Power Up Procedure

1. Perform any non-Whitney 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 the Green **Power** button on operator's panel (lower left corner)

7. Wait for Main screen to appear (may take 3-5 minutes)

8. Release all emergency stops

9. Press **Reset** hardkey

10. Press **Oper Ack** hardkey

11. Repeat steps 9 & 10 slowly 1 more time

12. Press **Hyd On/Off** hardkey

13. Press **Torch Inhibit** hardkey to turn inhibit off

14. Press **Ram Inhibit** hardkey to turn inhibit off

15. Press **Spindle Start** hardkey (light should turn green)

16. Press **Feed Start** hardkey (light stays red in auto, green in JOG or MDA)

17. Press **Machine** softkey

18. Press **MDA** hardkey

19. Ensure CLAMPLOCATION and M30 are the only command's without a ";" (semi-colon) in front of them in the MDA window (scroll down through all commands to verify). Insert command if needed

20. Press **Cycle Start** hardkey

    Note: If machine does not move, a message will inform you of the problem. Watch messages scroll to check information. Press **Oper Ack** hardkey to clear messages once stated problem has been corrected. The Clamp 1 Unlocked and Clamp 2 Unlocked messages can not be cleared with Oper Ack. Press **Cycle Start** after clearing all messages possible to run CLAMPLOCATION (which will clear these messages once completed)

21. Turn on torch by pressing the green button labeled "**Torch On**" on the pendant until it stays lit. This may take up to 5 seconds with an HT2000. HPR units should be immediate and will begin purging itself. HPR owners skip to step 26
    Note: If button will not stay lit, refer to status lights on front of torch power pack for problem. On HPR, refer to HPR screen for more information

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

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

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

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

26. Once motion is complete, place ";" back in front of CLAMPLOCATION command

27. Power up is complete

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