

Error:

Limit Exceeded in Z Position (Value) when running a Job.

Verification:

- The value of the error matches the pierce height configured in the AVHC settings.
- The value of the error states -10.000.

Solution:

Ohmic Sensing/IHS On:

1. Remove the retaining cap and clear out any metal or debris between the shield and the nozzle. See Cause #1
2. Verify that the correct nozzle and shield combination is assembled in the retaining cap. See Cause #1

Ohmic Sensing/IHS Off:

1. Set the value for the top of the material. See Cause #2
 - a. Jog the Z axis up using the Z+ command until at the top of the lifter station.
 - b. Select the option Reset Z Position.
 - c. Go to Job Setup
 - d. Jog the Z axis down using the Z- command until the torch is touching the material:
 - i. Slow down the rate of travel while approaching the material so that the torch does not crash into the plate.
 - e. Click on the Set button associated with the Top of Material setting.

Ohmic Sensing/IHS On or Off:

1. Verify that the torch makes contact with the material when jogged all of the way down to the material. Adjust the torch per the plasma cutter specific guides that can be downloaded using the links below.

[Flexcut 80 Torch Positioning Procedure](#)

[Flexcut 125 Torch Positioning Procedure](#)

See Cause #3



Limit Exceeded in Z Position when Running a Job

Cause:

1. The shield is shorting to the nozzle which is causing a false ohmic detection. This may be caused by a piece of metal debris or the use of the wrong shield with nozzle. See plasma cutter manual for correct consumable stack installation.
2. The top of material is set to 0.00.
3. The torch lead is not able to make contact with the material because it is adjusted too far up in the clamps. Adjust the torch per the plasma cutter specific guides that can be downloaded using the links below.

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**Cutting
Systems**