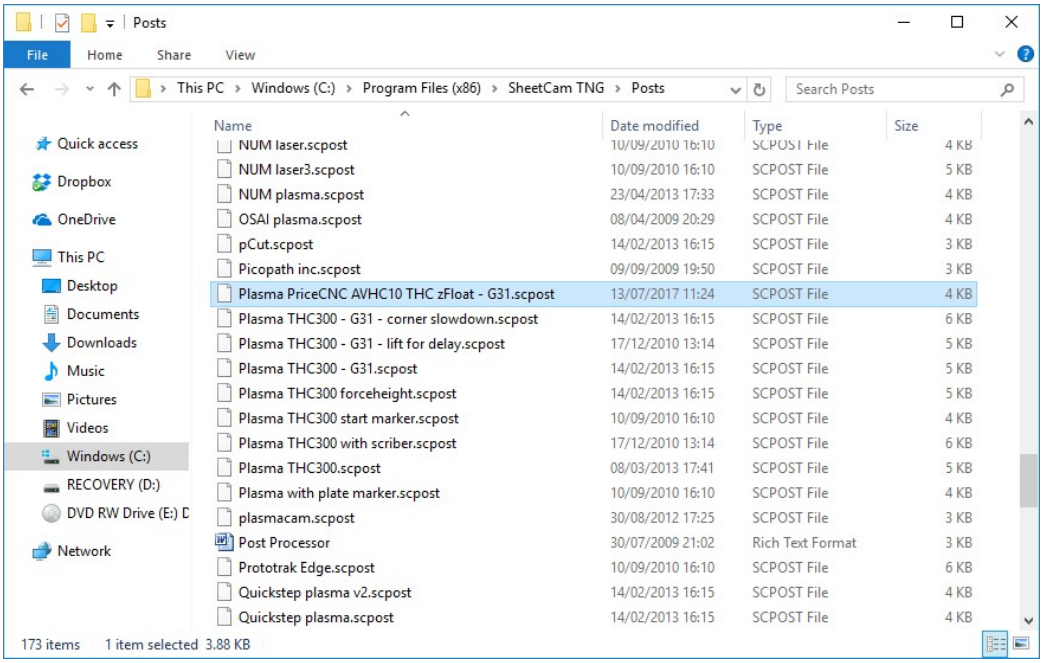
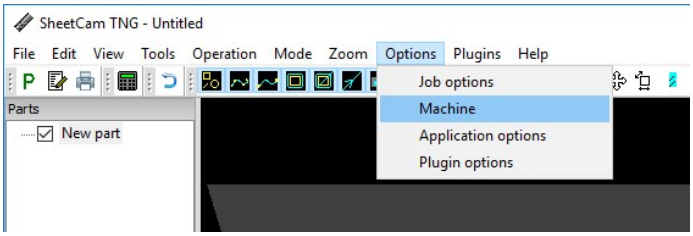
# How to add the Post Processor for the PriceCNC AVHC10 Arc Voltage Height Controller to Sheetcam TNG software

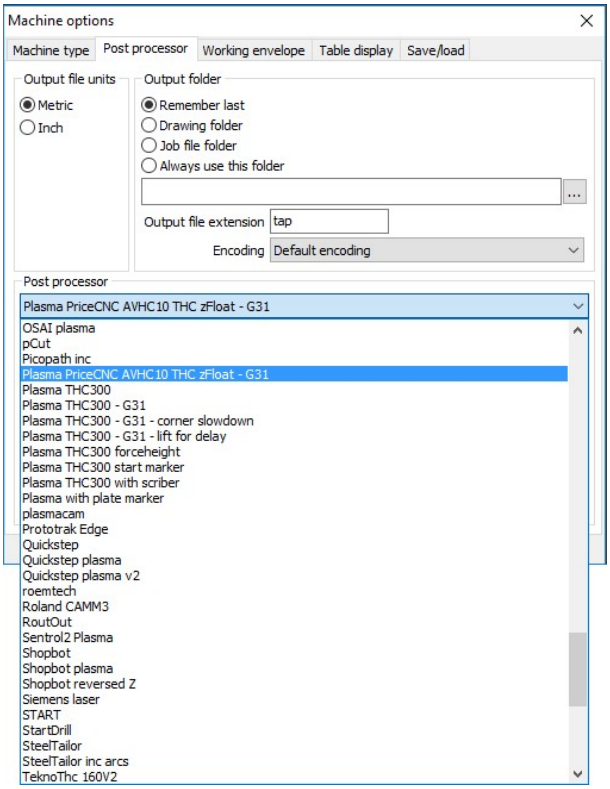
1. Downlaod the Post Processor to your PC.
2. Open the Downloads folder on your PC and find the following file:
   *Plasma PriceCNC AVHC10 THC zFloat - G31.scpost*
3. Right-click and Copy the file.
4. Open the Sheetcam folder on your computer, usually filed under C:\Program Files (x86)\SheetCam TNG\Posts then right-click and Paste the post processor in to this location.



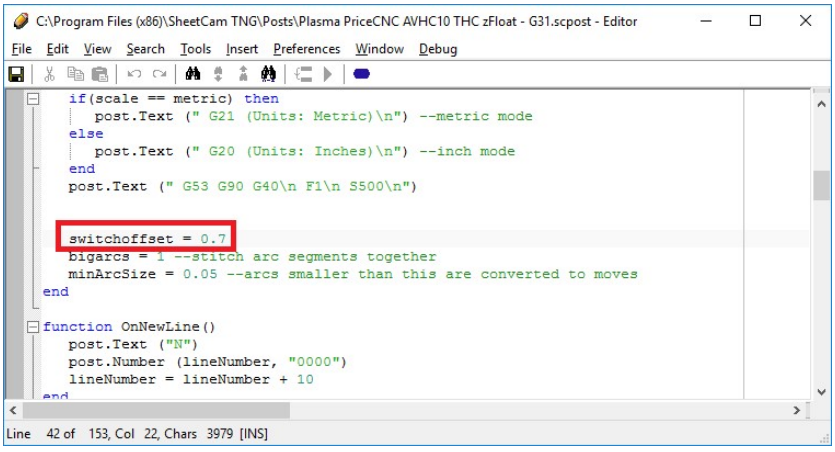

5. Open the Sheetcam Software
6. From the menu bar click on Options > Machine



7. Click on the Post Processor Tab
8. From the dropdown list select the *PriceCNC AVHC10 THC zFloat - G31* Post Processor

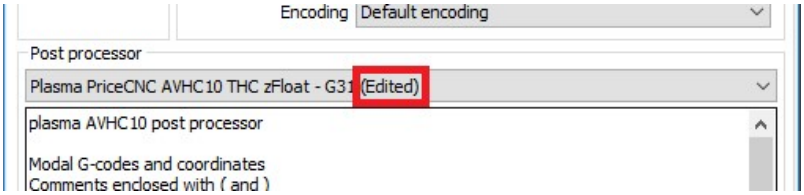



9. Click on Edit post to open the post processor editor and locate the section of the code called switchoffset.



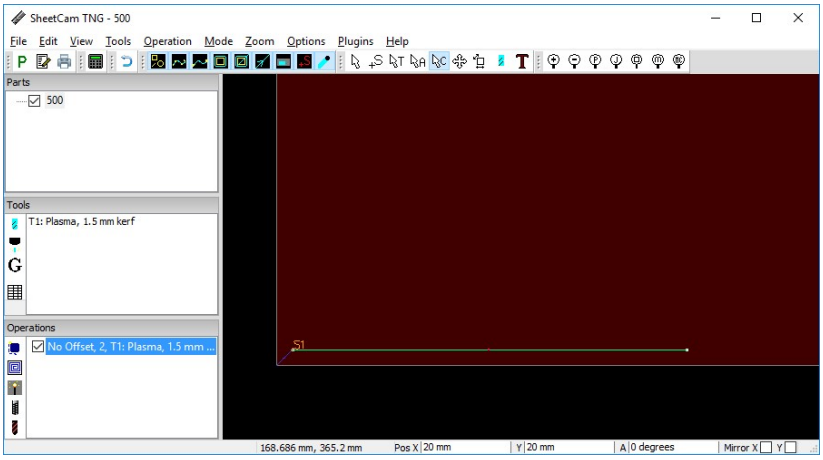

10. The switchoffset needs to be set to the vertical distance travelled by the z-axis from, the position where the decending torch touches off the material, to the position where the probe/floating-z switch is triggered. To determine this value, slowly lower your z axis until the torch just touches the work piece. Then reset the Z-axis DRO to zero and lower the Z-axis very slowly until the probe switch is activated (probe signal visible on Diagnostics screen in Mach3 or UCCNC). The distance travelled by the z-axis between these two points is the switch offset value you require. Change this value as required.

11. Save your changes, your new saved version of the post processor will default to this location: *C:\Users\username\AppData\Roaming\SheetCam TNG\posts* and will appear in Sheetcam with (Edited) beside the Post Processor name




# Sample of G-code

For this example, I created a simple cut job with just one 500mm long horizontal line.




When I run the post processor it creates G code like the below:

N0010 (Filename: 500.tap)
N0020 (Post processor: Plasma PriceCNC AVHC10 THC zFloat - G31.scpost)
N0030 (Date: 12/04/2017)
N0040 G21 (Units: Metric)
N0050 G53 G90 G40
N0060 F1
N0070 S500
N0080 (Part: 500)
N0090 (Process: No Offset, 2, T1: Plasma, 1.5 mm kerf)
N0100 M06 T1 (Plasma, 1.5 mm kerf)
N0110 G00 X20.0000 Y20.0000 Z10.0000 = Move over start position
N0120 G31 Z -100 F500.0 = Lower Z-axis until probe command is received
N0130 G92 Z0.0 = Reset Z-axis DRO to zero
N0140 G00 Z0.7000 = Move z-axis up to the switch-offset value
N0150 G92 Z0.0 = Reset Z-axis DRO to zero
N0160 G00 X20.0000 Y20.0000 Z3.0000 = Move to pierce height
N0170 M03 = Fire torch
N0180 G01 Z1.5000 F100.0 = Move to cut height
N0190 X520.7285 = Cut material
N0200 M05 = Torch off
N0210 G00 Z10.0000
N0220 M05 M30