

WATTSAN 0503 Hobby-T CO2 Laser Machine Manual



Wattsan

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Dear customer!

Thank you for purchasing our equipment. We hope that his work will delight you for a long time.

The machines are manufactured in accordance with global standards. Each equipment undergoes pre-sale preparation.

First of all, we strongly recommend that this manual be read carefully and completely before using the equipment. Failure to comply with certain points of the Operating Manual may result in injury to personnel and/or damage to equipment!

Follow the instructions in this instruction. This will not only make the work easier, but also make the use of the equipment safe and long-term. Please follow these instructions carefully.

This document is intended to provide an overview of the basic technical data and requirements for the use of the Wattsan machine.

In the event that the equipment is transferred to another customer, this document shall be transferred with it.

The manufacturer reserves the right to make changes and improvements to the design that do not impair the declared characteristics of the equipment.

Basic information about the equipment and its technical data:

Equipment name:

Serial Number:

Month and year of issue:

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Information about signs and symbols

In this instruction manual, the following designations, signs and symbols are used to convey particularly important information:

	This indicates a hazardous situation that could result in serious injury or death if the specified instructions are not strictly followed.
	Indicates a potential hazard that could result in minor injury or damage to the product.
	It contains important information about the safe and correct handling of the product.
	This component is energized. In these places, strictly follow the safety rules when working with electricity.
	Caution: Laser beam hazard.

Read the instructions carefully before starting.

Note!

The equipment you directly purchased may differ from the equipment shown in the figures.

	Untrained personnel should not be allowed to work with or install this equipment.
	The equipment complies with a safety class 4 laser source. The use of this equipment may lead to the following consequences: • Ignition of nearby materials • Materials exposed to laser radiation can become sources of dangerous gases • Laser beams can cause direct harm to humans
 MUST-DO	The location of the equipment must be equipped with fire extinguishing equipment. It is forbidden to store flammable and explosive substances near the device.
 MUST-DO	The user must ensure that the material to be processed is suitable for laser processing to avoid risks to personnel and equipment operation.
 FORBIDDER	The operator must not leave the equipment unattended while it is in operation. The equipment must be turned off at the end of operation.
	The use of highly reflective materials is prohibited to avoid the reflection of the laser beam on a person.
	The equipment must be located in a dry, uncontaminated place. The temperature inside the room should be 10-40 Co. Humidity should be in the range of 5-70% (provided there is no condensation).
	The equipment operates from an alternating power supply of 220V with a frequency of 50 / 60 Hz. It is forbidden to use the equipment without a voltage stabilizer.

Attention!

The seller is not responsible for the improper use of the equipment and if the user fails to take precautions.

Specifications

Model	0503 Hobby-T
Working field, mm	500x300
Laser power, W	55
Diameter of the laser tube, mm	55
Wavelength, nm	10600+-10
Focal lens	D18
Mirror diameter, mm	D18
Axle Motors	two-phase stepper motors
Cutting speed, mm/s	<500
Engraving speed, mm/s	<500
Positioning accuracy, mm	0,03
Control system	Ruida
Software	RDWorks
Supported formats	PLT, DXF, BMP, JPG, PNG, etc.
Supported OS	Windows XP/7/8/10/11 (32/64)
Connection Interface	USB / Ethernet / Wi-Fi
Cooling system	Water (built-in)
Ambient temperature range, °C	10~35
Ambient humidity value, %	<70
Air assist	Built-in air compressor
Gas pressure in the system, MPa	<0,4
Power Supply Configuration	220±10% V AC 、 50/60 Hz
Dimensions (LxWxH), mm	590x1035x275
Package dimensions (LxWxH), mm	715x1145x400
Classification of the laser system	Class 4

Equipment

Name	Quantity
Laser Cutting Machine	1 pc
Power Cable	1 pc
Allen wrench set	1 pc
Duct tape	1 pc
Sealant	1 pc
Corrugated pipe 2m	1 pc
Ethernet Cable	1 pc
USB Cable A-A	1 pc
USB-flash drive	1 pc
Machine manual	1 pc

CHAPTER 1. INTRODUCTION

1.1 MAIN PURPOSE AND SCOPE OF THE EQUIPMENT

The WATTSAN **CO₂ laser machine** is designed for high-precision **cutting** and **engraving** of non-metallic materials using laser radiation. This equipment allows you to automate and optimize the processes of processing materials with high quality and accuracy. The machine allows you to perform both serial and small-scale production of products of various complexity with minimal time and resources.

1.2 BASIC OPERATING REQUIREMENTS

- 1) Connected Ground: Ground resistance $<5 \Omega$.
- 2) It is necessary to install a mains voltage stabilizer to stabilize the voltage of the machine.
- 3) Good ventilation is required to prevent the accumulation of dust and combustion products.
- 4) Operation of the equipment is allowed only with an activated built-in air.
- 5) To prevent fire, the workplace must be equipped with a suitable fire extinguisher.
- 6) There should be a clear space around the machine of about 1 m on each side.

1.3 IMPACT ON THE ENVIRONMENT AND PEOPLE

The laser machine belongs to the IV class of laser equipment. Its laser beam and reflected light can cause damage to the human body (especially the eyes). The operator and operating personnel should pay attention to eye protection and use special glasses (with radiation protection with a wavelength range of 10600 nm).

Chapter 2. Safety Instructions

2.1 OVERVIEW

Before operating the machine and performing daily maintenance, the operator should read this chapter carefully, learn the safety precautions and requirements of the machine, and follow the appropriate precautions.

2.2 ENSURING THE SAFETY OF WORKING WITH EQUIPMENT

- 1) It is necessary to appoint an industrial safety specialist for the operation of the equipment, determine the scope of his responsibilities and provide safety training for the machine operator.
- 2) Specify the machine location area, set a warning card for entering and exiting the machine area, specifying: machine power, type of laser source, type of eye protection used, full name of the industrial safety specialist, etc.
- 3) The machine operator must receive special training.

2.3 LASER SAFETY WARNING



Never point the laser beam at people or animals. High-power laser radiation can cause serious burns or damage to vision. Always keep an eye on the direction of the beam and control its movement.

2.3.1 EYE AND SKIN PROTECTION

Laser radiation can damage the retina of the eye. The laser can cause cataracts of the eye and skin burns. Therefore, appropriate protective measures are applied when adjusting the laser. This machine is equipped with a CO2 laser source class 4; **it is prohibited to work with the lid open**. The lid glass is equipped with radiation protection for a wavelength range of 10600 nm.

A combination of face shields, masks, filters, and/or goggles will provide better protection while the equipment is running. All personnel working near the laser treatment area are advised to wear PPE.

	Parts can be very hot even after the machining process is complete. Take steps to prevent skin damage by wearing protective clothing such as flame retardant gloves, caps, leather apron, and other flame retardant clothing. Sleeves and collars should be buttoned.
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2.3.2 FIRE PROTECTION

Sparks during operation can easily cause a fire. Therefore, there should be no flammable and explosive objects in the working area of the machine.

	Fire extinguishers should be nearby and accessible, and staff should be trained in their use.
--	---

2.3.3 SECONDARY RADIATION HAZARDS

During engraving and cutting, both visible and invisible light radiation is generated. The interaction between high-power laser light and the materials being welded can create plasma, which produces UV radiation and "blue light," which can cause conjunctivitis, photochemical damage to the retina, and/or a sunburn-like skin reaction. Even short-term exposure to invisible ultraviolet light during laser operation can cause blurred vision, burning, watery eyes, eye pain, and irritation (a feeling of sand in the eye).

	To avoid the effects of radiation, it is necessary to work with the lid closed.
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2.3.4 SMOKE POISONING HAZARDS

The smoke emitted from the material during laser treatment can consist of very small particles and gases, the smoke and gas are formed from a mixture of fumes of the material being treated, paints, coatings, taking into account chemical reactions and air pollutants. Smoke can negatively affect the lungs, heart, kidneys and central nervous system. When the laser interacts with materials such as plastics, metals, composites, the material can start to evaporate. Often the fumes and mist are not visible, but they are highly toxic and pose a serious health risk.

Handling material in a poorly ventilated confined space is extremely dangerous. Dangerous concentrations of toxic fumes and gases can build up very quickly, causing loss of consciousness or death by suffocation.

	Always work in an area with adequate ventilation. Use a fume extraction system to remove vapours, particles, and hazardous debris from the machine operating area.
---	--

Keep your head away from smoke while working. In confined spaces and other circumstances, a respirator may also be required.

Read and follow the safety guidelines and warning labels for all materials used.

Regular air monitoring should be carried out to determine the levels of hazardous vapours in the area of operation.

2.4 ELECTRICAL SAFETY

- 1) Make sure the installation is properly grounded.
- 2) Make sure the correct AC supply voltage is used before applying power to the unit. Using the wrong voltage may damage the installation.
- 3) Never use the device in a humid or wet environment. Do not touch electrical contacts and switches with wet hands to avoid electric shock.
- 4) Do not open the electrical cabinet or change the machine parameters without consulting the manual. If you need to change something, then these changes must be approved with the equipment supplier. Before modifying, record the original values so that the machine can be restored to its original parameters if necessary.
- 5) Always turn off the device when not in use. Never leave the laser machine running unattended.

	After turning off the power to the machine, you must wait at least 5 minutes, and only then you can touch the electrical circuit of the machine. For a period of time after the power is turned off, there may be a high voltage in the machine's electrical system, which can cause harm to people and equipment.
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2.5 OBLIGATIONS OF THE OPERATOR

- The operator must undergo special training in order to start working on the machine.
- Follow the instructions for regular maintenance of the appliance to keep it operational and prevent accidents.

	It is forbidden to work on faulty equipment. If a fault is detected, turn off the equipment and unplug it. Inform the specialists. Do not repair the equipment yourself.
---	--

2.6 PROCESSING MATERIALS

- Before processing, the operator must ensure that the material is suitable for processing.
- It is forbidden to process Teflon, polyvinyl chloride (PVC), getinax, fluoroplastic, vinyl, any other fluorine, chlorine, bromine, iodine, astatine-containing materials on the equipment, as the gas emitted during cutting is extremely harmful to human health, and spoils the mechanics and optics of your equipment.
- It is forbidden to process materials with a high reflectance in the IR spectrum.
- Before handling materials, the operator must check whether harmful substances can be generated during their processing and whether your extraction (filtering) peripheral equipment is suitable for this type of material.
- Work with materials that emit caustic substances (acrylic, plastic, etc.) must be carried out with the lid closed and respiratory protection equipment must be used to avoid poisoning.



It is the responsibility of the user to take into account national and regional thresholds for dust, mist and gases when selecting filters and exhaust systems.

Chapter 3. Transportation and installation

3.1 ACCEPTANCE



Keep the packaging box. You will need it in case of return. Dispose of all waste in accordance with current waste disposal legislation.

- 1) After opening the package, check the complete set.
- 2) Check the equipment for damage in transit.



First of all, carefully inspect the laser tube for chips or broken glass, both inside the laser tube and outside. This is the most fragile part in your equipment!

3.2 INSTALLATION

- The machine must be installed on a flat surface without bevels and slopes. It is necessary to leave free space on the sides of the machine from 1 m.
- The space around the machine should be freed up for quick and easy access to the panel and other machine components.

3.3 REQUIREMENTS FOR THE PREMISES

1. Ambient temperature

When operating the machine, the ambient temperature should be between +10 °C and +40 °C. When the equipment is switched off, the ambient temperature should not be lower than + 4 °C. If the ambient temperature is above 40 °C, a device that lowers the temperature (e.g. air conditioner) must be installed in the room.

2. Humidity

For the correct operation of the equipment, it is recommended to use it at a relative humidity of <70%. A wet room is not suitable for the operation of the machine, as it corrodes it, which leads to the failure of the electrical and mechanical systems of the machine



It is forbidden to use the equipment at a relative humidity of more than 70%.

Do not use the equipment at temperatures below the dew point.

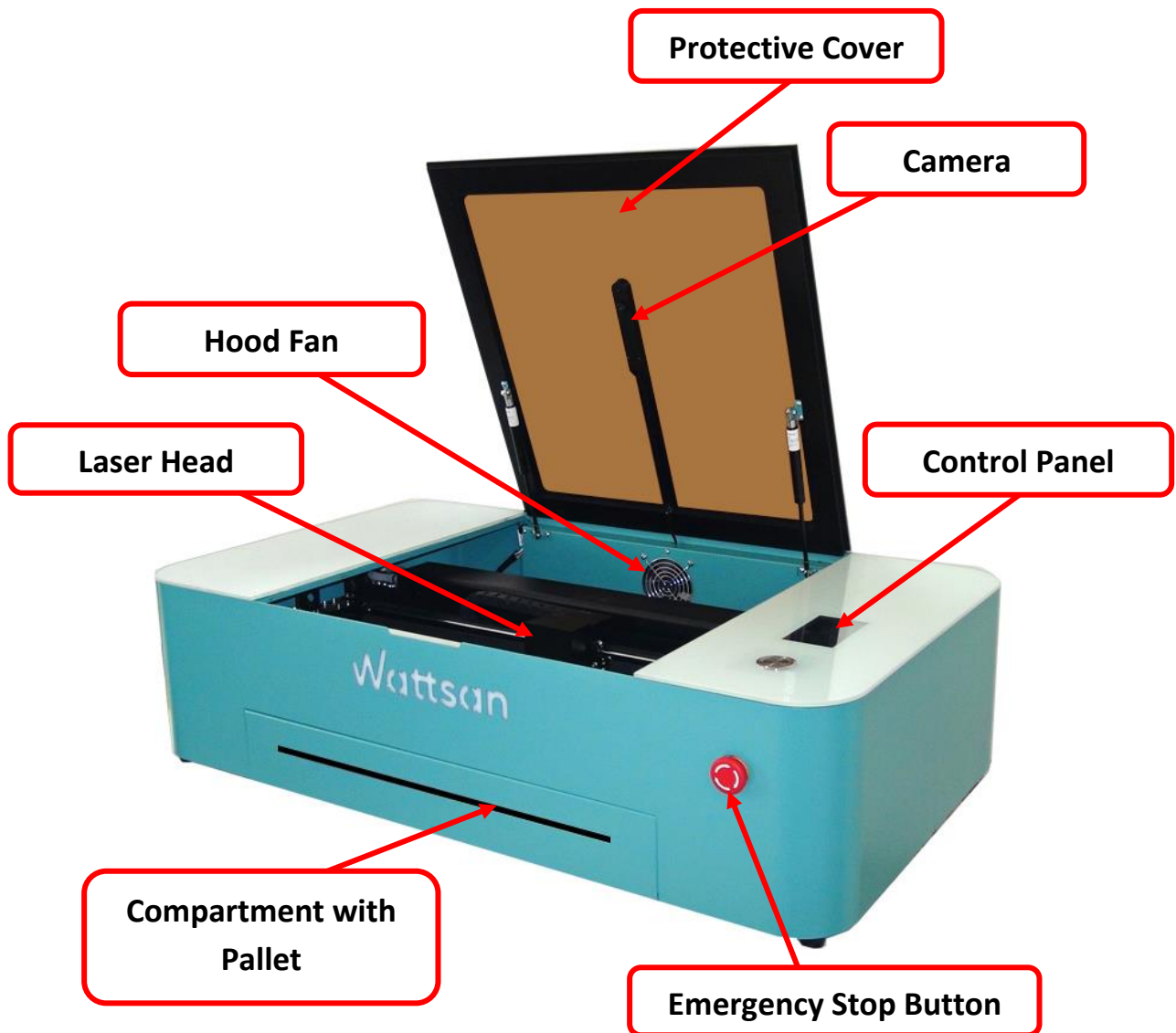
Temperature	Humidity															
	20%	25%	30%	35%	40%	45%	50%	55%	60%	65%	70%	75%	80%	85%	90%	95%
16°C				0	2	4	5	7	8	9	10	11	12	13	14	15
18°C			1	3	4	6	8	9	11	12	13	14	15	16	17	18
21°C		1	3	5	7	9	11	12	13	14	16	17	18	18	19	21
27°C	2	5	8	10	12	13	16	17	18	19	21	22	23	24	25	26
29°C	4	7	10	12	14	16	18	19	21	22	23	24	26	27	28	28
32°C	7	10	12	15	17	19	21	22	23	25	26	27	28	29	31	31
35°C	9	12	15	17	19	21	23	24	26	27	29	30	31	32	33	34
38°C	11	14	17	20	22	24	26	27	29	30	31	33	34	35	36	37

3. Cooling of electrical components

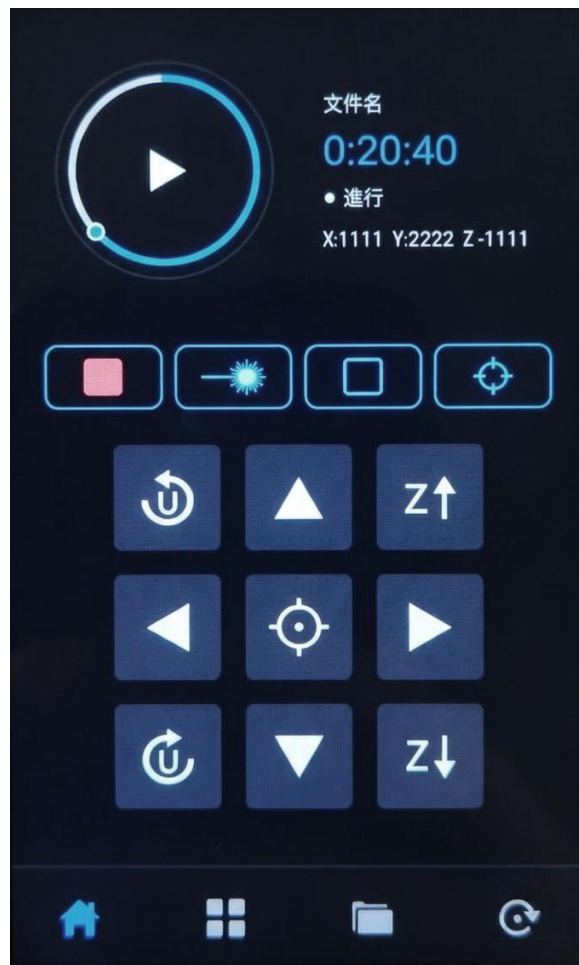
Cooling of the equipment inside the cabinet is carried out by air circulation. Therefore, it is important that the parts inside the cabinet are not contaminated with dust and dirt.

Chapter 4. Equipment design

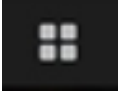
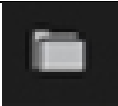
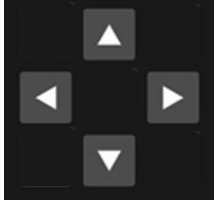
4.1 APPEARANCE



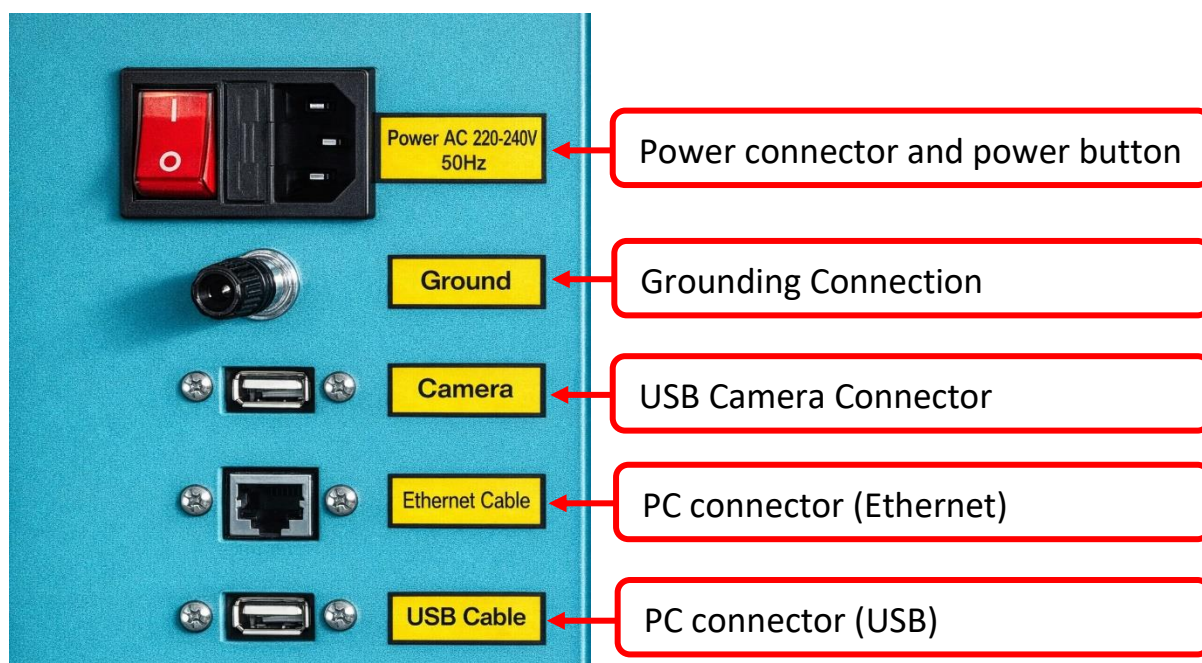
4.2 CONTROL PANEL



1		Reboot the system. The laser machine is restarted, and the laser heads go to the end sensors.
2		Start of the selected control program / Pause the execution of the control program.
3		Launch of laser radiation in manual mode. Used for testing or alignment.
4		Stops the execution of the daemon program.
5		Automatic focal length search (if you have a special sensor).
6		Traces the processing area of the uploaded file with the laser head.

7		Access to the controller settings menu.
8		Menu for accessing the list of control programs loaded into the controller's memory.
9		Move your head or select menu items.
10		Resetting coordinates to zero
11		Movement along the Z axis upwards.
12		Move down the Z axis.
13		Movement along the U-axis in a positive direction.
14		Movement along the U-axis in the negative direction.

4.3 BACK PANEL



Chapter 5. Installation

5.1 INSTALLATION OF THE EXHAUST SYSTEM.

The laser machine has an exhaust fan installed by default.

Take a corrugated pipe and a clamp. Install it and secure it with a metal clamp.



The other end of the corrugated pipe must be connected to your ventilation system.

5.2 GROUND WIRE CONNECTIONS

There is a special ground wire connection point on the laser machine bed. The machine comes with a ground connection wire.



Unscrew the plastic washer, secure the cable to the metal screw, and screw the plastic washer back to secure the ground cable. Check that the wires are tight enough that it will not fall off or dangle.

You need to connect the other end of the wire to the common ground point in your room.

5.3 VOLTAGE STABILIZER CONNECTIONS

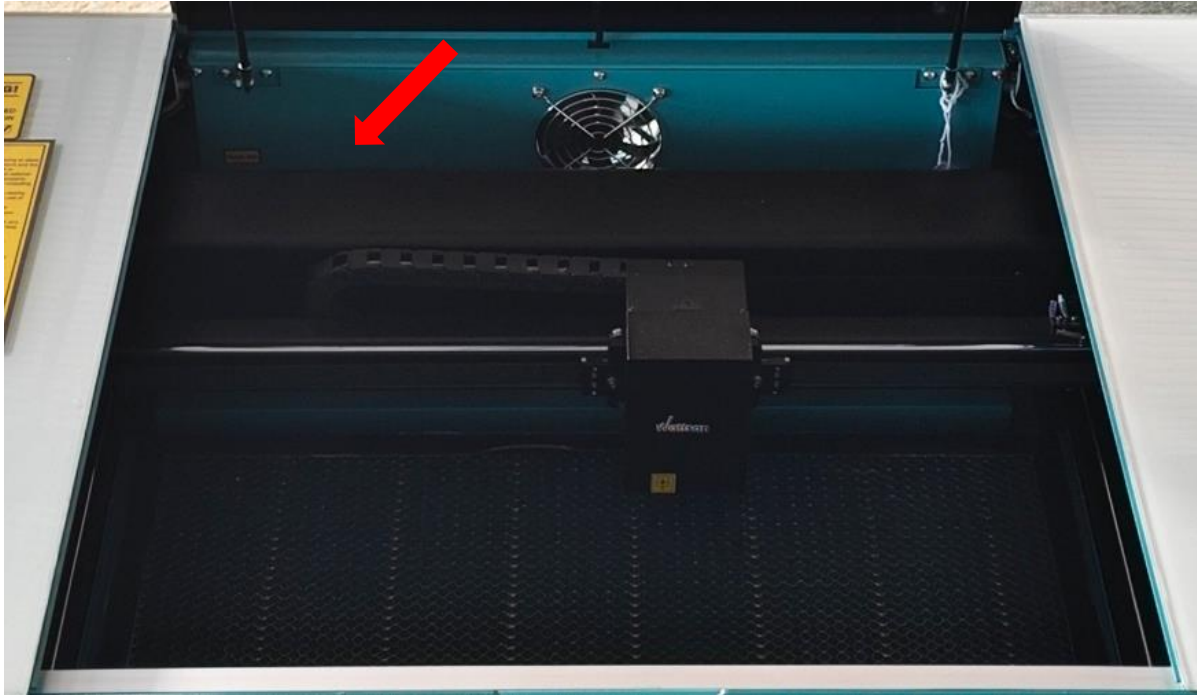
To ensure the proper operation of your equipment, it and all peripherals must be connected through a voltage stabilizer.

- Choose a voltage stabilizer that is suitable in power for your equipment (including chiller, PC, exhaust fan, etc.).
- Connect your gimbal to the ground.

5.4 CONNECTING THE ROTARY AXIS (OPTIONAL)

A rotary device is a special mechanism installed on a laser machine, which is designed to rotate workpieces during processing. The swivel device consists of a cylindrical clamping chuck fixed on the bed, and a stop - a rear centering stop moving on a skid. The rotary axis is driven by a stepper motor.

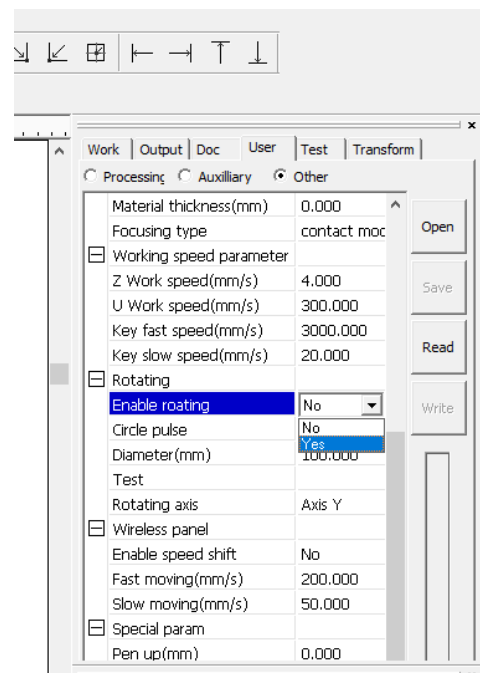
To connect, the plug from the rotary device must be connected to a special connector located behind the machine field. Next, you need to activate the switch for turning on the rotary device, located next to the connector.



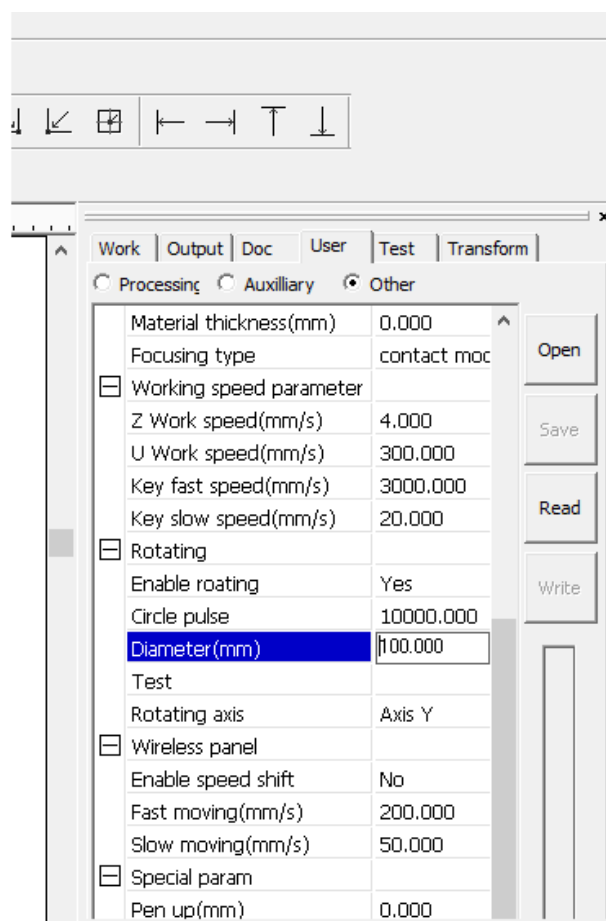
5.4.1 SETTINGS IN RDWORKS

1. Launch RDWorks

2. In the tab, find User Settings -> Other -> Rotating -> Enable rotating. And set it to Yes.



3. In the tab, find User Settings -> Other -> Rotating -> Diameter. And set a value equal to the diameter of your workpiece in mm.



4. Run the control program. If everything is correct, then the rotary device will rotate exactly 360 degrees.

5. If not, then you need to choose a gear ratio. It can sometimes be calculated empirically, since the usual error can be 2, 4 or 8 times. Or you can open the casing of your rotary device, where the stepper motor and gearbox are located, and find the gearbox pulleys there. It is necessary to measure the diameter of both gearboxes and find their ratio, it is usually equal to 1:2 or 1:3 or 1:4.

According to these calculations, you need to multiply or divide your Circle pulse value in the RdWorks program by 2 or 3 or 4.

6. Run the control program. If everything is correct, then the rotary device will rotate exactly 360 degrees. If not, go back to step 10.



When creating a control program for processing your workpiece, take into account that the dimensions of your drawing in the control program do not exceed the circumference of your workpiece.

CHAPTER 6. SETUP AND OPERATION

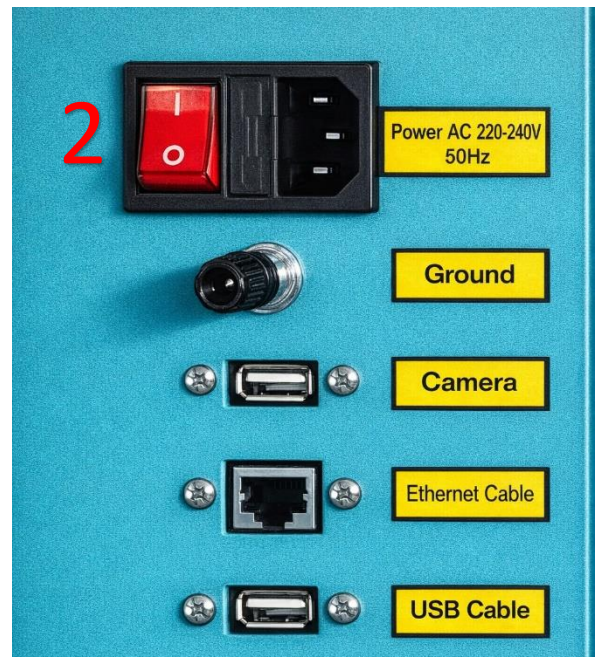
All electrical connections must be made before power is supplied to the unit. Whenever possible, all connectors should be secured with screws to ensure proper operation. The first start of the machine should be carried out by a specialist and carried out strictly in accordance with the rules set out in this manual. Correct setup is the basis for ensuring the normal operation of the machine.

6.1 EQUIPMENT ACTIVATION PROCEDURE

1. On the front panel, turn the emergency shutdown button clockwise.



2. Turn on the power on the back of the machine.



After the machine is turned on for the first time, it is necessary to check the basic settings of the machine and, if necessary, adjust the machine.

	Before starting the laser source, it is necessary to visually check the optics of the machine for contaminants: reflective mirrors and focusing lenses. Clean if necessary.
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6.2 MACHINE SHUTDOWN PROCEDURE

1. Disconnect the power to the rear panel of the machine.
2. Hold down the emergency stop button.

6.3 FOCAL LENGTH

The focal distance is the distance between the lens in the laser head and its focal point, at which all the beams from the laser emitter converge. The focal length must always be observed to ensure the best possible cutting through of your material.

This machine has an automatic focal length detection function (autofocus).

To use this feature, follow these steps:

1. Place the workpiece on the work field.
2. Position the laser head over the workpiece using the navigation buttons on the control panel.
3. Press the Auto Focus button. (The laser head will begin to descend until it touches the surface of the workpiece, then move up)
4. The focal length is set. You can get to work.

Note: By default, the focal length is set for the lens that comes with the machine. If you are using a lens with a different focal length, you must change the focal length setting in the system settings.

6.4 CONNECTING TO A PC VIA USB

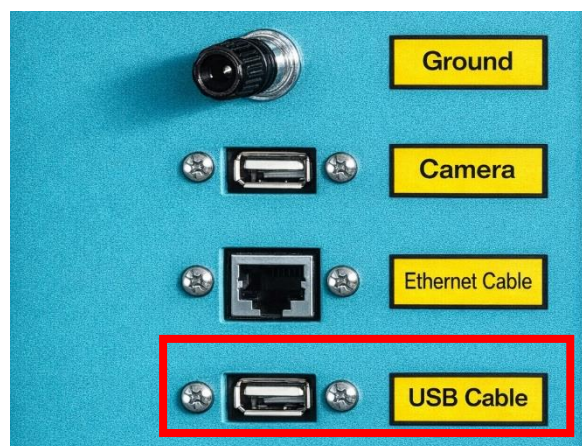
All control programs for the laser machine, power and speed settings are made on a PC in RdWorks or Lightburn programs.

To connect the machine to a PC:

1. Take the A-A USB cable that comes with the machine.



2. Plug the A-A USB cable at one end into the USB connector labeled USB Cable, which is located on the back of the machine.



3. Connect it to your PC with the second end.



4. Start the machine and PC.

5. After starting the PC, your system should detect a new unknown device.

6. Insert the USB drive that came with your machine into your PC.

7. Find the RdWorksSetup.exe program on it and copy it to your computer.

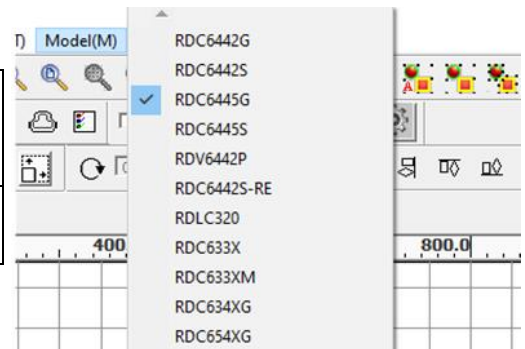


8. Launch this program and follow the installation instructions. In the process, the program will offer both the installation of drivers and the installation of the main RdWorks program.

9. Once installed, the RdWorks shortcut will appear on your desktop. Launch it.

10. Select the correct controller model in the list of controllers:

Controller on the machine	Selection in the RdWorks list
Ruida RDC 8445	RDC8445S

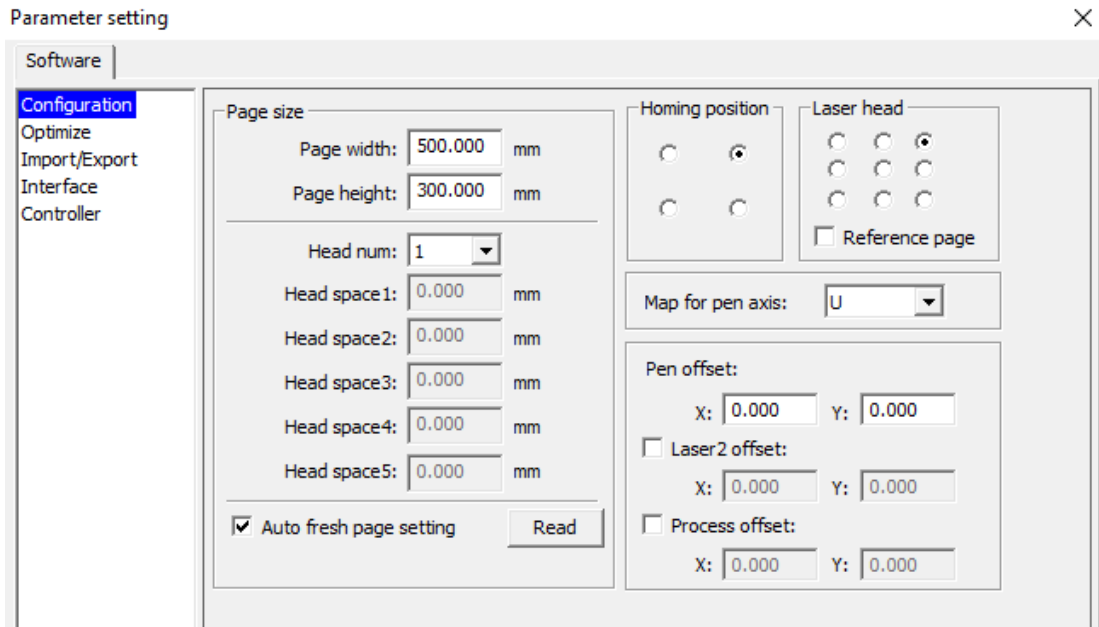


11. Set the working in the program according to the working field of your machine

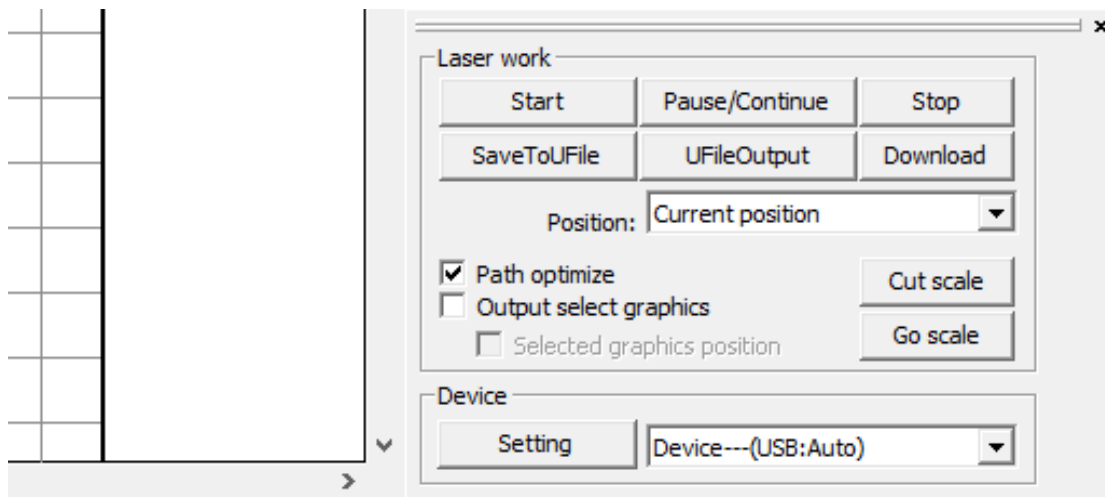
Start the RdWorks program. Go to Config - > System settings. In the Homing position field, set a point in the upper left cell.



If your layout is displayed incorrectly (mirrored) on the machine display when loading the layout into the machine memory, select a different point in the Homing position settings.



In the lower right corner of the program, check that the Device field is set to Device---(USB:Auto).

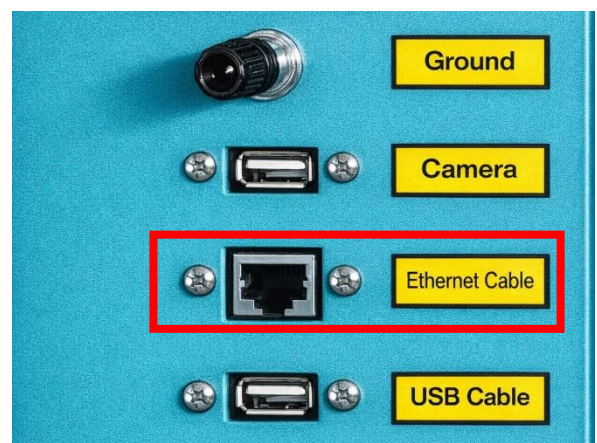


6.5 CONNECTING TO A PC VIA ETHERNET

The equipment can be connected to the computer not via a USB connection, but via an Ethernet cable.

Important: please note that to connect to the machine, you need to choose one of 2 connection methods - USB or Ethernet.

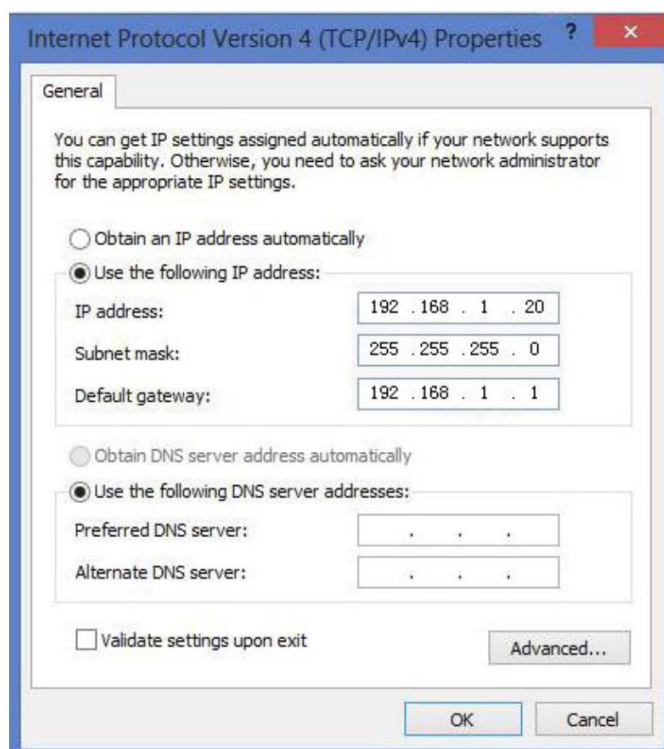
- Connect the Ethernet cable at one end to the ethernet port located on the back of the machine.



Use the other end to plug the cable into the Ethernet port in your PC.

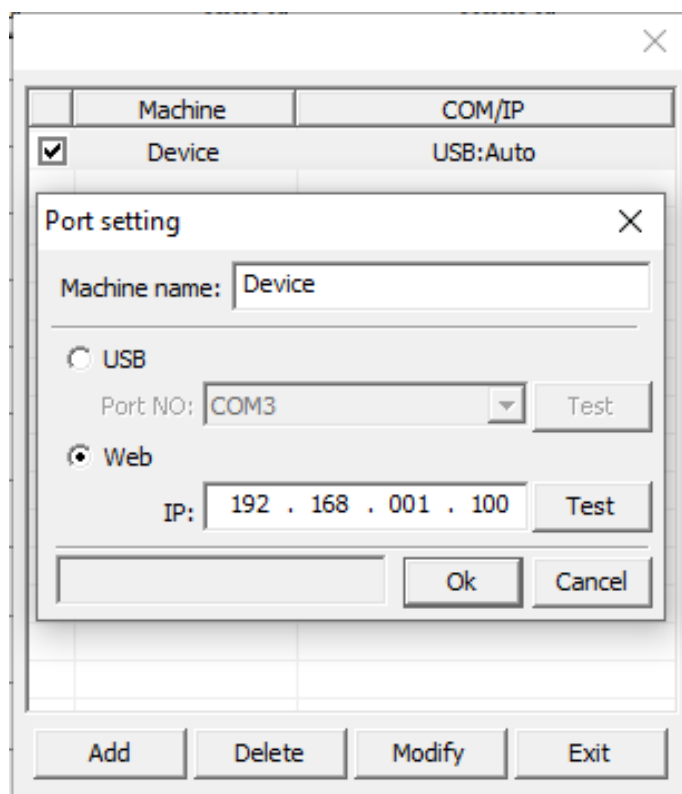
After that, make the following settings:

1. On your PC, go to the Network Connections settings and make the following settings in the Ethernet connection:



Note! set the IP address on the computer between **192.168.001.2 - 192.168.001.049**

2. In RdWorks, in the lower right corner, click "Settings" in the Device field. In the window that appears, click "Add". Put a dot opposite the Web. Set the IP address of the controller in the interval **192.168.001.100 - 192.168.001.149**.



Important!

1. Minimum PC Requirements:

- Windows XP, 7, 10 (32-bit or 64-bit versions)
- Intel Celeron / Core i3/5/7 or AMD Ryzen 3/5/7/9/
- 2 GB RAM
- 2 GB of hard drive space
- Mouse, tablet, or multi-touch monitor
- Monitor resolution 1280 x 720 at 100% (96 dpi)
- Microsoft Internet Explorer 11 or higher
- USB 2.0 / 3.0

2. The PC must also be grounded.

3. If you do not find a USB drive in your hardware package, please contact the supplier.

6.6 CONNECTING VIA WI-FI

The machine controller can be connected to other devices via Wi-Fi in two ways:

1. Create your own Wi-Fi hotspot and connect directly through the created network. (In this case, WEB functions will not be available)
2. Connect to an existing Wi-Fi network.

6.6.1 CREATING A WI-FI HOTSPOT

- To select this function, go to the wireless network settings in the controller menu at the following address: "Menu" -> "Controller+" -> "Net Setting" -> "Wi-Fi settings+".

Mode:

Name:

Password:

IP address: : : :

 Press <Shift> to open the lowercase letter soft keyboard

Mode: Select the wireless network mode (AP_5G/2.4G – create an access point; STA – Connecting to an Existing Wireless Network)

Name: Network Name

Password: Network password

IP address: The IP address of the network

- Select AP_5G or AP_2.4G mode.
- Set a network name and password (or use the default ones)
- If necessary, change the IP address of the network or use the default one
- Click Write.

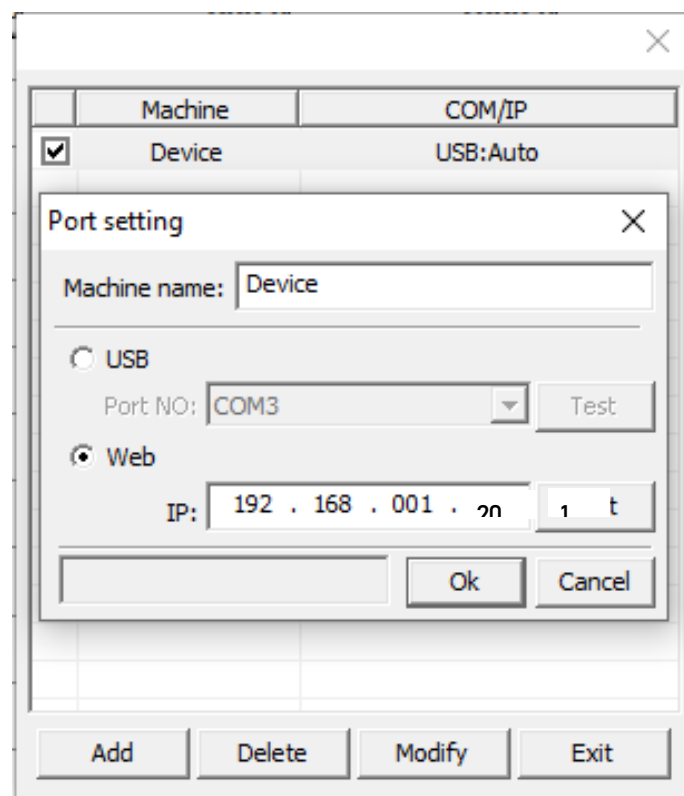
A window should appear with the following content. You can close the window and return to the main screen.

The hotspot has been
successfully opened!

Please <Esc>

After that, the network with this name should appear in the list of networks on the device you are connecting.

- Connect to the network you created.
- In RdWorks, in the lower right corner, click "Settings" in the Device field. In the window that appears, click "Add". Put a dot opposite the Web. Set the IP address of the controller, which was indicated on the screen of the "Wi-Fi settings+" menu 192.168.20.1. Click OK.



6.6.2 CONNECTING TO A WI-FI WIRELESS NETWORK

- To select this function, go to the wireless network settings in the controller menu at the following address: "Menu" -> "Controller+" -> "Net Setting" -> "Wi-Fi settings+".

Mode: STA

Name: abc

Password: 123456

IP address: 192 : 168 : 101 : 38

Read Write

Press <Shift> to open the lowercase letter soft keyboard

Mode: Select the wireless network mode (AP_5G/2.4G – create an access point; STA – Connecting to an Existing Wireless Network)

Name: Network Name

Password: Network password

IP address: The IP address of the network

- Select the STA mode.
- Enter the name and password of the existing network
- Click Write.

A window should appear with the following content. At the same time, the assigned IP address will be displayed on the screen, write it down. After that, you can close the window and return to the main screen.

WiFi connection is
successful !

Please <Esc>

Before the follow-up step, make sure that the device and the machine are connected to the same network.

- In RdWorks, in the lower right corner, click "Settings" in the Device field. In the window that appears, click "Add". Put a dot opposite the Web. Set the IP address of the controller, which was specified on the "Wi-Fi settings+" menu screen. Click OK.

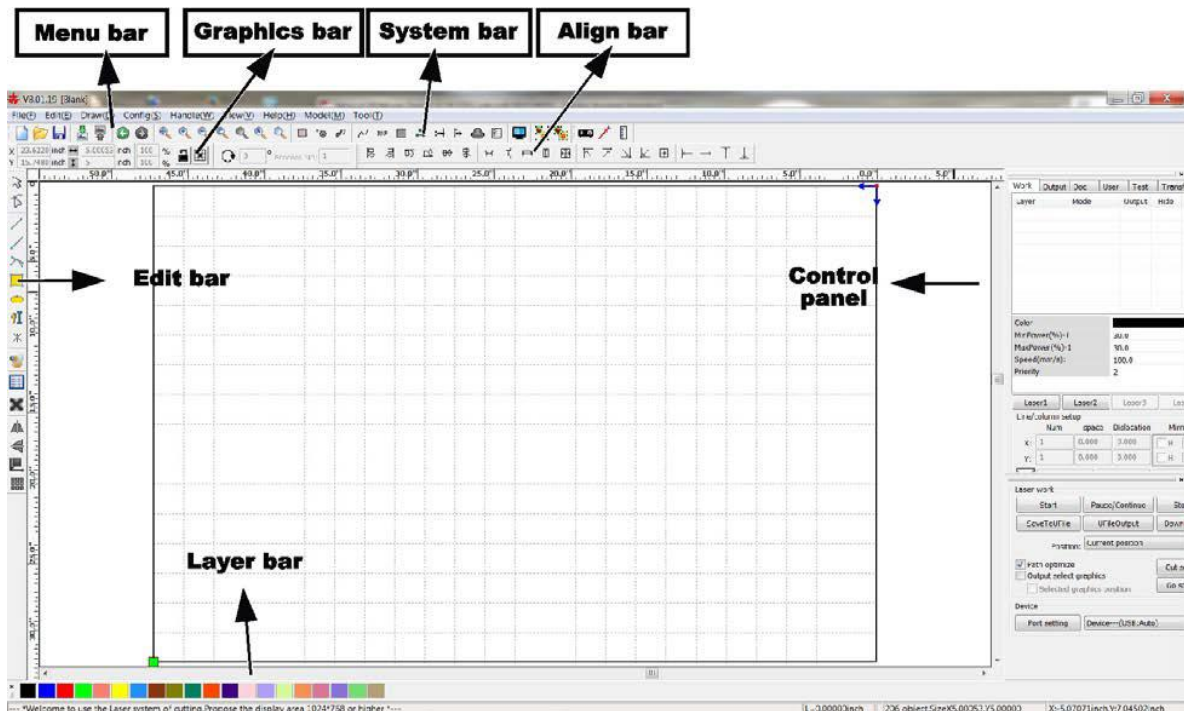
The screenshot shows a 'Port setting' dialog box with the following fields and controls:

- Machine:** Device
- COM/IP:** USB:Auto
- Machine name:** Device
- USB:** Unselected radio button
- Port NO:** COM3 (dropdown menu)
- Web:** Selected radio button
- IP:** 192 . 168 . 001 . 100
- Buttons:** Test, Ok, Cancel

At the bottom of the main window, there are buttons for Add, Delete, Modify, and Exit.

CHAPTER 7. SOFTWARE DESCRIPTION

7.1 INTRODUCTION TO SOFTWARE FUNCTIONS



- In RdWorks, you can create simple images or text using the Editing Panel. But most often, vector or raster programs (such as CorelDraw, Adobe Illustrator, Photoshop, etc.) are used to create an image, and the resulting files are already imported into RdWorks.
- To import your file into RdWorks, click File -> Import and select the file with the appropriate extension to import.
- To create a control program, only one graphic file is not enough. It is also necessary to configure the parameters for processing this file in the Control Panel.
- Processing parameters.
- In the control panel, you can set unique processing parameters (cutting or engraving) for each color (layer).

Processing parameter – cutting:

A screenshot of the 'Parameter library' dialog box in RdWorks. The dialog box is divided into two main sections. The left section contains settings for a specific layer, including 'Layer' (a color swatch), 'Is Output' (Yes/No), 'Speed (mm/s)' (100), 'Repeat num' (1), 'Processing Mode' (Cut), 'If Blowing' (Yes), and a table for 'Min Power (%)' and 'Max Power (%)'. The right section contains settings for the laser processing, including 'Seal' (0.000 mm), 'Open Delay' (0 ms), 'Close Delay' (0 ms), 'Laser through mode' (checked), 'Through power 1' through 'Through power 6' (all 50.0 %), and 'Auto synchronize when Modify laser para' (checked). The dialog box has 'Apply to same', 'Ok', and 'Cancel' buttons at the bottom.

1	Layer	Color of the editable layer
2	Is output	If you set No, then this color will not be processed in the current NC
3	Speed	Processing speed, mm/sec
4	Repeat	If you check the box, you can repeat the processing of this layer several times
5	Processing mode	Choosing a Processing Between Cutting and Engraving
6	If blowing	This function is used when an air compressor is connected to the control system in a certain way. If this is not the case, it does not matter whether this function is turned on or off
7	Min power	They can have values from 0 to 100 and determine the power of the laser emitter. The higher the value, the higher the laser energy, the lower the value, the lower the laser energy
8	Max power	
9	Seal	Close open lines. When this value is set, the laser head, after finishing processing the specified vector, will process it again, to the length in mm specified in this parameter.
10	Open delay	Used with the Laser through mode option. This is the time in ms when the machine does not start the movement of the laser head, but turns on the laser beam at the power specified in Through power.
11	Close delay	Used with the Laser through mode option. This is the time in ms when the machine has already finished moving the laser head, but does not turn off the laser beam, but hits it at the power specified in Through power.
12	Laser through mode	Includes a material piercing option, used in metal cutting
13	Through power	Used with the Laser through mode option. This is the power in % when the machine does not start the movement of the laser head, but turns on the laser beam for the time specified in the Open delay.

Processing parameter – engraving:

Layer Parameter

Parameter library

Layer:

Is Output: Yes ☐ ☐ Default

Speed(mm/s): 100 ☐ Default

Repeat num: 1 ☐

Processing Mode: Scan ☐ Advance...

If Blowing: Yes ☐

Min Power(%) Max Power(%)

☒ 1:	30	30	☐ Default
☒ 2:	30	30	
☒ 3:	30	30	
☒ 4:	30	30	
☒ 5:	30	30	
☒ 6:	30	30	

☐ Negative Engrave ☐ Optimized Scan

☐ Output direct ☐ Independent output

☐ Ramp Effect

Ramp Length: 0 mm

Overstriking: Un-process ☐ Advance...

Scan Mode: X_swing ☐ Advance...

Interval(mm): 0.1000 mm

☐ Enable blank:

Blank size: 1.0000 mm

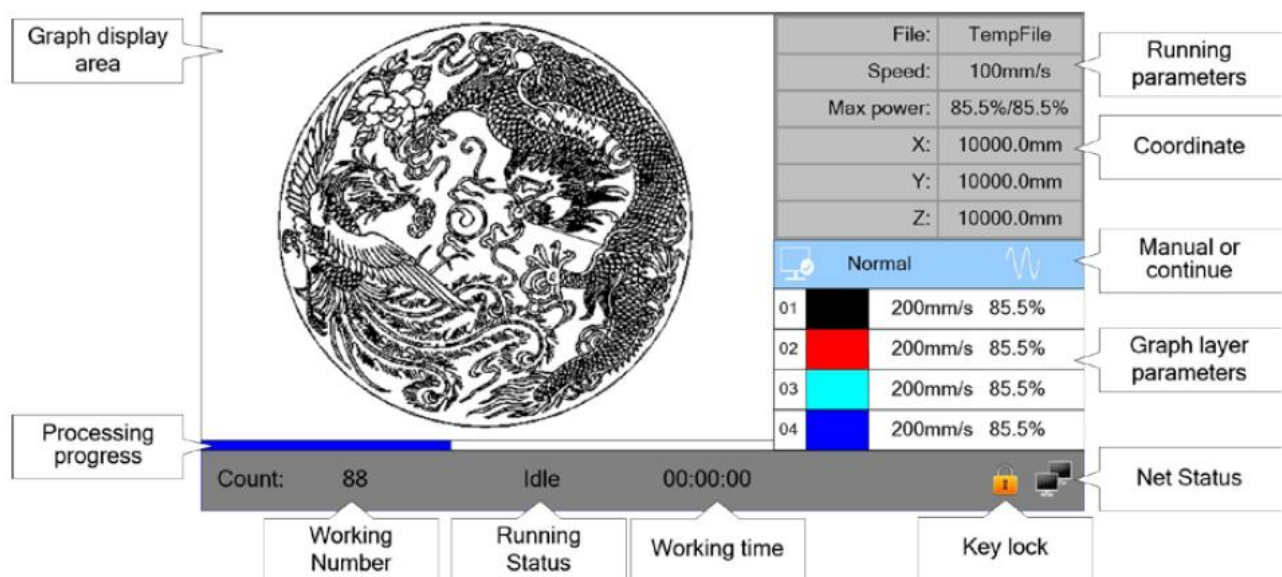
☒ Auto synchronize when Modify laser para

Apply to same Ok Cancel

1	Layer	Color of the editable layer
2	Is output	If you set No, then this color will not be processed in the current NC
3	Speed	Processing speed, mm/sec
4	Repeat	If you check the box, you can repeat the processing of this layer several times
5	Processing mode	Choosing a Processing Between Cutting and Engraving
6	If blowing	This function is used when an air compressor is connected to the control system in a certain way. If this is not the case, it does not matter whether this function is turned on or off
7	Max power	It can have a value from 0 to 100 and determines the power of the laser emitter. The higher the value, the higher the laser energy, the lower the value, the lower the laser energy
8	Negative engrave	Inverts black pixels to white and white pixels to black. It is used to process dark engravings.

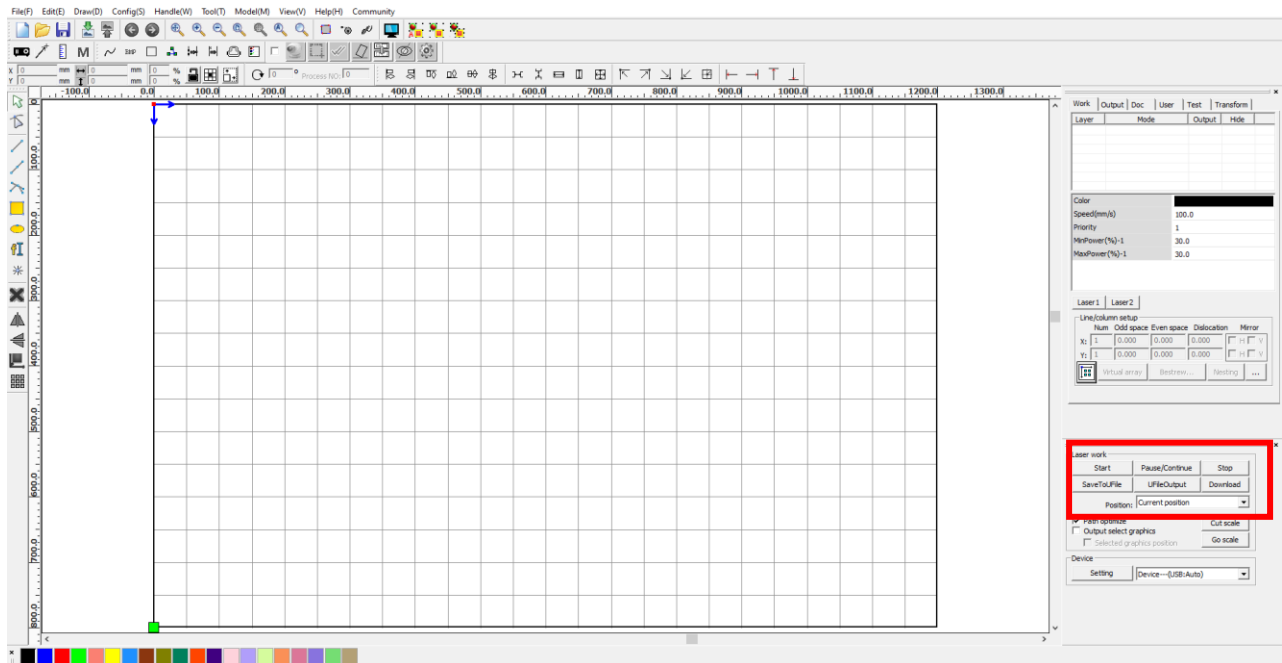
9	Output direct	If you enable this option, the dark colors of the image will be processed with more power, and the light colors of the image will be processed with less power. This option is used for glass and clear acrylic.
10	Optimized scan	Automatic engraving optimization mode, which can slightly reduce processing time
11	Ramp effect	The slope at the edges of the engraving, the length of this slope is adjusted by this parameter. For this option to work correctly, you need to set the minimum power lower than the maximum
12	Independent output	A mode in which each element will be engraved separately. This function is used to optimize processing, in some situations this function can significantly reduce the processing time, but it can also increase the
13	Overstriking	Engraving Modes Affecting Font Engraving
14	Scan mode	Engraving direction mode, X or Y axis, and unilateralism or swing. The unidirectional mode involves passing the laser from left to right and returning to the beginning of the line, and the bidirectional mode involves laser processing from left to right and right to left on the next line. The unidirectional mode correspondingly significantly increases the processing time, but can give higher quality in some situations, such as when engraving seals
15	Interval	The distance between the engraving lines. This value directly affects the quality and speed of processing. Standard values are 0.08-0.1 mm. The spacing can be set in millimeters or DPI (dots per inch)

7.2 DISPLAYING THE MENU ON THE MACHINE CONTROL PANEL SCREEN



7.3 HOW TO RUN A CONTROL PROGRAM

1. The control program can be run directly from the computer from RdWorks by clicking the Start button in the Laser work window.



2. The control program can be loaded into the controller memory and run from the machine controller display. Click the Download button in the Laser work window, enter the name of your control program under which you want to save it, and click the Ok button.

Then go to the machine display. Click the File button. Select the Read memory files menu item. Press Enter. Select the file you want. Press Enter. And press the Start/Pause button.

3. The control program can be loaded into the controller memory from a removable flash drive and run from the display of the machine controller.

Connect the removable flash drive to your PC. Click the UFileOutput button in the Laser work window. Enter the name of your control program under which you want to save it and click the Ok button.

Insert a removable flash drive into the USB slot on your machine.

Then go to the machine display. Click the File button. Select the Read USB files (Udisk) menu item. Select the file you want. Press Enter. And press the Start/Pause button.

CHAPTER 8. MAINTENANCE

To ensure the normal operation of the machine, it must be regularly maintained.

8.1 MAINTENANCE OF PERIPHERAL EQUIPMENT

Maintenance period	Maintenance content	Purpose
Once a year	1. Pull through all mechanical connections, including pulleys and gearboxes. 2. Pull through all terminals on the electrical components of the machine.	
Once every 3 months	1. Replace the water in the chiller	To ensure the normal operation of the laser
Once a month	1. Check the axis guides. Grease if necessary.	
	2. Check for breaks in the pipelines.	Make sure there are no leaks
	3. Check the tension of the timing belts. Correct tension if necessary.	
Daily	1. Monitor the purity and temperature of the water	To ensure the normal operation of the laser radiation source.
	2. Inspect the mirror and lens for contamination and timely replace/clean in case of contamination.	To ensure the normal operation of the laser head.
	3. Coolant level and temperature control.	For normal cooling of equipment
	4. Inspect the exhaust grate and fan of the machine for contamination and clean in time if dirty.	To ensure the normal operation of the hood.
	5. Checking the alignment condition.	
Perforce	1. Checking the condition of the focusing lens and timely replacement/cleaning in case of contamination.	To ensure the normal operation of the laser head.

8.2 FILLING THE COOLING SYSTEM

The laser source is water-cooled. Operating at elevated temperatures accelerates the aging of the laser and reduces its efficiency. If the laser source overheats, do not use the machine and contact our service center for assistance.

Check if there is fluid in the system tank. In its absence, it is necessary to pour distilled water into the tank.

The tank is located to the left of the working area of the machine, under the panel.



Only distilled water is allowed to be filled into the cooling system.

Refueling

- 1) Remove the water filler cap.
- 2) Pour distilled water into the tank. Make sure that the water level is at the level of 80% of the total volume. If necessary, remove the panel located above the tank. (It is necessary to unscrew the 6 nuts from the screws holding the panel)
- 3) Place the lid on the neck.

Trial Run



After starting the machine and distributing water throughout the system, its level in the tank may drop. Make sure that the water level is in the same area, adding it if necessary.

Check that there is a flow of water through the laser tube. Make sure there are no air bubbles in the water stream.



When working for a long time, always keep an eye on the coolant level. The water level should be checked in a timely manner and the hoses should be checked for leaks.

The presence of any opacity (e.g. suspension, filamentous, flaky, particles, etc.) indicates water contamination, so it is forbidden to use such water in the cooling system.



When storing equipment for long periods of time, at temperatures below 0°C, all hoses must be drained to avoid rupture.

8.3 CLEANING OPTICAL ELEMENTS

8.3.1 PREPARING FOR CLEANING THE OPTICS



If the optical element is damaged, it must be replaced as soon as possible. It is forbidden to operate the machine with damaged optics.

1. Before installing the optical element, wear clean clothes, wash your hands with soap and water, and wear clean white thin gloves. During any procedures, try not to touch the surface of the optical element.
2. When assembling/disassembling the optical system, do not blow on the optical elements. When installing optical elements, make sure that the installation area is not dusty or dirty.
3. When installing/replacing the optical element, do not apply too much pressure to it, as this may cause damage.
4. Be extremely careful when removing the optical element from the box in which it is stored. The optical element should be held only by its edges. Avoid dust on the optical element. After installing the optical element, blow it out with clean air from dust and other contaminants. If dirt or dust has accumulated on the optical element, it should be cleaned immediately.



Do not use water, ethanol or methyl alcohol, or other chemicals not listed in this manual for purification.

8.3.2 CLEANING MIRRORS

1. Open the compartment with the laser tube. Pat a cotton swab into the liquid and clean the machine's 1st reflective mirror in a gentle circular motion. Wait for the remaining liquid to evaporate from the surface of the reflective mirror.

2. Move the second mirror located on the machine gantry closer to the front of the machine. Pat a cotton swab into the liquid and clean the machine's 2nd reflective mirror in a gentle circular motion. Wait for the remaining liquid to evaporate from the surface of the reflective mirror.



3. The third mirror is located in the laser head. Blot a cotton swab into the liquid and clean the 3rd reflective mirror of the machine with gentle circular motions. Wait for the remaining liquid to evaporate from the surface of the reflective mirror.

8.4 REMOVING THE FOCAL LENS

To remove the focal lens, you first need to remove the casing from the laser head.

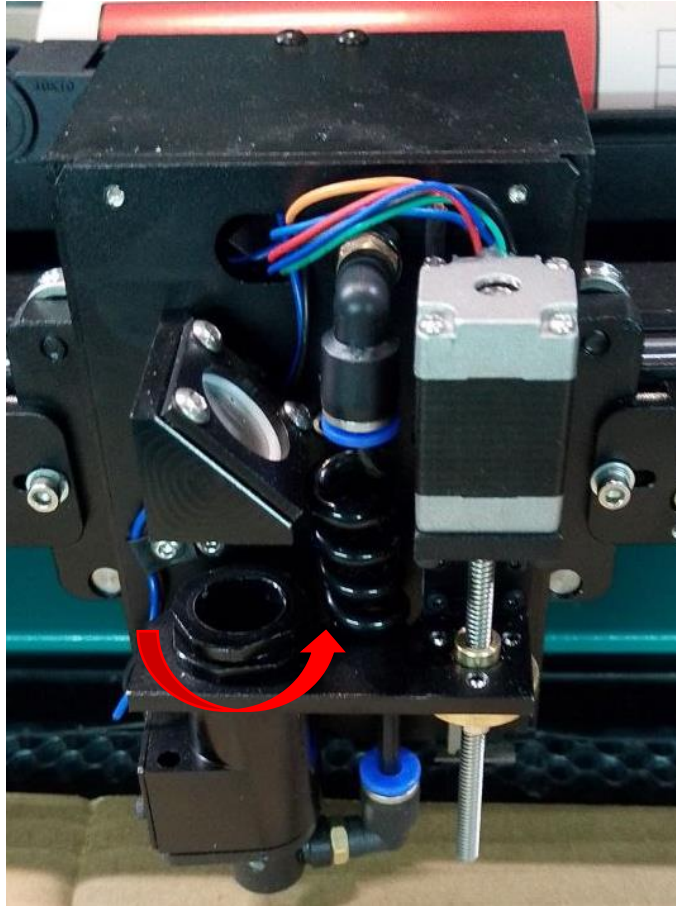
To do this, first unscrew the locking screw that holds the casing.



Next, pull the shroud upwards until it is removed from the grooves.

You should now have access to the tube with the focal lens.

Unscrew the tube from the laser head body and remove it.



Next, disassemble the tube:

- Unscrew the lens clamp from it.
- Remove the O-ring
- Remove the focal lens



Carefully pick up the lens. **Only touch the edges along the diameter!**



Take a cotton swab (lint-free) or special cloths for cleaning optics and a liquid for cleaning optics (specialized or high-purity acetone or high-purity isopropyl alcohol). Clean with smooth movements directed to one side.

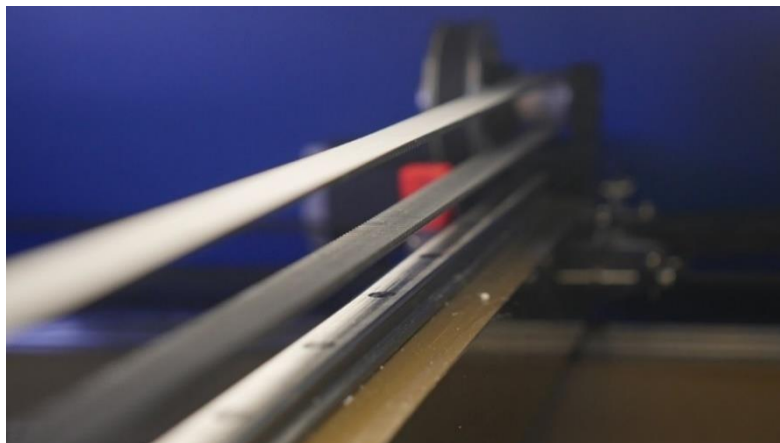
After cleaning the lens, insert it back into the sheath, tighten the pressure. Insert the sheath back into the laser head, tighten the nozzle and insert the air supply hose.



Do not allow mechanical damage to the reflective mirrors and the focusing lens. If the reflective mirror or lens is damaged, it must be replaced!

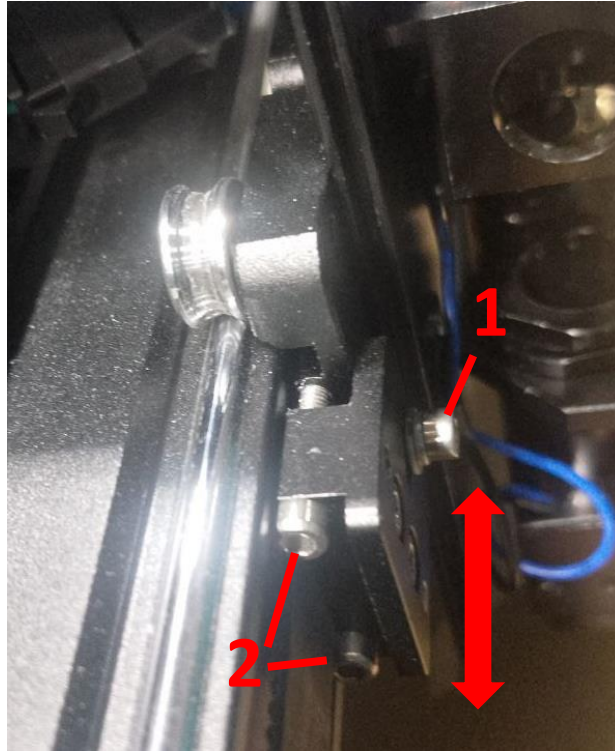
8.5 TIMING BELT TENSION

Timing belts on a laser machine are necessary to transmit the force from the stepper motor to the kinematics of the machine to realize the movement of the laser head. In order to move the laser head efficiently, accurately, and quickly, the timing belts must be tensioned in a certain way.



We recommend that you check your belt tension every day to make sure your equipment is working properly and will perform well throughout the shift.

Use special tensioners to tension the straps.



1. Loosen the fixing screw.
2. Change the position of the adjustment screws. (To twist – to increase the tension, to screw in – to reduce the tension)
3. Apply force to the belt tensioner so that the adjusting screws rest on the housing and tighten the locking screw.

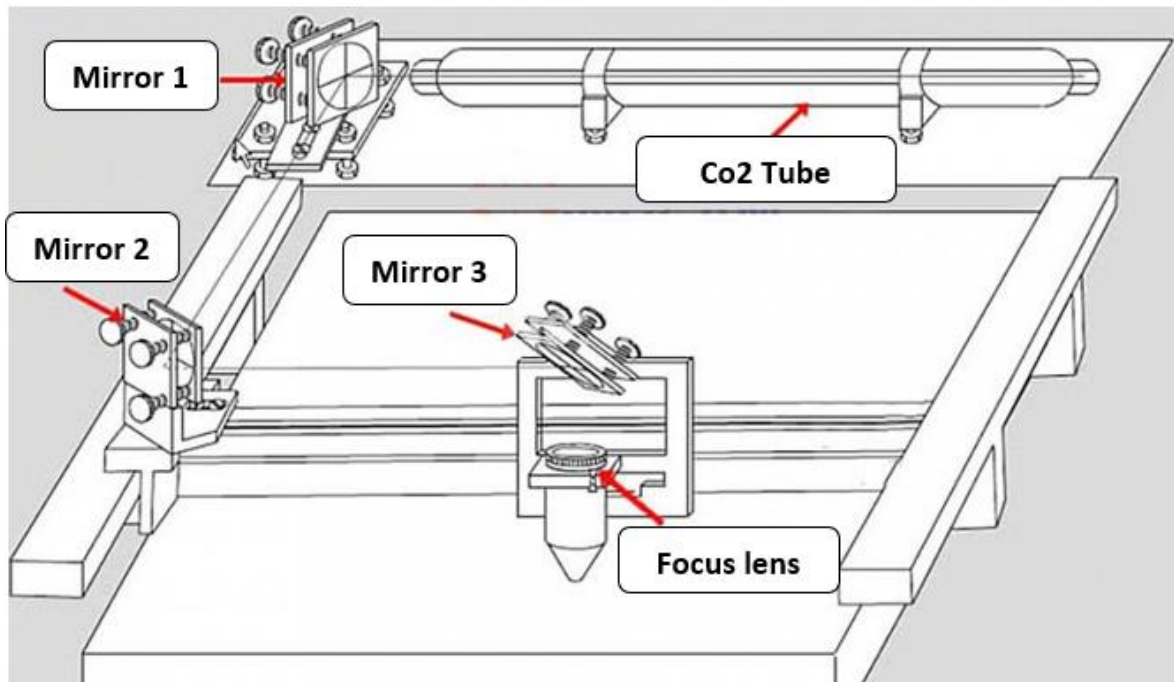
Proper belt tension: Take the belt by the middle and try to rotate it around its axis 360 degrees. You should be able to make one turn of the belt, but no more.

Improper belt tension: The belt sags without operator effort or sags very easily when lightly pressed on the middle of the belt. Or the belt is taut like a string and resonates strongly if you press sharply on the middle of the belt with your finger.

8.6 ALIGNMENT

Alignment should be carried out at the first start-up of the equipment, as well as checked daily before starting work.

Optical path structure



Before starting alignment, open the rear compartment of the machine with the laser tube.

You will need masking tape. It is used in 2-4 layers so that it does not catch fire, and glued to the mirror.

The power on the display is set to about 15-25%.

The laser tube in its mounts is installed in the lower position. Masking tape (in 2-4 layers) is glued to the first mirror and ironed with your fingers so that the borders of the frame are visible.

If the laser beam does not hit the center of the first mirror, then the position of the laser tube must be adjusted. For up-and-down adjustment, the laser tube mounts have a handy wheel and scale that make it easy to align the back and front of the tube.

To adjust to the right and left, you need to loosen the bolts of the laser tube fasteners to the machine bed, after which the fasteners can be moved to the right and left.

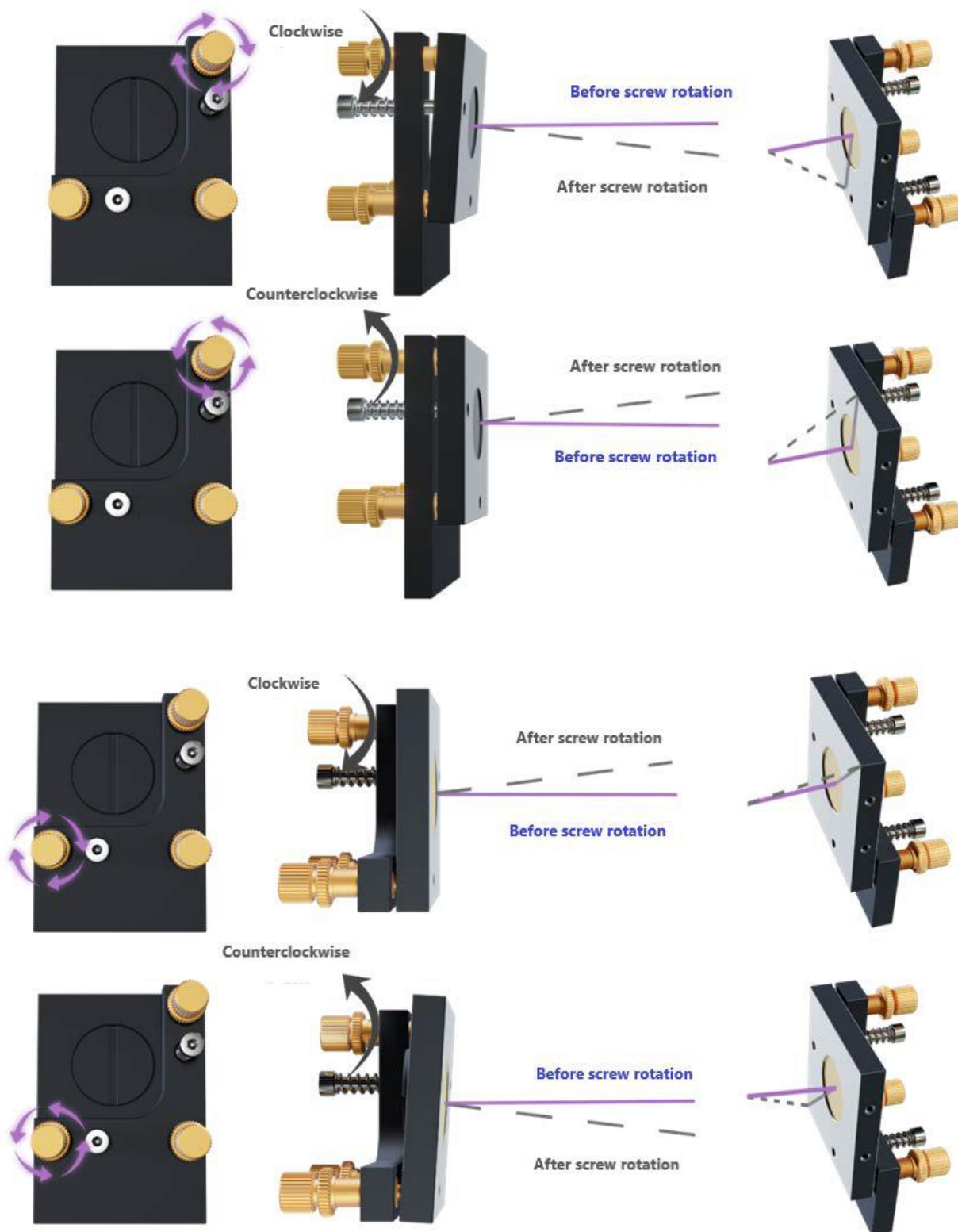


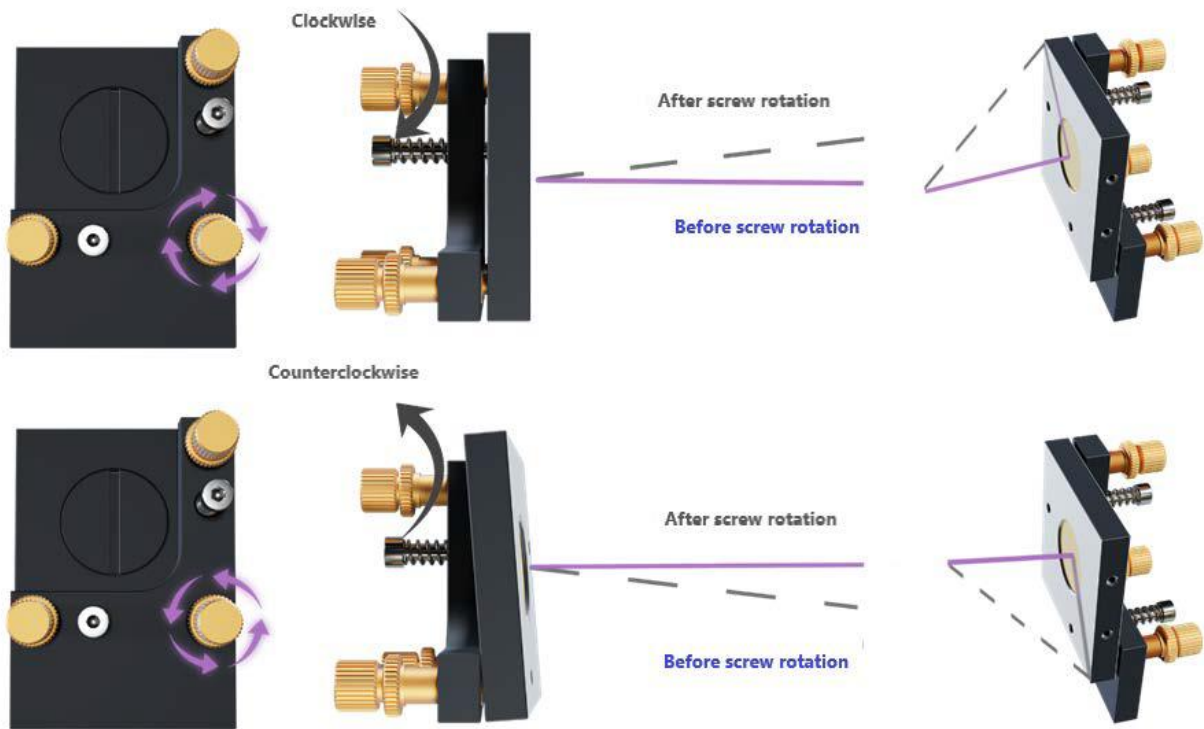
The beam does not have to fall into the very center of the first mirror. The most important thing is to get into the center of the second and third mirrors.

8.6.1 SETTING UP THE FIRST MIRROR

Each mirror mount has brass screws that adjust the angle of inclination, pushing the frame with the mirror from different sides.

The upper screw adjusts the angle of inclination vertically, and the right and left screws horizontally and diagonally. The larger the field of the machine, the more sensitive the laser is when the screw is turned.





The mirror is adjusted with screws until the entire beam hits it, without touching the mount even at maximum power.

8.6.2 CONFIGURING THE SECOND MIRROR

The first check is carried out at a close distance so that the beam cannot go beyond the boundaries of the frame.

The principle of adjustment is the same as in the previous stage. If necessary, all three adjusting screws can be tightened by the same number of revolutions, thereby moving the frame strictly horizontally.

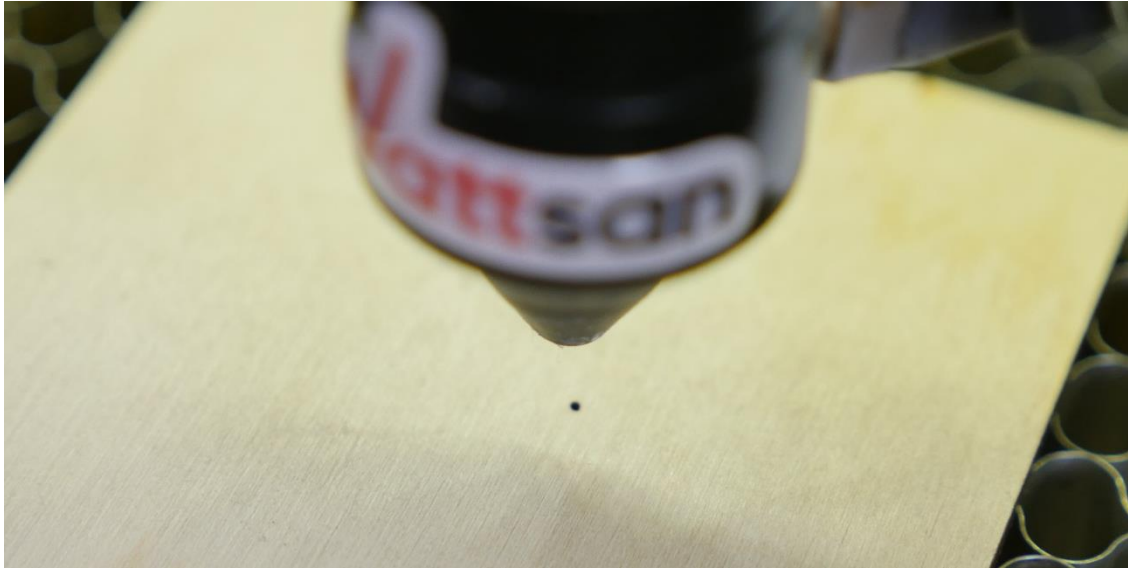
The tuning is similar to the previous time, but now it is important that the beam comes to the center.

Sometimes, in order to accurately correct the impact on the center of the second and third mirrors, it is easier not to start moving the second and first mirrors, but to move the laser tube a little. By loosening the locking screws and shifting it slightly, you can quickly adjust the accuracy of the beam hitting the desired point.

Next, the laser hits one point on all mirrors in extreme positions is checked.

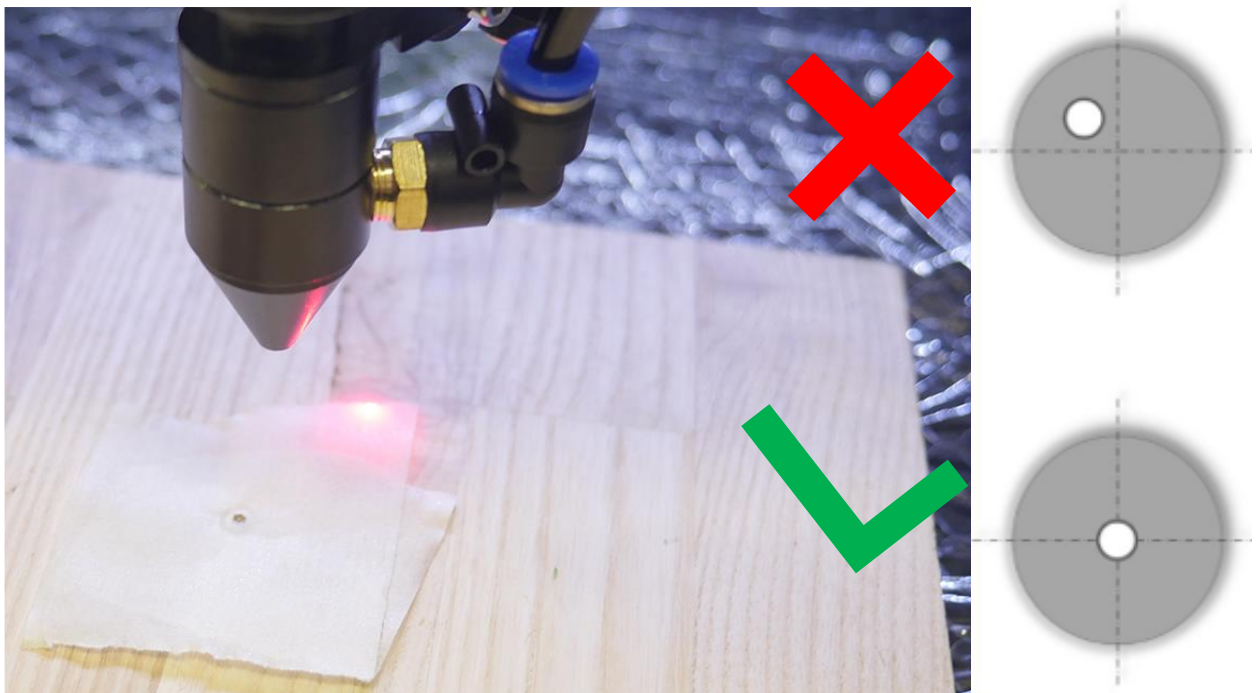
8.6.3 SETTING THE THIRD MIRROR – SETTING THE VERTICALITY OF THE BEAM

The setup should be done in a similar way. It is necessary to make sure that the beam passes through the tube and falls on the material. It is more convenient to do this in an unfocused position of the laser head, so that the shape of the print is better visible.



When the print has become round, a transparent adhesive tape is glued to the nozzle. The minimum power is set, about 10%, Laser is pressed.

A nozzle imprint and a trace of the beam will remain on the tape. The hole should be exactly in the center of the nozzle. The centering is corrected by adjusting the 3rd mirror. The tape is glued again, the alignment is checked. The operation is repeated until the correct position is reached.



After the beam is correctly centered, a small round dot remains on the material.



After alignment, it is necessary to tighten the screws with locknuts! When tightening, the screws must be held by hand so as not to accidentally displace them. After tightening, the alignment accuracy is checked again.

CHAPTER 9. POSSIBLE MALFUNCTIONS AND WAYS TO ELIMINATE THEM

No.	Description of the malfunction	Cause of malfunction	Solution
1	Lack of laser head movement	Check if the device is properly connected to the network	Reconnect the device to the network
		Incorrect control parameters are set on the equipment control panel	Set the control parameters according to the instruction manual
		The emergency button is not pressed	Press the emergency button
2	The laser beam does not turn off	The laser control parameters in the main controller of the machine are set incorrectly	Set the controller parameters according to the instruction manual
		Non-permanent contact on the control unit or main controller	Check the terminals and pull them through
3	Unsystematic laser radiation during operation	Check the water circulation	Clean the water container, water wand and water pump
		Check the stability of the mains voltage	Install the voltage stabilizer
		Faulty water flow sensor or lid closure sensor	Replace the sensors
4	No response when transmitting data to the equipment	Make sure that you have selected the correct connector for uploading data.	Choose the right connector
		Check equipment grounding	Ground the equipment
		Check if the driver for USB is installed	Install the USB driver
5	No laser radiation	Check the alignment	Adjust the trajectory of the laser beam, check the purity of the optical elements

		Check the cooling of the laser tube	Set up your cooling system
		Check the water flow sensor and lid closure sensor	Replace the sensors
6	The PC does not "see" the equipment	Computer or connection problem	Change your computer or USB port
7	Incorrect dimensions of the resulting products	Check the PLT settings in your graphics editor (CorelDraw). PLT resolution must be 1016 units	Change the PLT resolution in CorelDraw for 1016 units
		Check the gear ratios in the controller settings	Recalculate the gear ratios in the controller settings
8	Skipping steps	Check equipment grounding	Ensure that equipment is grounded with a resistance of no more than 5 Ω
		Check the source file for errors, for open curves	Fix the original file
		PC and hardware connection problem	Change the connection port in the PC or use a different PC
9	Low laser beam power	- Check the cleanliness of the translucent mirror of the laser tube. Check if there are any scratches on the translucent mirror. - Check the amperage of the high voltage unit. - Check the coolant temperature, cleanliness, and water flow pressure. – Check the alignment and cleanliness of the laser machine optics.	During the operation of the laser tube, the environment and smoke from cutting the material can easily contaminate the mirror of the tube. We recommend checking the mirror at least once every two weeks and cleaning it if it gets dirty.

10	High Voltage Breakdown at Laser Tube Contacts	Check that there is no metal near the contact - Check the humidity in the room. Check that no condensation accumulates on the contacts of the laser tube. - Check the high-voltage unit wires for bending and damage	Replace the laser tube
11	Laser tube cracked	- Check the coolant temperature. - Avoid freezing coolant. - Check that the coolant is circulating at the correct pressure and that the cooling hoses are not pinched or twisted.	Replace the laser tube

CHAPTER 10. TRANSPORT, UNLOADING AND STORAGE

10.1 TRANSPORTING THE MACHINE



Before transportation, it is necessary to drain the water from the cooling system, as well as blow out the cooling system.

- 1) A standard stacker or an electric forklift up to 1 ton can be used to load the machine.
- 2) The machine can be transported at a height of at least 100 mm from the ground.

10.2 MACHINE TRANSPORTATION AND DELIVERY FEATURES

- 1) When transporting the machine, it is necessary to avoid rain, moisture, strong inclination, rodents, potholes on the roads. The ambient temperature should be in the range from -10 °C to + 40 °C, relative humidity should not exceed 70%. It is forbidden to store the machine in the open air for a long time.
- 2) Do not put other loads on the machine during transportation.
- 3) The packaging of the machine should protect from moisture and sunlight.

10.3 STORING OPTICAL ELEMENTS

- 1) The storage conditions of optical elements affect their quality.
- 2) The ambient temperature should be between 10°C and 40°C. Do not freeze the optics!
- 3) Optical elements should be stored in a separate box and should not be exposed to vibration, as this can cause damage.

10.4 MACHINE CONSERVATION

If you want to suspend the use of the machine for a long time, then you need to drain the water from the cooling system, cover the machine with an impermeable material.

Storage conditions	
Temperature (°C)	-10 to 40
Humidity (%)	up to 70%

CHAPTER 11. WARRANTY

11.1 DURING THE WARRANTY PERIOD

In case of equipment breakdown during its warranty period due to a defect caused by the manufacturer, repair is carried out by the supplier's company free of charge.

However, consumable parts such as optical parts (focusing lens, laser tube, reflective mirrors, etc.) are not eligible for warranty service.

For free repair or replacement of accessories, the buyer bears the cost of delivering new components from the place of their storage to the buyer's address, and, if necessary, the buyer bears the cost of the specialist's visit to the place of work.

If the equipment failure is caused by a defective part or assembly of the equipment, this part or assembly is repaired or replaced free of charge.

Defective components and parts must be returned to the supplier.

If the malfunction is not caused by the quality of parts or components of the equipment, the buyer will have to pay the cost of repair as well.

Warranty service is also not subject to malfunctions due to improper use of equipment, non-compliance with maintenance rules, operating conditions, as well as warnings specified in manuals and on warning plates that have arisen during the warranty period.

It is also a prerequisite that your equipment and peripheral devices are grounded and operated through a voltage stabilizer.

11.2 SPECIAL WARRANTY FOR LASER TUBES

1. Do not exceed the recommended maximum current value of the high voltage unit when using the laser tube, as it may shorten the service life of the laser tube.
2. If the laser tube is turned on without circulating cooling water, it will fail within a few minutes. In this case, the laser tube is not covered by the warranty.
3. If the laser tube needs to be sent to the supplier for diagnosis and repair, be sure to pack it in its original packaging. Coolant must be completely removed from the laser tube before packaging.

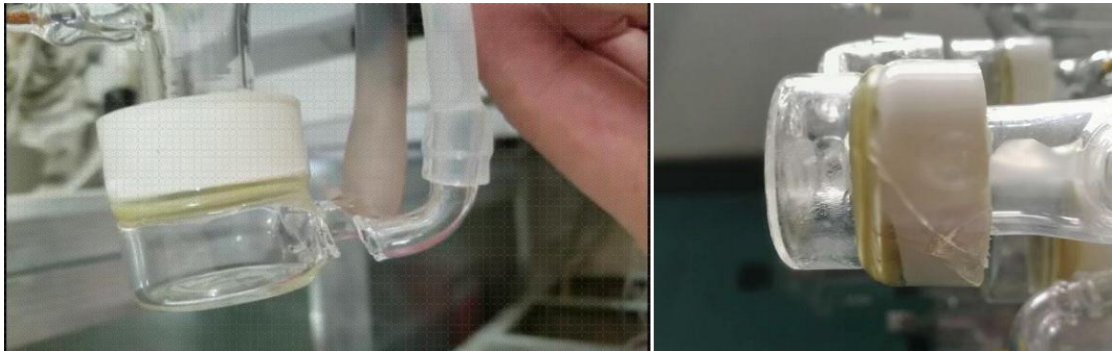
How to properly send a claim for a malfunction of the handset:

1. If there is no laser beam inside the laser tube:
 - Provide photos or videos of the laser tube model and serial number.
 - Provide photos or videos of the laser tube output end.
 - Provide photos or videos of the high voltage end of the laser tube.
 - Provide photos or videos of the output connector
2. If there is a laser beam inside the laser tube but it does not come out of the laser tube:
 - Provide a video that includes: the model and serial number of the laser tube, as well as the working current readings of the laser tube. During operation, slowly record video from the end of the output to the end of the high voltage and stay on the label for 2 seconds.
3. If the laser power is too low:

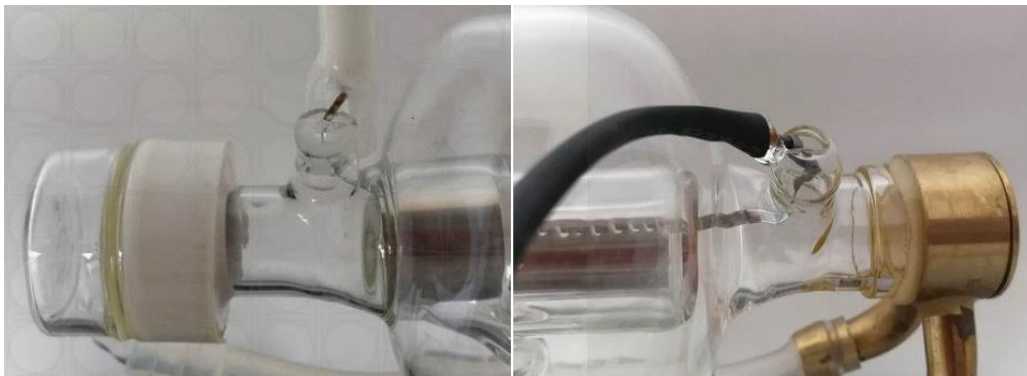
- Provide a video that includes: the model and serial number of the laser tube, as well as the reading of the operating current of the laser tube. During operation, slowly record video from the end of the output to the end of the high voltage and stay on the label for 2 seconds.
- Provide a video showing the shape of the laser beam spot on the first mirror.

11.3 NON-WARRANTY SITUATIONS

1. The laser tube warranty has expired.
2. Damage to the electrode or water cooling system due to the fault of the user. For example: Damage to the electrodes or water cooling system caused by the user. The picture below shows damage to the glass connector of the water cooling system.



3. Crack of the negative electrode. This usually happens when the contact is installed or soldered.



4. Poor cooling may cause cracks in the laser tube glass. Similar phenomena are associated with poor water cooling. The pictures below show breakdowns caused by poor water cooling.



5. The product label is damaged, stained, hidden, or the two serial numbers do not match.
6. Damage due to transportation.
7. The product is damaged due to shipping or packaging when returned to the supplier under warranty.
8. Power reduction due to long-term continuous operation with maximum current.
9. Reduced power or broken contacts due to improper installation of the laser tube.
10. Power loss due to contamination of the output translucent mirror.
11. The laser tube has failed due to a large amount of dirt or dust on it.
12. The color of the anode contact has undergone changes.