

**Operations Manual for**  
**SONOWELD Generator**

# **SONOWELD GENERATOR**

**ULTRASONIC GENERATOR – Manual**

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## **INTRODUCTION**

Dear Customer,

Thank you for your purchase of the product.

This ultrasonic SONOWELD-generator has been developed using the latest technologies to allow for greater overall performance and stability.

**Please read and follow these operating instructions carefully before installing or commissioning your product. As with any electrically powered device, failure to observe these instructions can present a risk to life.**

**The device may only be operated and maintained by personnel who have read and understood this operating manual and are familiar with the applicable legal regulations for accident prevention and workplace safety. Failure to comply with this will result in a loss of warranty rights.**

## **SAFETY INSTRUCTIONS**

Before starting up your device, please read through the following instructions carefully, both for your own safety and for the safety of the device.

Keep this manual where it can be readily accessed by all systems users.

### **Installation is to be carried out by qualified technical personnel only!**

This ultrasonic generator is to be operated by properly trained personnel only!

Due to the way it operates, **additional** safety measures must be taken if the device is to be used in areas posing an explosion risk.

The electromagnetic compatibility corresponds to the standards and regulations listed in the specifications.

All necessary settings were either made in the factory or are described in this handbook.

However, should problems occur on start-up, please do not make any prohibited adjustments to the device, as this would endanger your warranty rights. If in doubt, please contact our technical service staff.

Please contact our technical service if at all in doubt. [Please see the last page.](#)

Inspection or diagnostic work inside the device may only be carried out to the extent described and, as with the electrical connection should only be performed by skilled personnel. When performing such work, the ultrasonic generator must be completely disconnected from the main power source. (unplug the mains connection).

The device must always be disconnected from the mains before cleaning or when installing/uninstalling an option. Do not use liquid cleaners or sprays. Only use a damp cloth.

Inputs or outputs that are used for controlling or monitoring purposes should be twisted and shielded. The device must not be in close proximity to electrically charged components or cables.

The shielding should be connected to the generator's earth on one side of the generator.

Attention: All connections for the signal or control lines are galvanically connected to the generator.

Always observe any warnings or instructions provided on the device itself.

The platform for the device must be sufficiently stable, as the device being jolted or falling could cause severe damage.

Ensure that the power supply specifications given on the device are met.

Only those transducers which have the correct frequency, power output and dimensions may be used with this generator.

HF cables from the generator to the transducer as well as mains cables to the generator may not be rolled up if they are too long. Instead, they must be shortened to the required length due to the risk of overheating.

With the exception of the permitted tasks listed in the handbook, you should never attempt to repair or modify the device yourself.

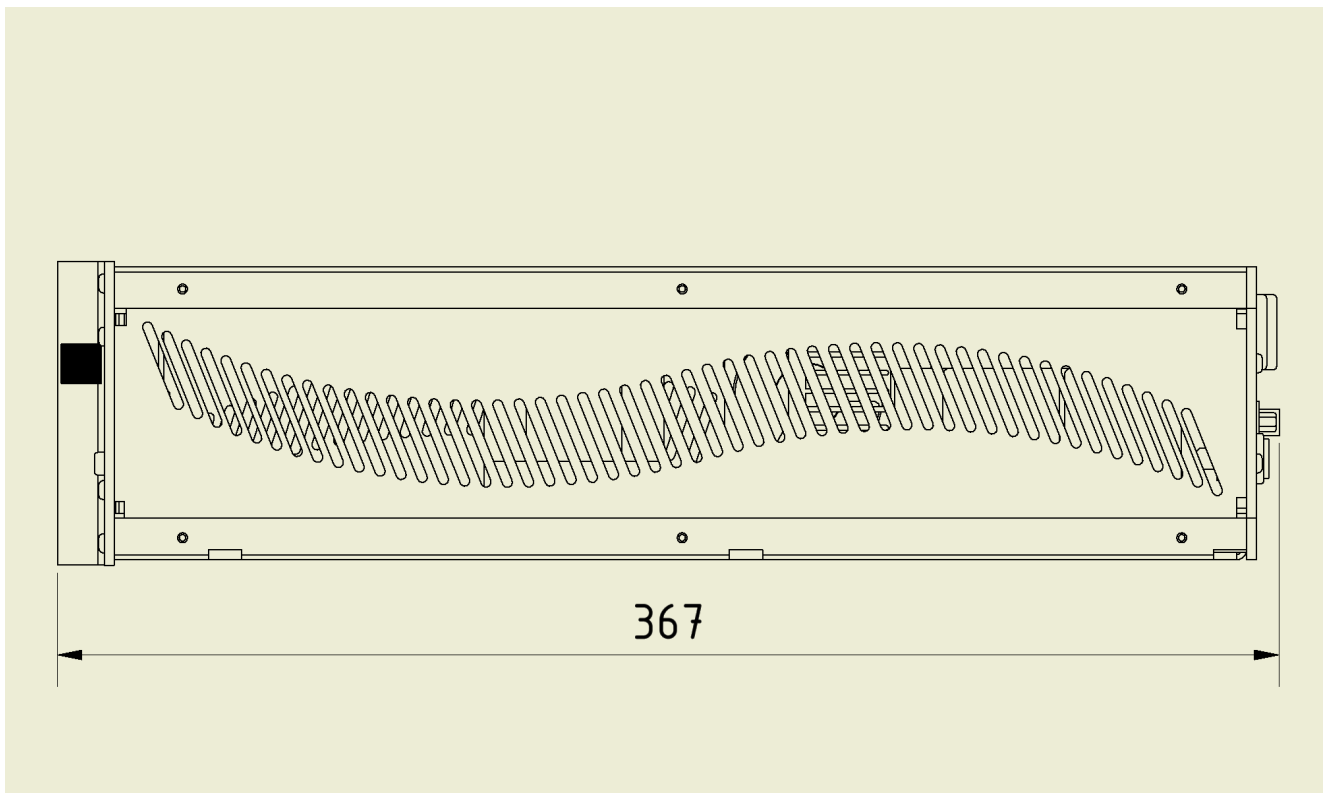
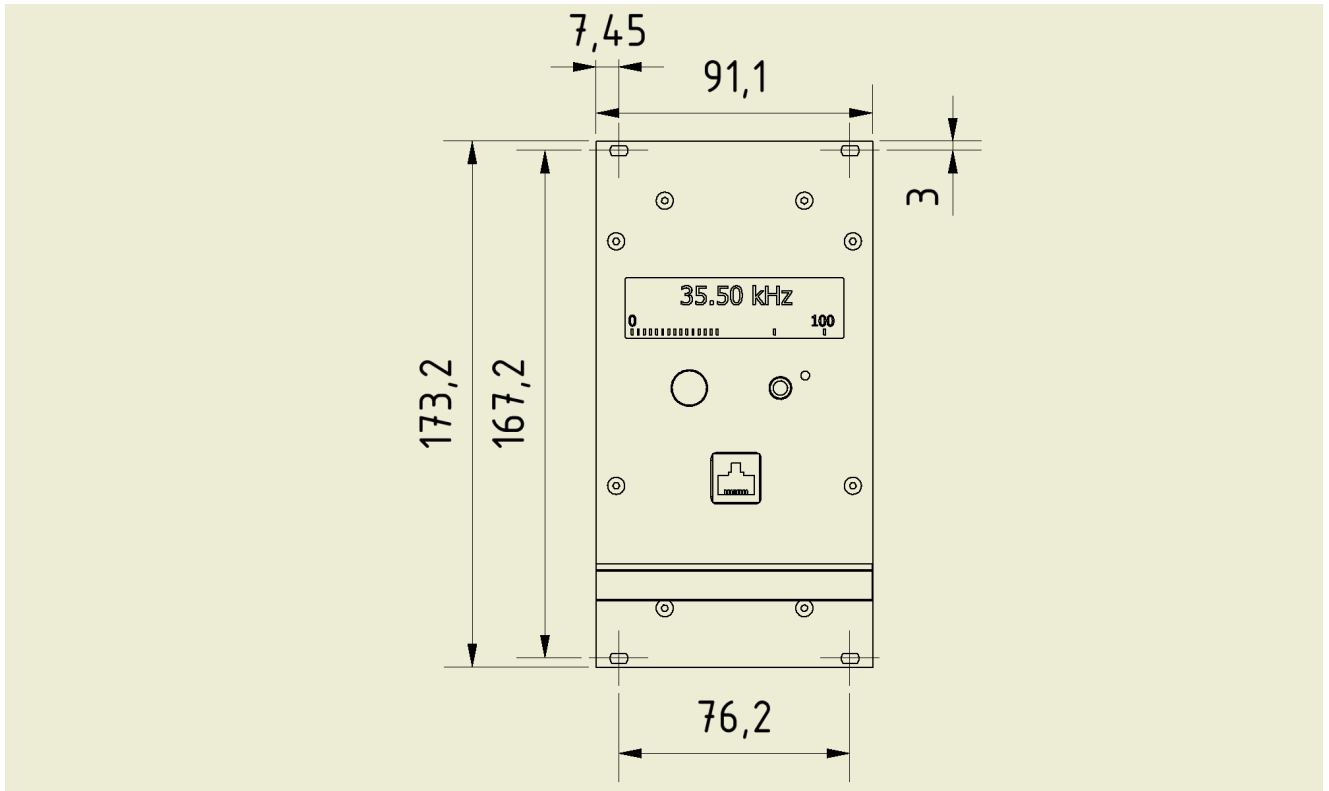


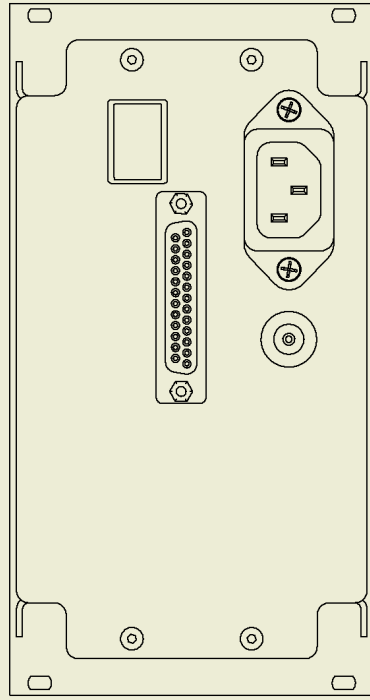
In the following cases you should disconnect the device from the mains and contact a qualified service engineer:

- If the mains cable or plug is damaged
- If liquid has penetrated into the device
- If the device has fallen over or the housing is damaged
- If the device displays noticeably different behaviour than standard operation

**ATTENTION:** Repairs and modifications may only be carried out by competent, skilled personnel

**GENERAL VIEW AND DIMENSIONS /mm/**





## **INSTALLATION & ENVIRONMENT**

Choose a suitable location that will protect the device from moisture, water, excessive sunlight and heat. The selected location for the device should be in an area where ambient temperatures do not exceed 40°C.

If the generator cannot dissipate the heat sufficiently, it will display an error message due to excess temperature (see also the "OVER TEMPERATURE" error description).



**ATTENTION:** • Choose a location that will prevent steam or any other aggressive vapours from penetrating the device. Ambient temperatures of over 30°C should be avoided.

• Over a period of time, chemically contaminated ambient air can lead to the device being irreparably damaged.

### **Power supply**

The ultrasonic generator draws its power (210-250VAC/50-80Hz) via the connection cable with **Power socket**.



It has an internal main fuse (10 AF).

If you need to change the fuses, unscrew the cover of the housing.

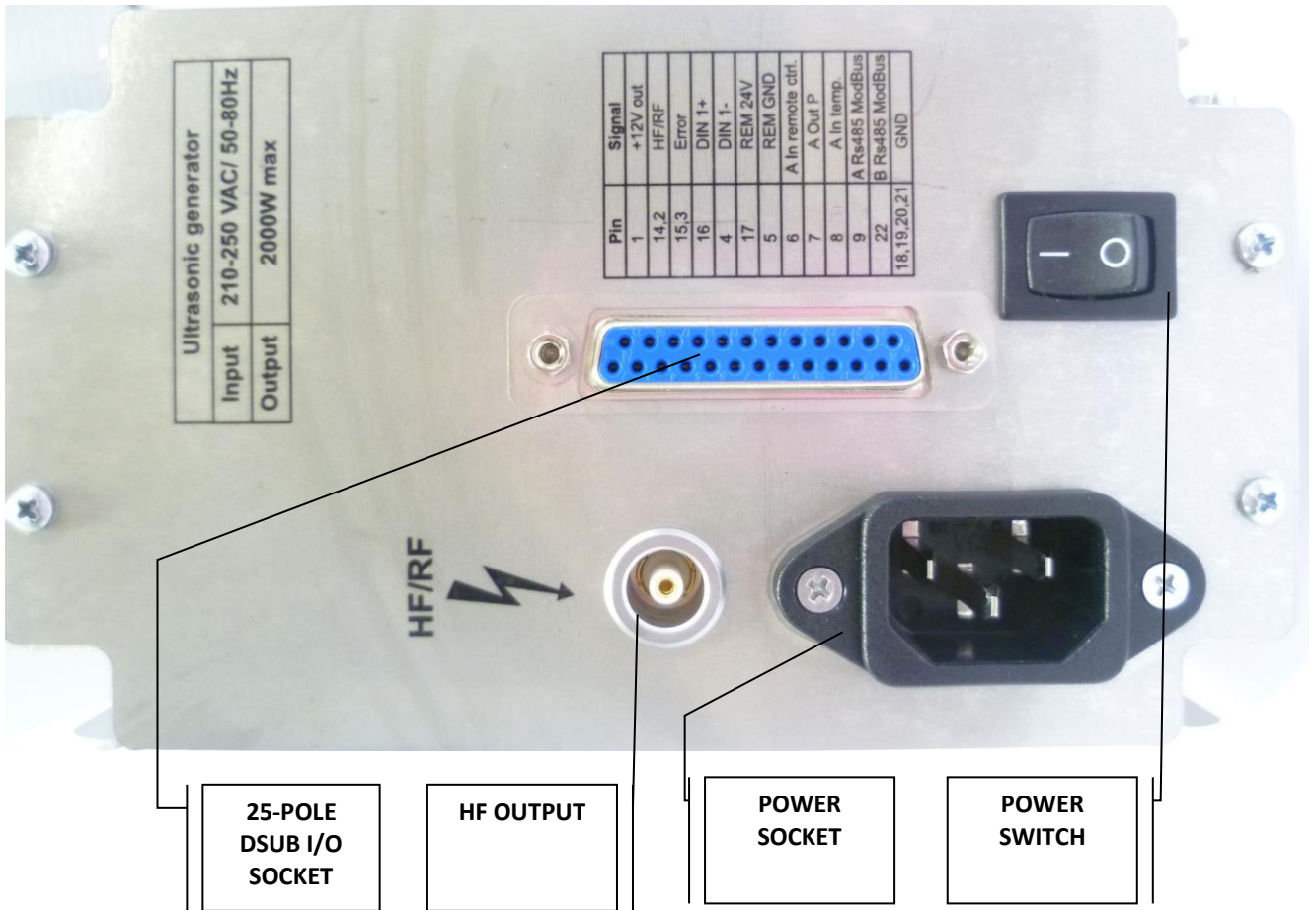


**ATTENTION:**

- For safety reasons, always disconnect the unit from the mains before changing fuses.
- Plug racks into earthed sockets only.
- Always replace blown fuses with new fuses of the same type.
- This should only be performed by qualified, skilled personnel.



**Connections on the back of the generator**

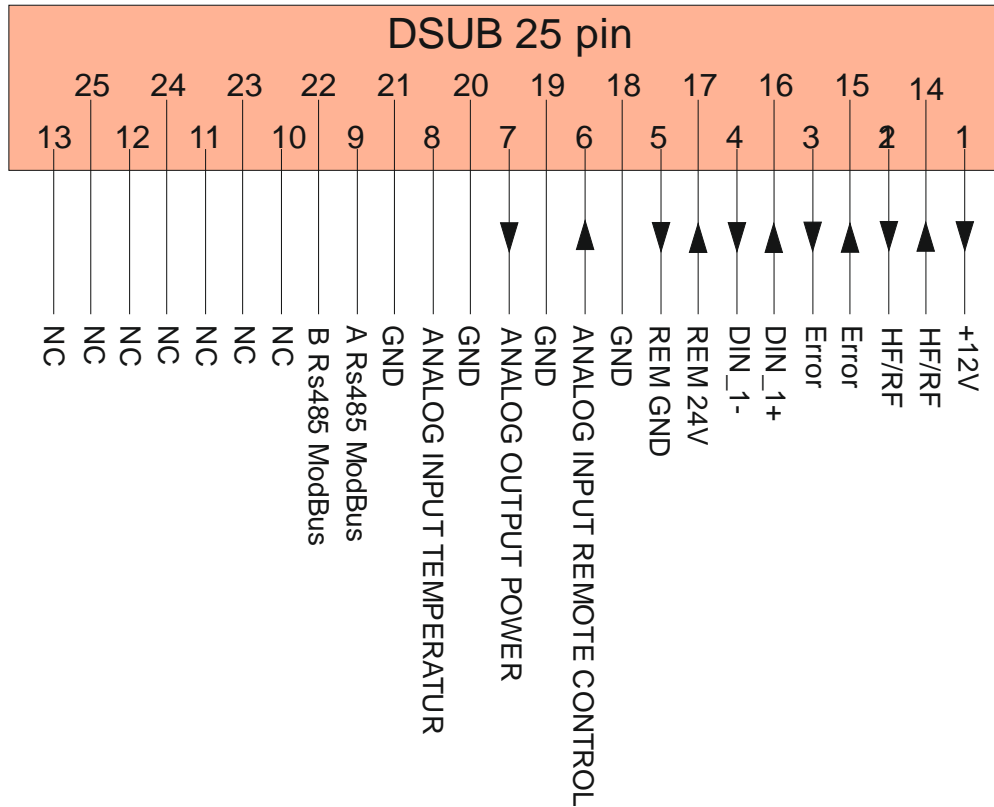
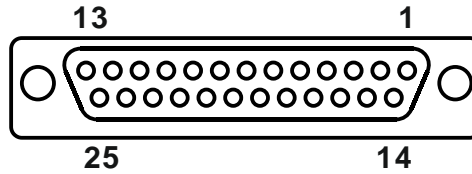


**ATTENTION:**

- Output voltage could be between 600V and 1200V AC.
- Only use cables specified by the manufacturer.
- Use only shielded transducer connection cables.
- Only use cables with sufficient cross-section.
- Minimum cross-section: 1.5 mm<sup>2</sup>.

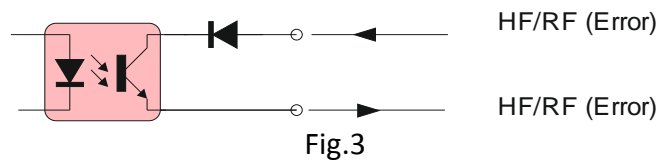
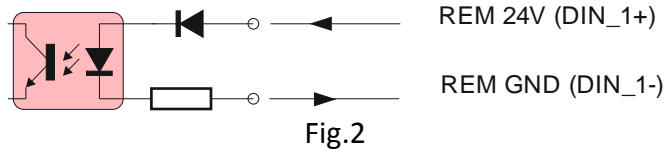
## 25-pin DSUB I/O socket

### Assignment of the 25-pin DSUB interface socket



CONTROL I/O				
Pin Number	Signal	Direction	Signal level	Description
1	+12V	Output	+12Vdc	Supply voltage for external use 100mA max
14,2	HF/RF	I/O	Up to 24Vdc	Input and output Relay HF-DA. Contact is closed depending of selected mode. See chapter HF_DA Relay mode.
15,3	Error	I/O	Up to 24Vdc	Input and output Relay Error. Contact is closed up on error. (seeFig.3)
16	DIN_1+	Input	Up to 24Vdc	Digital input for external STOP (seeFig.2)
4	DIN_1-	Output	Up to 24Vdc	Digital input for external STOP (seeFig.2)
17	REM 24V	Input	Up to 24Vdc	Remote input (active high). Reference is "REM GND" (see Fig.2)
5	REM GND	Output	Up to 24Vdc	Remote input "REM GND" (see Fig.2)
6	Analog input remote control	Input	0-10V	Input for amplitude control. 2.5V=50% Output power. 5V=100% Output power. Reference is GND.
7	Analog	Output	0-10V	Voltage corresponding to the current output

	output power			power 0- 100%. Reference is GND.
8	Analog input temperature	Input		Voltage corresponding to the transducer temperature. Reference is GND. 0V=0°C; 10V=100°C
9	A RS485 ModBus	I/O		A signal RS485 ModBus Protocol
22	B RS485 ModBus	I/O		B signal RS485 ModBus Protocol
18,19,20,21	GND	Output		Internal GND



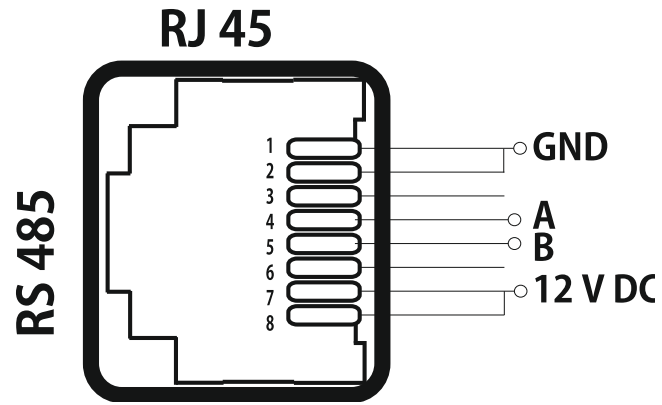
**ATTENTION:** A shielded control cable must always be used for the interface.

## OPERATION

### Interface socket RS485 ModBus

#### RJ 45 CONNECTOR:





PINS	DESCRIPTION
1	GND
2	GND
3	N/C
4	A
5	B
6	N/C
7	Output 12 V DC(max 100mA)
8	Output 12 V DC(max 100mA)

## Operator elements and display on the front panel



**Bicolour LED:** Lights up **green** when generator is switched on and works properly  
Lights up **red** in the event of an error

**ON/OFF button:** The functionality of the button could be selected from System window (6) or in LabView software PROPERTIES tab.

### **Rotary Encoder & Push Button**

Multifunction button:

1. By pressing the encoder you can move the cursor and select parameters on the current window;
2. By rotating you can change the value of the current parameter.
3. By press+hold for 2 seconds you will WRITE TO MEMORY all present settings of the generator.
4. Fast double pressing returns to the main starting window.

## The LCD display

0. Main starting window :

After the generator is powered on, the initial screen contains the following status information.



Dynamic bar

**Freq** – Actual frequency of the generator.

**P = Power** – Actual consumed power (in Watts)

**T = Last operational time** –(in s)

**E = Last operational energy**(in Joules).

Dynamic bar shows the Output Power Value.

1. Power window



**Power** – setting for maximal power (in W)

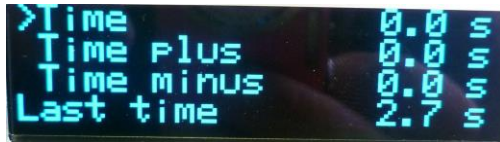
**Amplitude** – setting for maximal amplitude (in % where 100% = 1000V)

**Frequency** – setting for starting frequency (in kHz)

**P** – Actual Output Power Value (in Watts)

I – Actual Output current through the transducer (in mA)

## 2. Time window



```
>Time 2.000 s
Time Plus 2.000 s
Time minus 2.000 s
Last time 2.700 s
```

**These are welding regime settings. Welding by time:**

**Time** – time when the generator is on (in seconds)

**Time plus** – shows the maximum duration of the control signal (in seconds)

**Time minus** – minimum duration of the control signal (in seconds)

*Note: If entered a control signal from external control unit (PLC) out of limits **Time Plus** and **Time minus**, the bicolour LED will light in red and an error message **Limit Time** will be displayed.*

**Last time** - duration of the last working cycle (in seconds)

## 3. Energy window



```
>Energy 0 Ws
Energy Plus 0 Ws
Energy minus 0 Ws
Last Energy 245 Ws
```

**These are welding regime settings. Welding by energy:**

**Energy** – setting of nominal energy during the welding process (in Ws). If the setting is different from 0 and the generator reaches the set value the Welding Time(see page 23-24) automatically stops.

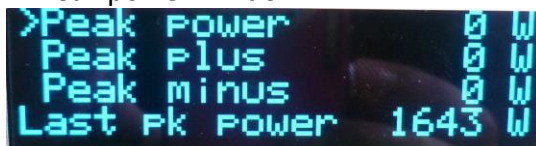
**Energy plus** – maximum allowed energy reached during the welding process.(in Ws)

**Energy minus** – minimum allowed energy reached during the welding process (in Ws)

*Note: If the energy during the welding process is out of limits **Energy Plus** and **Energy Minus**, the bicolour LED will light in red and an error message **Limit Energy** will be displayed.*

**Last Energy** – energy of the last working cycle (in Ws)

## 4. Peak power window



```
>Peak Power 0 W
Peak Plus 0 W
Peak minus 0 W
Last pk Power 1643 W
```

**These are welding regime settings. Welding by peak power:**

**Peak Power** – setting of the peak power (in W). If the setting is different from 0 and the generator reaches the set value of the peak power, the Welding Time(see page 23-24) automatically stops.

**Peak plus** – maximum allowed peak power reached during the welding process (in W)

**Peak minus**– minimum allowed peak power reached during the welding process (in W)

*Note: If the Peak Power during the welding process is out of limits **Peak Plus** and **Peak minus**, the bicolour LED will light in red and an error message **Limit Peak Power** will be displayed.*

**Last pk Power** – peak power of the last working process (in W)

## 5. Delay, Hold and Afterbirst window

```

>Delay          00.00 s
Hold           00.00 s
Afterburst     20.00 s
Last time     2.70 s

```

**Delay** – after the start signal, the generator delays starting with the set value of the delay (in seconds) (see page 23-24)

**Hold** – the generator delays with the set hold value before executing Afterburst (in seconds) (see page 23-24)

**Afterburst** – setting the value of afterburst (in seconds)

**Last time** - time for the last working process (in seconds)

#### 6. System window

```

>Modbus Address 6
Speed          115200 b
Button         Trisser
Ext temp       24.0 °C

```

**Modbus Address** – shows the address of the generator in the Modbus network. The default Modbus Address is 6.

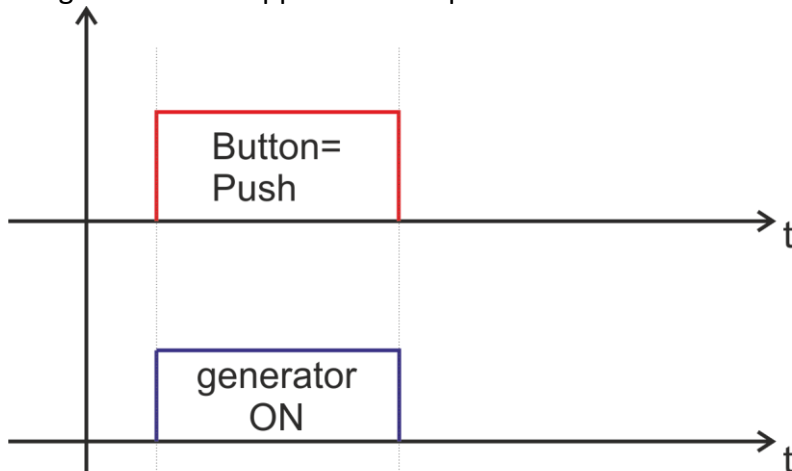
**Speed** – communication speed

**Button** – setting the functionality of the button

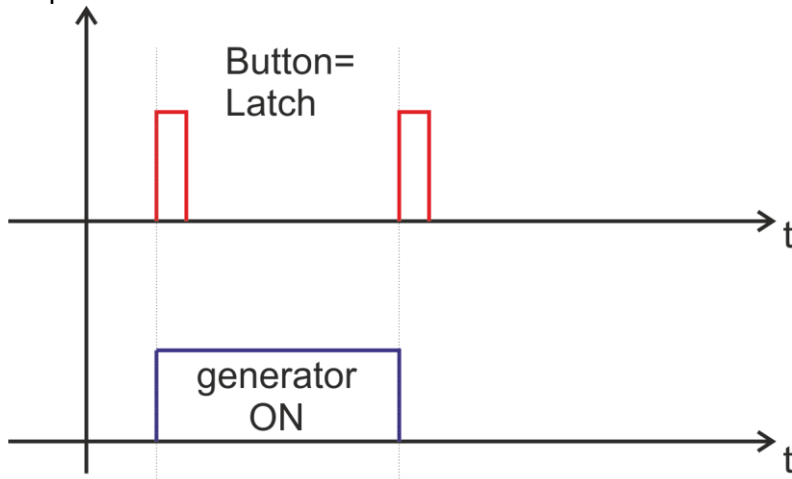
There are 4 options:

**OFF** – the button is off.

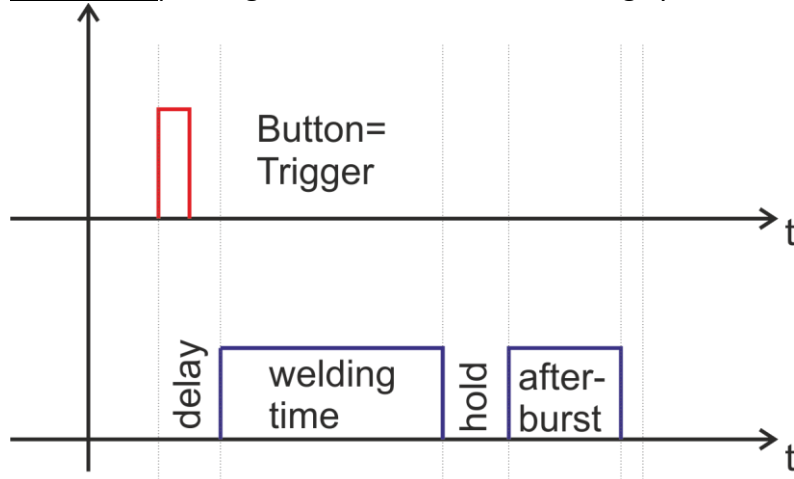
**PUSH** – the button works as a test button – while pushed the generator is on, while released the generator is stopped. See the picture below:



**LATCH**- pushing the button once the generator starts, pushing the button again the generator stops.



**TRIGGER** – pushing the button once the welding cycle starts.

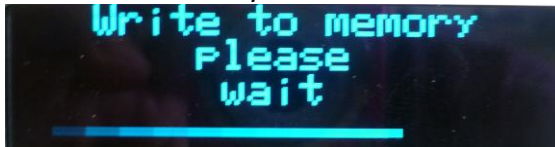


**Ext temp** – the value of the external temperature, in °C, depending of the signal on pin 8, where 0 to 10Volts= 0 to 100 °C.

The generator could generate error signal, when the temperature is over the set limit.

The limit for the **Ext temp** is set in Labview software in PROPERTIES Tab

7. Write to memory window

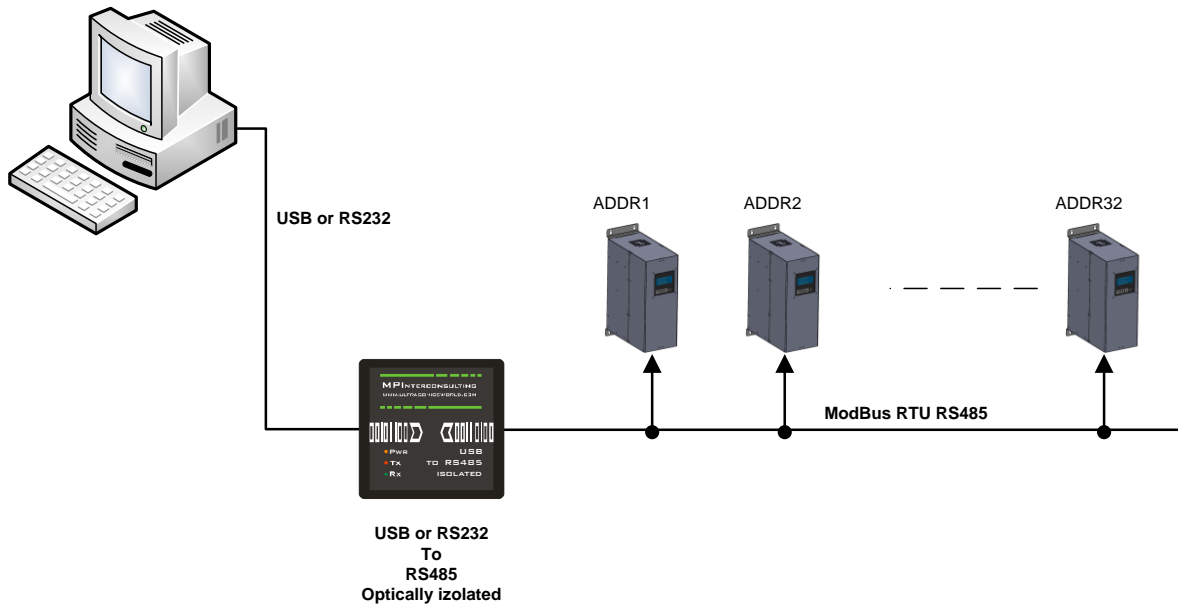


This window appears when you PRESS AND HOLD the Rotary Encoder for 2 sec.



## SETTING THE SOFTWARE

The generator has a standard communication interface ModBus RTU over RS 485. To connect to a PC you should use MPI adapter USB or RS 232 to RS 485 optically isolated.



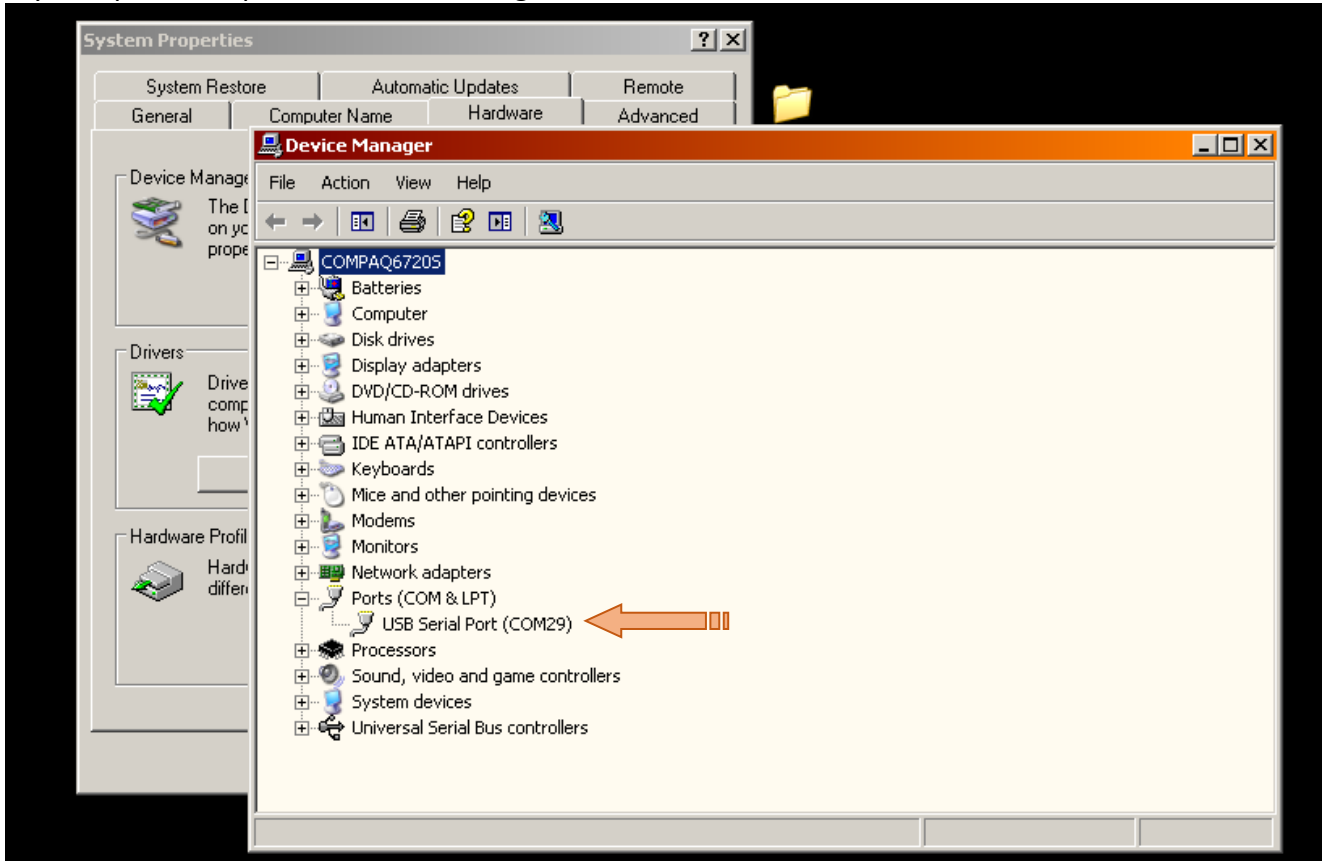
1. Download and install the latest version “runtime” for Windows, from the website of National instruments [www.ni.com](http://www.ni.com)
2. Download and install latest version ni-visa drivers (com port drivers) from the website of National instruments [www.ni.com](http://www.ni.com)
3. Download and install from mpi website LabView software for ultrasonic welding generator
4. Download and install the latest version FTDI vcp driver from [www.ftdichip.com](http://www.ftdichip.com)

1. Connect the generator to Labview software.
2. Go to COMM tab.



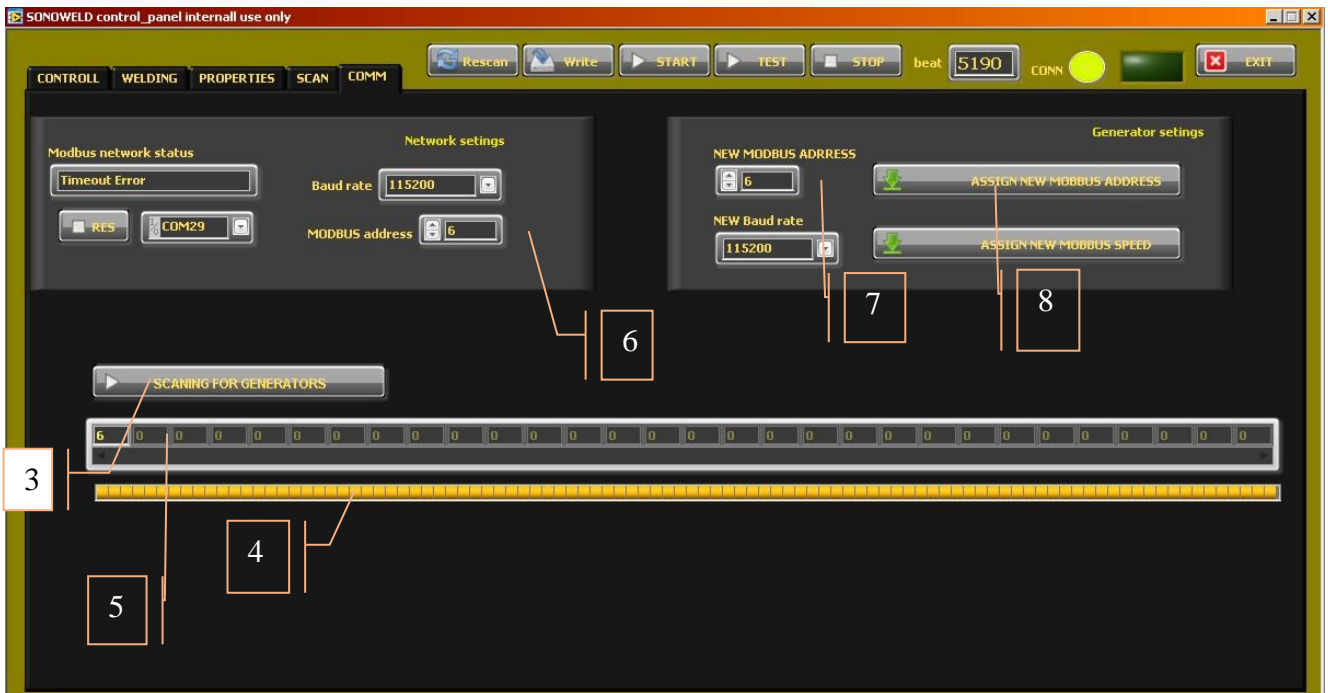
3. Select the exact COM port(1) to which the adapter is connected from the drop down menu.

If you are not sure what to select, check in:  
 My Computer/Properties/Device Manager/Ports



At this moment you will have NO connection (initialized in red on top of the window)(2). After validating the com port you will have connection (initialized in lime green on top of the window)(2).

4. Select the ModBus address of the generator you want to connect to. Every new generator has default ModBus address 6.



Press "SCANNING FOR GENERATORS" (3). After scanning (the yellow bar (4) will become full in a few seconds), you will find the address (es) of the available generator(s) you will drive (5). Check if the value of the address in "MODBUS address" field (6) is correct and if needed change it with the value shown in the table below the button "SCANNING FOR GENERATORS" (5). Beat counter will become

alive and will start changing the figures. Connection (lime-green)(2) light should be active. Now you are connected to the generator with the selected address.

**NOTE: Every new generator has 6 ModBus address by default.**

That's why you have the possibility in the upper right side of the window to change the Modbus address selecting a new value in the field "NEW MODBUS ADDRESS"(7) and then press the button ASSIGN NEW MODBUS ADDRESS(8).

**DO NOT FORGET TO CHANGE THE MODBUS ADDRESS IN FIELD(6) WITH THE NEW ASSIGNED MODBUS ADDRESS.**

**Save this setting in generator's EEPROM Memory by pressing button WRITE (top centre of the window).**

5. Select "Baud Rate". The default value is 115 200 bauds/sec.

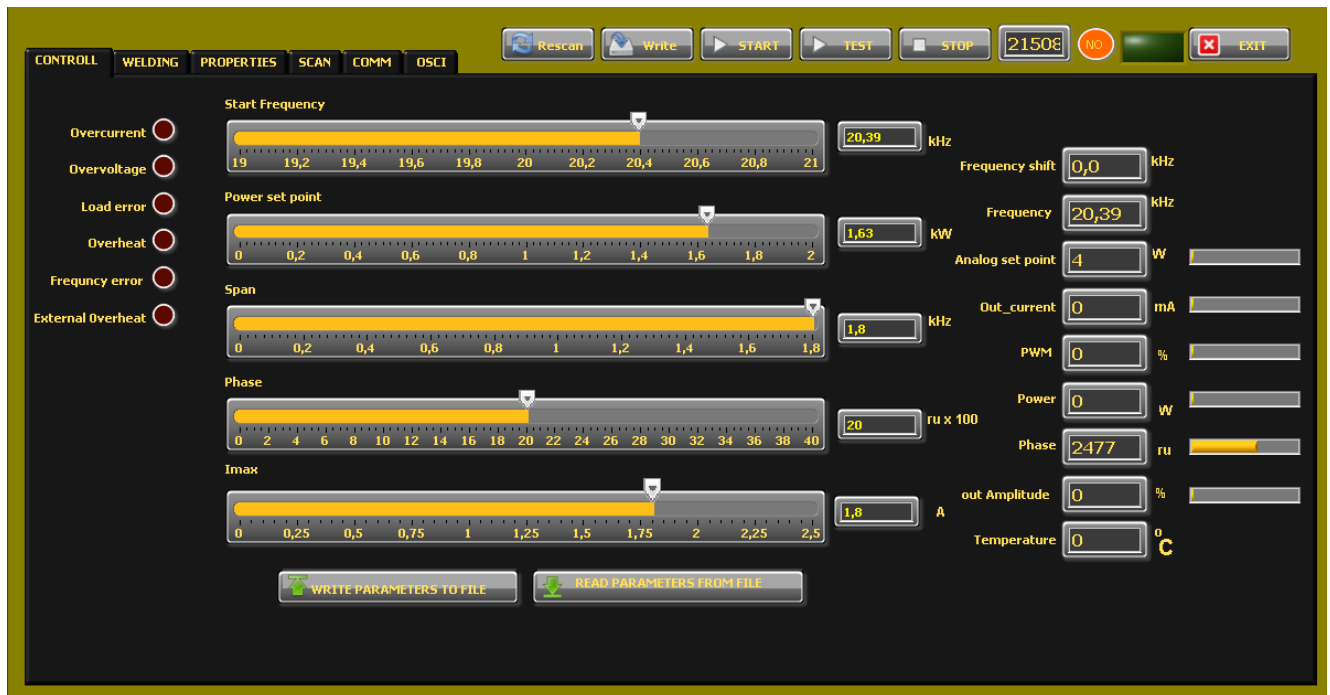
At this stage you could replace the ModBus address and the Baud Rate of the generator. This could be necessary in case you have more than one generator to adjust in the same network. The Baud Rate should be matched to the topology of your network.

The replacement is performed by pressing the button "Assign New ModBus Address" and / or button "Assign New Baud Rate".

**The change is saved after pressing the button "WRITE" (top centre of the window).**

6. If the generator is connected to the software, the indicator light CONNECTION (2) glows green (YES).

### Go to the first tab "CONTROL"



7. Go to CONTROLL Tab. The very first step is to press the button RESCAN to have all parameters and settings from the generator uploaded in Labview software.

8. In the slider Start Frequency set minimum frequency and check what is the frequency in the Frequency box(on the right side of the tab - the third box from top)

9. In the slider Start Frequency set maximum frequency and check what is the frequency in the Frequency box(on the right side of the tab - the third box from top)

10. Now you know the working limits of the generator.

In the working range of the generator should be selected safe limits for working with the transducer.

11. If the transducer is 20 kHz choose for Fstart set a little bit higher of 20 -for example 20,5. **Save this setting by pressing button WRITE (top centre of the window).**

12. In “SPAN slider” set initially safety operation window 2 kHz, it means Span=2 kHz.

#### **Buttons:**

**RESCAN** – By pushing RESCAN all parameters saved in the generator’s memory will upload into Labview software.

**WRITE** - By pushing WRITE all parameters set in Labview software will download into the generator’s memory.

**START** - By pushing START the generator starts the welding cycle (see page 23).

**STOP** - By pushing STOP the generator stops working.

**TEST** - Button “TEST” will start the generator even the Time is selected 1sec. and will stop only when button “STOP” is pressed.

**WRITE PARAMETERS TO FILE** - WRITES all parameters set in Labview software into a text format(.txt) file on the hard disk of the computer.

**READ PARAMETERS FROM FILE** - READS all parameters from text format(.txt) file on the hard disk of the computer and downloads the data into the generator.

#### **Sliders:**

**Start Frequency** – sets the start frequency of the generator.

**Power Set Point** – sets the output power of the generator.

**Span** – sets the working window, where the generator seeks the working frequency of the transducer, because the working frequency could change because of loading the transducer and/or the temperature of the transducer.

**Phase** – The optimal phase is 2000. (in relative units x 100)

**I max** - This is the maximum allowed current over the transducer. You need to check the label on your transducer and set the value.

#### **Actual Values:**

**Scan Shift** – for service use only (in relative units)

**Frequency Shift** – shows (in kHz) how many the starting frequency is changed by the frequency regulator of the generator.

**Frequency** – shows (in kHz) the actual working frequency of the transducer.

**Analog Set Point** – shows(in Watts) the actual value of the analog power set point(0-10V) over the 25-pin connector(see page 10, pin3).

**Out current** – shows (in mA) the output RMS current through the transducer.

**PWM** – shows (in %) PWM ratio over the gates of the power transistors.

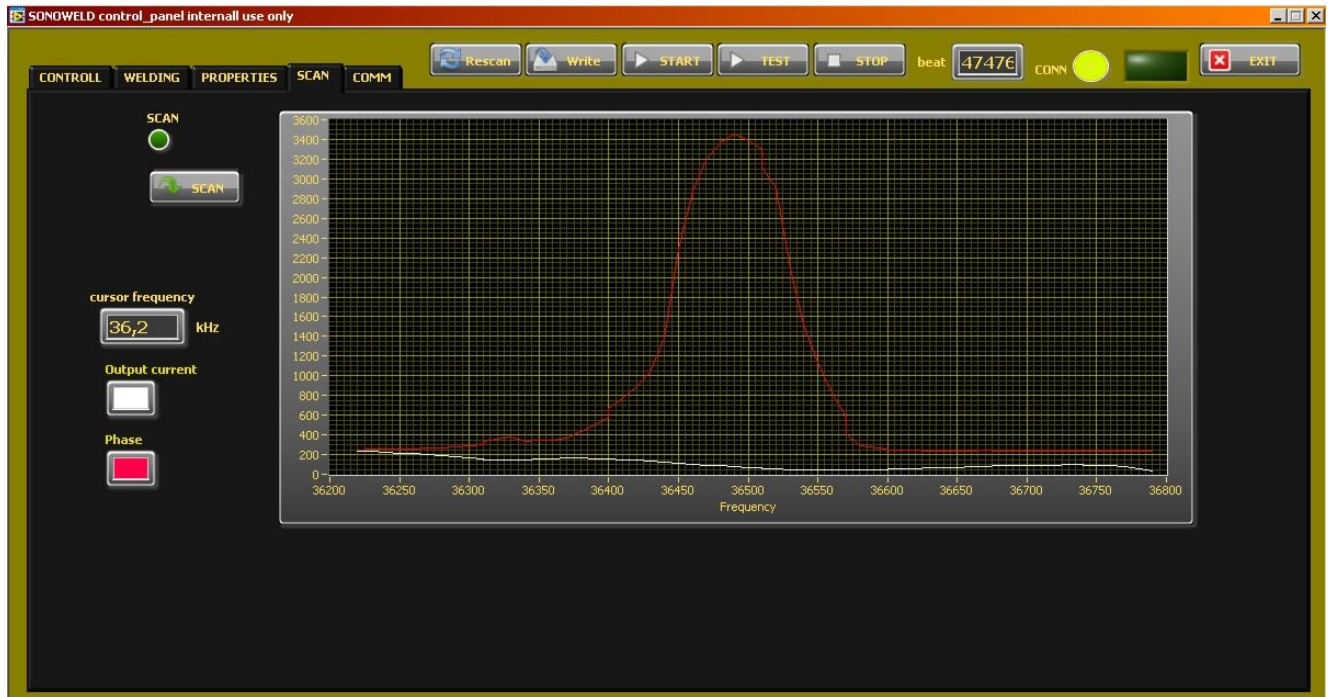
**Power** – shows (in W) the actual output power.

**Phase**– shows (in ru=relative units) actual working phase.

**Amplitude** – The actual voltage over the transducer (in Volts)

**Temperature** – Voltage over pin 8 of the Interface connector, corresponding to the transducer temperature. Reference is GND. 0V=0°C; 10V=100°C (in °C)

Go to "SCAN" tab and activate SCAN.



13. Press the SCAN button. The scanning procedure starts. There is a drawing consisting of phase characteristic (red line) and current characteristics (white line). It should be similar to the picture with well-defined phase feature. This diagram shows the actual operating parameters of the transducer. If necessary, pick new Fstart and SPAN (in CONTROL tab).

You will see an active operating area of transducers, like on the picture above. It starts a scanning procedure on low power that indicates the Phase characteristic (red line) and consumed output current (white line). **For F-start you need to select, by dragging the yellow cursor, the value closed to the working frequency of your transducer, which is where the red line just starts to grow+500 Hz.** On the left side of the SCAN window, you will see the value of "cursor frequency", also shown in a small box "cursor frequency from scan tab" in the right down corner of the CONTROL tab. **Click the WRITE button on top of the window to write in generator's memory all present settings.**

14. In "POWER Set Point " in CONTROL tab, set the desired value for maximum power, of your generator.

15. Go to PROPERTIES tab.



16. Now, your generator and transducer are ready to operate.

17. Start the generator, by pressing button “TEST” .The generator will keep on working until pressing button “STOP”.

18. Start the Welding cycle, by pressing button “START”.

#### Sliders:

**Regulator voltage** – This is the  $K_i$  of the output voltage regulator(amplitude)

**Regulator current** - This is the  $K_i$  of the output current regulator(amplitude), in case it is selected CURRENT Mode in Regulator Mode Selection Menu.(Phase Mode is the default mode).

**Amplitude** – The voltage over the transducer (in %)

**Nominal power** - The nominal power of the generator(in Watts).

**Umax** – the maximum output voltage(in Volts).

**TEMPERATURE TRESHHOLD-External Temperature Limit** – setting of the External Temperature Limit (in °C)

## 19. OSCI tab.



There is an added function for **recording data** – frequency, output current, phase, amplitude and power. Select the duration of the record in the field “**time to write**” – in seconds. The recording starts by START of the generator and ends when the selected time to write is finished (STATUS bar shows when the record is completed). After recording is finished, when the button read is pressed, the data from generator is uploaded in the Labview software and is visualized graphically.

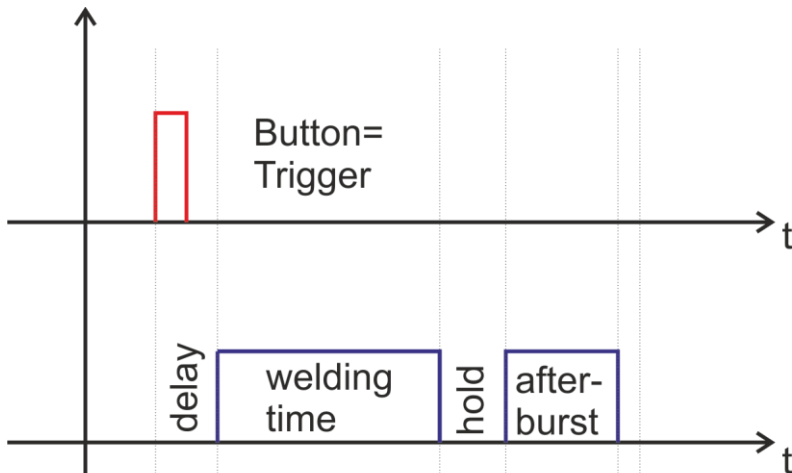
# SETTING THE WELDING CYCLE PROPERTIES

## 1.Go to WELDING Tab.



The generator allows **carrying** out the welding cycle by three criteria:

**By TIME - reaching** the preset time, the generator stops



When an external start signal (from PLC for examp.) enters on pin 5, pin 17 on the 25-pin DSUB interface socket, the generator starts the programmed welding cycle (as shown on the graphic above).

Welding cycle includes:

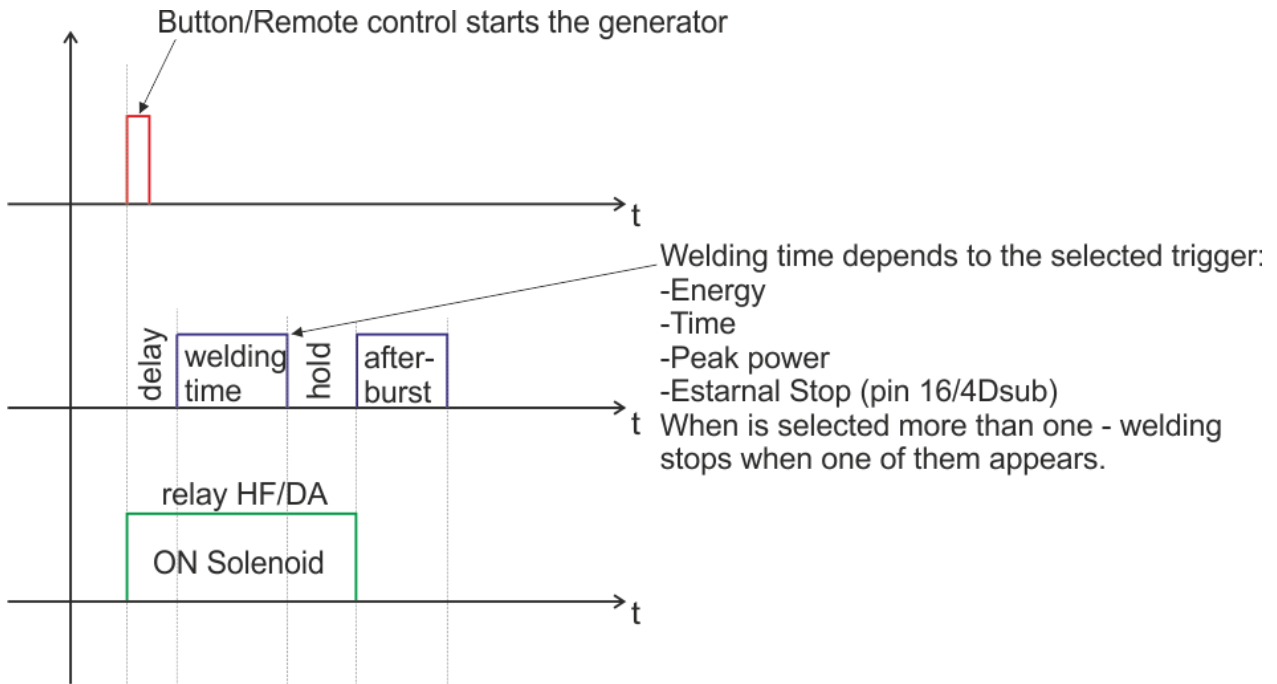
**Delay** – delay after the start signal to turn the generator ON.

**Welding time** – the generator is ON.

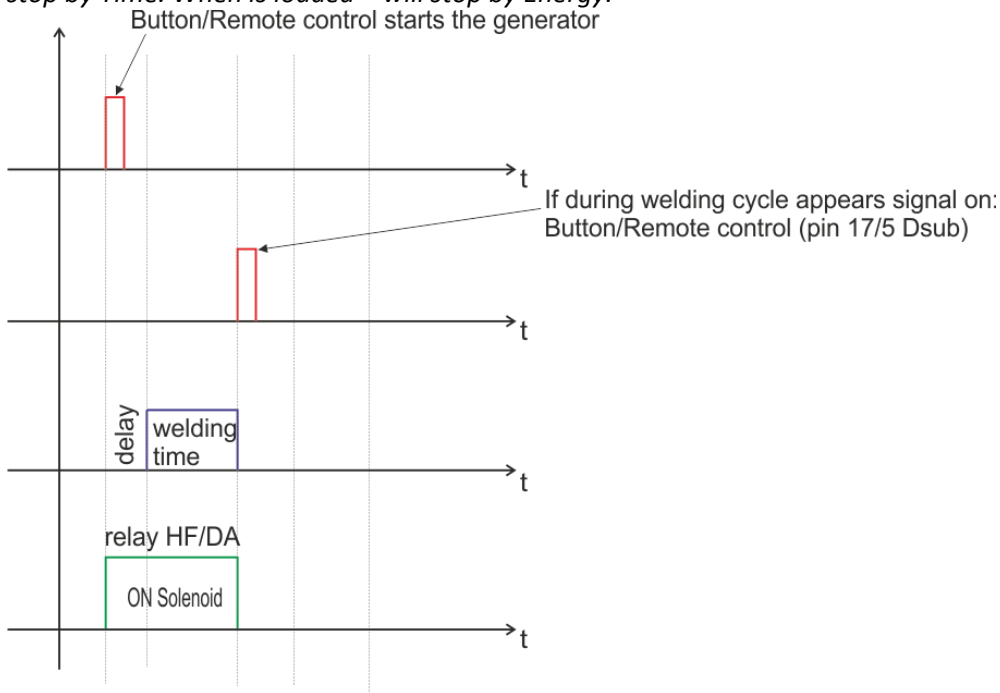
**Hold** – the generator is OFF for the preset hold time.

**Afterburst** - the generator is ON for the preset afterburst time.





When an external start signal(from PLC for example) enters on pin 5, pin 17 on the 25-pin DSUB interface socket, the generator starts the programmed welding cycle (as shown on the graphic above). *i.e. When is selected high value for Energy and certain seconds for Time , but generator operates on air – generator will stop by Time. When is loaded – will stop by Energy.*



When second signal on enters on pin 5/17Dsub - the generator stops , but when an external stop signal(from PLC and sensor for example) enters on pin 4 and pin 16 on the 25-pin DSUB interface socket, the generator stops **only** the programmed Welding Time and keep on to execute hold and afterburst .

**By ENERGY - reaching** the preset **energy**, the generator stops **only** the programmed Welding Time (as shown on the graphic above) and keep on to execute hold and afterburst .

**By PEAK POWER - reaching** the preset **peak power**, the generator stops **only** the programmed Welding Time (as shown on the graphic above) and keep on to execute hold and afterburst .

There is an option to set limits for TIME, ENERGY and PEAK POWER or any combination of these 3 criteria. If there are preset limits for TIME, ENERGY and PEAK POWER together or combination of them, different from zero, the generator will stop after reaching any of the given parameters. If there are preset limits for TIME, ENERGY and PEAK POWER together or combination of them, equal to zero, the generator will work continuously.

### Sliders:

(correspond to the parameters on the display of the generator(see pages 13-16)) :

#### Welding by time:

**Time** – time when the generator is on (in seconds)

**Time plus** – shows the additional safety time. This maximum duration of the control signal (in seconds)

**Time minus** – minimum duration of the control signal (in seconds)

*Note: If entered a control signal from external control unit (PLC) out of limits **Time Plus** and **Time minus**, the bicolour LED will light in red and an error message **Limit Time** will be displayed.*

**Last time** - duration of the last working cycle (in seconds)

#### Welding by energy:

**Energy** – setting of nominal energy during the welding process (in Ws). If the setting is different from 0 and the generator reaches the set value the generator automatically stops.

**Energy plus** – maximum allowed energy reached during the welding process.(in Ws)

**Energy minus** – minimum allowed energy reached during the welding process (in Ws)

*Note: If the energy during the welding process is out of limits **Energy Plus** and **Energy Minus**, the bicolour LED will light in red and an error message **Limit Energy** will be displayed.*

**Last Energy** – energy of the last working cycle (in Ws)

#### Welding by peak power:

**Peak Power** – setting of the peak power (in W). If the setting is different from 0 and the generator reaches the set value of the peak power, the generator automatically stops.

**Peak plus** – maximum allowed peak power reached during the welding process (in W)

**Peak minus**– minimum allowed peak power reached during the welding process (in W)

*Note: If the Peak Power during the welding process is out of limits **Peak Plus** and **Peak minus**, the bicolour LED will light in red and an error message **Limit Peak Power** will be displayed.*

**Last pk Power** – peak power of the last working process (in W)

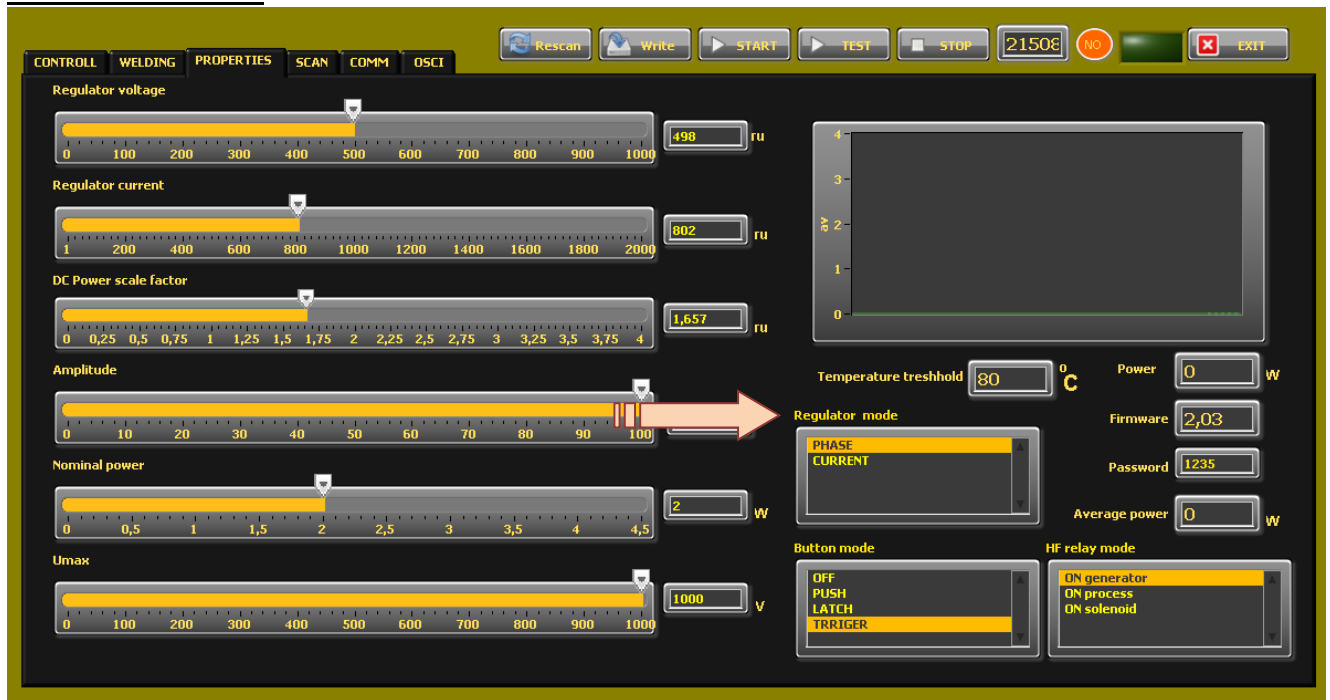
**Delay** – after the start signal, the generator delays starting with the set value of the delay (in seconds)

**Hold** – the generator delays with the set hold value before executing Afterburst (in seconds)

**Afterburst** – setting the value of afterburst (in seconds)

**Last time** - time for the last working process (in seconds)

## REGULATOR MODE



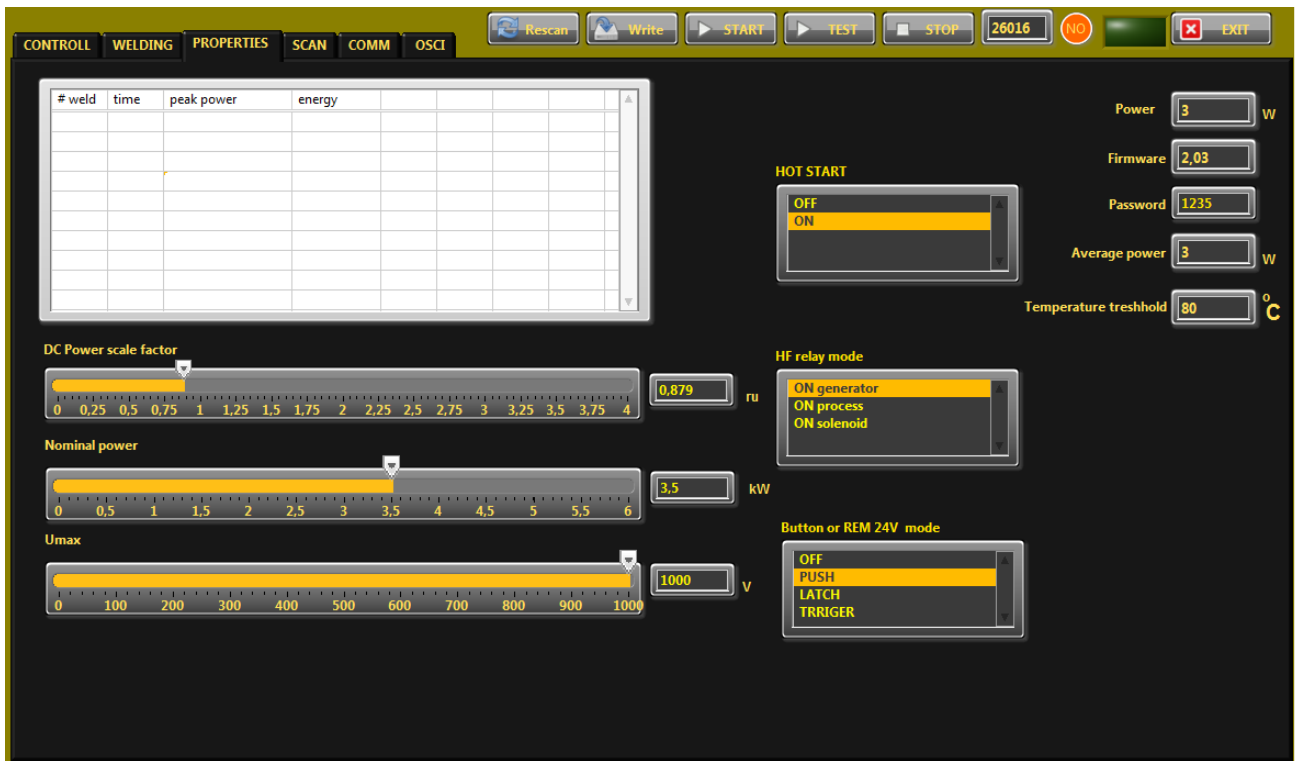
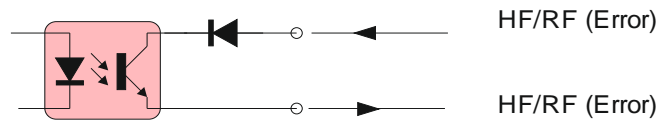
### Regulator Mode-

**PHASE** is the default Mode. The generator regulates the selected **Phase** setting from the CONTROL Tab. In this case, the **Imax** from CONTROL tab is limit of the Output Current.

**CURRENT** is the optional Mode, most frequently used for special applications, in case of overloaded transducer, when the phase characteristic of the load is low. The phase characteristic is low when, after scanning with loaded transducer, the **phase curve** is not over **2400 ru** (see **SCAN** tab). The **Current mode** of regulator, regulates the selected output current (**Imax**) from the CONTROL tab.

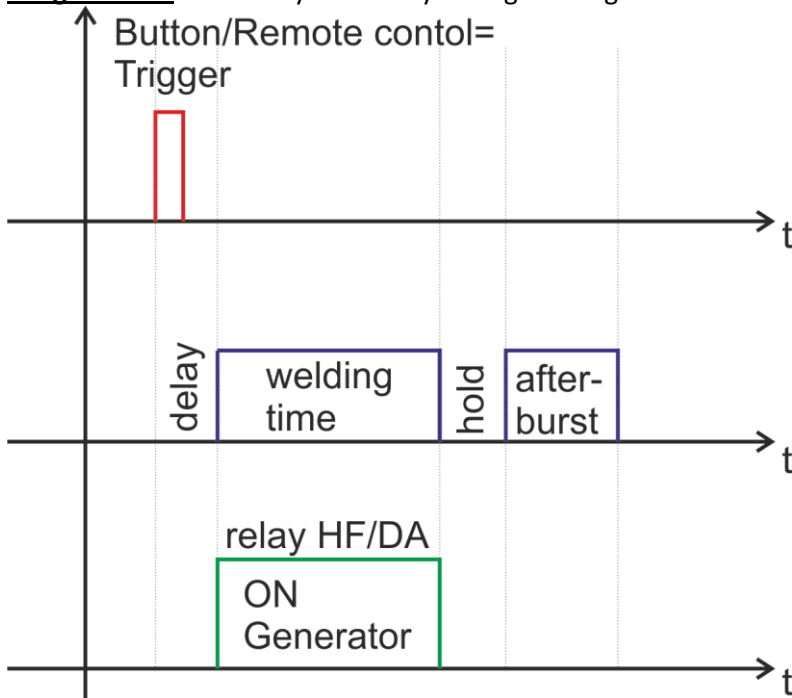
**Note:** *The maximum output current should be selected according maximum allowed value from the supplier the transducer.*

## HF-DA RELAY MODE

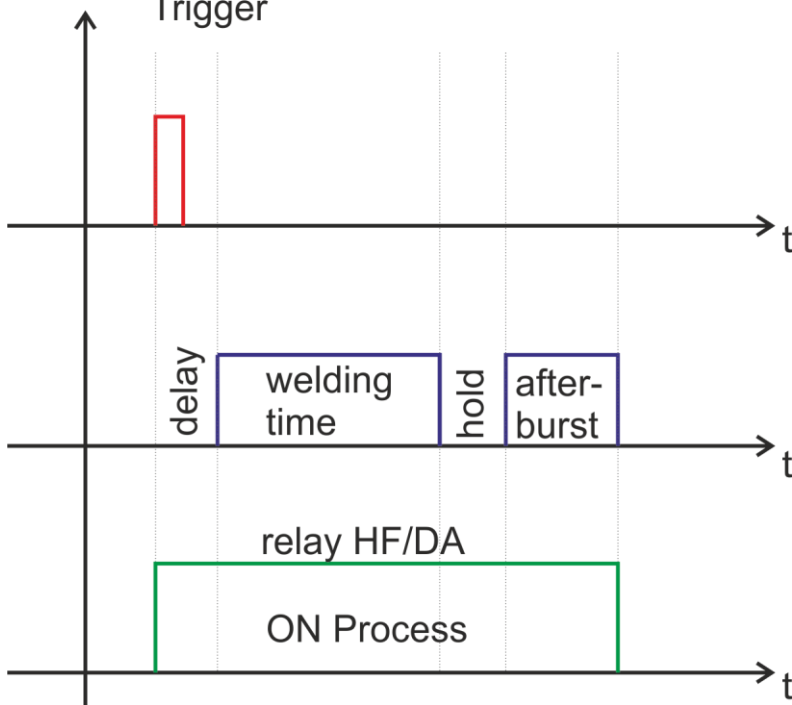


In PROPERTIES Tab you can select the HF Relay Mode(see right bottom corner) from three options:

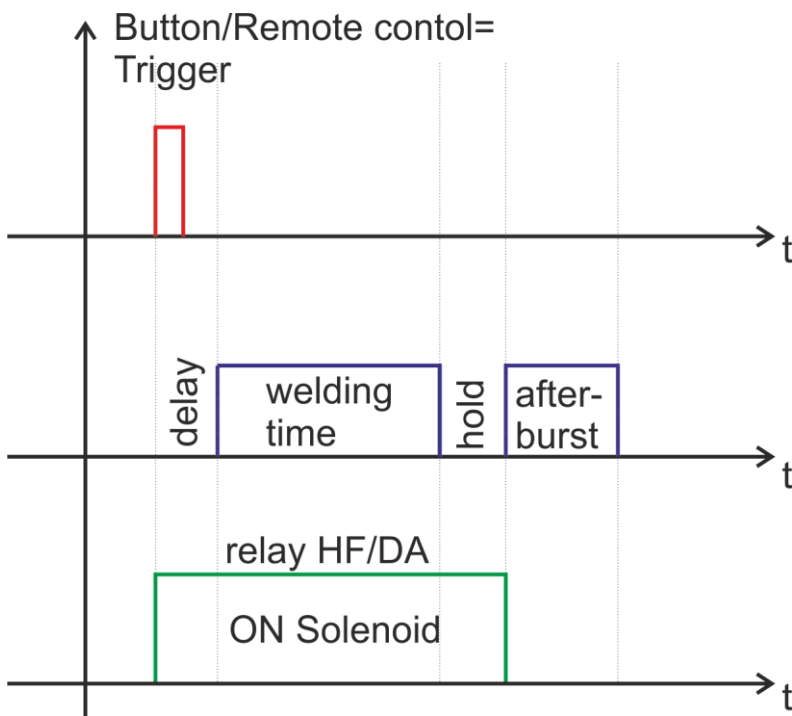
**ON generator** – the relay is ON only during welding time.

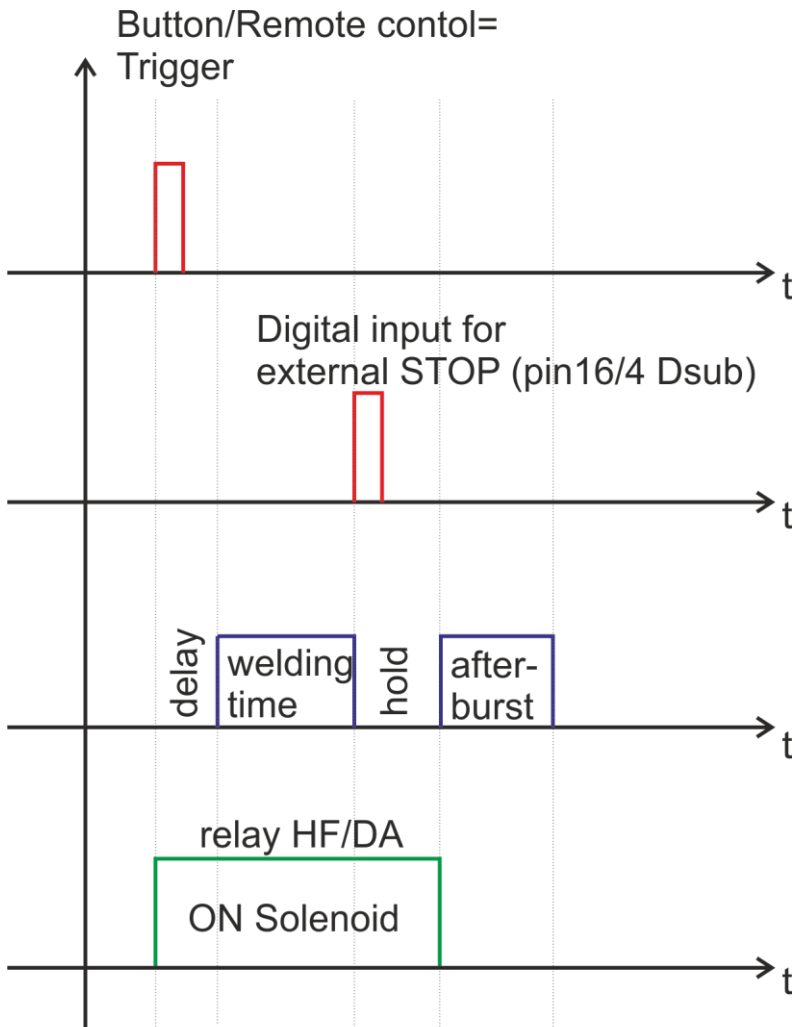


**ON process** – the relay is ON during whole process, including delay, welding time, hold and afterburst.  
 Button/Remote control= Trigger

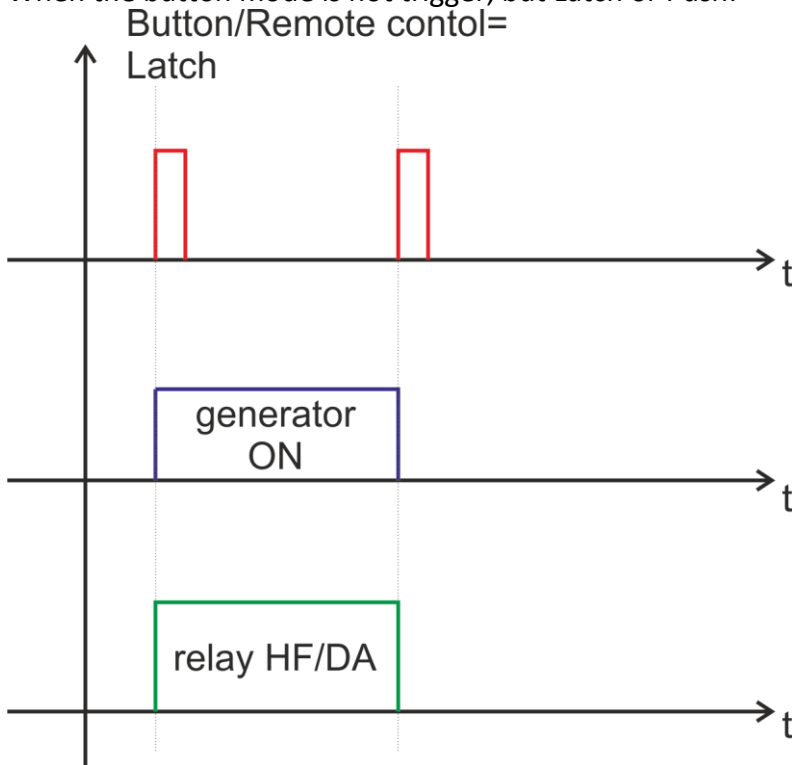


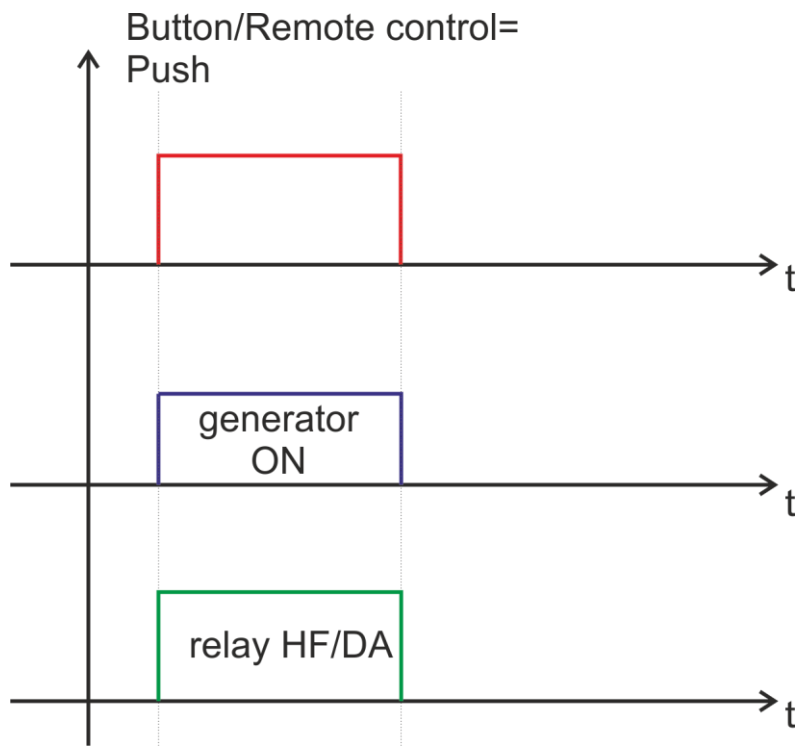
**ON solenoid** - the relay is ON during delay, welding time and hold.





When the button mode is not trigger, but Latch or Push:







## **ERROR MESSAGES AND TROUBLESHOOTING**

When error event occurs the bicolour LED will light up in red. The error message will appear over the dynamic bar graph. If you want to see it properly you need to press the rotary encoder once, to move to next window of the display (Power window), where on the last row an error message will be displayed.

**All types of error messages will be cleared after restarting the generator.**

The following error messages may appear on the display:

### **OVERCURRENT – Overlimited high current is flowed through the power transistors**

The electronic overcurrent trigger has detected an error.

#### **Possible causes:**

- Short circuit in the cable or transducer
- Starting frequency selected is too HIGH(see on page 17-22)
- Starting frequency selected may be too LOW(see on page 17-22)
- There is a problem with the transducer.

#### **Troubleshooting:**

- Switch on the generator without the transducer connected. If OVERCURRENT Message does not appear on the display, this means that the generator is in good working condition.
- Check the cable between the generator and the transducer.
- Check the transducer for short circuit.
- Change and set properly the starting frequency, if it is not in range as described in this manual(see on page 17-22).

Error message:

### **OVERHEATING**

The electronic overheating trigger has detected an error

#### **Possible causes:**

- Not enough space around the generator.
- Ambient temperature is too high.
- The fan is dirty or malfunctioning .

Error message:

### **OVERVOLTAGE -Overlimited high voltage is applied over the transducer**

#### **Possible causes:**

- The cable between the generator and transducer is broken or just disconnected.
- Starting frequency selected is too HIGH(see on page 17-22)
- Starting frequency selected may be too LOW(see on page 17-22)

**Troubleshooting:**

- Rescan and re-adjust the generator as described in this manual (see on page 17-22)

Error message:

**LOAD ERROR – the generator cannot find the resonance frequency of the transducer inside the chosen frequency window.**

**Possible causes:**

- Starting frequency selected is too HIGH(see on page 17-22)
- Starting frequency selected may be too LOW – below the resonance frequency (see on page 17-22)
- Span selected may be too LOW(see on page 17-22)
- The cable between the generator and the transducer is broken
- The transducer is defective

**Troubleshooting:**

- Rescan and re-adjust the generator as described in this manual (see on page 17-22)
- Check the cable between the generator and the transducer.
- Check the transducer for disconnection.

Error message:

**FREQUENCY ERROR**

**Possible causes:**

- Bad frequency setting
- Control board is damaged

**Troubleshooting:**

- Check the frequency settings

**LIMIT TIME ERROR**

**Possible causes:**

- Over limit for Time Plus or Time minus has been entered (see page 14 and 23)

**Troubleshooting:**

- Check the Time settings

**LIMIT ENERGY ERROR**

**Possible causes:**

- the energy during the welding process is out of limits **Energy Plus** and **Energy Minus**, (see page 14 and 23)

**Troubleshooting:**

- Check the Energy settings
- Check the Welding Process for lapses

## **LIMIT Peak Power ERROR**

### **Possible causes:**

- the Peak Power during the welding process is out of limits **Peak Plus** and **Peak minus** (see page 14 and 23)

### **Troubleshooting:**

- Check the Time settings
- Check the Welding Process for lapses

## **MAINTENANCE**

The ultrasonic generator does not need special maintenance.

Dust and dirt should be removed regularly using a damp cloth.

### **ATTENTION:**

- **Do not use aggressive cleaners!**
- **Not suitable for ultrasonic cleaning!**

## **SPECIFICATIONS:**

<b>Frequency</b>	<b>SONOWELD 2000</b> <b>35 kHz</b>	
<b>Operating voltage</b>	210-250 V , 50-80 Hz	
<b>Power consumption</b>	9 A	
<b>Maximum output</b>	2,000 W	
<b>Fuse protection</b>	10 A	
<b>Dimension casing</b>	<b>W x H x D/mm/</b> 90x180x370	<b>Weight</b> 3.3 kg
<b>Operating Temperature range</b>	-10 to +40°C	<b>Protection class</b> IP 20, IEC 60 529, EN 60 525

## **WARRANTY**

The length and coverage of the warranty can be found in the terms of delivery as part of the general terms and conditions (valid at the time of purchase) or in the sales contract / order confirmation, should any special agreements have been made.

### **The following cases are not covered by warranty:**

- Damage caused by inappropriate operation
- The device not being used for its intended purpose
- Inappropriate alterations or modifications made without prior authorization from the manufacturer
- Damage caused by extreme circumstances, such as knocks, falling over, moisture and dirt
- Insufficiently qualified operating staff
- Non-compliance with current safety and accident-prevention regulations
- Damage resulting from modifications made to the operating instructions

## **SERVICE HOTLINE**

Should you still have questions after reading through this operating manual, please feel free to call our service hotline.

Service contact details  
ADDRESS  
TEL  
FAX  
EMAIL  
SKYPE  
Etc.

**Please have the device type and serial number at hand, to help us quickly answer your questions (the serial number is on the backside of the generator)**

## **SPARE PARTS**

Parts are available upon request. Please provide us the serial number of your device, to ensure we supply you with the appropriate replacements.