

Plasma table general instructions

Hook up air line, Fill table using ball valve, ensure gate valve is closed. (only turn ball valve 45 degs to not over-pressurize) once water begins to bubble close ball valve.

Ensure computer is on (login:txrx password:hack1t4tw)

ensure plasma table software is open (plasmazilla icon on desktop with penguin, if software is already open there will be a tab named gmoccapy no need to open multiple times)

Insert usb (each time a new usb is inserted it must be opened from the desktop by double clicking before use)
With gmoccapy window in front, turn machine on (power button on right side of screen)

Check that machine is homed (position readouts [x,y,z] should be green if they are red home machine)

(To home, enter jogging menu, [arrow menu on right hand side of screen], move z axis up to clear table and work using page up key, use arrow keys to move machine near to back left corner, choose homing menu left button on bottom panel and choose home all button, left button on bottom panel, wait for homing routine to finish and then exit homing menu by choosing return error on bottom right side of panel.)

Load material.

Use jog keys to move machine out to allow access for consumables, install correct set of your consumables

Turn on plasma cutter and ensure you set amperage per your consumable, don't forget to set pilot arc or constant pilot arc mode on selector switch.

Jog machine to x,y,z start point on material, lower head to within 1" of table, switch to touch off mode (second button from left along bottom panel.) Click x, y, z zero button along bottom panel in order and make sure position readout changes to 0,0,0. Click return arrow on right side of bottom panel.

Change to run mode (machine to table icon middle button of right button panel)

Choose load folder on right side of bottom panel.

Find file and double click on it in window (files posted on machine will be in /home/txrx/linuxcnc/nc_files files on usb drives will be under /media/usb or /media/usb0)

check Overrides are correct (in general over volt set to 15, over volt checked, pierce delay unchecked, pierce height unchecked, voltage unchecked, ensure the button is pushed, ensure torch control button is not pushed)

press play!

Drain table and remove material when done, turn off plasma cutter and turn off power button in software.

Notes: if you change consumables while the plasma cutter is on then you will have to power cycle it as it enters an error state. Incorrect settings will lead to failed cuts and waste materials. If water is low use hose to add water to table. if torch is too low during homing or jogging it may hit table or edges of table or material, always check and raise it before moving in x/y direction.

if facing table from operator terminal side standing along long edge, x- is left, x+ is right, y- is toward operator, y+ is away from operator. home position is front left corner. Use caution when driving to home machine if not homed as you can run it into things.