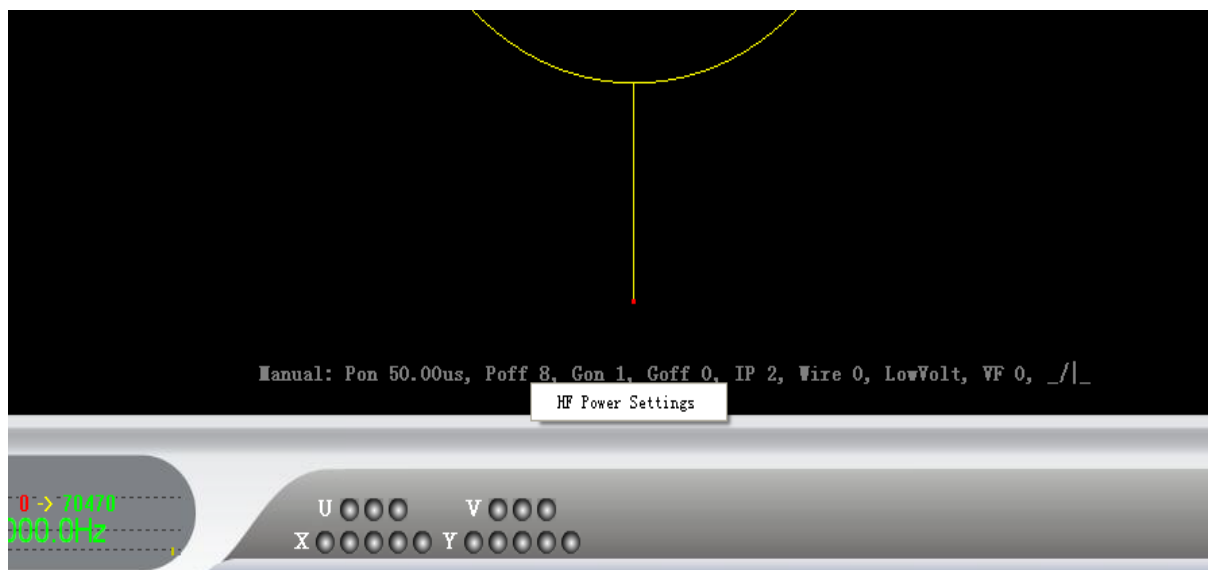


Manually setting the parameters please –right-click the mouse. And choose the HF power setting.



You will see follow Picture.



1. Pulse on, means the pulse on time, the bigger you choose the Pon, the cutting speed will be higher, but the surface finishing will be worse and the wire easy to be broken.
2. Pulse off, means the pulse off time, the bigger you choose the Poff, the cutting speed will be lower, but the surface finishing will be better. And the chips will be easy to remove.
3. Please change Group On is "1", Group Off is "0",
4. Current is the IP ,you can choose 1-6, means the Power you choose, the higher you choose, the cutting speed will be faster, but easy to broken the wire and the surface finishing will be worse
5. Wire speed, means the wire winding drum running speed. During putting the wire to the drum , you should choose the lowest speed level "3". For normal cutting, we always use level "0" the highest speed.

6. Voltage, you can choose low voltage (the max Voltage is around 80V), the higher Voltage is around 100V.

7. VF is the follow speed, which used for adjust the stability of cutting, the smaller you choose, the slower the follow speed. If you choose "0" means without setting follow speed.

8. Max speed, means the max cutting speed. You can choose 0-500. Normally, choose 300. If you cutting higher thickness, should choose bigger value, if you cutting thinner work piece, should choose big value. If you choose "0", means without setting max cutting speed.

13. Then you click "Update"