

Cutting Systems

Torchmate

This guide will walk you through setting up the Torchmate Driver Software to keep track of the amount of times the plasma on command is encountered. This will assist in keeping track of how long and how much use you are getting out of your torch consumables.

How to Set the Pierce Counter:

Go to Configuration > Tools > Tool Life Management.

🌌 Torchn	nate - No G-Cod	le File Open - Torchmate2.STP - Torchmate.tlg
File Edit	Configuration	Controller View Coordinates Favorites Help
	Edit	
	System	
	I/O	Electric Company Not Connected
	Programming	
	Tools	Tool Library
	Sensing	Tool Life Management
Cutting	Preferences	Tool Change
Pierce	Delay: 1.5000	100is in Changer
	rabaat 0.0000	40
AVHC	? (T/F): True	v
	Edit Acce	pt Cancel

In the next configuration screen you are going to need to set some parameters. Below is a screen shot of what you will see. There are (2) options available. 1. Track Time or 2. Track Counter. Circled below are the settings you are going to want to copy. The last setting to the right labeled "life" needs to be set to the amount of pierces your plasma cutter's manufacture recommends. Once the system reached this number in count, the program will be paused alerting you to change the consumables.

Output Lines Variable Output	Tool Life I	Management					Γ	Displa	y Shortcut
⊡ Programming	Tool Track Time			Track Counter					
M-Code Definitions M-Code Execution	Tool #	Description	Active	Elapsed Cutting Time (hrs)	Life (hrs)	AUth	Description	Curr Count	Life
	1	Plasma	No	0.000	0.000	Yes 💌	Pierce	0	150
User Variables	2	Platemarker	No	0.000	0.000	No 🕖		0	0
Counters	3		No	0.000	0.000	ING		0	
Cutter Compensation	4		No	0.000	0.000	No		0	0

Next, in the tree menu just above "Tool Life Management" you will go to "M-Code Definitions" and click on the Macro drop down arrow.

Configuration														
Beference Points	M-Code	Definitions									ΠD	isplay	Shortc	ut
- Fixture Offsets														
Threading	M-Code	s to Control Output Lines		(F	For Line	e Columns	: '1'=	Turn	On '0	l' = Tu	m Off	'' = N	o Actio	on)
<u>⊨</u> -1/0		General					1	Action						
Input Lines Output Lines	M Code	Description	Program Line First Action	M-Code First Action	Delay (sec)	Ln. 1	Ln. 2	Ln. 3	Ln. 4	Ln. 5	Ln. 6	Ln. 7	Ln. 8	
Variable Output	50	Plasma On	M-Cd	Set Ln 🔻	0.1	1	•	•	•	•	•	•	<u> </u>	
🖻 Programming	51	Plasma Off	M-Cd	Set Ln	1.0	0				•			•	
M-Code Definitions	52	Plate Marker On	M-Cd	Set Ln	0.2					•	•	•	•	
- M-Code Execution	53	Plate Marker Off	M-Cd	Set Ln	1.0	•				•	•	•	•	
G-Code 🔨 🔤	54	Oxy On	M-Cd	Set Ln	3.0	•			•	•	•	•	•	
- User V riables	55	Oxy Off	M-Cd	Set Ln	1.0	-	-	•	•	•	•	•	•	
- Cour ers			M-Cd	Set Ln	0.0	-				•	•	•	•	
- Cutier Compensition			M-Cd	Set Ln	0.0	-		-	-	-	-	-	•	
Import			M-Cd	Set Ln	0.0	-				•	•	•	· ·	
Cycles			M-Cd	Set Ln	0.0	-	•	•	•	•	•	•	· ·	
E- Tools			M-Cd	Set Ln	0.0	•		•	•	•	•	•	•	-
				•										
- Tool Life Management	M-Code	s to Execute Macros												
Tools in Changer	M Code	Description	Macro			Program Line Fisc Asson	Dis Out	play in put Bo	×	1				
- Tool Length Sensing	20	Plasma Only	IF #AVHC -	=		M-Cd	No			1				
- Program Zero Sensing	22	Mulit Tool Start	IF #CURR1	roo		N Cd	No							
Touch Probe	23	Multi Tool Stop	IF #CURRI	roo		M-Co	No							
Preferences						M·Cd	11.2							
Main Screen —						M-Cd	No							
Viewports						M-Cd	No							

In the macro, you will add a G160 command as shown, then hit ok at the bottom of the screen:

🚰 Edit M-Code Macro		×
IF #AVHC = True THEN M50 M101 H "No Pierce Signer Heceiv G160	With AVHC	<u>_</u>
ELSE M50 G1 utpiercedelay G160 ENDIF	With out AVHC	
		~1
	OK Cancel	

Once all the above is complete, you will be on the main macro configuration screen. Make sure to hit OK, at the lower left to apply the new settings.

When on the main screen, you will need to change your TORCH to Plasma in order to view the counter. You will now be able to run files as normal. When the "life" number that you previously set is reached, the system will pause and give you a warning to change your consumable(s).

Tool Life Inform	mation
	The current tool will exceed its life while this file is running.
	Plasma Pierce
	Current Count: 1602
	Count for File: 12
	Tool Life: 1603
	Life Exceeded By: 11
	Action
	[Make a Selection]
	[Make a Selection]
	Continue Using Tool
	OK Cancel

You can now take notice and manage the amount of pierces you are getting out of your consumables and adjust settings, parameters, etc. to get the most CUT for your buck!

Thank your Choosing Torchmate.

Technical Support

Call, Fax, or Email When building or maintaining a table, if a question or concern arises, or a part is missing, please contact Torchmate technical support.

Technical support will also help you with operating the CNC system, and troubleshooting problems.

Technical support is available Monday through Friday from 6:00 AM to 4:00 PM Pacific Standard Time.



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