



PRACTEC

CNC CUTTING MACHINE

**SIMPLE OPERATION
MANUAL**

BEIJING TOPTECH TECHNOLOGY CO.,LTD

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- This User's Manual is only available for TopTech CNC Cutting Machine.
- Ensure that the operator has read and understood this User's Manual before any operation on TopTech CNC Cutting Machine.
- There may be few differences between the pictures in this User's Manual and the machine you received.
- Never hesitate to contact us for on-line technical service when you have any questions or you need help, and it's our pleasure to serve for you. Our E-mail is info@toptechone.com

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Section 1: Safety



Warning: Safety Information

- This symbol is used to identify potential hazards. When you see the warning symbol in this manual or on your machine, understand the potential for personal injury and follow the related instructions to avoid the hazard.



Follow Safety Instructions

- Read carefully all safety messages in this operator manual and safety labels on the machine.
- Learn to operate the machine and the Controller properly.
- Do not let anyone operate the machine without learning to operate the machine.
- Keep the machine in proper working condition. Unauthorized modifications to the machine may affect safety and the service life of the machine.



Electric Shock

- Electric shock can injure or kill.
- Never touch any parts that are electrically “live”.
- Repair or replace all worn or damaged parts.
- Disconnect power source before performing any service or repair.
- Read and follow all the instructions in the Operator Manual.



Grounding

- Make sure you connect the power cord ground wire to the ground in the disconnect box.
- Tighten all electrical connections to avoid excessive heating.



Moving Parts

- Keep away from moving parts such as fans.
- Have only qualified persons remove the covers, panels or guards for maintenance as necessary.
- Reinstall covers, panels or guards when maintenance is finished and before re-connecting the input power.



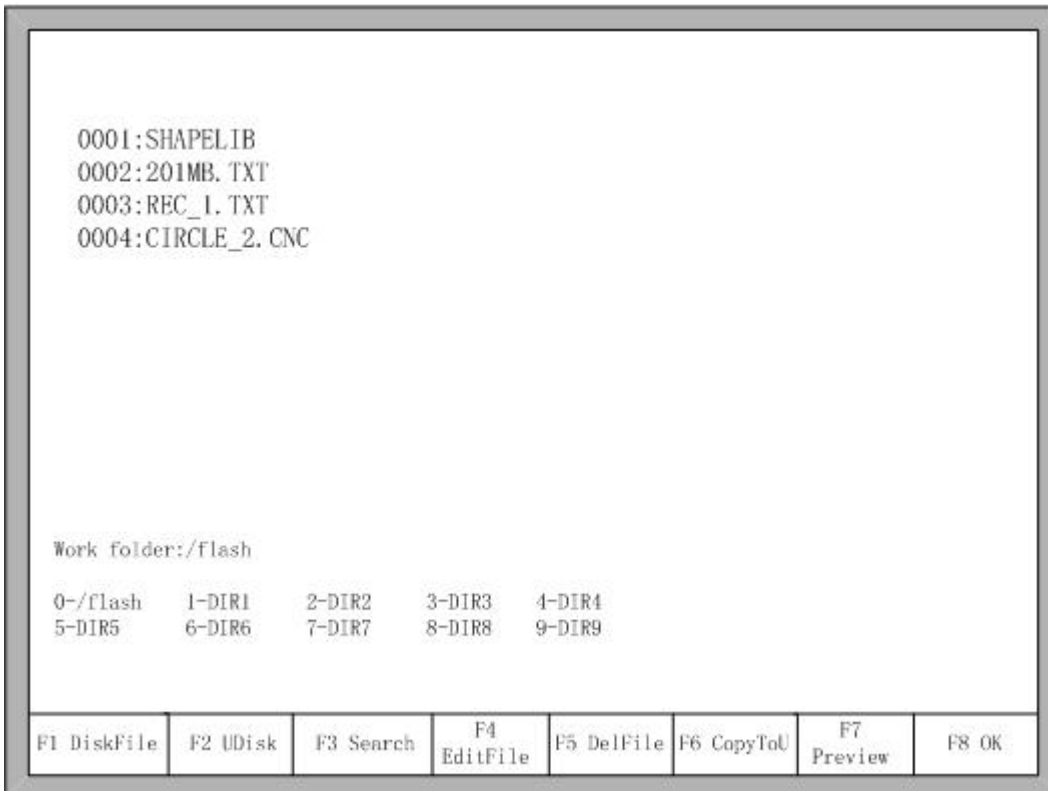
Static (ESD)

- Put on grounded wrist straps before handling Printed Circuit Boards or parts.
- Use proper static-proof bags and boxes to store, move or ship Printed Circuit Boards (PCB).

Section 2:Starting up

- 1.Check machine body.
- 2.Check air, oxygen, gas.
- 3.Check electrical circuit.
- 4.Turn on the main switch.
- 5.Make sure the EMG switch is normal.
- 6.Press the “Power on” button on the operation panel.
- 7.CNC starting up .
- 8.Press any button on the CNC panel when the picture is appear, enter the main screen.

Section 3.Read NC Program



- 1.Insert the USB into the operation panel.
- 2.Press F2 “Files” button.
- 3.Press F2 “UDisk” button.
- 4.Select NC program.
- 5.Press F8 “OK”, enter main screen.

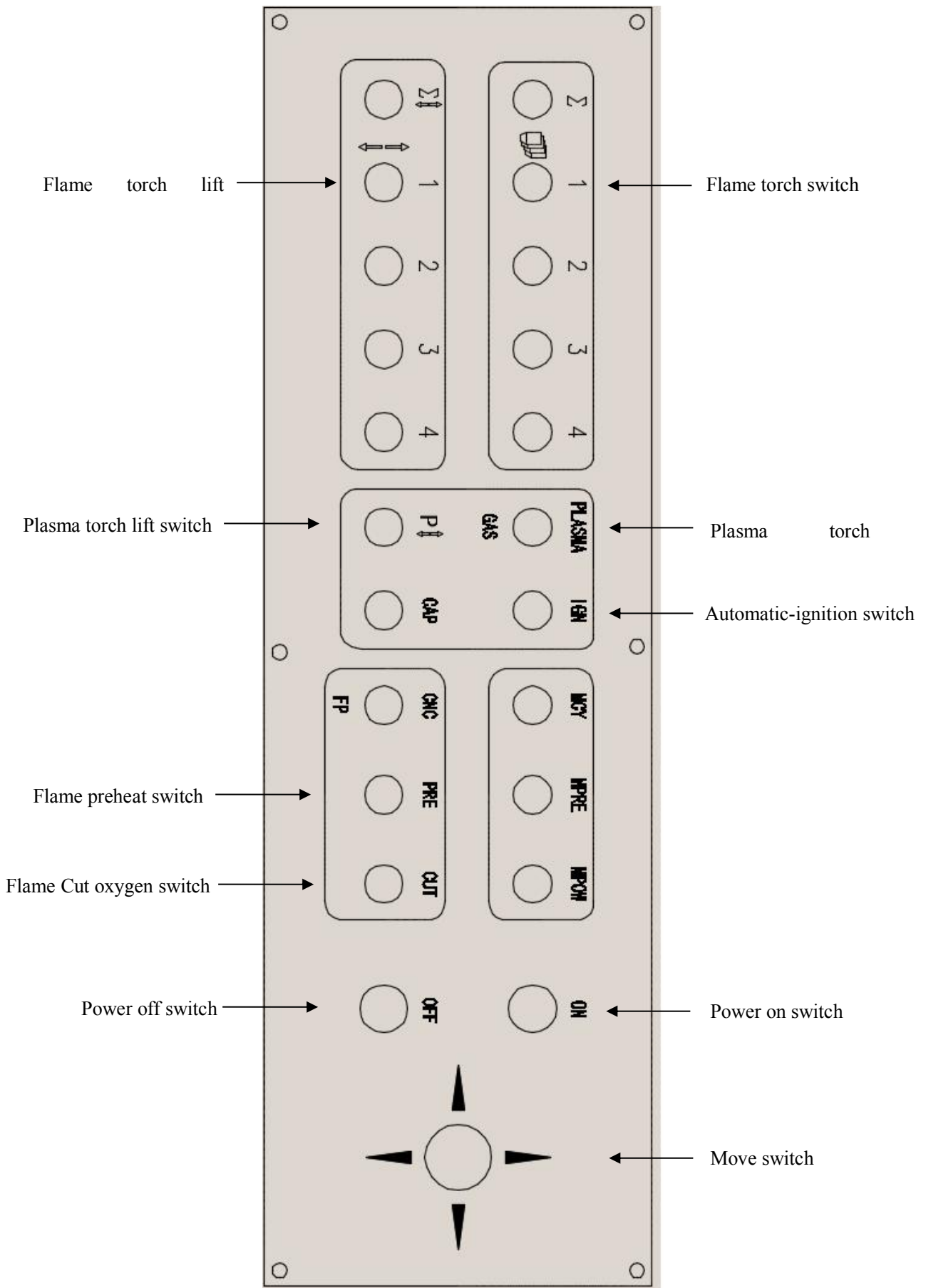
Section 4.Select cutting mode

Max cutting speed	3000.00	mm/min
Manual move speed	3000.00	mm/min
G00 move Speed	3000.00	mm/min
Demo/back speed	3000.00	mm/min
Dust speed	3000.00	mm/min
Kerf value	3000.00	mm
Corner speed(1-100)	3000.00	%mm/min
Demo Run Speed	3000.00	mm/min
Cutting type	Flame	

F1 Common	F2 Flame	F3 Plasma	F4 Powder	F5 System	F6 Import	F7 Export	F8 Save
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- 1.Press F4 “SETUP” button.
- 2.Select “Plasma” or “Flame” mode .
- 3.Input “Kerf value” .
- 4.Input Cutting speed.
- 5.Press “START” button on the CNC operation panel, start cutting.

Section 5.Operation Panel



Section 6.Appendix Propane tip cutting parameter

Tip №	thickness (mm)	kerf value (mm)	oxygen pressure (MPa)	propane pressure (MPa)	cutting speed (mm/min)
0	3-10	1	0.6	0.025	600-700
1	5-20	1.5	0.6	0.025	550-600
2	20-30	2	0.7	0.025	450-550
3	30-50	2-3	0.7	0.03	380-450
4	50-70	3-4	0.7	0.035	320-380
5	70-100	3-4	0.7	0.035	250-320
6	100-150	5	0.7	0.04	160-250

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