OPERATOR'S MANUAL

PT-22 PLASMA TABLE
A12 HAND HELD CONTROL

Book 2of2

Baileigh Industrial, Inc.
P.O. Box 531
Manitowoc, WI 54221-0531
Phone: 920.684.4990
Fax: 920.684.3944
sales@baileighindustrial.com

Rev. 09/2016

Table of Contents

CHARACTERISTICS

1. Totally independent from PC platform.
2. Directly read files from U Disk.
3. Easily process G code or PLT file with super-size.
4. Strong system and process file examining function.
5. Easy to update system program.
6. It supports high micro step which makes precise and fast process possible.
7. Support to process part of the file.
8. Reliable data protection and recover function.
9. Friendly operating interface.

CAUTIONS

1. Do Not expose to static electrical charges.
2. Do Not use this product in strong magnetic fields or areas of interference.
3. Do Not Pull out U Disk while it is running a file.
4. Protect it from water, moisture, dust, and heat.
5. Protect it from metal contaminates getting into the cover.
6. Do Not remove cover. There are no user serviceable components inside.
7. Plug U disk and other cables gently into the device.

-  USE CARE. These settings are normally adjusted by the operator to get the best cut possible. Take notes and if possible practice on scrap material to get the settings which will produce the best results.
-  **STOP!** These settings are not normally changed. **DO NOT** change these settings unless asked to by an authorized Baileigh Industrial service technician.

CONTROLLER APPLICATION

The hand held pendant connects to the stepper controller interface board via the supplied cable. With the pendant you can download G-code programs (.nc) using the USB port and a memory stick. You also have the ability to “Home” and position the head as needed. Other functions include changing parameters such as process speed and acceleration. The menu button accesses various setup screens for performing self-checks.

Button Functions

Button	Function
X + 1 ▲	Positive movement of "X" axis, Menu scroll-Up, Enter numerical value 1
Y + 2 ∧	Positive movement of "Y" axis, Increase process speed, Enter numerical value 2, Menu scrolling
Z + 3	"Z" axis Not used, Enter numerical value 3
XY→0 4	Working origin of "X" and "Y" axis, Enter numerical value 4
X – 5 ▼	Negative movement of "X" axis, Menu scroll down, Enter numerical value 5
Y – 6 ∨	Negative movement of "Y" axis, Decrease process speed, Enter numerical value 6, Menu scrolling
Z – 7	"Z" axis Not used, Enter numerical value 7
Z →0 8	"Z" axis Not used, Enter numerical value 8
HOME 9	"X" and "Y" axis start position, Enter numerical value 9
HIGH/LOW 0	Manual moving mode, High speed or low speed selection, Enter numerical value 0
ON/OFF •	Use to turn torch arc On and Off Used with menu button to control C.A.D. function, Enter decimal point
MENU –	Access to setup menus, Negative symbol input, Multi process state checking
ORIGIN OK	All axis go to working origin, Confirmation of motions / inputting / operating
MODE	Manual move, Selection of continuous, step, and distance modes
RUN/PAUSE DELETE	Used to change menu values, Program selection, Pause

STOP CANCEL	Used to cancel inputting and operations, Adjusting high/low speed parameters, Use as return button

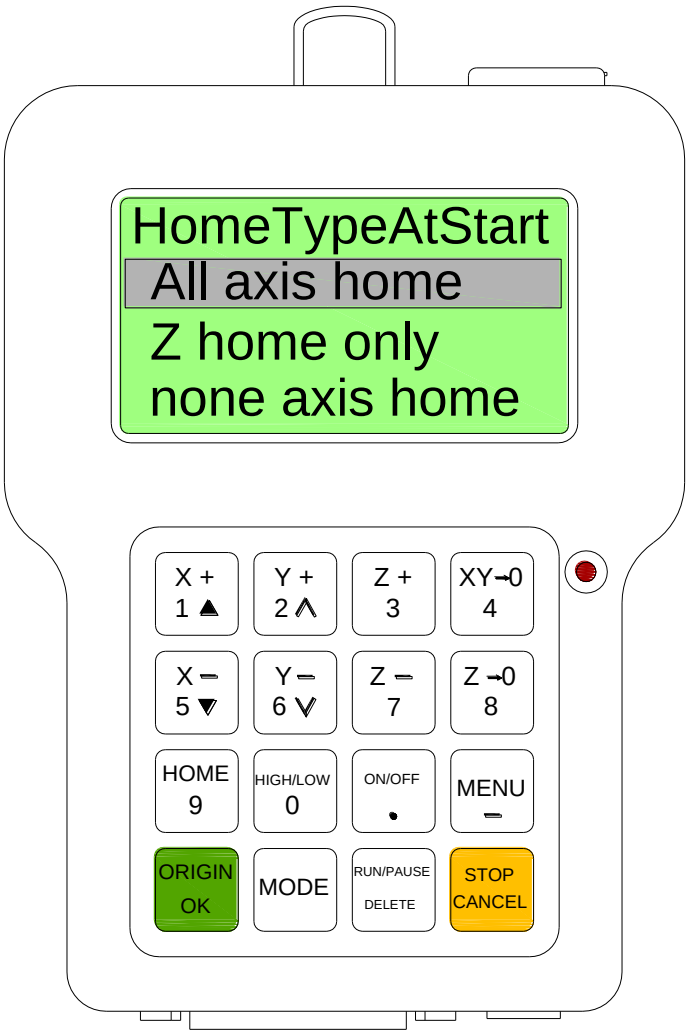
Compound Buttons

There are some compound buttons to be used for special applications.

1. The procedure is to press the first button and hold, then press the second button.
2. Now release the two buttons at the same time.

The functions of the compound buttons are listed below:

- MENU – + digit button = switch the working coordinate
- MENU – + ON/OFF • = C.A.D. function
- RUN/PAUSE DELETE + digit button = stop point process
- RUN/PAUSE DELETE + X + 1 ▲ = will enter the break point list
- RUN/PAUSE DELETE + HIGH/LOW 0 = advanced process



PROCESS

USE CARE. Process includes **Manual Process, Auto Process**, and **Advanced Process**.

Home Operation

CAUTION: As the head is going home, watch for any potential points of interference that could damage the head or material.

The Home operation must be performed each time power is turned on to the controller (recommended) or as desired by pressing the "Home" button.

- When power is turned on to the hand held unit, the message "All axis home" will be displayed on screen.
- If you want the head to go to the "0, 0" home position (recommended), determined by the X, Y axis proximity switches, press the ORIGIN OK button. The X and Y axises will move to the "0, 0" home position.

Note: *The coordinate values displayed in the X and Y lines will not necessarily be 0.00. It is common for the values of X and Y to be some Negative value.*

- If you do not want the head to go to the "0, 0" home position, press the STOP CANCEL button.
- When the hand held unit is in Manual state, press HOME 9 and the head will go to the "0, 0" home position.
- While it is going home, pressing the STOP CANCEL button will stop the head at its current location.

Note: *It is recommended to always Home the head each time the table is powered ON. This will clear any previous coordinates which may cause the system to display a false over-limit error.*

Set Working Origin

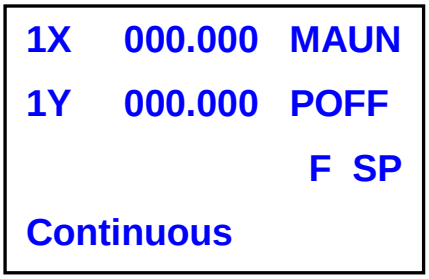
- When the controller is in manual state, move the 2 axes to the desired starting position on the table where it will run the file.
- Then press XY→0 4 to establish a new "**X, Y**" working origin.
- This now sets the starting point for the file to be run from. The head may be moved back to this point by pressing the ORIGIN OK button.
- This may be tested by pressing the "Home" button and allowing the head to move home. Then press the ORIGIN OK button and the head will move back to the origin point.

It is recommended to always set an origin point which is different from the home position. Even if the origin is only 0.5mm in the + direction for X and Y. This will allow for head travel that will not normally engage the proximity limit switches causing an inadvertent stopping of the program.

Manual Process

Manual process is the normal screen and operation of the controller when it is not running a program. In this condition, the head is moved about the table by the operator pressing the desired buttons to move the head upon the desires axis.

The main screen as shown to the right, displays the X and Y axis dimensional coordinates. It also shows the operational state of the controller in the far right column.



Line 1 MAUN or RUN will display when operating in manual mode or running a program.
Line 2 POFF or P ON will display when the torch (arc) is off or on.
Line 3 F SP or L SP will display indicating the speed the head will move at during manual movements.
Line 4 will display the movement operation mode.

Manual process speed can be changed between **Fast speed** and **Low speed** by pressing the HIGH/LOW 0 button. To adjust the speed for the current setting press STOP CANCEL. The screen displays as below:

Low spd,	mm/min
X Axis:	1200.00
Y Axis:	1200.00
Z Axis:	600.00

OR

Highspd,	mm/min
X Axis:	3000.00
Y Axis:	3000.00
Z Axis:	1200.00

The cursor will be on the "**X**" axis line and highlighted. Press the RUN/PAUSE DELETE button to set the value.

Input the new number and press ORIGIN OK to save the new value. If the input number is not correct, press RUN/PAUSE DELETE to delete the last number. Use the X + 1 ▲ and X − 5 ▼ buttons to scroll to a different line.

Manual Process Modes

In order to meet various manual movement requirements there are three available modes: **Step**, **Continuous**, and **Distance**.

- **Step** mode always moves at a slow speed with a spacing of a grid per second. The **Low Grid** value will be set between (0.05mm to 1.0mm). Each time the axis buttons X + 1 ▲ Y + 2 ∧ X − 5 ▼ Y − 6 ∨ are pressed and released the head will move one grid position. This mode is suitable for precise placement of the head.

- **Continuous** mode allows the operator to move the head using the axis buttons: X + 1 ▲ Y + 2 ∧ X − 5 ▼ Y − 6 ∨. The head will move until the button is released or until it reaches the end of travel. This is the default mode setting and is usually used to move the head about the table. Its speed is determined by the current speed mode.

Note: *If the button is pressed for less than 0.5 second, and released at once, the head moves to and stops at the nearest step point automatically. When this moving mode ends, the head always stops at the step point. This mode is suitable for adjusting the position of the head.*

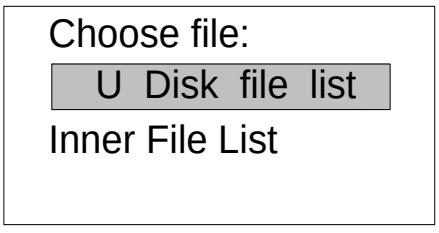
- **Distance** mode allows the operator to move the head about the table using a specific distance. From the manual start screen, press the MODE button until the **Dist** line is highlighted. Press RUN/PAUSE DELETE to set the distance value, used the digit buttons to enter a value. Press ORIGIN OK to save the new value. Pressing the axis buttons X + 1 ▲ Y + 2 ∧ X − 5 ▼ Y − 6 ∨ the head will move to that specific location according to current speed mode and set spaces. The moving is not influenced by the grid point and stops precisely at the set distance.

Auto Process

Auto Process refers to running USB disk files and Inner files also called file process. Before running any file, the machine and system parameters should be set correctly. The Auto Process operating steps are as follows:

Choose File

After the origins have been set, press RUN/PAUSE DELETE. The Choose file screen will display as shown:



Using the X + 1 ▲ and X − 5 ▼ buttons, move the cursor to highlight the desired file source and press ORIGIN OK to select where to get the file from. Only three files appear on the screen at any one time. Use the same scroll Up/Down buttons as above to view more files. Press ORIGIN OK to select the target file or STOP CANCEL to quit and return to the previous menu.

Process Parameter Settings

After pressing the ORIGIN OK button, the controller needs to set the process parameters including: **Work Speed, Fast Speed, SpdScale, FallDown**.

Note: *Only three lines can be viewed at any one time.*

To scroll use the X + 1 ▲ and X − 5 ▼ buttons. To change the values in the line, press the RUN/PAUSE DELETE button to set the value, then enter the new number, and press ORIGIN OK to save the new value.

After all changes are made press ORIGIN OK to begin checking the G-code data. After checking the data, the table / cutter should start cutting the piece.
The screen display is shown here:

WorkSpd: (Work Speed) The speed at which the data file is read or processed. Cutting speed.

FastSpd: (Fast Speed) The speed at which the head moves on the "**X** & **Y**" axes when it is not cutting.

SpdScale: (Speed Scale) It is used to reduce the process speed. The actual process speed is (process speed x Speed Scale). Its range is (0.1 – 1.0).

FallDown: N/A. Refers to "**Z**" axis functions not used on this table.

Process Adjust

When the file is executing, press Y + 2 ∧ and Y − 6 ∨ to change the speed ratio. Each press on Y − 6 ∨ drops the ratio 0.1 until it is 1.0. The speed values change synchronically. Each press of the Y + 2 ∧ button raises the ratio 0.1 until it is 1.0.

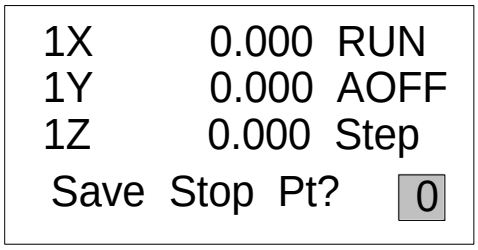
Process Pause and Position Adjust

While it is processing, press RUN/PAUSE DELETE to adjust the position of the axes. Press RUN/PAUSE DELETE to Pause. It asks “Original?”. Press ORIGIN OK to confirm your change. It then processes from the new position. Press STOP CANCEL to cancel the change and it will process from the original position.

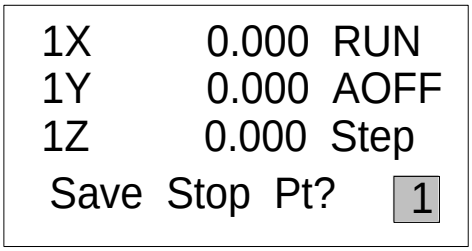
Process Stop and Stop Point Saving

While it is processing, press STOP CANCEL to stop the processing. It pauses to save a stop point.

If it needs to restart the process from the current position at a later date then you should save it.



Pressing X + 1 ▲ will save the stop point as No.1.
It will display on the screen as shown:



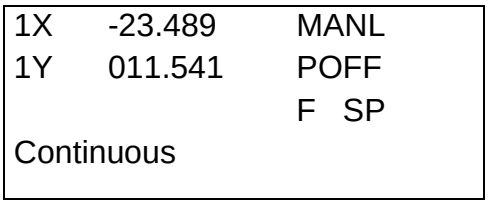
Press ORIGIN OK to save the setting. The axes will go back to the home origin. If it needs to continue to process from Stop Point 1, press compound buttons RUN/PAUSE DELETE + X + 1 ▲. It now starts processing from Stop Point 1. Follow the same operating steps for Stop Point 2, Stop Point 3, and so on. In order for the stop point process to work, the 3 axes must have been homed before saving the stop point.

Power Off Protection

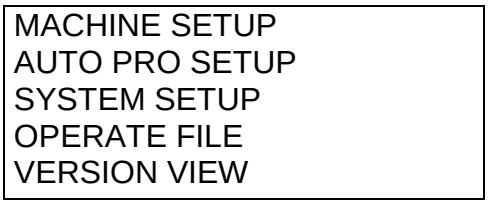
The system will automatically protect the process data should the power suddenly be disrupted. When the power is restored, press ORIGIN OK to go back to the machine origin. Then it pauses at “**PowerOff reboot?**”. Press ORIGIN OK to continue to process unfinished work or STOP CANCEL to quit.

MENU SETUP

Upon reaching home position, the unit will be in Manual state and appear similar to the screen shown:



Press the MENU – button to enter the menu screen. There are five headings but only four can be viewed at any one time. The fifth heading is **VERSION VIEW.**



Press the X + 1 ▲ or X – 5 ▼ buttons to scroll through them.

MACHINE SETUP

<u>STOP!</u> The parameters shown in the MACHINE SETUP menu below should only be changed by an experienced operator. Failure to do so may result in incorrect machine motions and possible machine damage.

Machine Setup	Pulse Equiv 	Unit pulsePermm XEquival 160.00 YEquival 160.00 ZEquival 400.00	
	Table Size 	Unit mm X Size 610.00 Y Size 610.00 Z Size 200.00	
	Axis Prohibite 	AxisDisableMask X Mask Enable Y Mask Enable Z Mask Disable	
	Arc Delay 	Unit MicroSec OnDelay 300 OffDelay 0	
	Cylinder Delay 	Cylinder Delay DwnDelay 1000 UpDelay 1000	
	Home Setup 	Home Speed	Unit MMPerMin X Spd 3000.00 Y Spd 3000.00 Z Spd 1800.00
		Home Order	Home Order Z, X and Y Z, X, Y Z, Y, X Z Only X and Y, Z X, Y, Z Y, X, Z XY Home X, Y, Home Y, X Home None Home X Home Only XZ and Y

		Home Direction	Input home dir X Dir Neg Y Dir Neg Z Dir Pos
	Accel 	Unit MMPerSec2 LnAccel 800.000 CvAccel 1000.000	
	Start Spd 	Unit MMPerSec SkipSpd 100.000	
	Voltage Setup 	01234567 ↓↓↓↓↓↓↓↓ 01234567 ↓↓↓↓↓↓↓↓	
	Max Spd Limit 	Unit mmPerSec X-MaxSp 600000 X+MaxSp 600000 Y-MaxSp 600000 Y+MaxSp 600000 Z-MaxSp 600000 Z+MaxSp 600000	
	DistTime Limit 	Distance Timeout DistTime 30 o Timeout set 0	
	Input Config 	InputDisableMask X1:Enable X2:Enable X3:Enable X4:Enable X5:Disable X6:Disable X7:Disable X8:Disable	

Machine Setup Parameters

  ***IMPORTANT:*** *The Machine Setup Parameters are preset at the factory and should not need to be changed. If these setting become changed for any reason; contact the factory for reset instructions.*

In general, to change the value or setting of any of the Machine Setup Parameters, press RUN/PAUSE DELETE to active the value to be changed. Input the new number and press the ORIGIN OK button.to save it. The cursor moves to the next line or back to the previous screen.

If it does not need to change, press STOP CANCEL to advance to the next line or to the previous menu.

Pulse Equivalent

 Pulse equivalent means the pulse number when the axis moves 1mm. Its unit is pulse / mm. Pulse equivalent = (360 degrees / step angle).

 ***IMPORTANT:*** *If the pulse equivalent in the controller is different from the factory settings, the processed file size will* ***NOT*** *be to the drawn specification.*

Table Size

 Table size refers to the actual motion size of the axes. Because the system applies the table size as the soft limit, you should set the table size with the number it actually is. Otherwise it will show as “Over the Limit” or it might run into the side rail.

Axis Prohibite

 Turn off the axis or axises that are not used by the controller.

Arc Delay

 Arc Delay is the delay time to allow the torch to establish an arc and pierce the material before moving to complete the file pattern. The arc delay is set in milliseconds. The default value is 300 milliseconds.

Cylinder Delay

This machine does not have an active Z axis. This function is unused.

Home Setup

Three Home parameters are **Home Speed, Home Order,** and **Home Direction.**

Home Speed

Home speed refers to how fast the head returns to the home position.

Home Order

The home order is set for XY Home. This means that the X and Y axises will move to home. If either axis reaches home first, it will stop and the remaining axis will finish it homing.
The order of the letters indicates the order for the axis movement.
A comma is a separator that indicates a pause before the next axis will move. No spaces or the word “And” indicates that those axises will move at the same time.

IMPORTANT: *The Z axis is not active. It is the operator’s responsibility to plan for and consider the path that the head will move in while completing the homing process. Damage to material, tooling and the head or other components from this type of action are not covered under warranty.*

Z, X and Y
Z, X, Y
Z, Y, X
Z Only
X and Y, Z
X, Y, Z
Y, X, Z
XY Home
X, Y, Home
Y, X Home
None Home
X Home Only
XZ and Y

Home Direction

Home direction indicates the moving direction of the axis to reach the home position.

These settings are set for X Dir = Neg, Y Dir = Neg, and Z Dir = Pos. Z us not active and will have no effect. These settings will move the head to the front left corner of the table. Changing these settings to move the head in different directions will change the operation of the table possibly causing damage to the drive motors and gears.

Accel

Linear Acceleration

Linear acceleration relates to line motion ability. Its default is 800mm / sec2. To change, input the value directly and press ORIGIN OK to save. If the auto process speed is less than 10 meters / minute, the acceleration is about 300-600mm / sec2. If the speed is more than 10 meters / min., you should adjust the acceleration value. To return to the menu screen press STOP CANCEL.

Curve acceleration

Curve acceleration relates to curve motion ability. Its default value is 1000mm / sec2. To change, input the value directly and press ORIGIN OK to save. If the auto process speed is less than 10 meters / minute, the acceleration is about 300-600mm / sec2. If the speed is more than 10 meters / minute, you should adjust the acceleration value. To return to the menu screen press STOP CANCEL.

Start Speed

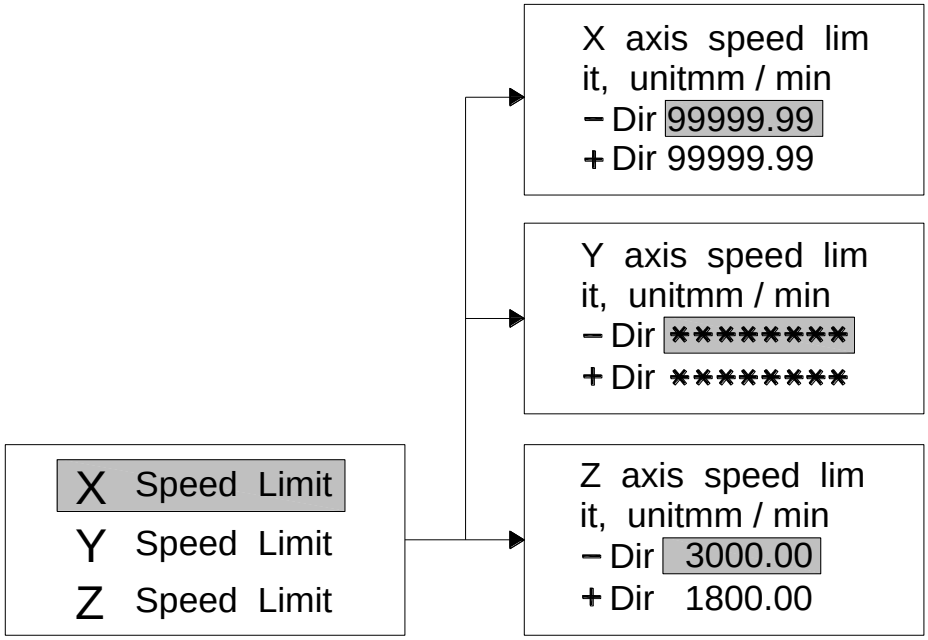
The start speed is set in mm/min. The system default start speed is 100.000 mm/min. This reduces the noise of the low-frequency vibration of the motor. The machine will run smooth from stationary state to full work speed.

Voltage Setup

The voltage property menu shown in the “Machine Setup” chart has been set at the factory. No further adjustments are required.

Speed Limit

Speed limit stands for the MAX speed of X, Y, & Z axes. *This is a default setting and was set at the factory. No further adjustments should be required.*
The machine will run at the default speed if you set up a processing speed higher than the default speed.



Distance Time Limit

This function is active when the manual movement mode is set to distance.
The default value is 30 seconds. When the distance function sets idle and unused for 30 seconds, the system will time out and change the mode back to continuous.
To change the distance time limit,

Press the ORIGIN OK button to enter the setting. If it needs to change, press RUN/PAUSE DELETE to active the value to be changed. Enter the desired time delay and press the ORIGIN OK button to confirm and save the setting. If it does not need to change, press STOP CANCEL to advance back to the previous menu.

Input Configuration

The input configuration is preset at the factory and should not need to be changed. If these setting become changed for any reason; contact the factory for reset instructions.

AUTO PRO SETUP

STOP! The parameters shown in the AUTOPRO SETUP menu below should only be changed by an experienced operator. Failure to do so may result in incorrect machine motions and possible machine damage.

Auto Pro Setup	Work Speed	Unit mmPerMin WorkSpd 3000.00 FastSpd 3000.00	
	Safe Height	Unit mm SafeHgh 40.00	
	Auto Scale	SpeedRatio SpdScale 1.00	
	Stop Statue	Work Stop State FinAct Pickup XCoordnt 0.000 YCoordnt 0.000 ZCoordnt 0.000	FinAct Pickup Z BackToWorkOrg BackHome BackPosition NoneMove
	G Code Setup	F Read Ign F AbsCntr Off T Read Ign T Head NTLLG FilterJD None S Read Ign S Read G54 IgnG54 Read G49 IgnG49 Read G40 IgnG40 CodeHead Skip G83 Spac 0.000	Each item has a Sub-Menus
	Circle Limit	CirclelLimit CirLmt 4242.641	
	Work Array	ArrayParameter ColCount 1 RowCount 1 ColSpace 0.000 RowSpace 0.000 Interval 0 ArryZDlt 0.000	

	Plasma Config 	Plasm Config PreOnDly 0 PreOfDly 0	

  ***IMPORTANT:*** *The Auto Pro Setup Parameters are preset at the factory and should not need to be changed. If these setting become changed for any reason; contact the factory for reset instructions.*

In general, to change the value or setting of any of the Auto Pro Setup Parameters, press RUN/PAUSE DELETE to active the value to be changed. Input the new number and press the ORIGIN OK button.to save it. The cursor moves to the next line or back to the previous screen.

If it does not need to change, press STOP CANCEL to advance to the next line or to the previous menu.

 ***Note:*** *The Auto Pro Setup has mixed configuration of setting. The Work Speed setting will be changed at various times. Settings such as G-Code and Plasma Config should not be changed. Setting such as Safe Height, Auto Scale, Stop Statue, Circle Limit, and Work Array may be changed if the operator takes good notes to be able to return the original settings and if attention is given to the operation after the setting changes to verify that the change has not created any interference or collision issues.*

Work Speed

 The work speed accesses the settings for how fast the head will move around the table during operation. These settings are also accessible when loading a program.
The work speed is the speed the head will move during a program while actually cutting material.
The fast speed is the speed that the head will move at during a program when moving to different positions without the torch actually cutting material.
Press the ORIGIN OK button to enter the setting. Press the X + 1 ▲ or X − 5 ▼ to move the cursor to the line to be changed. Press RUN/PAUSE DELETE to active the value to be changed. Enter the desired speed value and press the ORIGIN OK button to confirm and save the setting. If it does not need to change, press STOP CANCEL to advance back to the previous menu.

Safe Height

 The safe height is the distance that head will rise between the various segments of a cut. This machine does not have an active Z axis. This function is unused.

Auto Scale

 The auto scale is a ratio of the work speed. This is normally set at 1.0.

Stop Statue

 The stop statue is used to set the conditions and actions for table movement when the program has completed running.
The default is that the head stops at the location it is at when it finishes its final cut. This allows the operator to move the head to a location away from the work piece. The operator can see the table and avoid any interference.
Changing this setting to have the head move back to home, origin, or some other predetermined location will require that the operator is prepared to stop the operation should an unexpected obstruction or interference occur.

G Code Setup

 The G code settings have been set at the factory and should not be changes.

Circle Limit

 The circle limit is the size of the largest circle controlled by the radius coordinates. Larger circles and controlled based upon X and Y coordinates similar to diagonal lines.
The default is 4242.641.

Work Array

 The work array sets up the basic grid pattern that the system will use to create a simple nesting layout. These settings will vary based upon the size of the part.

Plasma Config

The plasma config settings have been set at the factory and should not be changes.

SYSTEM SETUP

STOP! The parameters shown in the SYSTEM SETUP menu below should only be changed by an experienced operator. Failure to do so may result in incorrect machine motions and possible machine damage.

System Setup	Languages	LanguageType Chinese English	
	Data Initial		
	Inner Format	System will be formatted, any files in the internal will be removed, do you want to continue?	Stop Cancel = No Origin OK = Yes. Percent count, System is formatted successfully.
	Wipe Cache	Information System cache has been cleared successfully. You must restart system now.	
	Function Config	Set Function PausePkup NoPick SpdlAtP Stop ScaleFast None Manual Trad Pretrt Parse QuryPara Query StrtHome Query FileSort ByCopy CopyWork On RetOrgPZ Pick Z TolstAct Pickup PausRstr All NI Mode Full Bk type CurLn SpdOutpt Polar	Press Run/Pause Delete and use arrow buttons to select choice. Must restart after changes.
	Probation Pas	Please input new time password: 14344120777568198108	

	Backup Pas 	Input new password:	**Make and retain a note of the password created. The factory will not know what this is and will not be able to override this password.
	Input Port 	Input Config X1: Home of 1 axis X2: Home of 2 axis X3: Home of 3 axis X4: Toolset, Plasma cylinder in place X5: None Used X6: None Used X7: None Used	
	Output Port 	Output Config Y1: Spindle CW state, Spindle CCW state Y2: Plasma Cylinder Y3: None Used Y4: None Used Y5: None Used Y6: None Used Y7: None Used Y8: None Used	
	Button Check 	Key Test 1234 OK and 5678 Cancel To 90.M Quit EORC	
	Backup Data 	Backup Target Internal Flash Disk	
	Restore Data 	Restore Target Internal Flash Disk	
	Auto Upgrade 	SelectUpdateFile Udisk File Internal File Recent File	

  ***IMPORTANT:*** *The System Setup Parameters are preset at the factory and should not need to be changed. If these setting become changed for any reason; contact the factory for reset instructions.*

Languages

The default language is **English**. The alternate choice is **Chinese**.

Data Initial

The **Data Initial** feature will display that the format has been initialized successfully. This will then reset the handheld back to the initial factory settings.

IMPORTANT: *These setting will not the same as the operating settings.*

Inner Format

Inner Format refers to formatting the internal flash memory.

IMPORTANT: *These setting will not the same as the operating settings.*

Wipe Cache

The **Wipe Cache** feature is used to erase ALL of the program files stored in memory.

Function Configuration

The **Function Configuration** feature is used to set system functions such as file format, I/O checking, button checking, and system update.

Probation Pass

The **Probation Password** is the factory preset password. This is a 20 digit password.

Backup Pass

The **Backup Password** is the password input by the owner/operator.

IMPORTANT: *Make and retain a note of the password created. The factory will not know what this is and will not be able to override this password. This is not covered by warranty and will require the purchase of a new handheld controller.*

Input Port

Input Port refers to the system checks input terminal properties.

Output Port

Output Port refers to the system checks output terminal properties.

Buttons Check

Buttons Check refers to checking the buttons on the hand held unit. Move the cursor to the line labeled **Buttons Check** and press ORIGIN OK. Press each button on the hand held unit and the corresponding button should highlight on the screen.

To exit back to the previous screen press compound buttons ORIGIN OK + STOP CANCEL.

Backup Data

Backup Data will allow for the internal parameters to be backed up either internally or to a flash drive. A flash drive is recommended. Install a clean well marked flash drive. Highlight the Flash disc and press s ORIGIN OK to confirm the backup. A “data.bak” file will be created on the flash drive. Store the flash drive is a safe location for use should the hand held parameters become corrupted.

Restore Data

Restore Data will allow the “data.bak” file created from the Backup process to be used to restore the specific parameter files. . Install the flash drive with the “data.bak file on it. Highlight the Flash disc and press s ORIGIN OK to confirm the restore. A “data.bak” file will restore the parameters onto the hand held controller. Restart the system to complete the process.

Auto Update

DO NOT use this function!
This will change the controller setting and parameters and is not supported. We will not have the ability to match the settings to you table.

OPERATION FILES

STOP! The parameters shown in the OPERATION FILES menu below should only be changed by an experienced operator. Failure to do so may result in incorrect machine motions and possible machine damage.

Operate File	Copy File	SelectCopyFile Udisk File	SelectCopyFile *Files on Udisk will be listed*
	Del File	SelectRemoveFile Internal File	SelectRemoveFile *Files on internal memory will be listed*
	View File	SelectViewFile Udisk File Internal File Recent File	SelectViewFile *Files on the drive selected will be listed*
	Pro Info	Work Info *The note will tell about the last file that has been run.	
	Check Pro Time	SelectWorkFile Udisk File Internal File Recent File	SelectWorkFile *Files on the drive selected will be listed* Select the desired file. Will then display time in hours, min, sec. to complete the program.

IMPORTANT: *The Operation File Parameters may be used on a regular basis. It is highly recommended that the operator(s) practice and become familiar with the use and operation of these features.*

In general, to use the features or setting of the Operation File Parameters, press RUN/PAUSE DELETE to active the value to be selected. Used the X + 1 ▲ or X – 5 ▼ buttons to scroll to the desired menu item. Press the ORIGIN OK button to select the item. The cursor moves to the next line or back to the previous screen. If it does not need to change, press STOP CANCEL to advance to the next line or to the previous menu.

Copy File

To Copy a file use the X− 5▼ button to scroll down and highlight the **Copy File** line. Press ORIGIN OK to read the following note: "*Please select the file that needs to be copied, **any button** to continue.*" The **U Disk** file list will be highlighted. Press the ORIGIN OK button to list the files. Scroll through and select any file by pressing the ORIGIN OK button. The following note will appear: "*Please select target file, **any button** to continue*". Scroll to a line that says **No file** and press ORIGIN OK. The file will be copied. To do a check, scroll up to the **View File** and press ORIGIN OK. Scroll to and press ORIGIN OK to select **Inner file list.** Your copied file should be listed.

Delete File

To Delete a file, follow the procedure below.

***Note:** Once a file is deleted it cannot be recovered.*

Using the X− 5▼ button scroll down to **Delete File** and press ORIGIN OK. Scroll to the file you want to delete and press ORIGIN OK The screen will show **File Deleted**. Press STOP CANCEL to return to the previous menu.

View File

View File is used to view the files stored on a specific drive. Use the X+ 1▲ or X− 5▼ buttons to scroll up or down to see files on other pages.

Pro Info

This function will display the processing information of the last file which has been run. If no file has been run since the machine was turned ON, the display message will indicate this.
This will display process time and total linear millimeters of travel for the file.

Check Pro Time

This function will display the processing time for the selected file. This time is based upon the current speed settings.

VERSION VIEW

Update Version
Q11-221
Product ID:
A0202400
Soft Version:
A1.2903
Emerg Version:
A1.2268
Soft Type:
Plasma

Hardware Type:
Plasma
3 inch screen
FlashDiskMode

NOTES

NOTES

PT-22 WITH A12 CONTROLLER QUICK REFERENCE GUIDE

START

- Turn on console, → [ORIGIN OK] home is now set.
- Load material.
- Turn on plasma cutter.

SET X, Y ORIGIN

- → [X + 1 ▲] [X − 5 ▼] [Y + 2 ∧] [Y − 6 ∨] to move to desired location for origin
- → [XY→0 4] location is now saved

Baileigh Industrial, Inc.
1625 Dufek Drive
P.O. Box 531
Manitowoc, WI 54221-0531

(Ph): 920. 684. 4990
(Fax): 920. 684. 3944
www.baileigh.com

SET Z HEIGHT

- Manually raise or lower the torch to the height indicated in the table provided by the plasma cutter manufacturer.

LOAD AND RUN PROGRAM

- Insert USB → [RUN/PAUSE DELETE] → Udisk file [ORIGIN OK]
- → [X + 1 ▲] [X − 5 ▼] highlight desired program
- → [ORIGIN OK] → work speed [RUN/PAUSE DELETE] →
- → Enter work speed with keypad →
  [ORIGIN OK]
- Program will execute and start cutting.

BAILEIGH INDUSTRIAL, INC. 1625 DUFEK DRIVE MANITOWOC, WI 54220
PHONE: 920. 684. 4990 FAX: 920. 684. 3944
www.baileigh.com

BAILEIGH INDUSTRIAL, INC. 1455 S. CAMPUS AVENUE ONTARIO, CA 91761
PHONE: 920. 684. 4990 FAX: 920. 684. 3944

BAILEIGH INDUSTRIAL LTD. UNIT D SWIFT POINT
SWIFT VALLEY INDUSTRIAL ESTATE, RUGBY
WEST MIDLANDS, CV21 1QH UNITED KINGDOM
PHONE: +44 (0)24 7661 9267 FAX: +44 (0)24 7661 9276
WWW.BAILEIGH.CO.UK

BAILEIGH INDUSTRIAL GMBH HOFENER STRAßE 64
70736 FELLBACH
DEUTCHSLAND
WWW.BAILEIGHINDUSTRIAL.DE

BAILEIGH INDUSTRIAL PTY. LTD.
P.O BOX 1573, 126 MELROSE DRIVE TULLAMARINE,
VIC 3043 AUSTRALIA
PHONE: 011 61 383 743 888
WWW.BAILEIGH.COM.AU