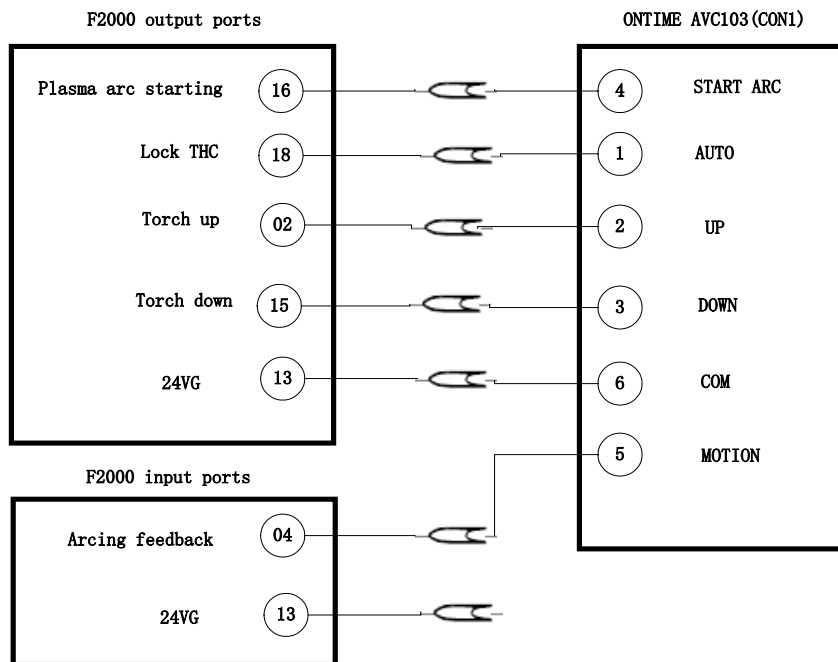


The method of definition:

F2100T, F2300 T (A/B), F2500 T (A/B), F2600T:

F5 (Diagnose), F8 (System Def), F3 (define), input password: 1396.

### A3.5 Connection with ONTIME THC



Plasma parameter	Range of value	Recommended value
Delay Before Arc	0	0
Pierce time	0	0
Torch up time	0-3	3
Arcing Check Time:	5-30	30
Position check Time:	0	0
Speed to lock THC	90-100	95
Distance to lock THC	0-15	10
Lose arc delay	0-1	0.5
Watch arc enable	Yes	Yes

The method of setting parameter:

F2100T, F2300 T (A/B), F2500 T (A/B), F2600T:

F4 (Setups), F3 (Plasma).

#### Input definition

	Port	Type
Position detect	05	NC

#### Output definition

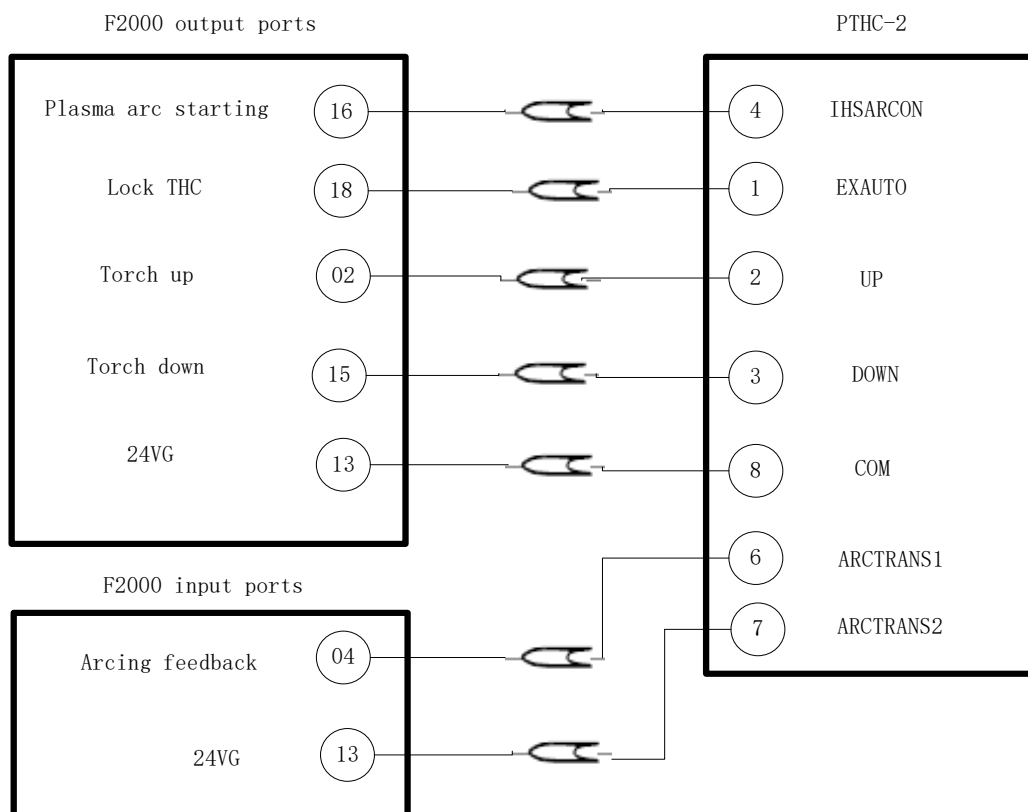
	Port	Type
Lock THC	18	NO

The method of definition:

F2100T, F2300 T (A/B), F2500 T (A/B), F2600T:

F5 (Diagnose), F8 (System Def), F3 (define), input password: 1396.

### A3.6 Connection with PTHC-2



Plasma parameter	Range of value	Recommended value
Delay Before Arc	0	0
Pierce time	0	0
Torch up time	0-3	3
Arcing Check Time:	5-30	30
Position check Time:	0	0
Speed to lock THC	90-100	95
Distance to lock THC	0-15	10
Lose arc delay	0-1	0.5
Watch arc enable	Yes	Yes

The method of setting parameter:

F2100B, F2300 A/B, F2500 A/B, F2600:

F4 (Setups), F3 (Plasma).

Input definition

	Port	Type
Position detect	05	NC

Output definition

	<b>Port</b>	<b>Type</b>
Lock THC	18	NO

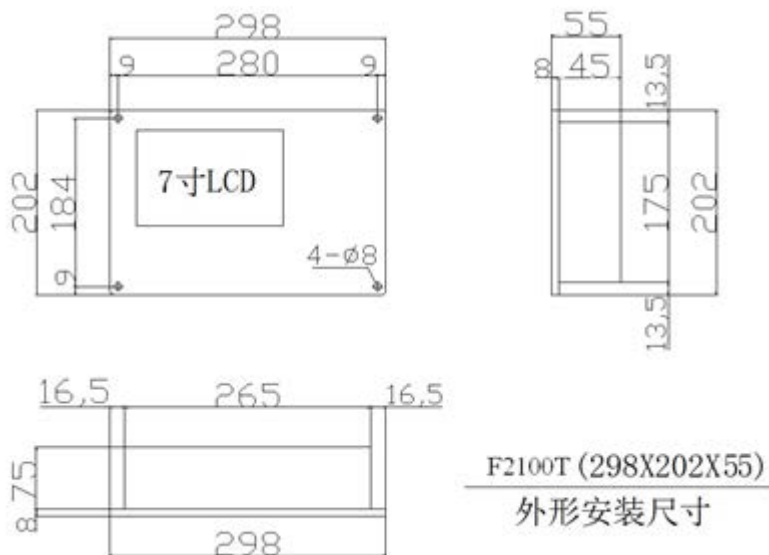
The method of definition:

F2100B, F2300 A/B, F2500 A/B, F2600:

F5 (Diagnose), F8 (System Def), F3 (define), input password: 1396.

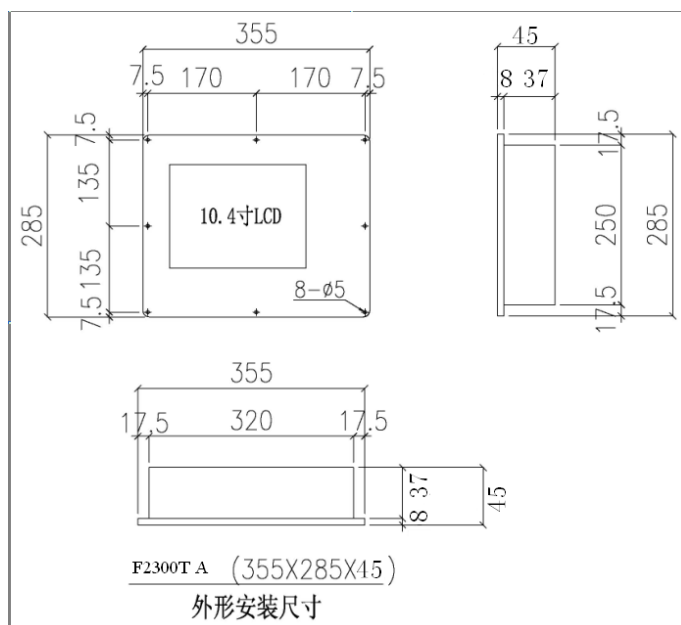
## Appendix 4 Interpretation of F2000 Full Series System Install Size

### A4.1 F2100B/T Profile Install Size

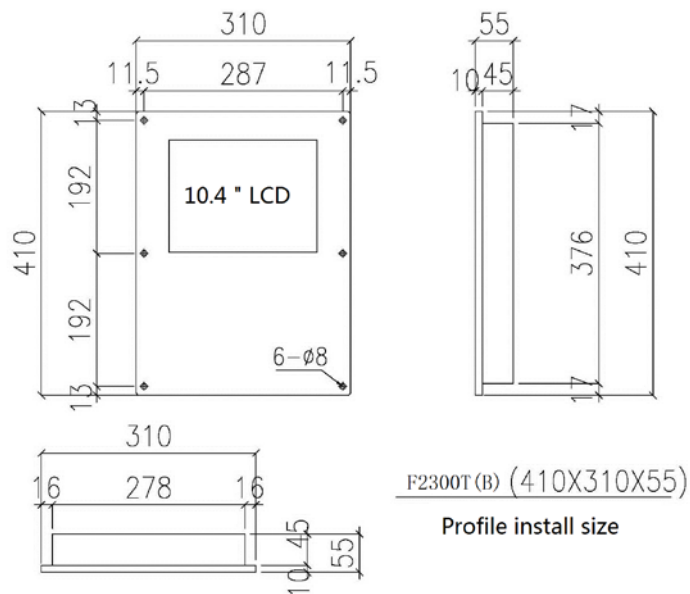


Appendix fig.4.1 F2100B/T installation size

### A4.2 F2300A/B/T Profile Install Size

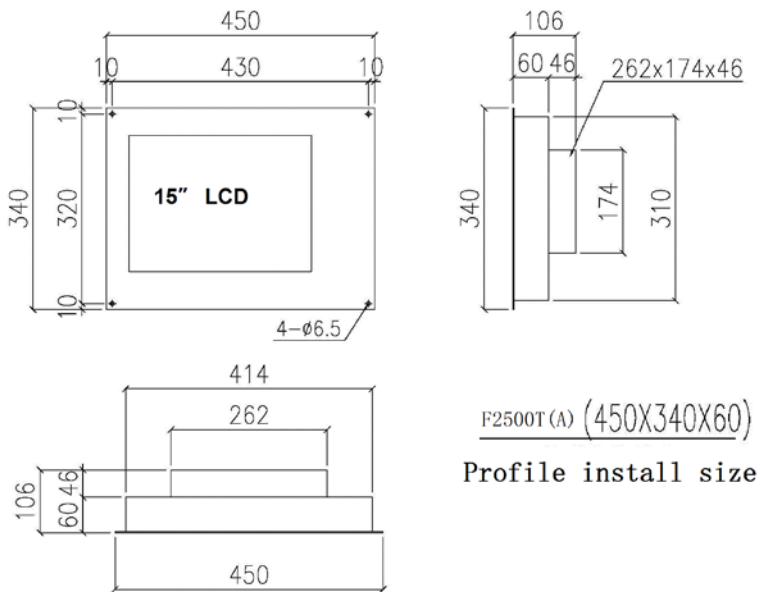


Appendix fig.4.2 F2300A/TA installation size

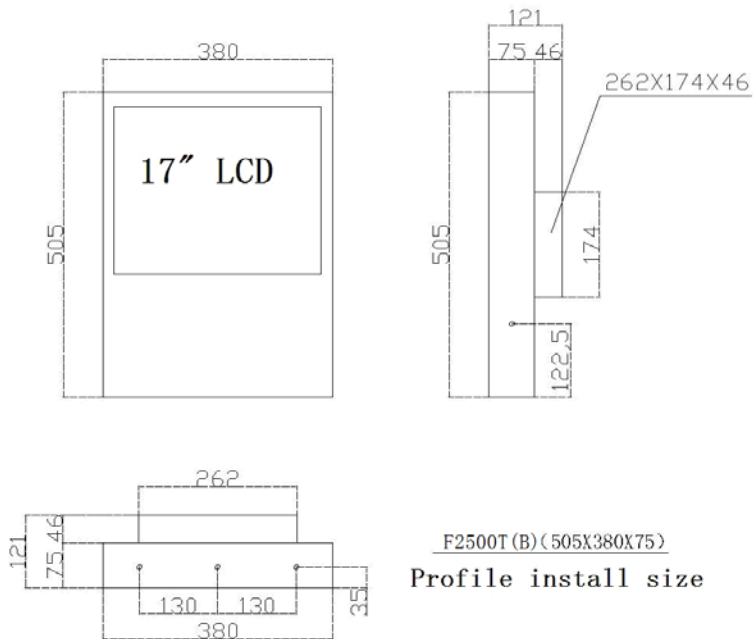


Appendix fig.4.3 F2300B/TB installation size

### A4.3 F2500A/B/T Profile Install Size

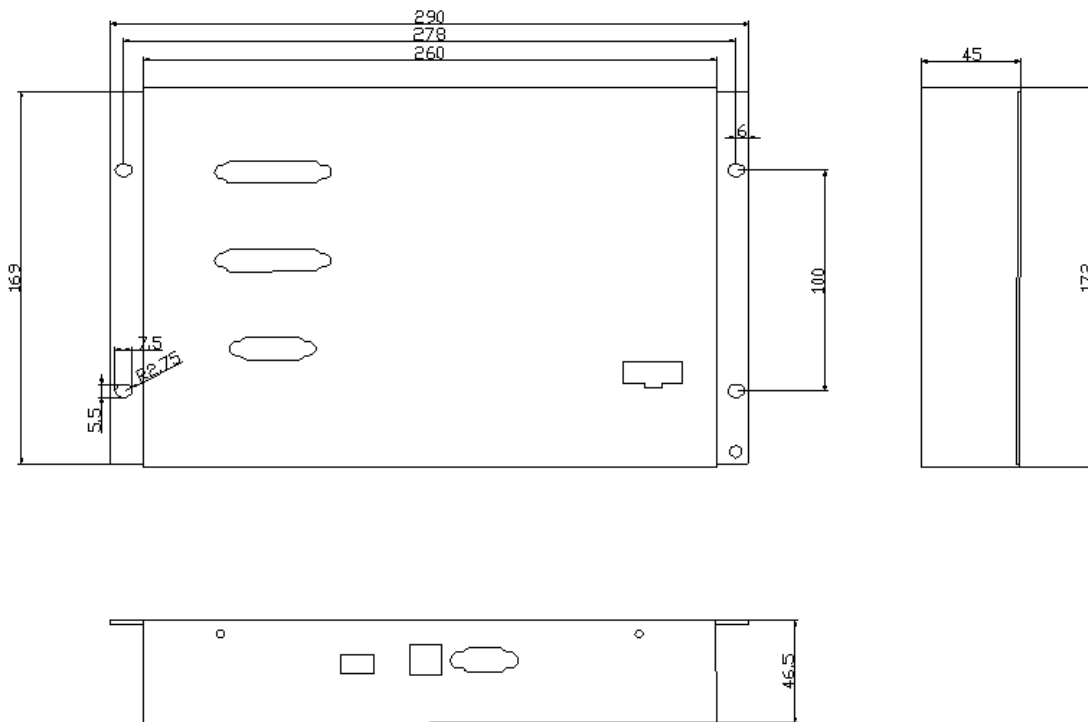


Appendix fig.4.4 F2500A/TA installation size



Appendix fig.4.5 F2500B/TB installation size

### A4.4 F2600/T Profile Install Size



Appendix fig.4.6 F2600/T installation size



## Appendix 5 Common Problems

<b>Error Code</b>	<b>Fault performance</b>	<b>Reasons</b>	<b>Solutions</b>
No	X, Y axis-motor not move	1. Wiring error 2. Motor chip is broken	1. Detection of wiring 2. Refer to A5.1
No	X, Y axis-move in opposite direction	1. Wiring error 2. Wrong parameter setting	1. Detection of external wiring 2. Refer to section 8.7.5, change motor direction
No	X, Y axis-move towards only one direction	1. Wiring error 2. Servo parameter setting is wrong 3. motor chip is broken	1. Detection of wiring 2. Detection of servo parameter setting: Is motor control mode set as pulse+direction 3. Refer to A5.1
No	X, Y axis interact	1. Wiring error 2. Wrong parameter setting	1. Detection of external wiring 2. Refer to section 8.7.5, set parameter "XY interchange" as "YES"
No	X, Y axis-motor sometimes turn, while sometimes not	1. system and motor plug contact undesirable 2. Motor chip is rosin joint	1. Plug the motor interface 2. Return to factory maintenance
No	Cutting graphics is smaller than normal	1. Pulse setting error 2. Mechanical problem	1. F5 system parameter of the pulse number is too small 2. Detection of mechanical
No	Cutting graphics is bigger than normal	1. Pulse setting error 2. Zero drift 3. Mechanical problem	1. Adjust the pulse number of F5 system parameter 2. Well grounding jacketed&magnetic ring 3. Detection of mechanical
No	Cutting size of inner circle and outer circle size are not correct	The kerf setting is too large or too small	Reset the kerf value
No	Cutting parts size suddenly large and small	1. Mechanical problem 2. Electrical matching problem	1. Check gear, gear rack and the speed reducer 2. Pulse signal matching problem of system and driver, Parallel 4.7K-10K resistance at both ends of Pul+ and Pul-
No	All input ports have no response	Wiring error, public end is wrong	Check the wiring, input public end should be P13 or P15 of the CN1, Input power

			24V-
No	Individual input port has no response	1. Wiring error, public end is wrong 2. Input port is broken	1. Check the wiring, input public end should be 0V 2. Read Appendix A5.2
No	Automatic interface crash after boot	1. File error 2. Parameter error	1. Boot to welcome picture, press DEL to enter 2. Parameter recovery (F5diagnose, F8definition, F1 recovery)
No	crash after entering file management	File system error	1. Factory settings (press F5, F8, F8, press F4 in pop-up window, password 6931) 2. Empty code (press F5, F8, F8, press F7 in pop-up window)
No	once boot on, it moves towards one direction	Eight remote control ports(NO and NC ports) on the right side of the input port are opposite	Refer to A5.3
No	Manual move tip: hard limit alarm	1. Four limit of input port NO&NC are opposite 2. Machine tool meet the hard limit	1. Read Appendix A5.4 2. Cancel the alarm limit
No	Manual move tip: emergency stop	1. Emergency stop button is pressed 2. Input port emergency stop NO&NC are opposite	1. Emergency stop button restoration 2. Refer to A5.5
No	No action after the start of plasma cutting	1. Positioning input signal back 2. Arc output port bad 3. Edge perforation setting 4. Arc time set to 0 5. DSP program missing	1. Refer to Appendix A5.6 2. Refer to Appendix A5.7 3. Change this parameter in the parameter settings 4. Set up arc time 5. Upgrade program
No	Collision tip, but no collision happens	1. Interference 2. Collision switch	1. Control jamming source 2. Detect collision switch
No	Collision warning tip	Cutting torch hit the plate	Improve the cutting torch position
No	All output ports can not open	1. Wrong connect of public output port end 2. U50/U51 chip burning	1. Check connection 2. Replacement chip
No	Individual output port can not open	Output port damage	Refer to Appendix A5.8
No	“Close the height adjust corner signal”	1. NO&NC are opposite for closing the height adjust	1. Refer to Appendix A5.8 2. Recommend parameter

	not open at the corner	corner signal 2. Wrong setting of speed shut down and closing height-adjust minimum distance in plasma parameter	speed closing height-adjust is set to 95% 3. The minimum distance is 5mm
No	Motor's four directions have no action	1. Motor or driver is bad 2. Wrong connection from system to driver 3. Motor chip is bad 4. Speed is set to 0 5. DSP loss	1. Check motor and driver 2. Check connection 3. Replace motor chip 4. Set speed 5. Upgrade program
No	Movement direction is opposite	1. Line pick reverse 2. Servo parameter error 3. System settings error	1. Check line 2. Adjust servo parameters 3. Refer to section 8.7.5 for modifying system parameters
No	Positive and negative poles of a certain axis go towards one direction	Motor chip destroy	Replace motor chip
No	Some axis only one button can move	1. Servo parameter 2. Motor chip destroy	1. Adjust servo parameter 2. Replace motor chip
No	Motor walk short	1. Pulse equivalent 2. Mechanical problem	1. Adjust precision 2. Adjust machinery
No	Motor walk more	1. Pulse equivalent 2. Zero drift 3. Mechanical problem	1. Adjust precision 2. Add magnet ring for servo encoder line 3. Adjust machinery
No	Fail to open file	1. Check file format 2. Version is old	1. Refer to the various formats of the instruction manual 2. Program upgrade
No	Edit file, can't edit file tip	No file in hard disk	Put at least one file in hard disk
No	Keyboard keys no action	1. Wrong interface 2. Keys destroy	1. Go to the right interface 2. Replace keyboard keys
No	Keyboard hang in the balance	Keyboard line loose	Plug keyboard line
No	Keyboard has no action	1. Code card damage 2. Keyboard wire loose 3. Foreign body stuck	1. Press DEL after boot to the welcome screen 2. Plug in keyboard line 3. Removal of foreign body
No	U disk insertion no response	1. U disk is bad 2. USB interface is bad 3. USB connecting wire loose	1. Replace U disk 2. Replace USB line 3. Plug in USB line

No	Tip open file failed	1. File format is incorrect 2. Folder deleted	1. Check if file format is TXT, CNC, NC, etc. 2. Make new folder
No	Tip no file	1. File format is incorrect 2. No file in U disk 3. U disk format is incorrect	1. Check if file format is TXT, CNC, NC, etc. 2. Check if there's a file in U disk, if the file is under root of U disk 3. Format the U disk into FAT or FAT32 format
No	Tip "can't edit file"	No file in hard disk, at least put one file in it	Copy one file from U disk to hard disk
No	Tip "cutting speed error"	Speed in common parameters exceed the max speed of system	Adjust the max cutting speed limit in system parameters
No	Tip "manual shift speed error "	Speed in common parameters exceed the max speed of system	Adjust the max speed limit of manual shift in system parameters
No	Tip "empty range shift car speed error"	Speed in common parameters exceed the max speed of system	Adjust the max speed limit of empty range shift car in system parameters
No	Tip "Cutting slot error, clear cutting slot"	The slot value exceeds the introduction of cutting graphics or the minimum radius of a circular arc in a graph	1. Modify the introduction of lead 2. Reduce the slotting compensation value 3. Delete the small arc inside the graphics
No	Tip "parameter import failed "	1. There is no parameter file in the U disk. 2. USB interface problem 3. U disc problem	1. Detection of U disk to find F2300.DAT file 2. Detection of USB interface 3. Replace U disk
No	Tip "parameter export failed "	1. U disk is not plugged well 2. U disc problem	1. Re plug U disk 2. Replace U disk
No	Tip "please insert U dick" when upgrading program	1. Not insert U disk when upgrading program 2. USB interface problem 3. U disc problem	1. Please insert the U disk before upgrading 2. Replace USB interface 3. Replace U disk
No	Tip "Upgrade file not found" when upgrading program	1. U disk has no upgrade file 2. The upgrade file is not on the root directory of U disk	1. Check if there's upgrade file in U disk 2. Put the upgrade file on the root directory of U disk
No	Tip "upgrade fail"	Upgrade failed	Re upgrade after reboot
Error code 0	Tip "error code 0"	Encryption time expires	Need to decryption

No	Blank screen after booting	<ol style="list-style-type: none"> <li>1. The system is not powered</li> <li>2. Insufficient supply voltage</li> <li>3. 3A fuse is bad</li> <li>4. Motherboard does not start</li> </ol>	<ol style="list-style-type: none"> <li>1. Test switch power supply</li> <li>2. Detection of DC24V voltage</li> <li>3. Replace fuse</li> <li>4. Send back to replace motherboard</li> </ol>
No	Appear white screen, flower screen, flash screen after booting	<ol style="list-style-type: none"> <li>1. Drive plate destroy</li> <li>2. Display destroy</li> <li>3. Cable loosening</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace drive plate</li> <li>2. Change display screen</li> <li>3. Re plug display cable</li> </ol>

## A5.1 Motor Chip Detection

### 1. X axis motor not move, you can test system CN3 socket according to the following four cases:

- The measurement of running state, the correct voltage for pins 1 and 9 should be DC 3V-3.5V
- The measurement of stop state, the correct voltage for pins 1 and 9 should be DC 3V-3.5V
- The measurement of running state, the correct voltage for pins 2 and 10 should be DC 0V
- The measurement of stop state, the correct voltage for pins 2 and 10 should be DC 3V-3.5V

If one of the above four cases is not correct, motor chip is bad. Then it should be sent back to factory for maintenance.

### 2. Y axis motor not move can test system CN3 socket according to the following four cases:

- The measurement of running state, the correct voltage for pins 3 and 11 should be DC 3V-3.5V
- The measurement of stop state, the correct voltage for pins 3 and 11 should be DC 3V-3.5V
- The measurement of running state, the correct voltage for pins 4 and 12 should be DC 0V
- The measurement of stop state, the correct voltage for pins 4 and 12 should be DC 3V-3.5V

If one of the four cases is not correct, motor chip is bad. Then it should be sent back to factory for maintenance.

## A5.2 Input Port Detection

If individual input port has no response, please enter into input diagnose interface to check.

Press F5(system diagnose) to enter input diagnose interface

Input					
	Serial No.	Type		Serial No.	Type
Forward Limit	02	●	Move Up Input	09	●
Back Limit	15	●	Move Down Input	10	●
Right Limit	14	●	Move Left Input	07	●
Left Limit	01	●	Move Right Input	08	●
Emergency Stop	03	●	Acceleration Input	16	●
Arc Feedback	04	●	Deceleration Input	17	●
Position Detect	05	●	Torch Up Input	18	●
Plasma Collision	06	●	Torch Down Input	19	●

Serial No. —PgUp, PgDn change      Type—Enter change

F1Input	F2Output		F5Keyboard Diagnose	F6Self Check	F7DateTime	F8System Definition
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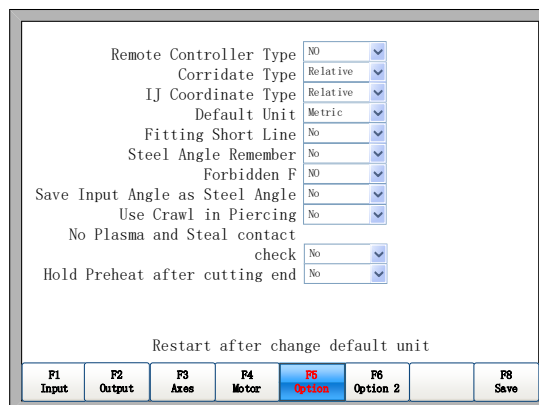
You can connect the input corresponding to CN1 pin number (such as the front limit of 02 foot) with 0V (CN1-13 number foot) to make short test:

- If input the corresponding input port into the diagnose, with change of status indicator, then it is normal.
- If input the corresponding input port into the diagnose, with no change of status indicator, then it is abnormal.

Please redefinition of input port.(refer to operation manual V2.1, section 8.7.2)

## A5.3 Remote Controller Type Problem

Machine walks on its own after powering to system, usually because of the incorrect settings of remote type by YES, and "forward" "back" "left" "right" all have signal.



Please set remote controller type to NO.

## A5.4 Hard Limit Alarm Problem

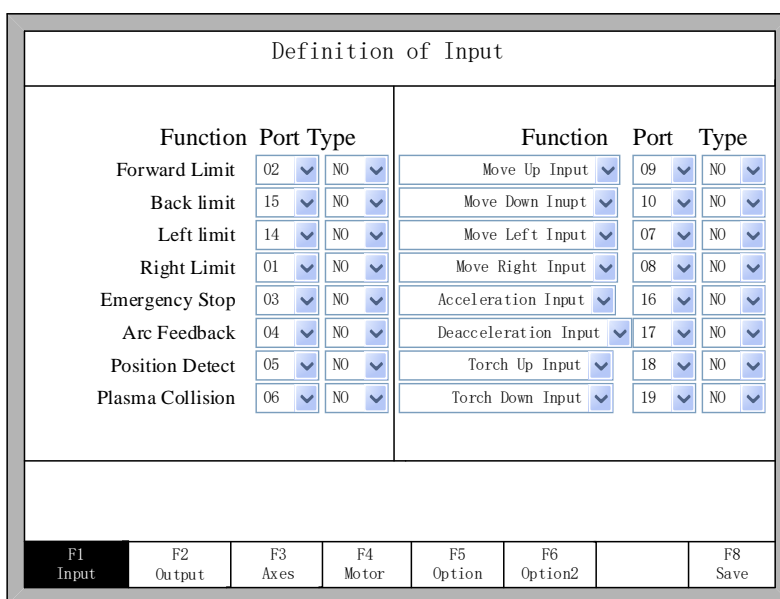
### Tip: hard limit alarm

If machine doesn't collide the limit, it's usually caused by the opposite connection of input port NO&NC. You can enter into system input definition to modify:

Press F5 (System diagnose)

F8 (system definition)

F3 (definition) password: 1396, modify the condition of input port NO and NC



Eg. If back limit has limit alarm, you can set "back limit" to the opposite side, that is, red to green or green to red.

## A5.5 Emergency Stop Alarm Problem

### Tip: emergency stop

If the emergency stop button is not pressed down, it's usually caused by the opposite connection of NO and NC for emergency stop alarm signal.

You can enter into system input definition to modify:

Press F5(System diagnose)

F8(system definition)

F3(definition) password: 1396, modify the input type of emergency stop in system definition interface.

Definition of Input								
Function	Port	Type	Function	Port	Type			
Forward Limit	02	NO	Move Up Input	09	NO			
Back limit	15	NO	Move Down Input	10	NO			
Left limit	14	NO	Move Left Input	07	NO			
Right Limit	01	NO	Move Right Input	08	NO			
Emergency Stop	03	NO	Acceleration Input	16	NO			
Arc Feedback	04	NO	Deacceleration Input	17	NO			
Position Detect	05	NO	Torch Up Input	18	NO			
Plasma Collision	06	NO	Torch Down Input	19	NO			

F1 Input	F2 Output	F3 Axes	F4 Motor	F5 Option	F6 Option2		F8 Save
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You can set “emergency stop” type to the opposite side, that is, NC to NO,NO to NC.

## A5.6 THC Problem

Usually, common arc voltage THC has two types: with the initial positioning function and without initial positioning function.

1. System plasma parameter settings for THC with initial positioning function are as follows:

- The detection time is set to 0
- The location rise time is set to 0



●The diagnosis successful feedback status indicator for input interface positioning must be green as the interface:

Input					
	Serial No.	Type		Serial No.	Type
Forward Limit	02	●		Move Up Input	09 ●
Back Limit	15	●		Move Down Input	10 ●
Right Limit	14	●		Move Left Input	07 ●
Left Limit	01	●		Move Right Input	08 ●
Emergency Stop	03	●		Acceleration Input	16 ●
Arc Feedback	04	●		Deceleration Input	17 ●
Position Detect	05	●		Torch Up Input	18 ●
Plasma Collision	06	●		Torch Down Input	19 ●
Serial No. —PgUp, PgDn change			Type—Enter change		
F1Input	F2Output			F5Keyboard Diagnose	F6Self Check
				F7DateTime	F8System Definition

2. System plasma parameter settings for THC without initial positioning function are as follows:

- The detection time is set to 15S
- The location rise time is set to 0.8S
- The diagnosis successful feedback status indicator for input interface positioning must be green as the interface:

Input					
	Serial No.	Type		Serial No.	Type
Forward Limit	02	●		Move Up Input	09 ●
Back Limit	15	●		Move Down Input	10 ●
Right Limit	14	●		Move Left Input	07 ●
Left Limit	01	●		Move Right Input	08 ●
Emergency Stop	03	●		Acceleration Input	16 ●
Arc Feedback	04	●		Deceleration Input	17 ●
Position Detect	05	●		Torch Up Input	18 ●
Plasma Collision	06	●		Torch Down Input	19 ●
Serial No. —PgUp, PgDn change			Type—Enter change		
F1Input	F2Output			F5Keyboard Diagnose	F6Self Check
				F7DateTime	F8System Definition

## A5.7 Plasma Arc Starting Problem

The method of testing the normal working for plasma arc output is as follows:

1. Press F5(system diagnose)

F2(output) open plasma arc port

2. Plasma arc status indicator should be green after press “F3 open”

输出诊断			
	序号	类型	
点火开关	03	●	排气口
低压预热 (默认)	01	●	电容调高盒使能
高压预热	17	●	等离子定位
低压切割氧 (一级)	04	●	等离子起弧
中压切割氧 (二级)	05	●	关闭调高(拐角信号)
高压切割氧 (三级默认)	14	●	喷粉
割炬升	02	●	扬粉
割炬降	15	●	喷粉预热
			06 ●
			08 ●
			19 ●
			16 ●
			18 ●
			07 ●
			20 ●
			21 ●

F1输入	F2输出	F3打开	F4关闭				
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3. Test system's back output socket CN2 pin 16 foot and common end pin (12 or 24 foot) to see if there's DC24V voltage.

- If there's DC24V voltage, plasma arc port is normal
- If there's no DC24V voltage, plasma arc port is burnout. Please redefine the output port. ((refer to operation manual V2.1, section 8.7.3)

## A5.8 Input/Output Problem

The method of testing the normal working of individual output port is as follows:

1. Press F5(system diagnose), F2(output)

输出诊断			
	序号	类型	
点火开关	03	●	排气口
低压预热 (默认)	01	●	电容调高盒使能
高压预热	17	●	等离子定位
低压切割氧 (一级)	04	●	等离子起弧
中压切割氧 (二级)	05	●	关闭调高 (拐角信号)
高压切割氧 (三级默认)	14	●	喷粉
割炬升	02	●	扬粉
割炬降	15	●	喷粉预热
F1输入	F2输出	F3打开	F4关闭

## 2. Open the output port for testing

Open system back output CN2's corresponding output pin number (e.g. "ignition switch" pin 03) and public port(12 or 24 feet) to check the correct voltage DC 24V.

- If there's no voltage, output port is burnout.
- If it's not correct, please redefine the output port. (refer to operation manual V2.1, section 8.7.3)

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