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## MPCP Setup Walkthrough

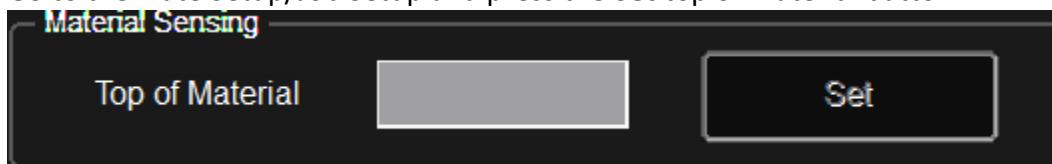
1. After loading the pipe, jog the torch near to where the cut will be go to the back side of the torch and align the bevel alignment gauge with the top of the material.



2. Then jog the torch down to the top of the pipe.



3. Go to the Plate Setup/Job Setup and press the **Set** top of material button.



4. Then jog the Z-axis up and if the torch is not already at the start location, jog the torch to the start location and press the Set Plate Origin/Set Program Zero button.



5. Move to the back again and set the desired bevel angle after setting the top of the

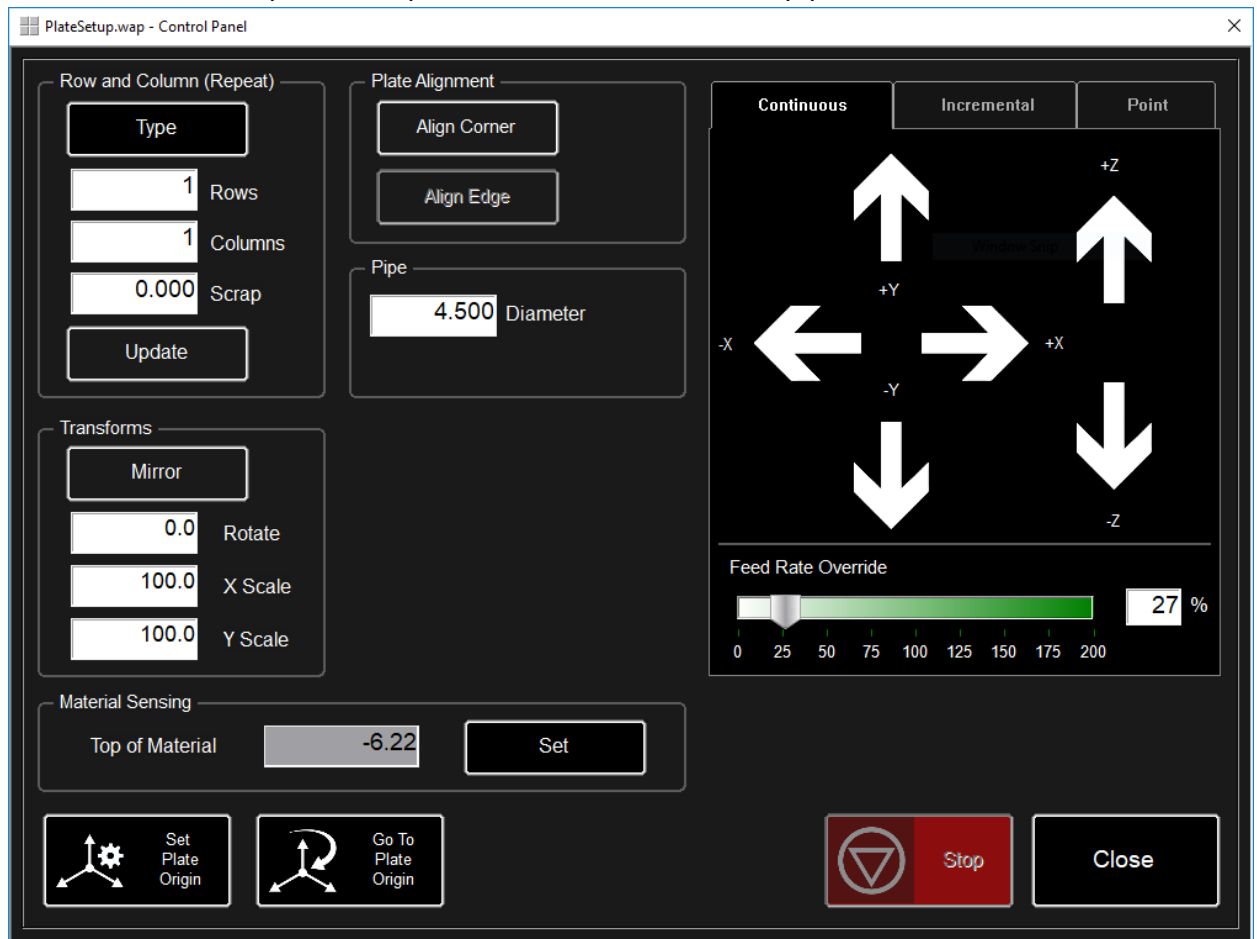


material.

6. In the Process setup tab make sure to set the material thickness and amperage that you will be cutting with for the wall thickness of the pipe.

Process Setup	Graphics	Program	Height Control														
<p>Plasma</p> <p><b>FLEXCUT - 80</b></p> <p><b>Material</b></p> <div><div>Mild Steel</div><div>Stainless Steel</div><div>Aluminum</div></div> <p><b>Thickness</b></p> <div>0.125 Inches</div> <p><b>Current</b></p> <div>40 A</div> <p><b>Plasma Pressure</b></p> <div>Setpoint 80 PSI</div>		<p><b>Cut Parameters</b></p> <table><tbody><tr><td>Transfer Height</td><td>0.160</td></tr><tr><td>Pierce Height</td><td>0.160</td></tr><tr><td>Cut Height</td><td>0.080</td></tr><tr><td>Pierce Delay</td><td>0.500</td></tr><tr><td>Retract Height</td><td>0.250</td></tr><tr><td>Arc Voltage</td><td>113.00</td></tr><tr><td>Feedrate</td><td>145</td></tr></tbody></table>		Transfer Height	0.160	Pierce Height	0.160	Cut Height	0.080	Pierce Delay	0.500	Retract Height	0.250	Arc Voltage	113.00	Feedrate	145
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7. Go to the Plate Setup/Job Setup and then set the OD of the pipe to be cut.



8. You can now open the job that you would like to cut by going to Select Job, make sure that Is Job Kerf Compensated is set to YES, find the job and click open.
9. You can adjust the Feed Rate Override if needed, and make sure that the IHS is set to off if you are cutting black iron pipe.
10. I personally like to do a dry run on the job to make sure that the torch is not making contact with the material when beveling. If it is raise the cutting height slightly to compensate for this.
11. From here you should be able to go to active run and Run Job.