

Complete Power Up Procedure on 160/180i Series Controls

1. Perform any external procedures (drain air compressor, start dryer, etc.)
2. Perform preventative maintenance as per Whitney daily checklist
3. Ensure main power at power island is on
4. Ensure air is provided to system
5. Ensure gases for cutting are turned on
6. Press **On** button on operators panel. Wait for logon screen to appear
7. Older NT controls will prompt for a password. If not prompted proceed to step 8.

Type **USER NAME:** **Operator**

PASSWORD: **3700FR** for a 3700 fixed ram machine
 3700RR for a 3700 rotary ram machine
 4400 for a 4400 MAX
 3400 for a 3400 RTC

then press **Enter**

8. Wait for Position screen to appear (black with yellow numbers)
9. Turn Emergency Stop key clockwise to release
10. Press **Oper Ack** three times slowly (1 second between presses)
11. Press **Hyd On/Off** on operator's panel
12. Press **Mem** hardkey
13. Press **Prog** hardkey
14. Type in **O9100**
15. Press **O SRH** softkey

16. Press **Cycle Start** on operator's panel

Note: If machine does not move, a message will inform you of the problem.

Press **Message** hardkey to see current messages. Press **Oper Ack** to clear messages once stated problem has been corrected. The 9100 message **cannot** be cleared with **Oper Ack**. Press **Cycle Start** after clearing all messages possible to run 9100 and clear this message.

17. Turn on torch by pressing the green button labeled "Torch On" until it stays lit.

This may take up to 5 seconds with a HT2000 torch. HPR users skip to step 22.

Note: If button will not stay lit, refer to status lights on front of torch power pack for problem.

18. Avoiding the safety barrier, move the gas switch to "Test Preflow" and verify settings. Adjust as necessary.

19. Move the switch to "Run" and let balls settle.

20. Move the switch to "Test Cutflow" and verify settings. Adjust as necessary.

21. Move the switch to "Run" and let balls settle.

22. Power up is complete. Load programs, tooling, and/or torch consumables as required and proceed with machine operation.

Note: This is a base procedure for reference only. Slight modifications may be necessary to conform to customer policies. Steps may change dependant upon problems and/or errors during execution as well as familiarity with system over time.