



PCL - USER MANUAL

		between 1 and 10
Comment	;	Comment

Number of line only at the beginning of the profile

Parameter	Meaning
P10	Piercing height [mm]
P11	Piercing delay [s]
P12	Cutting height [mm]
P13	High control activation delay [s]
P14	Arc voltage [V]
P15	Cutting speed [mm/minute]
P16	Torch high during rapid [mm]
P17	Cutting current [A] (optional)
P18	Current reduction percentage [%] (optional)
P19	Kerf [mm]
P20	X min
P21	X max
P22	Y min
P23	Y max
P24	Marking speed

Note

Activate a file means always to load it into memory.

4 Marker

The marker (dust, arcwriter, puncher,...) moves in the directions X and Y together with the plasma torch but it has, in comparison to it, a certain offset (both X and Y). This offset has to be set among the machine parameters.

The activation of a different technology from the plasma involves the contemporary activation of the offset correspondent.

The zero is always reported to the plasma, in other words even if a plan is done only to mark (event besides very unlikely) the zero of the plan must be done in comparison to the plasma torch.

At the beginning of the program the technology active is always plasma.

The compensation is not applied to the marking (often open profiles or points).