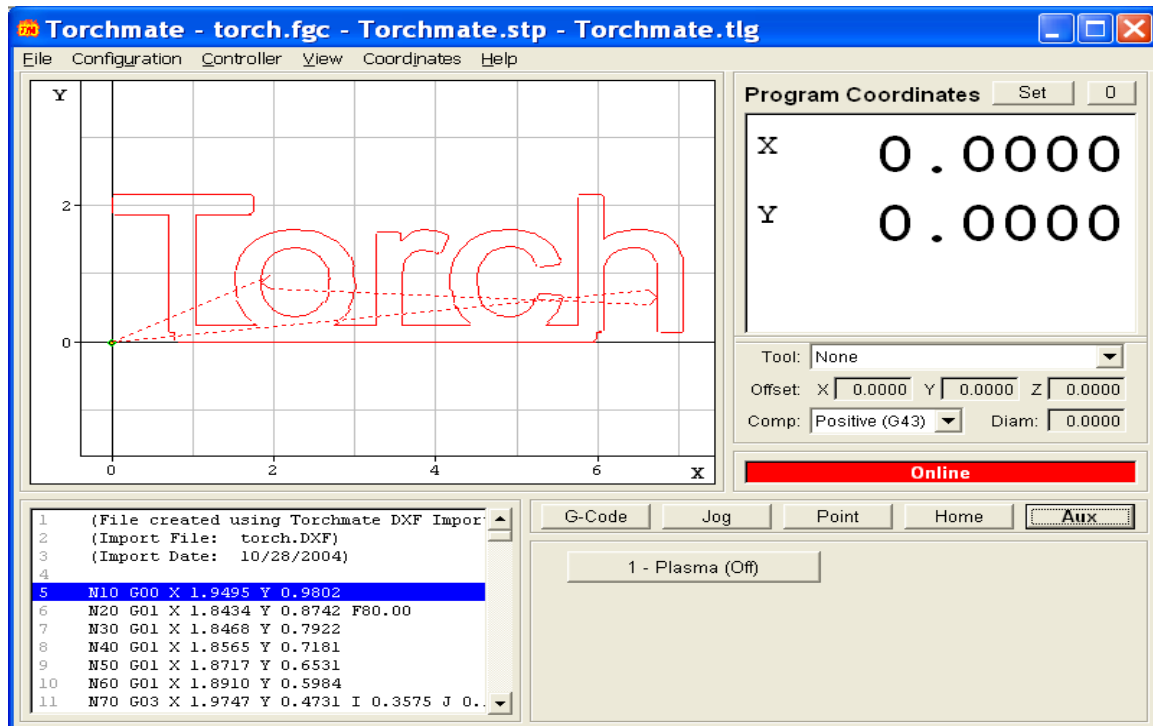
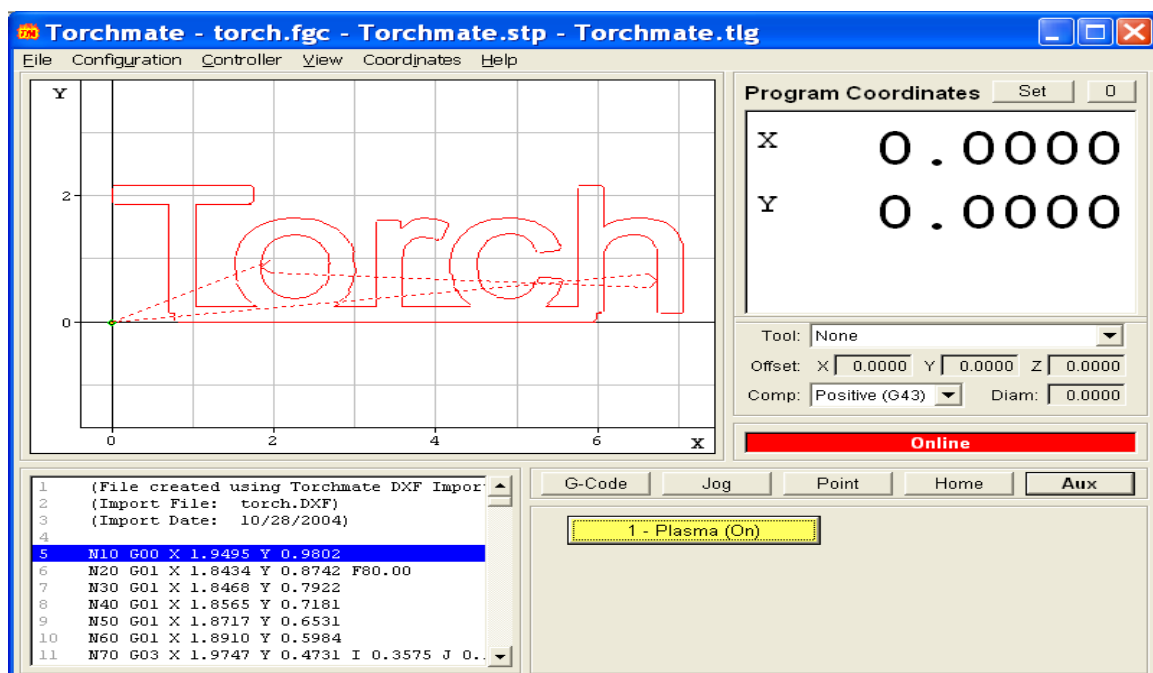


Manual Plasma Cutting Techniques

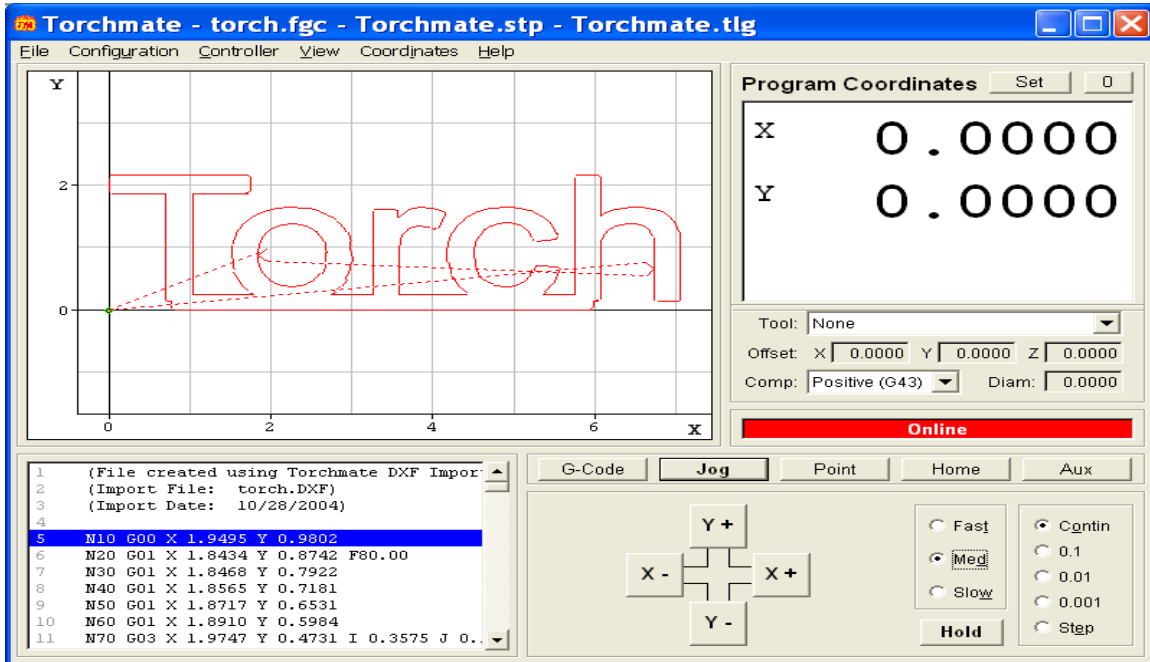
1. Align you torch so that it is directly over the edge of the material, and on line with the amount of material you wish to cut.
2. Turn plasma torch on.
3. Set the torch to Manual cutting.
4. On the main screen of your driver software, click on the Aux or auxiliary button.



5. Click on the button for Plasma OFF, which will turn the torch ON. You will see a prompt for the safety concerns, press OK to continue.



6. The Plasma ON button will turn yellow, signifying that the torch is engaged.
7. While torch head is moving toward the material, quickly switch to the JOG button and press it to open. Be sure to run the Jog at the Medium speed.
8. Jog the machine along the intended cutting direction by pressing the button for X+ or X-, or for Y+ or Y-.



9. At the end of the cut, click back on AUX, and then click on Plasma ON to turn the torch to the OFF position.
10. Move to a new position for cutting by using the Jog or Point buttons.
11. Turn torch OFF at the end of your cutting.