Lost Cut Recovery

Plasma Mode

Choose one of the three methods.

Auto Lost Cut Recovery

Description: Your machine will move to where the arc signal was lost and begin cutting.

When to Use:

- Your plasma torch was on, but you lost the arc signal.
- You want to re-start where the arc signal was lost.

WARNING: Your machine will move to the last location where an arc signal was lost. Make sure that your torch had been on. If not done properly, this mode could cause severe damage to your machine and/or material.

Manual Lost Cut Recovery

Description: Your machine will begin cutting at the current location and then continue executing from the line of G-Code you selected.

When to Use:

- Your torch never started (there never was an arc ok signal).
- You cannot start at the position that lost the arc signal.
- You want to start between two lines of G-Code.

WARNING: Your machine will pierce and then start cutting at the current position.

Run From Here

Description: Your machine will move into position and begin cutting at the line of G-Code you selected.

When to Use:

- You can start at the beginning of a line of G-Code.

WARNING: Run From Here ignores the current position. It will make a straight move to the G-Code command and then begin cutting.
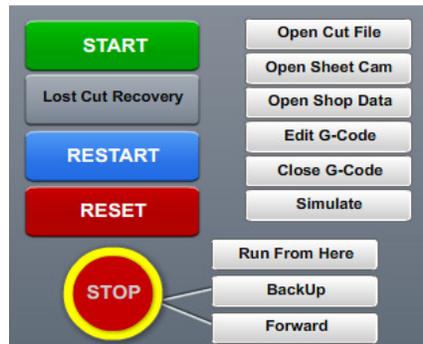
Drill Mode

Description: Your machine will move directly to the line of G-Code you selected and begin drilling.

You must always use **Manual Lost Cut Recovery** for a drilling cycle.
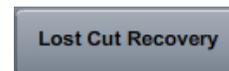
Lost Cut Recovery Buttons

If at any time you need to start executing your program from some point other than at the beginning, start by pressing **STOP**.

Plasma Mode

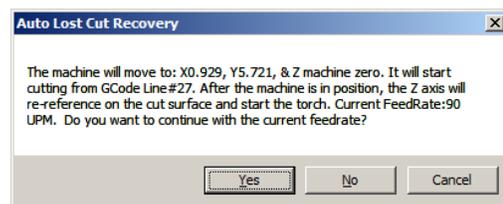## Auto Lost Cut Recovery

1. Press **Lost Cut Recovery**.

2. Then select **Auto**.

3. Select **Yes** to begin or **No** to change the feedrate.

4. If you selected **No** previously, update your feedrate and press **OK**.

Your machine will move to where the arc was lost, re-reference the Z axis, and then begin cutting.

Manual Lost Cut Recovery

1. Scroll through the G-Code until you locate the line where you want your program to begin cutting.

2. Move the machine to the EXACT X and Y position where you want the machine to begin cutting.
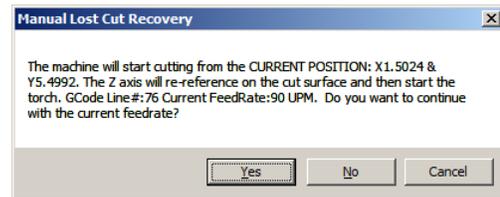
3. Press **Lost Cut Recovery**.

4. Then select **Manual**.

5. Select **Yes** to begin or **No** to change the feedrate.

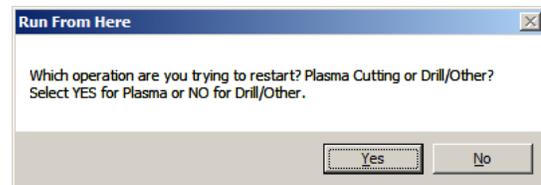6. If you selected **No** previously, update your feedrate and press **OK**.

Your machine will re-reference the Z axis and then begin cutting from the current location.

Run From here

1. Scroll through the G-Code until you locate the line where you want your program to begin cutting.

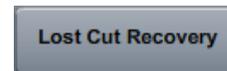2. Select **Yes**.

3. Update your feedrate and press OK.

Your machine will move into position, re-reference the Z axis, and then begin cutting from the G-code line you selected.

Drill Mode

1. Select the line of G-code that moves the X and Y axes to the next drill location.
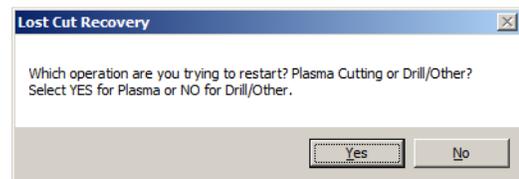
2. Press **Lost Cut Recovery**.

3. Then select **Manual**.

4. Select **No**.

Your machine will move to the correct position and then begin drilling from the G-code line you selected.