

3400RTC with HT 2000LHF Complete Power Up Procedure

1. Perform 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 control panel. Wait for screen to stop changing
7. Turn Emergency Stop key clockwise to release
8. Press **Oper Ack** one time
9. Press **Hyd On/Off** on operator's panel
10. Press **Mem** on operator's panel
11. Press **Prog** hardkey
12. Type **O9100**
13. Press **O SRH** softkey
14. Press **Cycle Start** on operator's panel
 - Note:** If machine does not move, a message will inform you of the problem. Press **Message** to see current messages. Press **Oper Ack** to clear messages once stated problem has been corrected. "Select and run program 9100" message **can not** be cleared with **Oper Ack**. Press **Cycle Start** after clearing all messages possible to run 9100 and clear this message
15. While machine is running, turn on torch by pressing the green button in the bottom left of the pendant until it stays lit. This may take up to 5 seconds
 - Note:** If button will not stay lit, refer to status lights on front of torch power pack for problem

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16. Avoiding the safety barrier, move the gas switch to “Test Preflow” and verify settings. Adjust as necessary
17. Move the switch to “Run” and let balls settle
18. Move the switch to “Test Cutflow” and verify settings. Adjust as necessary
19. Move the switch to “Run” and let balls settle
20. Once machine has completed program 9100, press **Custom**
21. Check screen for verification of clamp locations and active tool. Visually ensure clamps are in correct location and there is an empty tool cartridge to accept the currently active tool
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 customers policies. Steps may change dependant upon problems or errors during execution as well as familiarity with system over time.