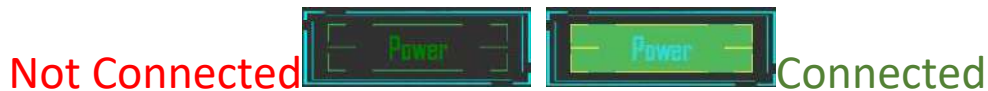# Quick Reference Guide

Machine Homing: Drive the X and Y axis to the lower left of the table or 6" from the stop switches. Under

Home click **_All_**.

Correct Program Zeroing: Drive the machine to the desired location to start. Select **_Set Start_**. Ensure the Coordinates are all **0.0000**.

Machine wont move: Ensure the power button in HALO is on.

Not Connected   Connected

Torch Diving: Ensure correct settings in **SheetCam**, Amperage, Material Thickness and Hypertherm machine is set to correct amperage. Check consumables for correct amperage and wear. Ensure voltage in **HALO** is within +/- 5 of targeted voltage.

Torch Raising: Remove consumables and inspect. Clean torch's sheild of debris or replace.

Failed to Detect Arc Error or No Fire: Check the Hypertherm for error codes. Error code meanings can be found in the Hypertherm and BOSS Table manuals. Check ground clamp for corrosion and locking end for tighness at the Hypertherm. Replace consumables.

Torch Fails to Cut Material: Check for proper settings in **SheetCam**, proper amperage on power unit. Check consumable tip for wear and correct amperage. Refer to cut chart that selected consumables are correct size or selection.

Scribe Wont Vibrate: Remove hose from the top of the scribe. Pour 1 drop of tool oil into the scribe and install the hose. With the scribe on tap the side of the scribe with a wrench. This will clear any debris in the scribes airway.

Powering On: Power on the Belkin power strip, Power on the controller, Power on the pc.

Powering Off:Power off the pc, Power off the controller, Power off the power strip.

Homing   Zeroing

Homing sets the dimensions for the tables driving perameters **ONLY**. Once homed the program will zero the machines coordinates. **This is not used to zero material or program coordinates!**

Zeroing sets the start point for a cut that is determined on the material location of your choosing. Zero the machine by selecting **_Set Start_**.

Powermax Error Codes

Warning/Fault codes (refer to operator manual)	
0-12	Low input gas pressure: warning
0-13	AC input unstable: warning
0-19	Power board hardware protection
0-20	Low gas pressure
0-21	Gas flow lost while cutting
0-22	No gas input
0-30	Torch consumables stuck
0-32	End of consumable life
0-40	Over temperature
0-50	Retaining cap off
0-51	Start/trigger signal on at power up
0-52	Torch not connected
0-60	AC input voltage error
0-61	AC input unstable: shutdown
0-98	Internal communication failure
0-99	System hardware fault – service required

BOSS Tables Technical Support

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