

Active

50000 | 6mm | PSF3-6 | 405mm/min 1,6 mm kerf ...

✓ All 1 2 3 4 5
6 7 8 9 10

FLAME

PROCESS

[bar]

H-O 4,0

F-G 0,20

C-O 0,0

[s]

30

reload

[mm]



8 ON



optional



Preheat

Active

50000 | 6mm | PSF3-6 | 405mm/min 1,6 mm kerf ...

✓ All

1

2

3

4

5

6

7

8

9

10

FLAME

PROCESS

Flame (H-O)

1.5

minus

plus

Flame (H-O)

1.5

minus

plus

Flame (H-O)

1.5

minus

plus

☰

5



!

Preheat

30

PREHEAT

Level 0

CUTTING DATA
Process
Brenner 1: <input checked="" type="checkbox"/> Enabled
Flame Setting
Height Setting
 Einstellungen 

HEIGHT SETTING

50000 | 6mm | PSF3-6 | 405mm/min 1,6 mm kerf ...

✓ All	1	2	3	4	5
6	7	8	9	10	






IGNITE

PEHEATE

PIERCE

CUT

HEAT

		HEIGHT [mm]		
H-O	4,0			Manual Calibration Mode
F-G	0,20		8 ON CALIB	
C-O	0,0			Height Mode Sensor/Program



Preheat

FLAME SETTING

50000 | 6mm | PSF3-6 | 405mm/min 1,6 mm kerf ...

✓ All 1 2 3 4 5
6 7 8 9 10

IGNITE

PEHEATE

PIERCE

CUT

HEAT


Flame (H-O) 1.5
minus plus

Flame (H-O) 1.5
minus plus

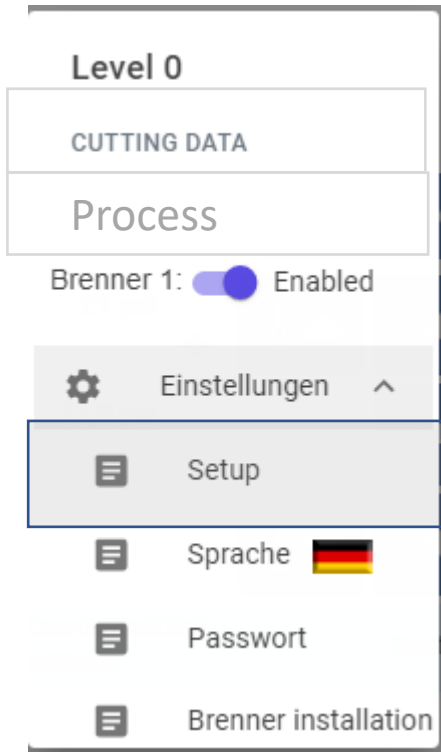
Flame (H-O) 1.5
minus plus



Preheat

ID	Material	Remark	Thick [mm]	Nozzle:	 Speed [mm/min]
1	Mild Steel	Piercing with Height sensor	3	PSF 3-6	780
50001	Mild Steel	Piercing with Height sensor	3	PSF 3-6	780
50002	Mild Steel	Edge start with Height Sensor	3	PSF 3-6	780
50003	Mild Steel	Piercing with Height sensor	4	PSF 3-6	760
50004	Mild Steel	Edge start with Height Sensor	4	PSF 3-6	760
50005	Mild Steel	Piercing with Height sensor	5	PSF 3-6	740

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Parameter	Value
Abstands Kalibrierung	
Taktile Erstfindung	<input checked="" type="checkbox"/> Enabled
Abstand für Kalibrierung	0,31 inch
Position	0,00 inch
Abstands Kalibrierung gültig	Ja
Abstands Kalibrierung aktiv	Nein
Rückzugsposition	
Rückzugsposition	10 inch
Rückzugs-position freischalten	<input checked="" type="checkbox"/> Enabled
Schlacke	
Slag Sensitivity	Default
Verspülung	
Verspülung starten	<button>Start</button>
Verspülung aktiv	Nein
Preflow active time	0 s
Lochstechen	
Piercing Height Control	<input checked="" type="checkbox"/> Enabled
Abstandsregelung	
Abstandsregelung aktiv	Nein
Position	0,00 inch
Status Height Control	Aus

ID	Material	Remark	Thick [mm]	Nozzle	Speed [mm/min]
1	Mild Steel	Piercing with Height sensor	3	PSF 3-6	780

1	Mild Steel	Piercing with Height sensor	3	PSF 3-6	780
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DUPLICATE

EDIT

DELETE

LOAD

50004	Mild Steel	Edge start with Height Sensor	4	PSF 3-6	760
50005	Mild Steel	Piercing with Height sensor	5	PSF 3-6	740

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	Ignition	PreHeating	Piercing	Cutting
H-O [bar]	1.5	3	3	1.2
C-O [bar]			2	2
F-G [bar]	0.2	0.3	0.3	0.2
Clearance [mm]		3	5	3
Time [s]		5	0.1	
Ignition flame adjust [%]	100			
Cutting Speed [mm/min]				780

CANCEL

SAVE

Safe actual dataset

Safe dataset

Replace existing

Duplicate existing and safe

Cancel

Always show data that are changed
(from database and modified in stations)

Select parameter that should be saved

Example:

	DB	1	2	3	4	5	6	7	8	9	10
H-O Ignition	1,5				1,4						
H-O PreHeat	3,0	3,1		2,9							
H-O Cut	1,2			1,0							
C-O Cut	2,0		3,0								

Select

Safe


Cancel

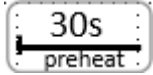
	Ignition	PreHeating	Piercing	Cutting
H-O [bar]	1.5	3	3	1.2
C-O [bar]			2	2
F-G [bar]	0.2	0.3	0.3	0.2
Clearance [mm]		3	5	3
Time [s]		5	0.1	
Ignition flame adjust [%]	100			
Cutting Speed [mm/min]				780

CANCEL

SAVE

Comments Active Process

- Active = Start Process on from CNC
- Idle = Start Process off from CNC
- Everything is Automatic
- Process step is in info line
- 30 sec preheat, press button to reload, slider to indicate remaining time, active during preheat
-  start piercing, active during preheat
- Manual up should be hard wired by customer

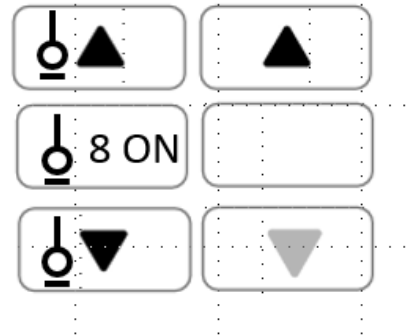


Active Process

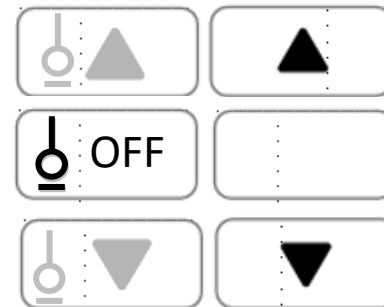
Start Process= ON

Height Control = ON

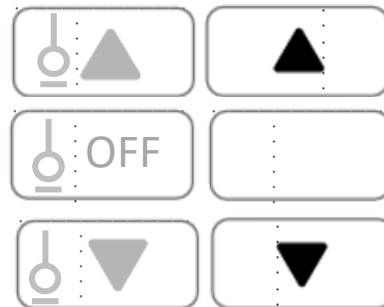
Manual Up/Down Optional,
wenn CNC Manual Up/Down nicht steuert



Height Control = OFF



Start Process = off



Alarm Acknowledgement

- Option 1
 - Select station with Alarm (e.g. press station 2)
- Option 2
 - Press Alarm Button
- Alarm Button
 - Alarms, warnings, information
 - Alarm list
 - Button is red, when Alarm

