

CUT80 Arc voltage feedback adjusting method

1. CUT80(L210) Built-in 3 kinds of arc pressure feedback step-down ratio(20:1、 30:1、 50:1), factory setting is 20:1.

2. Arc pressure feedback step-down ratio setting method:

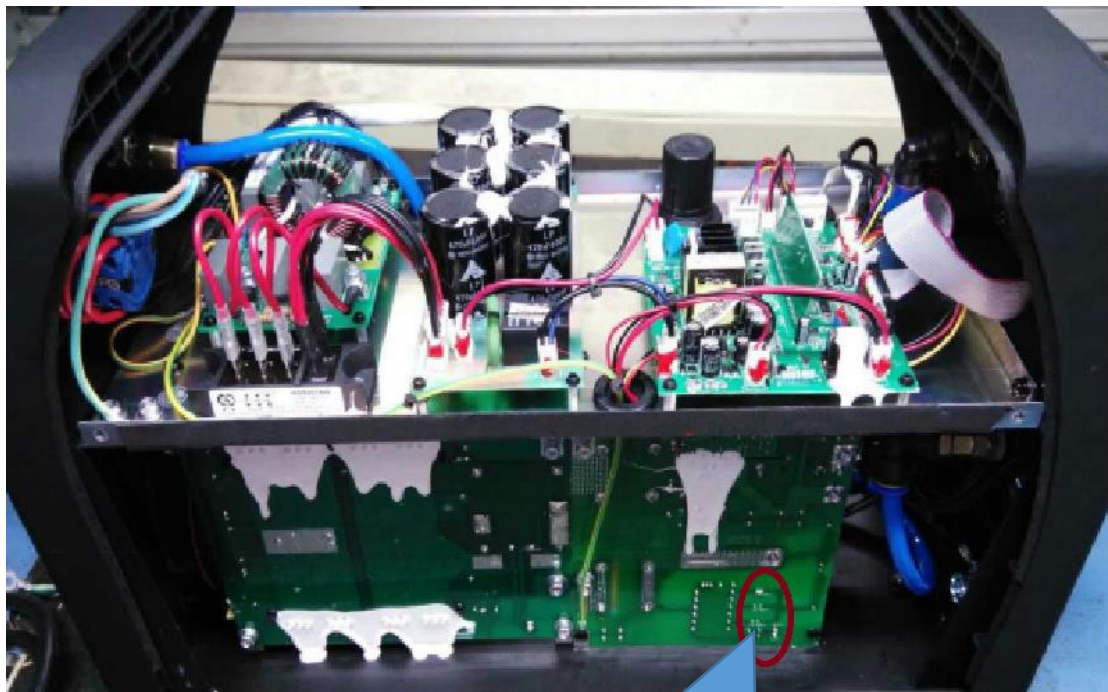
1)、 Open the machine cover, find the Striking Arc Board PH-228;

2)、 choose the required arc pressure step-down ratio in the circled of the figure below.

Needs 20:1, short circuit J1,

Needs 30:1, short circuit J2,

Needs 50:1, short circuit J3.



short circuit J1, step-down ratio is 20:1
short circuit J2, step-down ratio is 30:1
short circuit J3, step-down ratio is 50:1

Attention: each time can allow one kinds of step-down ratio only (that is, each time only can short circuit one circuit point), if change the arc pressure step-down ratio, have to cancel the original short circuit.

3. CNC interface is defined as follows

1)、 2 pin air socket, is for arc voltage signal output interface

Pin no.	function	remark
1	arc voltage feedback “+”	The arc voltage feedback is a fixed ratio output, initial setting is 20:1, can adjusted to 30:1 or 50:1 according to customer's requirements.
2	arc voltage feedback “-”	

2)、4 pin air socket, is for start signal input and striking success signal output.

Pin no	function	remark
1、 2	Start signal input	Normally open, open circuit voltage is 5 VDC. Need to dry contact closure activation at startup.
3、 4	Striking arc success signal output	Relay normally open contacts, closed while striking arc success. load capacity is 1A/30VDC, 0.5A/125V AC.