

# Wattsan G1/G2 Laser Welding and Cleaning 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 piece of 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.

## 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 by an electric current. 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 this equipment and install it.                                                                                                                                                                                                                                                              |
|                        | <div>The equipment complies with safety class 4. The use of this equipment may lead to the following consequences:</div> <ul style="list-style-type: none"><li>• Ignition of nearby materials</li><li>• Materials exposed to laser radiation can become sources of dangerous gases</li><li>• Laser beams can cause direct harm to humans</li></ul> |
| <br><b>MUST-DO</b>     | The location of the equipment must be equipped with fire extinguishing equipment. It is forbidden to store flammable and explosive substances near the device.                                                                                                                                                                                     |
| <br><b>MUST-DO</b>    | The user must ensure that the material to be processed is suitable for laser processing in order to avoid risks to the life and operation of the equipment.                                                                                                                                                                                        |
| <br><b>FORBIDDER</b> | 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 220 / 380 V 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                                              | G1                     | G1D        | G2                                                                                      | G2D        | G2 PRO                |
|----------------------------------------------------|------------------------|------------|-----------------------------------------------------------------------------------------|------------|-----------------------|
| Laser Head Model                                   | FWH20-S30C             | FWH20-S32C | FWH30-D10C                                                                              | FWH30-D20C | FWH30-DS10E           |
| Focal lens                                         | D20 F150               | D20 F200   | D20 F150                                                                                | D20 F200   | D20 F150              |
| Contact Spot Size (mm)                             | 0-5                    | 0-8        | 0-5                                                                                     | 0-8        | 0-5                   |
| Beam shape in welding mode                         | —                      |            | —、○、∞、∇、⊙、△                                                                             |            |                       |
| Beam shape in cleaning mode                        | —                      |            | —  ○ |            |                       |
| Laser Head Weight (kg)                             | 0.72                   |            | 1                                                                                       |            |                       |
| Connector Type                                     | QBH                    |            |                                                                                         |            |                       |
| Optical Cable Length (m)                           | 10/15/20               |            |                                                                                         |            |                       |
| Laser Source Manufacturer                          | Raycus/JPT             |            |                                                                                         |            |                       |
| Max. Modulation Frequency (Hz)                     | 5000/20000             |            |                                                                                         |            |                       |
| Max. Output Power (W)                              | 1500                   |            | 2000                                                                                    |            | 3000                  |
| Power Supply Configuration                         | 220±10% V AC 、 50/60Hz |            | 220±10% V AC 、 50/60Hz                                                                  |            | 380±10% V AC、 50/60Hz |
| Power Consumption (kW)*                            | 8,5                    |            | 11                                                                                      |            | 15                    |
| Working hours                                      | Continuous             |            |                                                                                         |            |                       |
| Wavelength (nm)                                    | 1080±5                 |            |                                                                                         |            |                       |
| Power adjustment range (%)                         | 10~100                 |            |                                                                                         |            |                       |
| Output Parameter Instability (%)                   | ±1.5                   |            |                                                                                         |            |                       |
| Cooling system                                     | Water                  |            |                                                                                         |            |                       |
| Coolant temperature (°C)                           | 22±1                   |            |                                                                                         |            |                       |
| Ambient temperature range (°C)                     | 10~40                  |            |                                                                                         |            |                       |
| Ambient humidity value (%)                         | <70                    |            |                                                                                         |            |                       |
| Maximum fluid pressure in the cooling system (Bar) | 4                      |            |                                                                                         |            |                       |
| Gas pressure in the system (mPa)                   | <1                     |            |                                                                                         |            |                       |
| Dimensions (LxWxH) (mm)                            | 1090x650x1080          |            |                                                                                         |            |                       |
| Weight (kg)                                        | ~ 235                  |            |                                                                                         |            |                       |
| Classification of the laser system                 | Class 4                |            |                                                                                         |            |                       |

## Technical Specifications of Wire Feeder

| WELDING EQUIPMENT MODEL    | G1/ G2/G2 PRO | G1D/G2D     |
|----------------------------|---------------|-------------|
| WIRE FEEDER MODEL          | FWS-01A       | FWS-02A     |
| MAXIMUM COIL WEIGHT (KG)   | 25            | 25          |
| MAXIMUM FEED SPEED (MM/S)  | 80            | 80          |
| MAXIMUM WIRE DIAMETER (MM) | 3             | 3           |
| SUPPLY VOLTAGE (V)         | 220           | 220         |
| EQUIPMENT WEIGHT (KG)      | 16.2          | 29          |
| DIMENSIONS (LXWXH) (MM)    | 560x240x472   | 605x398x472 |

## Equipment

| Name                                                | Quantity |
|-----------------------------------------------------|----------|
| Laser welding machine                               | 1 pc     |
| Automatic wire feeder                               | 1 pc     |
| Protective lens D25x2                               | 2 pcs    |
| Focal lens for D20 F800 cleaning mode               | 1 pc     |
| 100mm Cleaning module                               | 1 pc     |
| Wire feeding tube for steel wire                    | 1 pc     |
| Wire feeding roller set (30x10x12) 0.8V-1.6V        | 1 pc     |
| Wire feeding tube for double feeding of steel wire* | 1 pc     |
| Wire feeding roller set (30x10x12) 1.2V-2.0V*       | 1 pc     |
| Battery welding module**                            | 1 pc     |
| Key set                                             | 1 pc     |
| Nozzle set                                          | 1 pc     |
| Ethernet cable                                      | 1 pc     |
| Safety glasses in a case                            | 1 pc     |
| Machine manual                                      | 1 pc     |

\* - included with G1D/G2D

\*\* - included with G2 PRO

# CHAPTER 1. INTRODUCTION

## 1.1 MAIN PURPOSE AND SCOPE OF THE EQUIPMENT

Wattsan's handheld laser welding and cleaning machine is the most modern, high-tech and delicate way to perform high-precision and high-quality welding work, combining several functions for processing metals and other materials. This equipment is designed for use in industry, manufacturing, scientific research, and other fields that require high precision, speed, and quality welding.

## 1.2 BASIC OPERATING REQUIREMENTS

- 1) Connected ground: Grounding resistance  $<4\ \Omega$ .
- 2) It is required to install a voltage stabilizer that ensures the stabilization of the machine's supply voltage.
- 3) Good ventilation is required to prevent the accumulation of dust and combustion products.
- 4) To cool the laser source and laser head, it is necessary to properly configure and control the operation of the chiller. It is a specialized equipment that cools and circulates water and requires the use of distilled water only.
- 5) Operation of the equipment is allowed only with a connected compressed air or auxiliary gas supply system.
- 6) To prevent fire, the workplace must be equipped with a suitable fire extinguisher.
- 7) There should be a free area around the machine of about 1 m on each side.
- 8) The bending radius of the fiber optic cable should be at least 200 mm.

## 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 1080 nm).

# CHAPTER 2. SAFETY INSTRUCTIONS AND PRECAUTIONS

## 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.
- 4) Use the "SafeLock" protection system. A clamp must be installed on the workpiece so that laser radiation occurs only when it comes into contact with the surface of the surface.
- 5) For additional protection, use a separate room for working with laser equipment. At the entrance to the laser equipment work area, machines connected to the safety system are installed so that when the contact sensors open (the door opens), the laser radiation disappears.

6) Keep the machine key in a safe place, do not leave it in the lock when the machine is not in use.

## 2.3 MACHINE PROTECTION SYSTEMS

- **Emergency stop button:** When pressed, the laser light will stop, the controller will turn off.
- **Gas pressure sensor:** When the gas pressure is low, the laser radiation will not start.
- **Laser Source Temperature Sensor:** If the protective lens overheats, there will be an error, the laser emission will stop.
- **Temperature sensor on the QBH connector:** if the connector overheats, an error will appear, the laser radiation will not start.
- **Connection sensor on the QBH connector:** If the laser gun is not properly connected or tightly connected to the fiber optic at the QBH connector location, an error will appear and the laser light will not start.
- **Temperature sensor of the protective lens:** if the protective lens overheats, an error will appear, the laser radiation will stop.
- **"SafetyLock" protection system:** if the clamp is not mounted on the workpiece, and/or if the laser gun does not touch the workpiece, the laser radiation will not start.
- **Output for additional interlocking:** when the contacts are opened, the laser radiation stops. (Necessary for the installation of a protective room with a sensor on the door).



Additionally, the machine might have light signal indicator, which is lightning when the machine is working.



Laser equipment of hazard class 4 is recommended to be used in a special protective room, with a lock installed on the door connected to the machine. The laser operating area must be equipped in accordance with local regulatory requirements.

## 2.4 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.**

### 2.4.1 EYE AND SKIN PROTECTION

Fiber-optic laser sources can damage the retina of the eye because the wavelength of the laser beam is visible to the human eye. Both types of lasers 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 fiber laser, so it is strictly necessary to wear special safety glasses (with radiation protection with a wavelength range of 1080 nm).

Personal protective equipment (PPE) must not be damaged. If a PPE item is damaged, stop work and replace it with a similar one that meets safety requirements.

A combination of face shields, masks, filters, and/or goggles will provide better protection while the equipment is running. For example, an additional welding helmet (with appropriate filter glasses) that protects the wearer from UV and visible radiation should also be worn over laser goggles. A welding helmet can also protect the welder from injury due to hot splashes, metal particles and sparks. All personnel working near the laser welding area must also wear PPE.



**Parts can be very hot even after the welding or cleaning 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.**

### 2.4.2 FIRE PROTECTION

The use of oxygen, as well as sparks during operation, can easily cause a fire.

Therefore, there should be no flammable and explosive objects in the working area of the machine.

|                                                                                   |                                                                                                             |
|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|
|  | <p><b>Fire extinguishers should be nearby and accessible, and staff should be trained in their use.</b></p> |
|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|

---

#### 2.4.3 SECONDARY RADIATION HAZARDS

During welding, cleaning and cutting, both visible and invisible light radiation is generated. The interaction between high-power laser light and the target materials being welded can create a plasma that produces UV radiation and "blue light" that can cause conjunctivitis, photochemical damage to the retina and/or a sunburn-like skin reaction. Welders who are exposed to invisible ultraviolet light without proper protection can sustain permanent eye damage. 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).

|                                                                                   |                                                                                                                                            |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p><b>Each employee who is near the laser during its operation must wear appropriate laser safety goggles and protective clothing.</b></p> |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------|

---

#### 2.4.4 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.

Cleaning and welding 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.

Keep your head away from smoke while working. Always work in an area with adequate ventilation to ensure safe breathing air.

Hazardous vapors must be captured and pumped out. Use a fume extraction system to remove vapors, particles, and hazardous debris from the machine operating area.

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

In confined spaces and other circumstances, a respirator may also be required.

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

---

#### 2.4.5 ADDITIONAL SOURCES OF DANGER

##### 1. Noise level during operation.

In some operating conditions, the noise level emitted by this equipment may exceed 80 dB(A), which may be dangerous according to the requirements of some regulatory authorities. The exact sound pressure level should be measured under real operating conditions.

To protect your hearing, you may need to use headphones or other noise-canceling devices (such as soundproofing screens or partitions). Local codes, regulations, and requirements must be followed.

##### 2. Exposure to non-ionizing radiation on implants.

No additional effects on implants, except for those described above, have been revealed.

## 2.5 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.**

## 2.6 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 from the electricity. Inform the specialists. Do not repair the equipment yourself.**



**When using a laser gun, it is necessary to hold it at an angle of 30-70 degrees to the plane of the workpiece.**

**It is prohibited to work holding the gun vertically above the workpiece.**

# CHAPTER 3. COMPONENT INSPECTION AND INSTALLATION

Upon receipt, inspect the equipment for any damage in transit. Record all damage, if any. The transport company is responsible for the integrity of the equipment.

After opening the package, check the complete set. In case of non-compliance, please contact the supplier company.

## 3.1 EQUIPMENT



1. Ethernet cable (for connecting the laser source to a PC).
2. Ground cable (can be pre-installed in the machine).
3. Gas connection tube.
4. Safety glasses in a case.
5. Protective lenses.
6. Cleaning module together with focal lens.
7. A set of nozzles and a nozzle for cleaning seams.
8. DB9-DB9 cable and USB-DB9 adapter (for connecting the laser source to a PC).

## 3.2 MACHINE PLACEMENT

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. After installation, the stoppers on the wheels of the machine should be fixed.

The workplace should be a table for welding. The space between the workstation and the machine should be freed up for quick and unhindered access to the machine panel.

### 3.3 REQUIREMENTS FOR THE ENVIRONMENT

#### 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. Equipment Cooling

The equipment is cooled by air circulation inside the cabinet. Therefore, it is important that the parts inside the cabinet are not contaminated with dust and dirt.

# CHAPTER 4. EQUIPMENT DESIGN

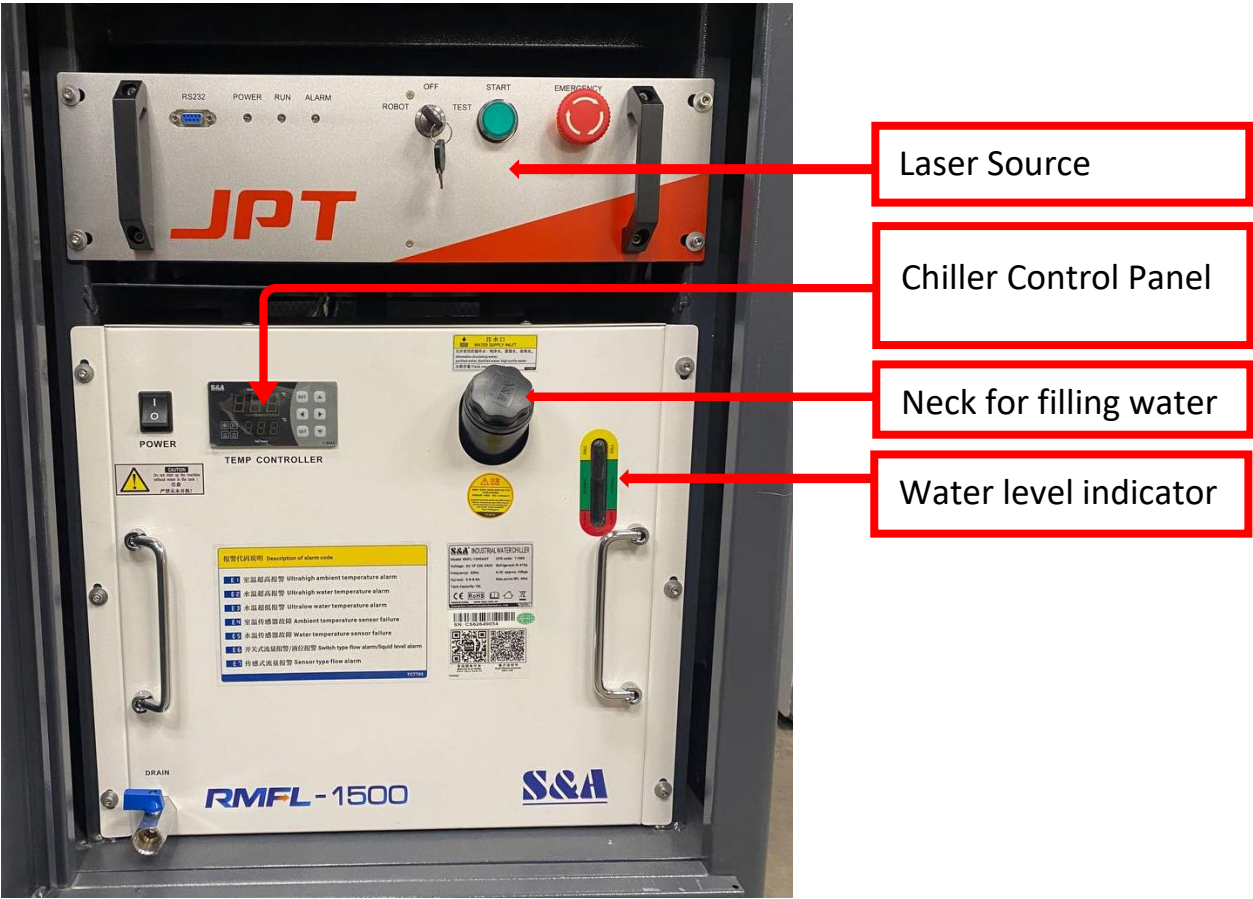
## 4.1 MAIN COMPONENTS OF THE MACHINE



4.2 CONTROL PANEL

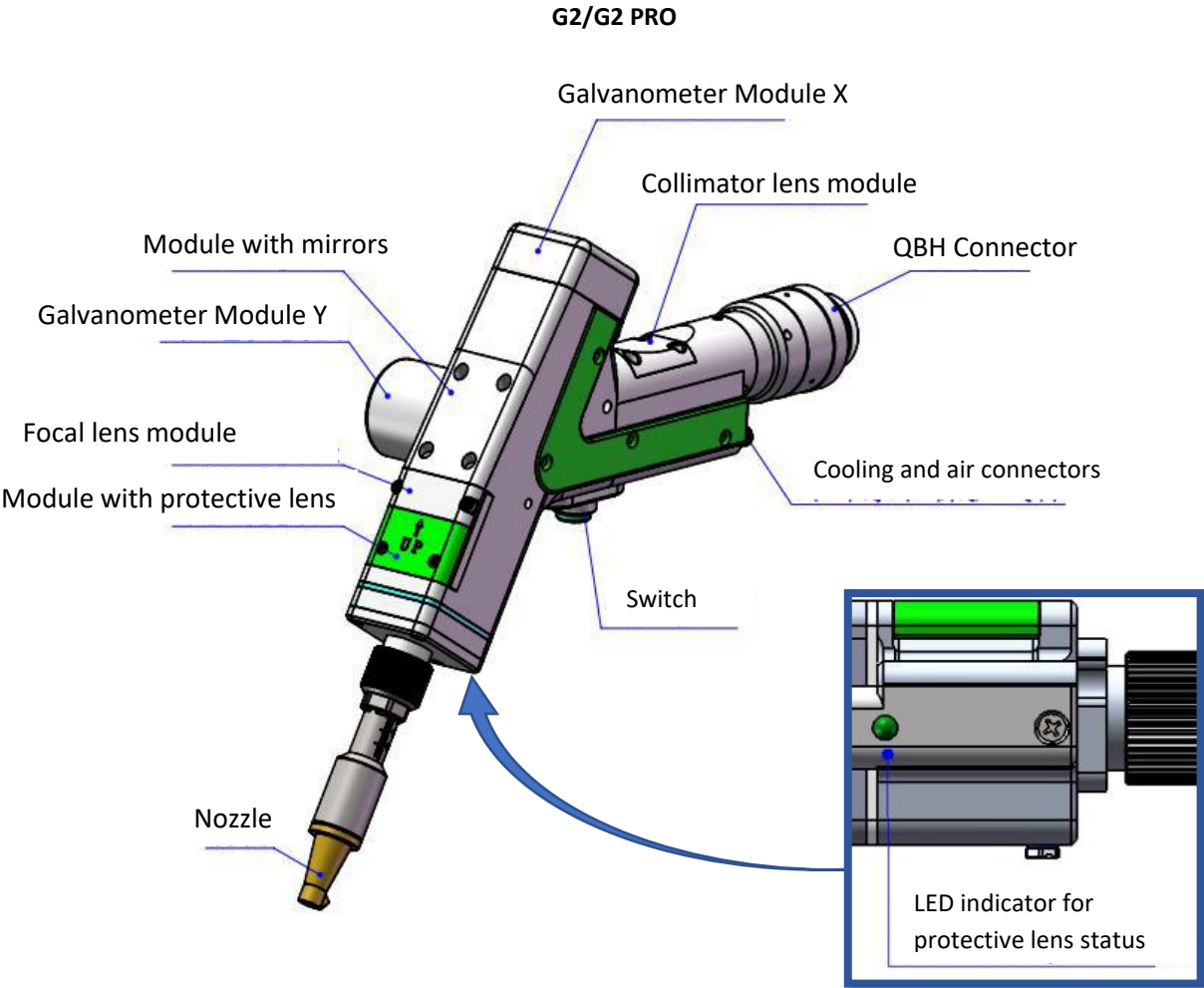
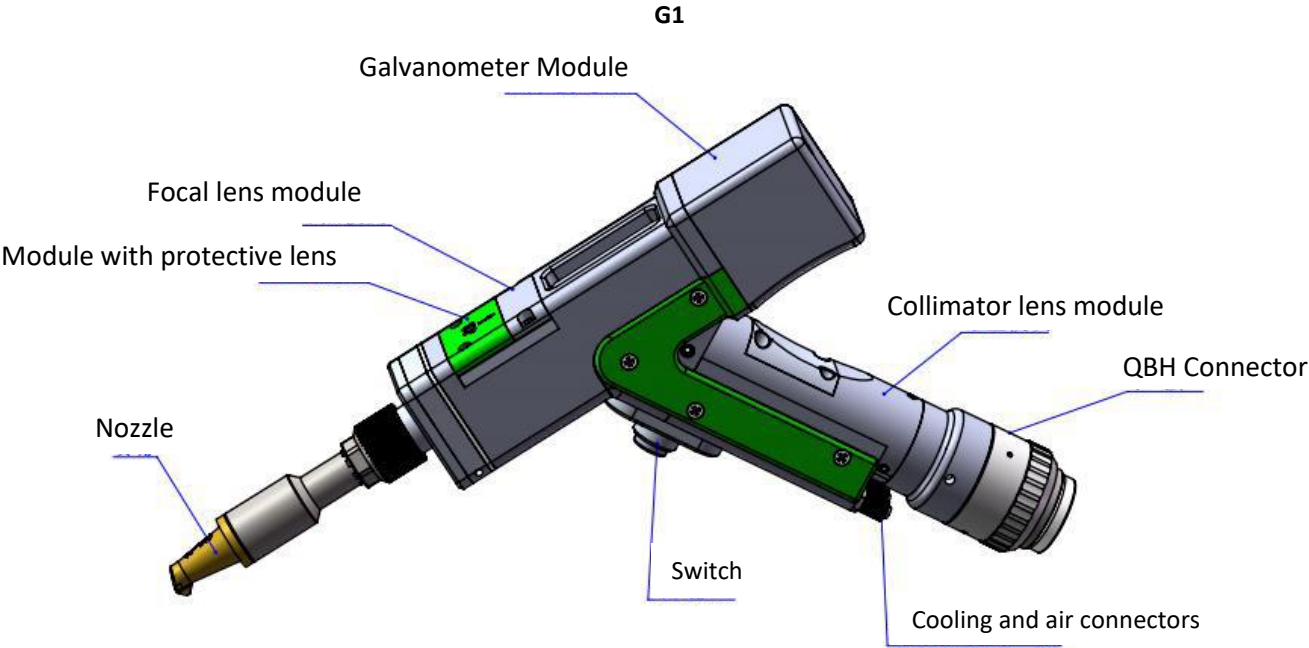


4.3 CHILLER AND LASER SOURCE



4.4 FIBER OPTIC CABLE

The bending radius of the fiber optic cable should be at least 200 mm.



# CHAPTER 5. SETUP AND OPERATION

All electrical connections must be connected 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.

## 5.1 CHILLER PREPARATION

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



All the necessary information about the chiller, including its setup and error codes, can be obtained by scanning the QR code on the chiller body.

### 1. Chiller Inspection

Clean the chiller's water tank to make sure the water tank is clean and free of contaminants. Next, check the connection of the cooling hoses for breaks.

**Make sure that the chiller is filled with refrigerant.** Contact the supplier if necessary.

### 2. Hose connection

Next, check the connection of the hoses for the outlet and inlet of water to the laser head. Make sure that the hoses inside are not dirty and do not have foreign objects (debris and fastener parts), and the hoses are not kinked along the entire routing route.



### 3. Filling the coolant



Only distilled water is allowed to be filled into the chiller.

- 1) Remove the water filler cap.
- 2) Pour distilled water into the tank. Make sure that the water level is in the green zone on the indicator scale.
- 3) Place the lid on the neck.

#### 4. Trial Run

- Check the tightness of the hoses and the compliance of the water pressure in the circuit with the required pressure for your equipment. If there is not enough cooling water in the tank, it should be added, also check that the chiller's water-cooling temperature limits meet the requirements of the equipment.
- When the water temperature reaches the set temperature, the chiller will start regulating the temperature automatically.
- After the water temperature in the cooling system and the water pressure difference reach the required value, the laser can be turned on.



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

#### 5. Color/Opacity

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 the equipment for a long time, at a temperature below freezing, it is necessary to drain the water from all hoses to avoid rupture.

### 5.2 CONNECTING THE GAS SUPPLY

#### 5.2.1 Gas requirements.

##### 1) Auxiliary gas

| Gas      | Purity  |
|----------|---------|
| Nitrogen | 99.99%  |
| Helium   | 99.998% |
| Argon    | 99.998% |



The temperature of the gas should not exceed 50 °C.

The gas pressure should not exceed 1 MPa

##### 2) Gas cylinder

The pressure reducer used in cylinders is the simplest way to supply gas.

When replacing a gas cylinder, first check the label on the cylinder to ensure that it meets the requirements for laser cutting gas (e.g., N2 gas purity requirements and pressure requirements). The gas level cannot be lower than the recommended gas level. Next, connect the hoses to the equipment in the correct direction, open the cylinder of the connecting valve, check the gas path for damage to the hoses.



Do not use gas cylinders until the cylinder is completely depleted. The pressure in the cylinder used must be higher than atmospheric pressure.

### 3) Cleaning mode

When using the machine in cleaning mode, it is necessary to connect the compressed air source to the gas supply system. Connect the compressor with the filter to the air supply system in the machine. Before connecting, make sure that the hoses inside are not dirty or have foreign objects, and the hoses are not kinked along the entire routing route.



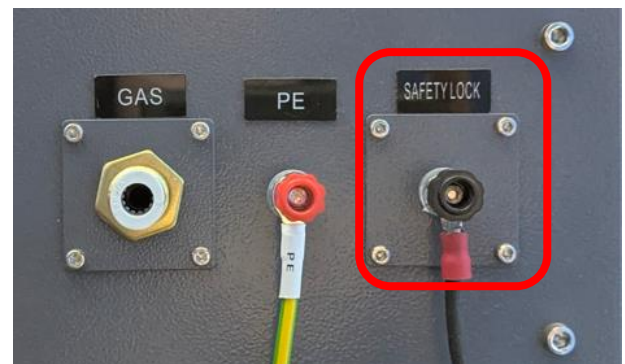
The air supply system must be equipped with a filter with a purification accuracy of 5  $\mu\text{m}$ , a moisture and oil separator. Otherwise, the optics of the machine will quickly fail.

## 5.3 CONNECTING THE SAFETYLOCK CABLE

1. Find the Safetylock cable among the packages.



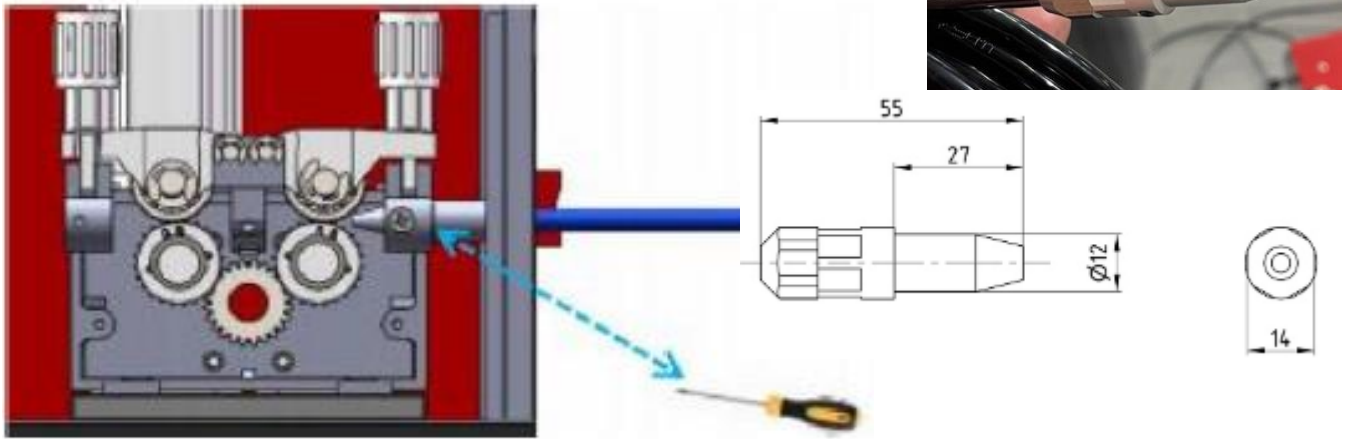
2. Connect the cable to the pin on the back of the machine labeled "SAFETYLOCK".



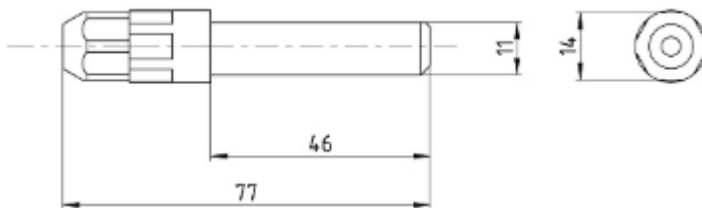
3. The clamp at the other end of the cable, when performing welding work, should be installed on the welding table or on the workpiece.

## 5.4 CONNECTING THE AUTOMATIC WIRE FEEDER

1. Connect the wire liner (guide channel) at one end to the wire feeder. Secure it with a screw.



2. Install the other end into the bracket and connect to the laser gun using the screws.



3. Install the wire tube and secure it with a clamping screw. Install the tip for the tube.



Tip

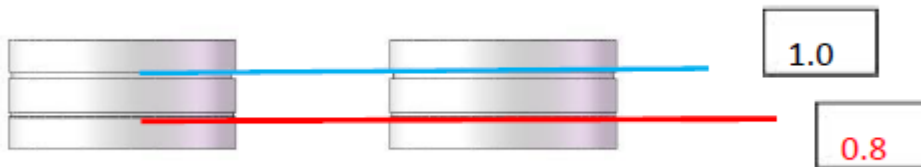
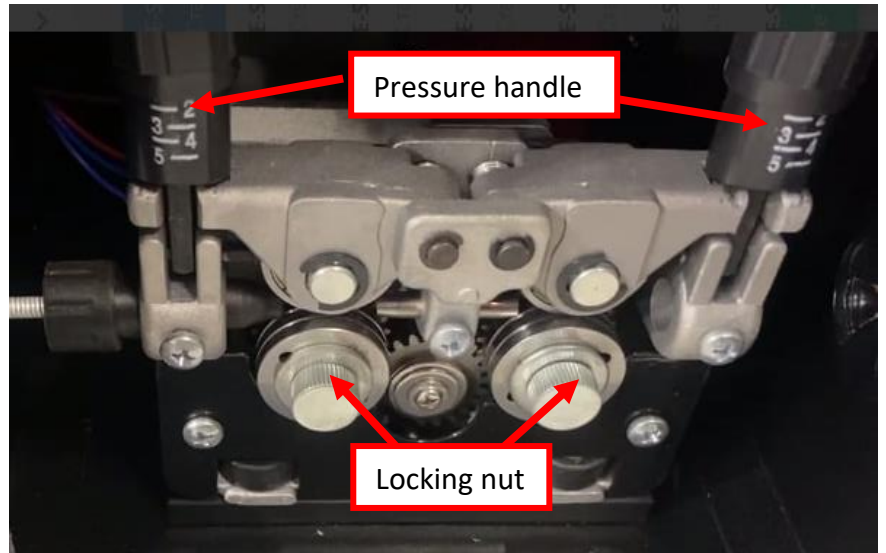
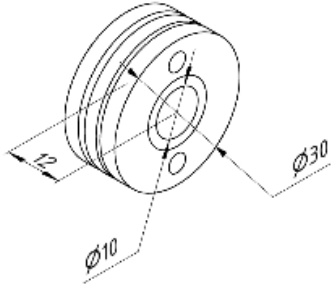
Pipe

Bracket



4. Install the rollers for the required type of wire:

- Unscrew the pressure handles counterclockwise
- Lower them 90°
- Unscrew the 2 locking nuts
- Replace the rollers and secure with nuts.



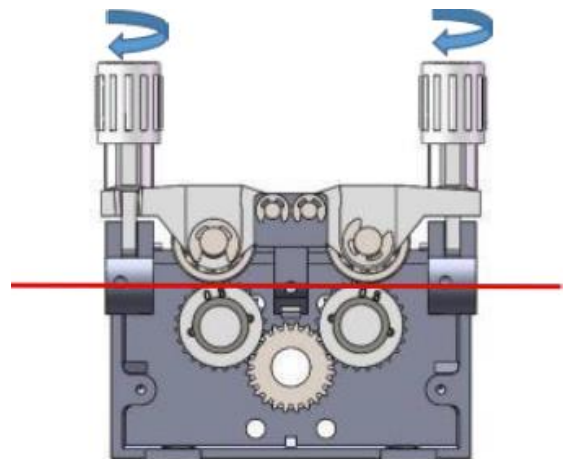
Generally, wire feeding rollers have 2 grooves for different wire diameters. Make sure the rollers are installed on the side so that the wire size and grooves are the same.

5. Load the coil of wire into the machine:

- Remove the pressure screw
- Install the coil on the shaft
- Tighten the screw



6. Pass the wire through the feed rollers and tuck the wire into the liner.  
Tighten the handles by twisting clockwise.





Before installing the wire, make sure that the correct rollers are installed in the feeder.

7. Connect the machine to the welding machine.



The tip, nozzle and rollers must fit the specified wire diameter.

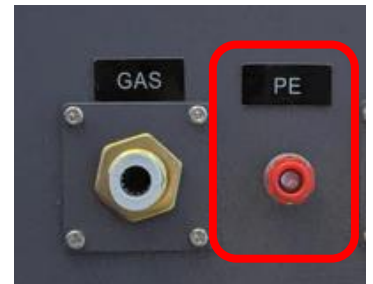
8. Connect the power to the machine.

#### 5.5 CONNECTING THE POWER SUPPLY

|                                          | G1/G2-1000/1500 | G1/G2-2000 | G1/G2-3000 |
|------------------------------------------|-----------------|------------|------------|
| Power, kW                                | 8.5             | 11         | 15         |
| Voltage, V                               | 220             | 220        | 380        |
| Maximum current for the entire system, A | 40              | 50         | 25         |

To connect the electrical power, follow these steps:

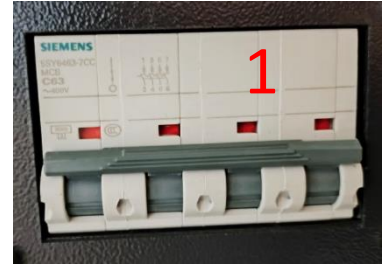
- 1) Connect to the mains power supply at the above voltage, phase, and frequency.
- 2) The unit must be permanently connected to a dedicated AC mains with a circuit breaker that meets the requirements of the equipment. It should be in the immediate vicinity of the installation, within the reach of the operator, and marked as a disconnect device for the installation.
- 3) Electrical wiring must comply with all national regulatory requirements. Electrical connections must be made by personnel with knowledge of electrical safety.
- 4) The unit must also be connected through a voltage stabilizer of suitable power.
- 5) The installation must be securely grounded. (The grounding contact is located on the back panel of the machine)



It is forbidden to use alternative sources of electricity, such as generators, etc.  
A failure in the power supply during operation can lead to equipment failure.

## 5.6 PROCEDURE FOR TURNING ON THE EQUIPMENT

1. Turn on the circuit breaker on the back of the machine.
2. On the front panel, turn the emergency shutdown button clockwise.
3. Turn the key to the ON position (it is responsible for turning on the laser emitter).
4. Turn on the chiller  (automatically enabled by default).
5. Then turn on the laser power (Laser button).
6. Start a compressor to start blowing optics or supply auxiliary gas.



## 5.7 EXTERNAL INTERLOCK CONNECTIONS (SAFETY ROOM)

- When installing the machine in a special protective room for working with laser equipment of hazard class 4, it is necessary to equip the doors with special sensors. The contacts from the probes should be connected to the "Interlock" connector on the back of the machine. When the door is opened, the sensors must open the circuit. After the contacts are opened, the laser radiation will stop.

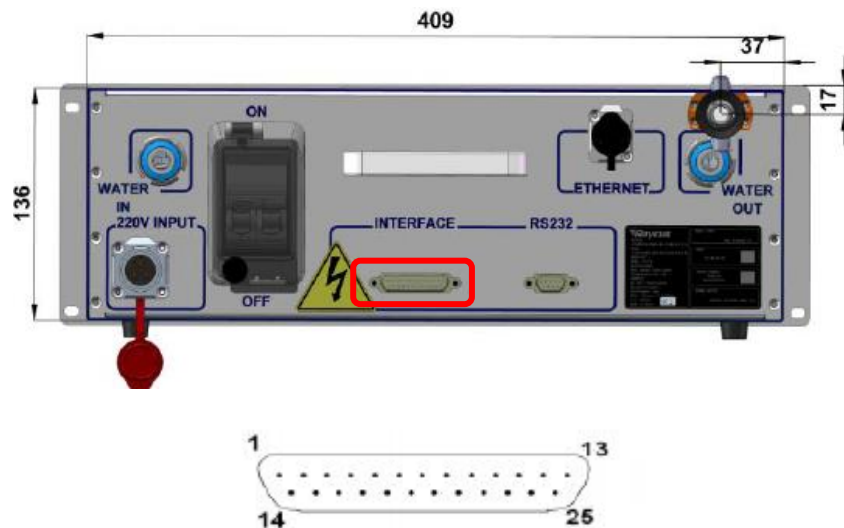


**For the laser source to operate, the "Interlock" contacts must be closed.**

- If there is no connector on the housing, the sensor should be connected to the corresponding signal cable marked ITL-1B\A or ITL-2B\A. The wires must be disconnected.



These cables are connected to the outputs in the DB25 interface on the rear panel of the emitter.



#### For Raycus Sources

| PIN | Signal      | Connection                                             | Note                                                    |
|-----|-------------|--------------------------------------------------------|---------------------------------------------------------|
| 1   | Interlock2- | For the laser to work, these 2 contacts must be closed | Do not connect to an external power supply or to ground |
| 4   | Interlock2+ |                                                        |                                                         |
| 2   | Interlock1- | For the laser to work, these 2 contacts must be closed |                                                         |
| 3   | Interlock1+ |                                                        |                                                         |

#### For JPT sources

| PIN | Signal      | Connection                                             | Note                                                    |
|-----|-------------|--------------------------------------------------------|---------------------------------------------------------|
| 22  | Interlock2- | For the laser to work, these 2 contacts must be closed | Do not connect to an external power supply or to ground |
| 9   | Interlock2+ |                                                        |                                                         |
| 21  | Interlock1- | For the laser to work, these 2 contacts must be closed |                                                         |
| 8   | Interlock1+ |                                                        |                                                         |

## 5.8 WELDING PROCEDURE

### 1) Nozzle Installation

Unplug the laser source before replacing the nozzle.

The nozzle is installed on the welding module.



### Nozzles included

| No | Nozzle | Application                                |
|----|--------|--------------------------------------------|
| 1  | FAS    | Filler Wire Welding Nozzle                 |
| 2  | FBS    |                                            |
| 3  | DAS*   | Nozzle for welding with 2 filler wire bars |
| 4  | DBS*   |                                            |
| 5  | FCS    | Wireless welding nozzle                    |
| 6  | FS     |                                            |
| 7  | FC     | Cutting nozzle                             |
| 8  | SS     | Wire Feeder Nozzle                         |

\*- Nozzle data is included in the double wire feed model kit

### 2) Adjusting the Nozzle Tube

To adjust the nozzle tube, loosen the nut first.

Once the tube is installed correctly, tighten the nut to secure the nozzle tube in place. Tighten only by hand!

### 3) Starting Welding

Select the type of nozzle you need. Install the nozzle on the welding cell. Select the programmed mode.

Fix the parts to be welded. In laser welding, it is desirable to clamp parts with a minimum gap and, if possible, with tight edge contact.

Make sure that the clamping contact is attached to either the part to be welded or to the electrically conductive welding table on which the parts are placed.



Touch the nozzle tip to the part to be welded and press the button on the laser gun. The photo below shows the correct angle for positioning the laser gun when pointing the nozzle at the part to be welded.



**When using a laser gun, it is necessary to hold it at an angle of 30-70 degrees to the plane of the workpiece.**

**It is prohibited to work holding the gun vertically above the workpiece.**

For seam welding:

Laser welding is performed in a pulling motion at a constant speed of movement to ensure a uniform seam depth. By adjusting the speed or power of the laser, you can change the depth of the weld.

Practice the movement before pressing the button on the laser gun. Do not break contact with the part. If you momentarily lift the nozzle tip over the part while the trigger is being pulled, the laser will automatically turn off.

For the tack welds:

Press and hold the trigger for 1 to 2 seconds. Release the button on the laser head, move to the next location of the tack welds, and repeat.

To further improve the welding process, operators can adjust the main process parameters by increasing or decreasing the laser power, vibration frequency or amplitude using the menu on the machine display.

## 5.9 MACHINE SHUTDOWN PROCEDURE

1. Press the laser shutdown button.
2. Turn the laser activation key to the OFF position.
3. Hold down the emergency stop button.



4. Turn off the circuit breaker on the back of the machine.



5. Turn off the compressor, turn off the gas.

# CHAPTER 6. SOFTWARE DESCRIPTION

## 6.1 INTRODUCTION TO SOFTWARE FUNCTIONS

As for the control system, a 7-inch TFT touch screen is used, with a user-friendly interface and simple operation. On the main screen, laser-related parameters can be configured and real-time display the status of input/output IOs, alarm information, and operation status.

## Home Screen



**Bluetooth Sign:** Indicates whether Bluetooth pairing has been made between the hardware and the mobile device.

**Settings Library:** Select from several groups of different welding parameters for different types of material.

**Power:** Sets the peak power value of the laser.

**Laser frequency:** Set the frequency of the PWM laser.

**Load cycle:** Setting the PWM cycle of the CW laser signal.

**Seam Type:** Laser spot shape setting.

**Welding Mode:** Sets the operating mode of the laser source.

**Frequency of vibration.:** Set the frequency of the galvanometer.

**Seam Width:** Sets the length of the laser scan.

**Feed Speed:** Sets the speed at which the wire will be fed during welding.

**System Options:** Click to go to the System Settings page and change the settings of the system functions.

**Error Display Area (Upper Right Corner of the Screen):** Displays the status of the systems by multiple pairs, such as shielding gas pressures, coolant flow, laser status and temperature, and galvanometer status. If a fault occurs, the corresponding icon will flash red and blue.

**Laser On/Off:** Programmatically locks the laser. In stop mode, pressing the button on the scanner will not trigger the laser light.

**Cleaning the seams:** Starts the cleaning mode of the joints (the nozzle needs to be replaced).

**Spot Welding:** Start the spot-welding mode.

## 6.2 SWITCHING OPERATING MODES

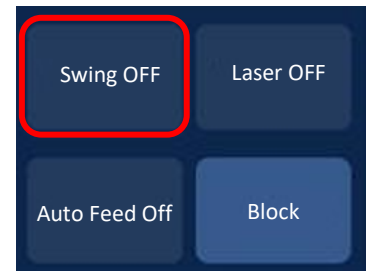
This type of equipment provides for several types of work:

- Welding
- Cutting
- Cleaning joints
- Cleaning
- Battery welding (optional)

By default, the machine works in welding mode, to start other modes, use the following instructions:

### 6.2.1 CUTTING

1. To start this mode, you need to disable swing on the main screen.

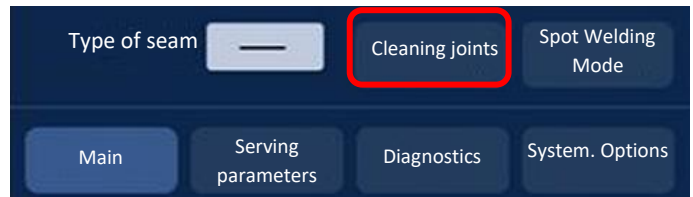


2. Replace the nozzle with a cutting nozzle.



### 6.2.2 CLEANING THE JOINTS

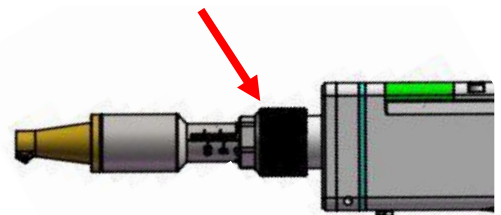
1. To start this mode, you need to select the joint cleaning item on the main screen.



2. Laser head module replacement for seam stripping mode.

- Removing the welding nozzle.
  - 1) Loosen the nut securing the nozzle;
  - 2) Remove the welding nozzle;
  - 3) Unscrew the 3 M2.5 screws holding the welding module;
  - 4) Remove the welding module.

Nozzle Nut

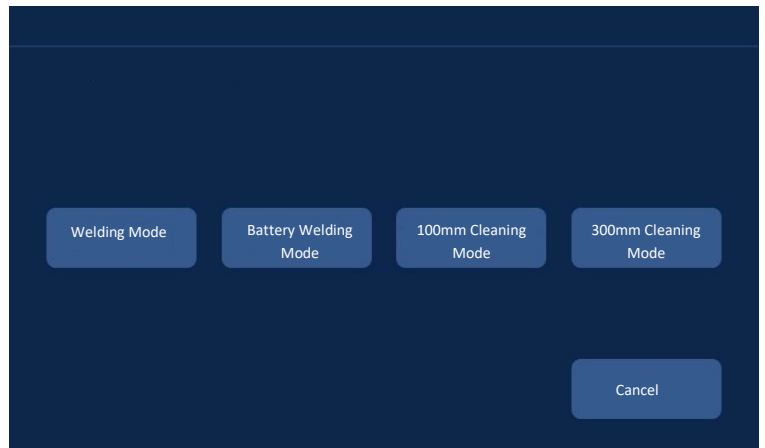


- Installing the weld stripping nozzle
  - 1) Install the weld stripping nozzle in the mount;
  - 2) Secure with a nut.



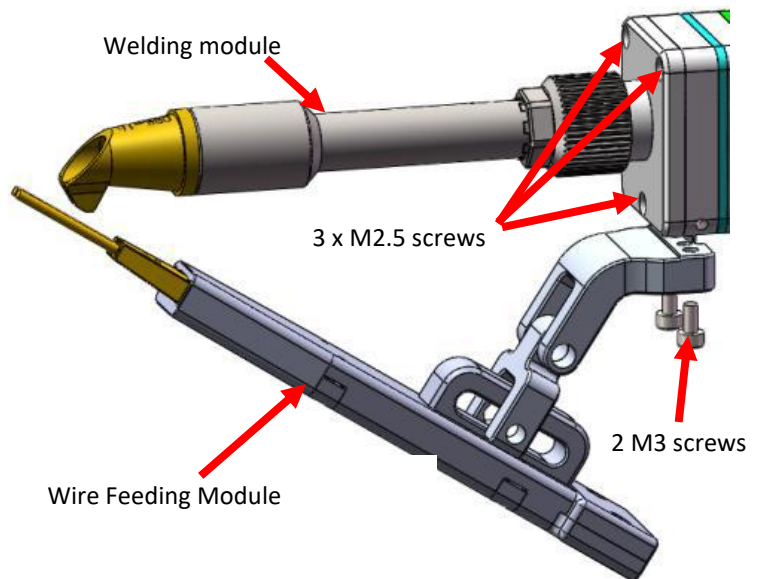
### 6.2.3 CLEANING

1. To start this mode, you need to select the system options -> authorization -> operating mode (password 666666) on the main screen. In the window that appears, select 100mm cleaning.

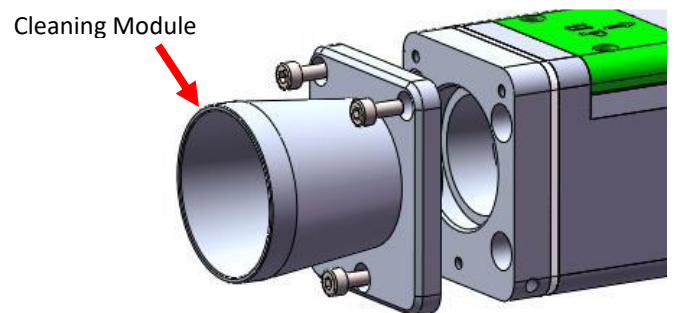


#### 2. Laser Head Module Replacement for Cleaning Mode

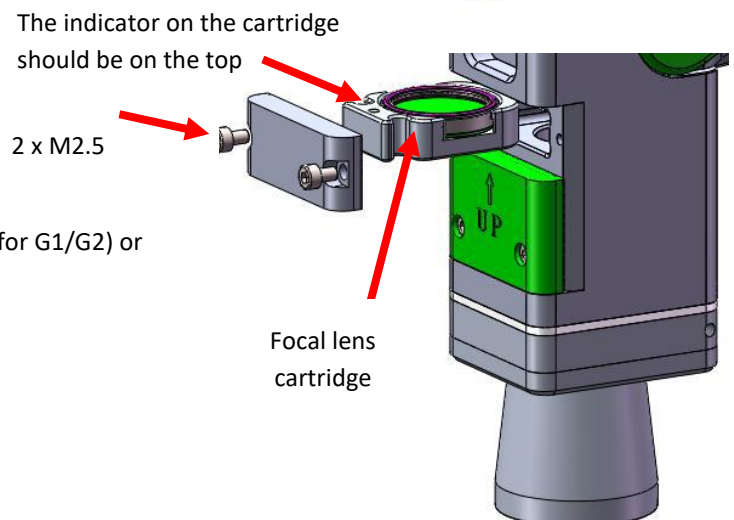
- Removing the welding module.
  - 1) Remove the 2 M3 screws holding the wire feeding module;
  - 2) Remove the wire feeding module;
  - 3) Unscrew the 3 M2.5 screws holding the welding module;
  - 4) Remove the welding module.



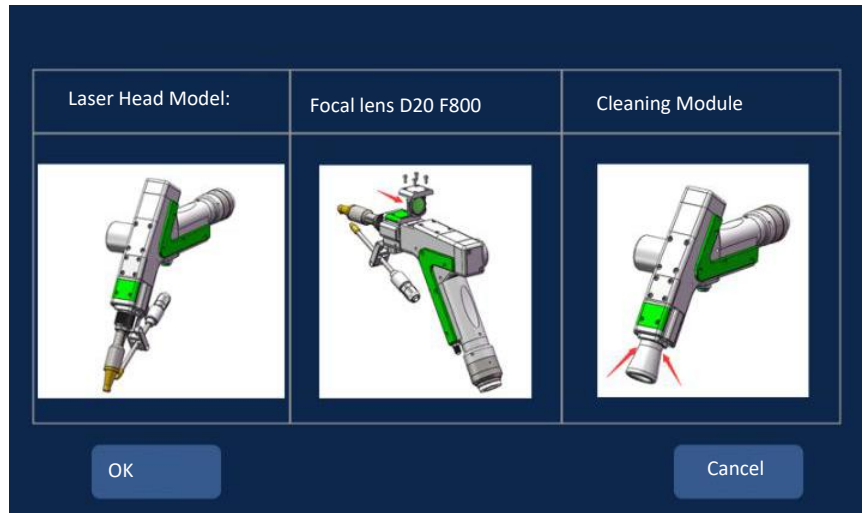
- Installing the Cleaning Module
  - 1) Install the Cleaning Module;
  - 2) Fix with 3 M2.5 screws.



- Replacing the focal lens
  - 1) Remove 2 M2.5 screws;
  - 2) Remove the cartridge cover;
  - 3) Remove the focal lens cartridge for welding D20 F150 (for G1/G2) or D20 F200 (for G1D/G2D);
  - 4) Install the D20 F800 Focal Lens Cleaning Cartridge;
  - 5) Install the cover back and fix it with 2 M2.5 screws.

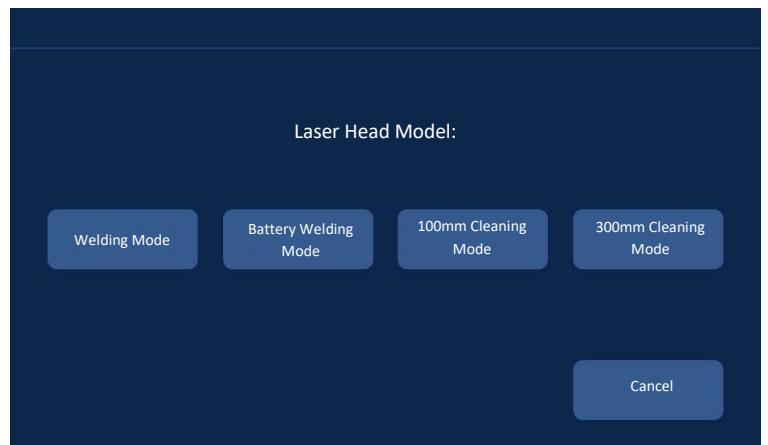


3. Make sure that the module is installed correctly and click OK.



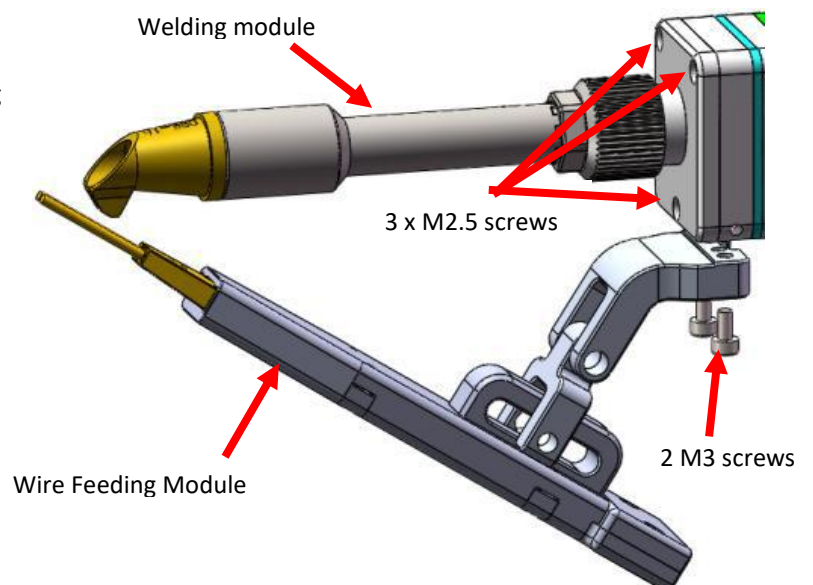
#### 6.2.4 BATTERY WELDING (OPTIONAL)

1. To start this mode, you need to select the system options -> authorization -> operating mode (password 666666) on the main screen.



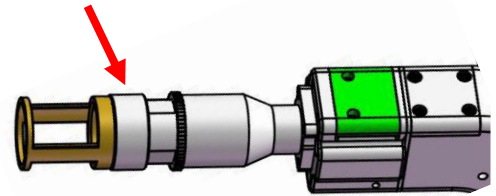
#### 2. Laser Head Module Replacement for Battery Welding Mode

- Removing the welding module.
  - 1) Remove the 2 M3 screws holding the wire feeding module;
  - 2) Remove the wire feeding module;
  - 3) Unscrew the 3 M2.5 screws holding the welding module;
  - 4) Remove the welding module.



- Installation of the resistance welding module
  - 1) Install the resistance welding module;
  - 2) Fix with 3 M2.5 screws.

Battery Welding Module



3. Make sure that the module is installed correctly and click OK.



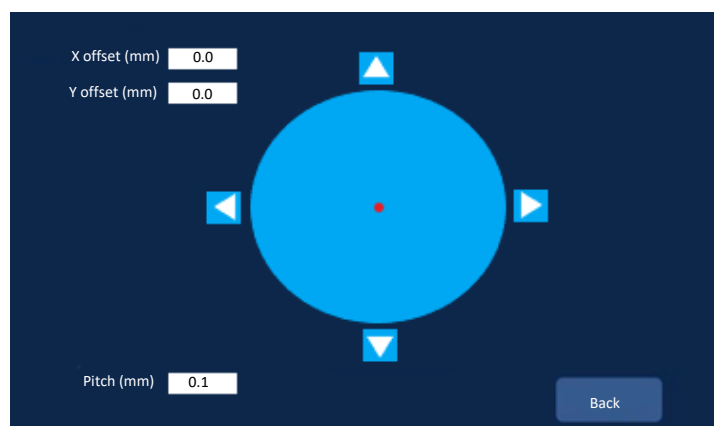
### 6.3 LASER BEAM ALIGNMENT

The laser beam in static mode should come out exactly in the center of the nozzle.



To correct the position of the laser spot, the following steps must be followed:

1. Go to the **System params.**
2. Select **Offset**
3. Apply the laser gun to the material on which the position of the laser mark from the pointing laser is visible.
4. On this screen, use the arrows to move the laser point to the center of the nozzle as shown in the diagram above.



# CHAPTER 7. MAINTENANCE

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

## 7.1 PERIPHERAL EQUIPMENT MAINTENANCE

| Maintenance period | Maintenance content                                                                                               | Purpose                                                                     |
|--------------------|-------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|
| Once a year        | 1. Check that the chiller body is dry, clean and well ventilated.                                                 | For long-term operation of the chiller                                      |
| Every 3 months     | 1. Replace the water in the chiller                                                                               | To ensure the normal operation of the laser                                 |
| Monthly            | 1. Clean the chiller body with soap and water (do not use gasoline, acids, metal brushes).                        | For long-term operation of the chiller                                      |
|                    | 2. Check the chiller condenser for dirt or dust buildup. If necessary, blow it out.                               | To ensure the normal operation of the chiller                               |
|                    | 3. Check the water quality.                                                                                       | Good water quality is essential for the normal operation of laser equipment |
|                    | 4. Checking the condition of the filter in the cooling and air supply systems, and timely replacement.            |                                                                             |
|                    | 5. Check for gaps in the pipelines                                                                                | Make sure there are no leaks                                                |
| Daily              | 1. Monitor the purity and temperature of the water                                                                | To ensure the normal operation of the laser radiation source.               |
|                    | 2. Inspection of the protective glass for contamination and timely replacement/cleaning in case of contamination. | To ensure the normal operation of the laser head.                           |
|                    | 3. Chiller water temperature control ( $22 \pm 1$ °C).                                                            | For normal cooling of equipment                                             |
| Of necessity       | 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.                           |

## 7.2 CLEANING AND MAINTAINING THE OPTICAL SYSTEM OF THE MACHINE



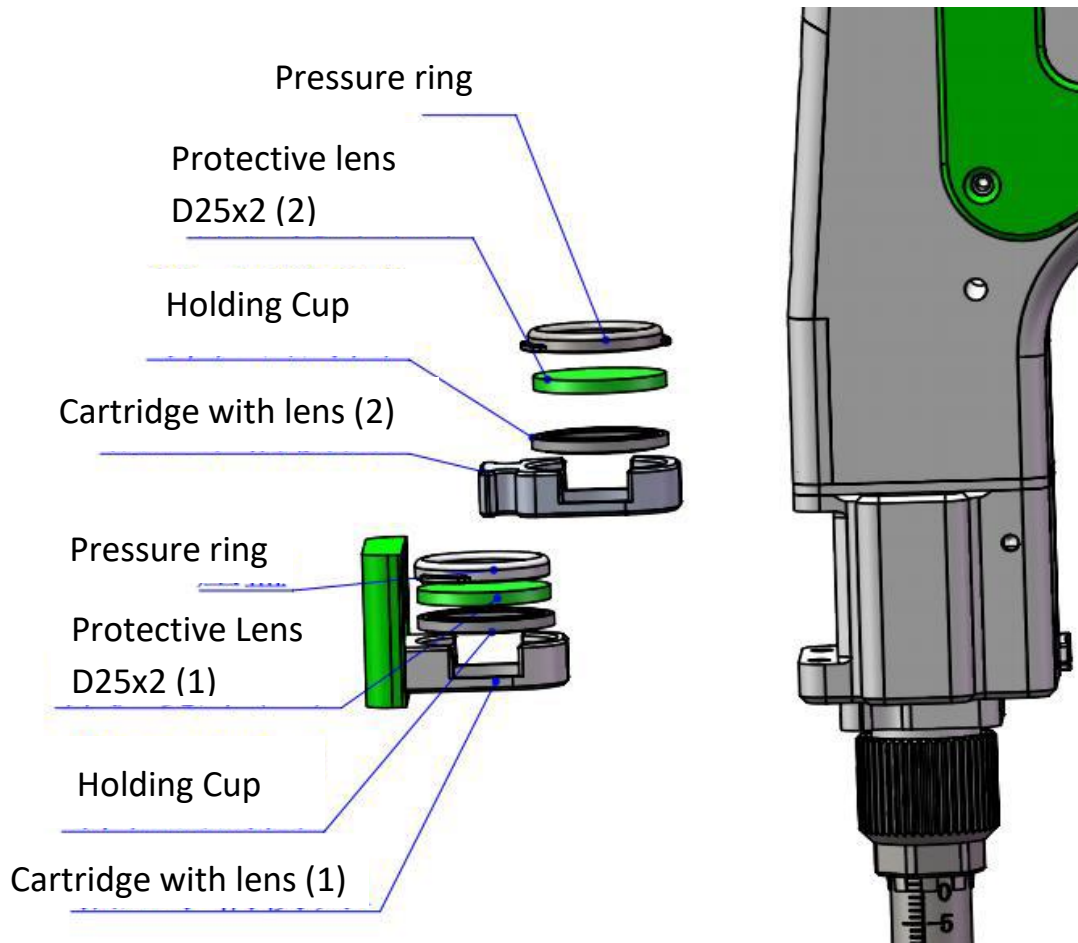
If the optical element is damaged, it must be replaced as soon as possible. It is forbidden to operate the machine with damaged optics.

### 7.2.1 INSTALLATION AND REPLACEMENT OF THE OPTICAL ELEMENT:

- 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.

### 7.2.2 PROTECTIVE LENS REMOVAL DIAGRAM

1. Take the cartridge with the protective lens on both sides and pull outward. After it is removed, cover the window with tape to prevent dust from getting there.
2. Turn the lens pressure ring counterclockwise and remove it.
3. Replace the protective lens.
4. Assemble the device in reverse order.



### 7.2.3 STEPS FOR CLEANING OPTICAL ELEMENTS.

|  |                                                                                      |
|--|--------------------------------------------------------------------------------------|
|  | Work on cleaning and replacing optical elements must be carried out in a clean room! |
|  | Optical elements must not be rinsed with water or detergents.                        |

There are different cleaning methods for different optical elements. If the surface of the optical element is flat and does not have a frame, then you can use special paper for cleaning the optics. If the surface of the optical element is curved or has a frame, and it is not possible to use special cleaning paper to clean it, then clean lint-free sticks should be used.

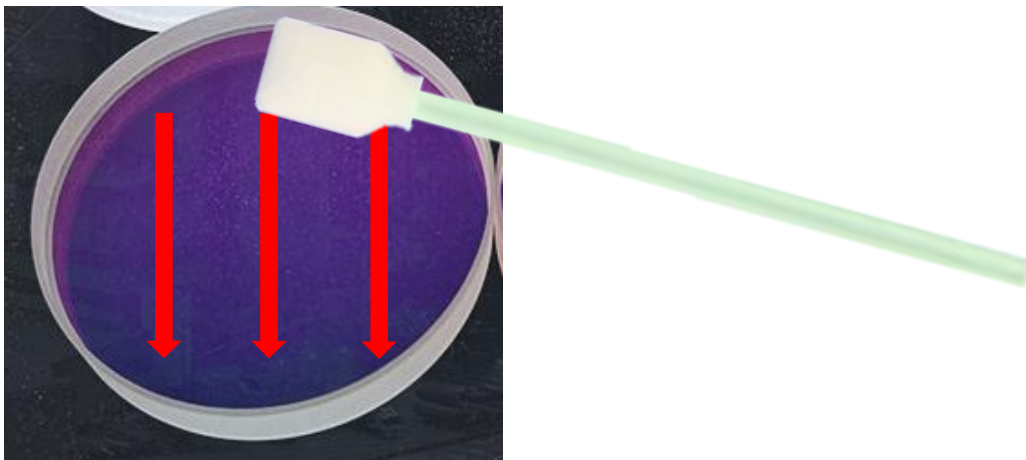
#### Cleaning methods:

- 1) Using special paper for cleaning optics.

Use clean air to blow the dust off the surface of the optical element. Use alcohol and special cleaning paper. Position the optical element horizontally on the special cleaning paper. Pour 2~3 drops of high-purity isopropyl alcohol or acetone onto the optical element and rub slowly, in the direction of the operator, with special cleaning paper on the surface of the optical element until the surface of the optical element is cleaned. Do not press the optical element and try not to scratch it. In no case rub dry on the surface of the optical element, use alcohol or acetone of high purity!

- 2) Using a special lint-free stick for cleaning optics.

Use clean air to blow the dust off the surface of the optical element. Pour 2~3 drops of isopropyl alcohol or high-purity acetone onto the optical element. Gently pinch the optical element at the edges. Wipe the surfaces of the optical element with a lint-free wand in one-way motions. **Do not allow backward movements on the surface of the optical element!** Do not use used wipes or lint-free sticks!



---

#### 7.2.4 STORAGE OF OPTICAL ELEMENTS:

- 1) The storage condition of the optical element affects its quality.
- 2) The ambient temperature should be 10~40C. Do not freeze the optics!
- 3) Optical elements must be stored in a separate box, must not be subject to vibration, otherwise they can be damaged.

# CHAPTER 8. TROUBLESHOOTING

| Defect                                                                     | Analysis of the cause                                                                                                                                                                                                                                                                         | Troubleshooting method                                                                                                                                                                                                                                                                                                                                                                                                                 |
|----------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>The point of the laser beam does not move</b>                           | <ul style="list-style-type: none"> <li>The scan width is too small.</li> <li>The connector of the laser head control cable is loose.</li> <li>The motor or control card is damaged.</li> </ul>                                                                                                | <ul style="list-style-type: none"> <li>Set a larger scan width (seam width).</li> <li>Tighten loose connections.</li> <li>Please contact us.</li> </ul>                                                                                                                                                                                                                                                                                |
| <b>Sudden loss of energy during cleaning or welding</b>                    | <ul style="list-style-type: none"> <li>There are foreign objects or damage on the optical lens.</li> <li>Laser malfunction or abnormality.</li> </ul>                                                                                                                                         | <ul style="list-style-type: none"> <li>If the cause is a protective lens, clean or replace it. For other lenses, please contact us.</li> <li>Please contact us.</li> </ul>                                                                                                                                                                                                                                                             |
| <b>The laser head heats up</b>                                             | <ul style="list-style-type: none"> <li>The optical lens is dirty or damaged.</li> <li>Optical path deviation.</li> </ul>                                                                                                                                                                      | <ul style="list-style-type: none"> <li>Clean or replace the protective lenses. For other lenses, please contact us.</li> <li>Align the laser beam.</li> </ul>                                                                                                                                                                                                                                                                          |
| <b>Water Cooler Alarm</b>                                                  | <ul style="list-style-type: none"> <li>The chiller is turned off.</li> <li>Insufficient water level.</li> <li>The water temperature is too high or too low.</li> <li>The water circulation hoses are clamped or clogged.</li> <li>The pump or other part of the chiller is broken.</li> </ul> | <ul style="list-style-type: none"> <li>Turn on the chiller.</li> <li>Check the water circulation system.</li> <li>Check the water temperature, if the temperature returns to normal, restart the machine.</li> <li>Check the water supply hoses, straighten and straighten them.</li> <li>Check the alarms on the chiller, refer to the cooler user manual.</li> </ul>                                                                 |
| <b>Laser Source Alarm</b>                                                  | <ul style="list-style-type: none"> <li>Error in the operation of the laser source.</li> </ul>                                                                                                                                                                                                 | <ul style="list-style-type: none"> <li>Check the laser source, if the alarm light is on, please contact us.</li> </ul>                                                                                                                                                                                                                                                                                                                 |
| <b>Air pressure alarm</b>                                                  | <ul style="list-style-type: none"> <li>There is no auxiliary gas/air supply.</li> </ul>                                                                                                                                                                                                       | <ul style="list-style-type: none"> <li>Check the air/gas pressure in the system. Whether the compressor is working, whether the gearbox in the cylinder is open.</li> </ul>                                                                                                                                                                                                                                                            |
| <b>The indicator of the protective lens on the laser head is solid red</b> | <ul style="list-style-type: none"> <li>The temperature of the protective lens exceeds the permissible values. The lens is dirty.</li> </ul>                                                                                                                                                   | <ul style="list-style-type: none"> <li>Replace/clean the protective lens.</li> </ul>                                                                                                                                                                                                                                                                                                                                                   |
| <b>Protective glass burns quickly and easily</b>                           | <ul style="list-style-type: none"> <li>Gas is not connected</li> <li>Contaminated gas / missing filter, moisture and oil separator.</li> <li>The protective glass is installed with dirt or dust on it.</li> </ul>                                                                            | <ul style="list-style-type: none"> <li>Connect the gas or air source and check the pressure.</li> <li>Install or replace the filters downstream of the air compressor.</li> <li>Replace the protective glass in a clean room, with clean hands.</li> </ul>                                                                                                                                                                             |
| <b>Temperature alarm</b>                                                   | <ul style="list-style-type: none"> <li>The double protective lenses or focal lens are damaged.</li> <li>The laser beam is not centered.</li> <li>Poor quality of the protective lens.</li> </ul>                                                                                              | <ul style="list-style-type: none"> <li>Inspect the lenses for spots under the light. If there is damage or dirt, replace the lenses with new ones.</li> <li>Check the position of the laser and center if necessary.</li> <li>Make sure that the compressed air passes through the dehumidifier's oil-water separator.</li> <li>Install protective lenses with good light transmission and resistance to high temperatures.</li> </ul> |

|                                                             |                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |
|-------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Temperature sensor error (XXX value or too high)</b>     | <ul style="list-style-type: none"> <li>• Poor contact in the signal line connector or no grounding</li> <li>• Interference from TIG welding.</li> <li>• System failure.</li> <li>• The temperature control board burned out.</li> </ul>                    | <ul style="list-style-type: none"> <li>• Open the cover and check the connection of the cable from the laser gun to the controller board, reconnect if necessary.</li> <li>• The working distance between laser welding and TIG welding should be <b>5-10m</b>.</li> <li>• Measure the voltage at the CN3 terminals:<br/>Pins 1-4: About 5 V.<br/>Pins 2-4: 0-0.18 V.<br/>Pins 3-4: About 2.5V.<br/>If there is no voltage, there may be a break in the signal cable or damage to the card.</li> <li>• Check the condition of the ground.</li> </ul> |
| <b>Vibration alarm signal (galvanometer)</b>                | <ul style="list-style-type: none"> <li>• Poor contact in the signal line connector.</li> <li>• There is no voltage of <math>\pm 15V</math>.</li> </ul>                                                                                                     | <ul style="list-style-type: none"> <li>• Open the cover and check the connection of the cable from the laser gun to the controller board, reconnect if necessary.</li> <li>• Check the connection of the <math>\pm 15V</math> power supply. Check the voltage at the output of the power supply.</li> </ul>                                                                                                                                                                                                                                          |
| <b>Lock Alarm</b>                                           | <ul style="list-style-type: none"> <li>• There is no contact between the Interlock cable and the laser gun.</li> </ul>                                                                                                                                     | <ul style="list-style-type: none"> <li>• Make sure the clamp is mounted on a conductive material that provides a closed loop with the laser gun nozzle.</li> <li>• Check the continuity of the cable with the clamp, measure conductivity with a multimeter if necessary.</li> </ul>                                                                                                                                                                                                                                                                 |
| <b>Wire feeding is not smooth</b>                           | <ul style="list-style-type: none"> <li>• The wire feeding tube is strongly curved.</li> <li>• The wire is deformed inside the tube.</li> <li>• The type of welding wire does not match the feed wheel.</li> <li>• The supply tube is not fixed.</li> </ul> | <ul style="list-style-type: none"> <li>• Straighten the wire feeding tube.</li> <li>• Remove the wire and check its condition.</li> <li>• Make sure that the type of wire is suitable for the installed rollers (for steel - <b>V-shaped</b>, for aluminum - <b>U-shaped</b>) and the supply tube (for steel - reinforced, for aluminum - Teflon non-reinforced).</li> </ul>                                                                                                                                                                         |
| <b>Wire feed wheel does not rotate (wire is not feeded)</b> | <ul style="list-style-type: none"> <li>• The wire feeder is switched off.</li> <li>• The signal cable is not connected to the machine.</li> <li>• Wire feed speed too high</li> </ul>                                                                      | <ul style="list-style-type: none"> <li>• Turn on the power.</li> <li>• Check the connection of the signal cable.</li> <li>• Reduce wire feed speed.</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                       |

# CHAPTER 9. TRANSPORTATION AND STORAGE



Before transportation, it is necessary to drain the water from the cooling system, as well as blow out the cooling system in order to remove the residual liquid.

## 9.1 TRANSPORTING THE MACHINE

- 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.

## 9.2 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.

## 9.3 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 50 |
| Humidity (%)       | up to 70% |

# CHAPTER 10. EQUIPMENT DISPOSAL

The service life of the laser machine is 7 years if all the requirements of this manual are met.

At the end of its service life, as well as if the machine becomes defective and cannot be restored, it must be decommissioned and disposed of.

It is important to note that the device does not contain components that are dangerous to human life and health.

Disposal of equipment should be carried out in accordance with:

- Internal regulations of the enterprise where the system was operated;
- Current national legislation in the field of waste management of electronic and electrical equipment.

# CHAPTER 11. WARRANTY

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, protective lens, 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.