

Complete Power Up Procedure on 00-P 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 main screen to appear
7. The control has 2 sides: MMC and CNC. If the screen says Machine Management Console you are on the MMC side and you may continue to step 8. If the screen comes up black with X & Y values in the upper left corner you are on the CNC side and need to press the **MMC\CNC** button to switch sides
8. Press **Error Msgs** softkey (on a Series B control, you may need to press **Mach Data** to get to **Error Msgs**)
9. Turn Emergency Stop key clockwise to release
10. Press **Intlk Fault** on operator panel
11. Press **Hyd Start** (or **On\Off**) on operator panel
12. Depending on the location of any given axis you may need to Jog before you reference. Verify the following:
 - 13.1 The X axis Home position is with the X clamp cover roughly 3” from the motor end plate. This axis must be at least 6” from this point (9” from motor mount) to reference correctly. If it is closer than this, press the **10IN/100MM** button, then press **+X** 1 time. If further away, your position is ok and you may continue to step 13.2

13.2 The Y axis Home position is with the table almost at the back of the machine. This axis must be at least 6" from this point to reference correctly. If it is closer than 6" to the rear, press the **10IN/100MM** button, then press **+Y** 1 time. If 6" or more, your position is ok and you may continue to step 13.3

13.3 The R axis Home position is with arm 1 facing the front of the machine. This axis must be at least 30 degrees from this point to reference correctly. If it is at 30 or less, press the **10IN/100MM** button, then press **+R** 3 times. If 30 or more, your position is ok and you may continue to the step 13.4

13.4 The Z axis Home position is with the robot at the top of travel (above the top tool shelf). This axis must be at least 6" from this point to reference correctly. If it is closer to the top than 6", press the **1IN/10MM** button (not 10IN/100MM as other steps), then press **+Z** 3 times. If at 6" or more, your position is ok and you may continue to the step 14

13. Press **Jog** on operator panel

14. Press **Home** on operator panel

15. Press **-R** on operator panel

16. Wait for R axis reference message to clear

17. Press **-Z** on operator panel

18. Wait for Z axis reference message to clear

19. Press and hold **-Y** on operator panel until axis slows down

20. Wait for Y axis reference message to clear

21. Press and hold **-X** on operator panel until axis slows down

22. Wait for X axis reference message to clear

Note: The machine will automatically run a clamp scan after referencing

23. IC300 users turn on the switch on front of the power unit and skip to step 29. For Hypertherm torch packs, turn on torch by pressing the green button in the bottom left of the pendant or on the amp setting box until it stays lit. This may take up to 5 seconds with a HT2000 torch.

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

24. Avoiding the safety barrier, move the gas switch to “Test Preflow” and verify settings. Adjust as necessary

25. Move the switch to “Run” and let balls settle

26. Move the switch to “Test Outflow” and verify settings. Adjust as necessary

27. Move the switch to “Run” and let balls settle

28. 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