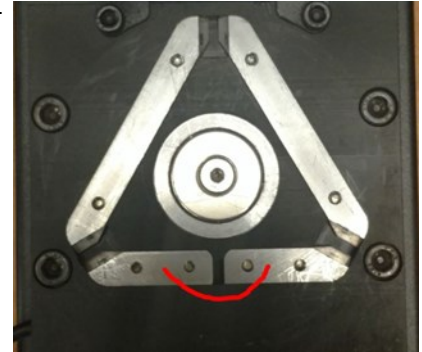


Error:

VMD software displays an error stating Execution Error: External Pause/Torch Breakaway Detected.

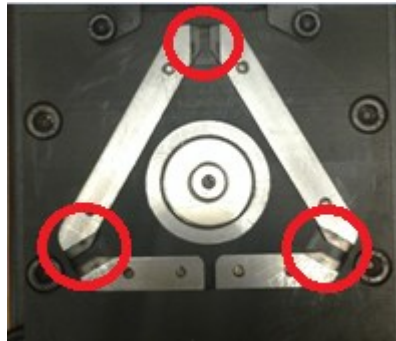
Verification:

1. Breakaway (1) status icon is yellow and states Open.
2. Remove the torch holder from the breakaway mount on the Z axis column and jump the bottom two bars to verify the breakaway circuit is working. If the Breakaway (1) status remains open contact support to have a case opened.



Solution:

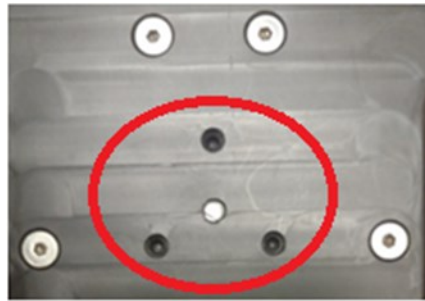
1. Reseat the torch holder to the breakaway mount on the Z axis column. See Cause #1.
2. Clean the torch breakaway saddles of any rust or debris. See Cause #2.



3. Verify the Breakaway cable is fully seated into both the Accumove Breakaway port and the pigtail on the breakaway. See Cause #3.
4. Check the Breakaway cable and pigtail for any damaged or missing pins. See Cause #4.

**Verification:
(cont'd)**

5. Adjust the magnet in the center of the breakaway mount so that it is flush with the black plastic base. See Cause #5.
 - a. Unbolt the breakaway mount from the Z-axis column.
 - b. Loosen the 3 set screws on the back of breakaway mount located behind the magnet.



- c. Tighten the countersunk bolt going through the front of the magnet until the magnet is flush with the black plastic base.
- d. Tighten the 3 set screws noted in step B until snug.
- e. Mount the breakaway mount to the Z-axis column.

Cause:

1. The connection between the torch holder and the breakaway mount was loose momentarily.
2. There was resistance between one or more of the metallic balls and its corresponding saddle keeping the breakaway circuit open.
3. There was a loose connection between the breakaway mount and the Accumove controller keeping the breakaway circuit open.
4. If one or more pins are damaged or missing then the breakaway cable needs to be replaced. This may have been caused by improper installation of the breakaway cable.
5. Improper adjustment of the magnet can cause poor magnet strength or interference with the torch holder plate.