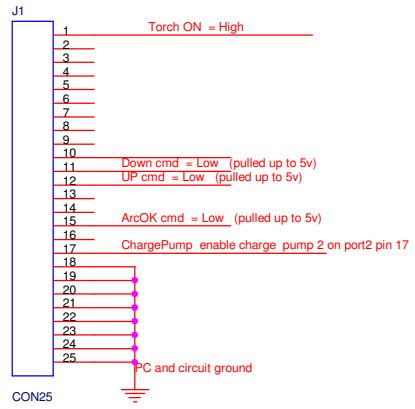


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To calibrate the THC for using the Divided tip volts.  
seen the plasma manual to determine the division ratio.  
Like 50:1 divide 250 by that number  $250/50 = 5$   
connect a 5v ps to J12-v J13 +v  
Start Mach3, click reset. You will see the Ready LED on  
the front panel. adjust the voltage on the meter to full up 255v using the coarse and fine controls.  
clip a lead across the ArcOK sw input J4 and J5. You will see the ArcOk led on the front panel.  
Toggle the Torch ON. You will see a voltage on the meter.  
adjust it to read 250 volts using VR1 on the main board in the box.  
remove the jumpers and the 5v signal.  
connect the divided tip volts out to J12-v and J13+v

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