

Operations Manual for ultrasonic

SONOWELD Generator

THE MPI6000 ULTRASONIC SONOWELD GENERATOR

ULTRASONIC GENERATOR – Manual

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INTRODUCTION

Dear Customer,

Thank you for your purchase of MPI 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.

For ease of reading this operating manual, the MPI6000 may also be referred to by the terms 'unit' or 'device' interchangeably

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.

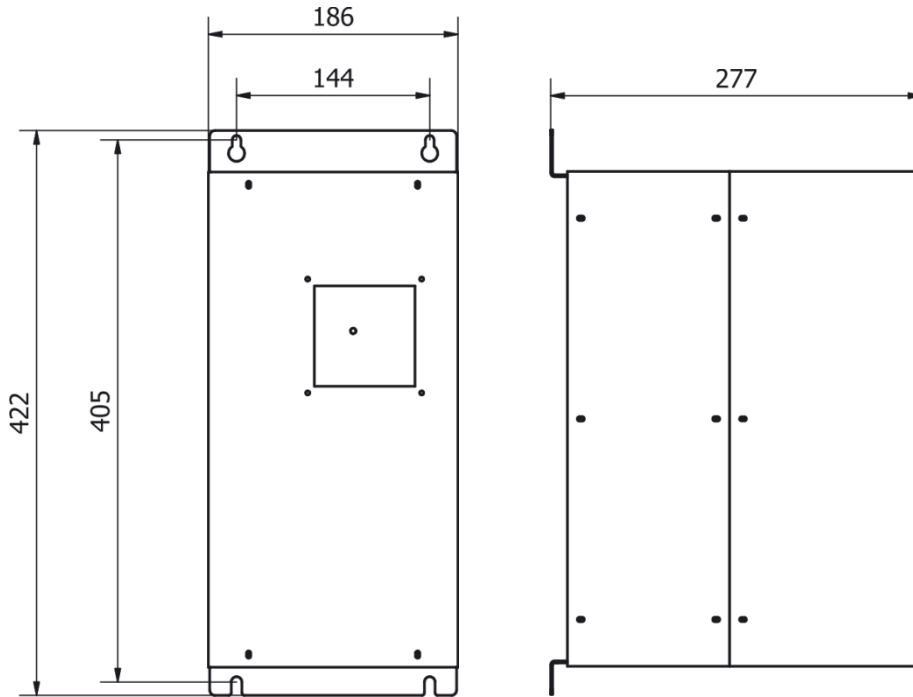


In the following cases you should disconnect the device from the mains and contact a qualified service engineer:

- **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 (3N400VAC/50-60Hz) via the connection cable with **Power socket**.



It has an internal 3-phase automatic circuit breaker 3N 16A.



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

HF OUTPUT: HF Output connector is a Lemo : ERA.1S.250.CTL

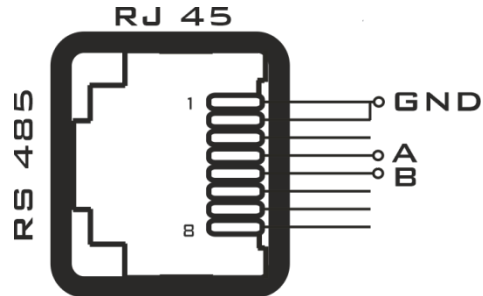


ATTENTION:

- Output voltage could be between 600V and 1200V AC.
- Only use cables specified by the manufacturer.
- Use only shielded transducer connection cables.
- Connect the shielding to the PE conductor on the generator side.
- Only use cables with sufficient cross-section.
- Minimum cross-section: 1.5 mm².

Interface socket RS485 ModBus

RJ 45 CONNECTOR:

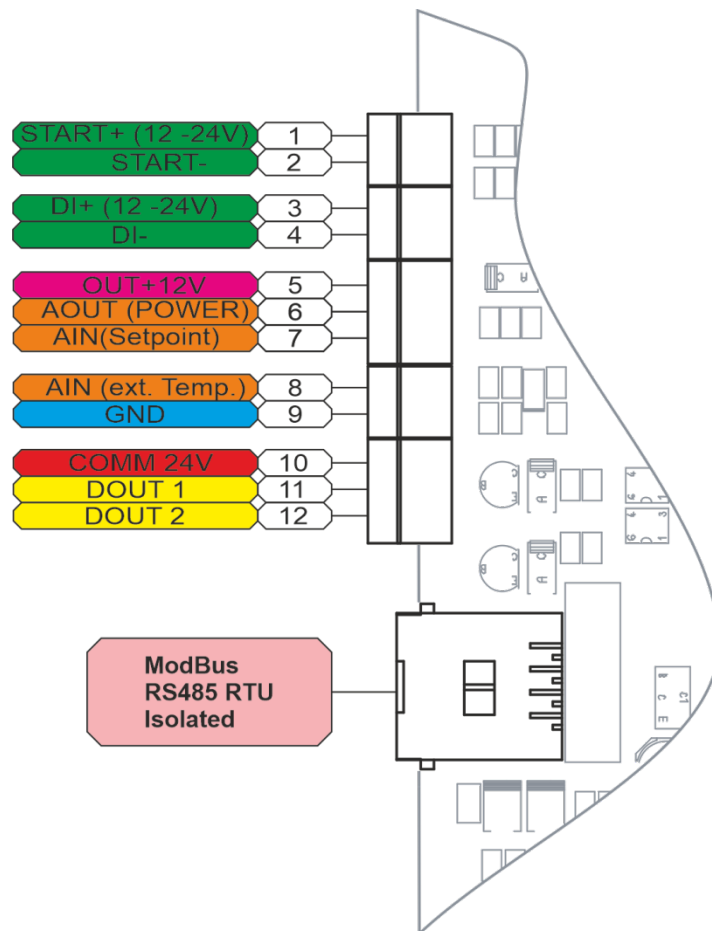


PINS	DESCRIPTION
1	GND
2	GND
3	N/C
4	A
5	B
6	N/C
7	N/C
8	N/C

12-Screw terminal

PIN NO. ON DSUB SOCKET	SIGNAL NAME	DESCRIPTION
------------------------	-------------	-------------

INTERFACE X1		
1	START +(12-24V)	Remote control input (with 12 – 24 Volt) positive
2	START -(12-24V)	Remote control input (with 12 – 24 Volt) negative
3	DI+ (12-24V)	Digital input for external STOP
4	DI- (12-24V)	Digital input for external STOP
5	OUT +12 VOLT	12 Volt for external use
6	AOUT(POWER)	Output 0 – 10 Volt = Power output 0 – 100 %
7	AIN(Setpoint)	Analog Input 0 – 10 Volt for power control
8	AIN (ext. Temp.)	Voltage corresponding to the transducer temperature. Reference is GND.
9	GND	Shared reference point = Ground
10	COMM 24V	Power Supply Digital Outputs 24V DC
11	DOUT 1	Digital Output generator ON
12	DOUT2	Digital Output generator ERROR



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

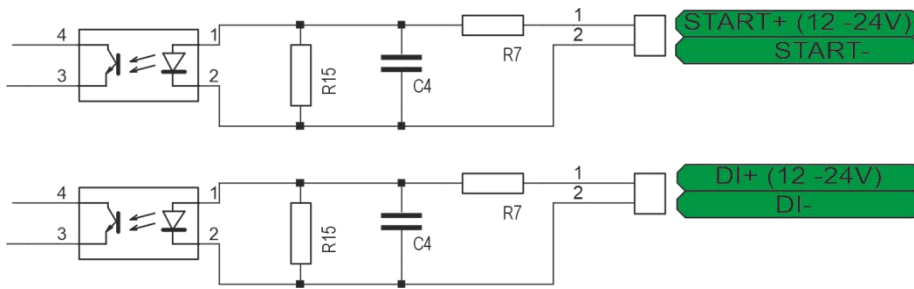
Interface Description

1.) Signal “START +(12-24V)”

PIN 1

Remote control input (with 12 – 24 Volt) positive”.

This voltage can also be used to switch on the generator on the input “START-24 V”.



2.) Signal “START -(12-24V)”

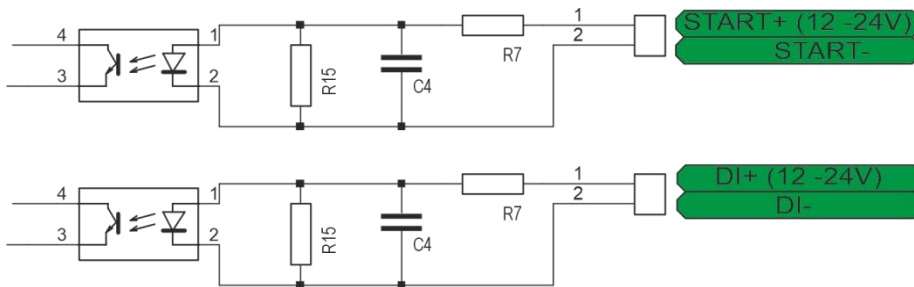
PIN 2

Remote control input (with 12 – 24 Volt) negative

3.) Signal “DI+ (12-24V)”

PIN 3

Digital input for external STOP



4.) Signal ” DI- (12-24V)”

PIN 4

Digital input for external STOP

5.) Signal “OUT +12 VOLT ”

PIN 5

Shared 12 Volt for external use

6.) Signal “AOUT(POWER)”

PIN 6

Output 0 – 10 Volt = Power output 0 – 100 %

7.) Signal “AIN(Setpoint)”

PIN 7

Analog Input 0 – 10 Volt for power control

8.) Signal “AIN (ext. Temp.)”

PIN 8

Voltage corresponding to the transducer temperature. Reference is GND.

9.) Signal “GND”

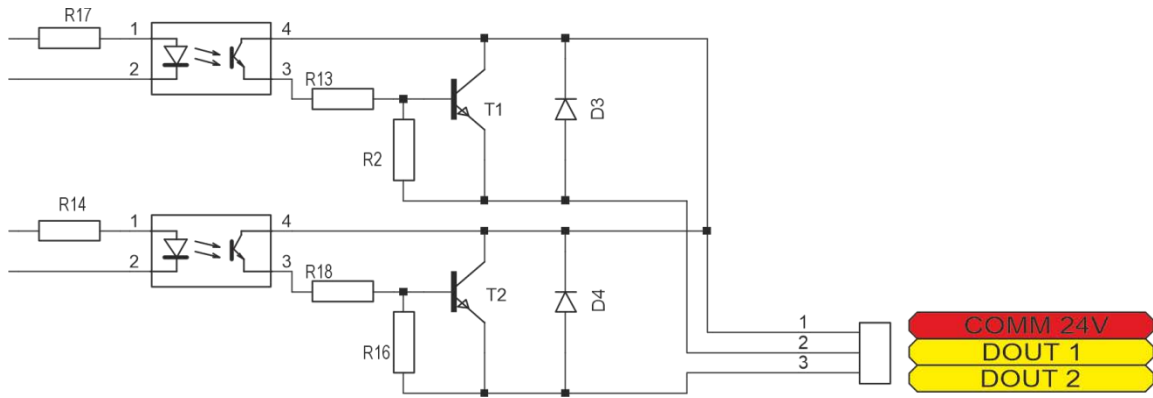
PIN 9

Shared reference point = Ground.

10.) Signal “COMM 24V”

PIN 10

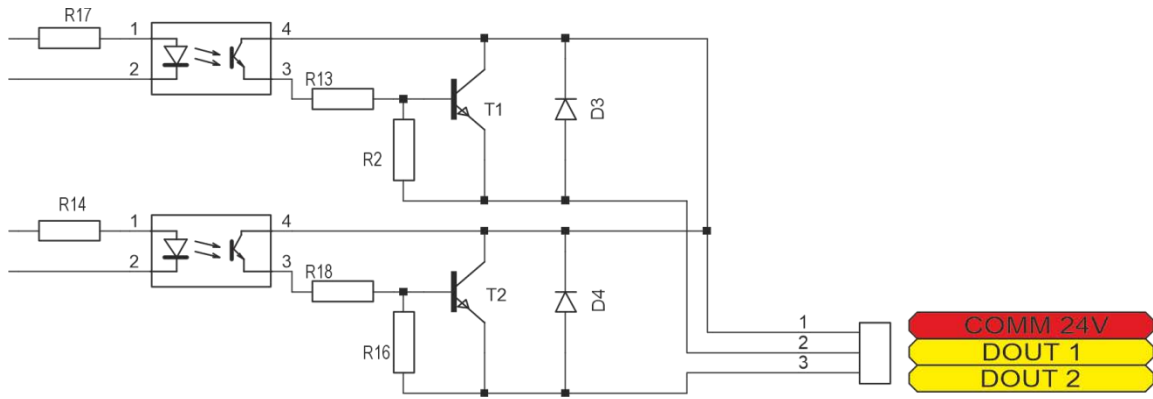
Power Supply Digital Outputs 24V DC



11.) Signal "DOUT 1"

PIN 11

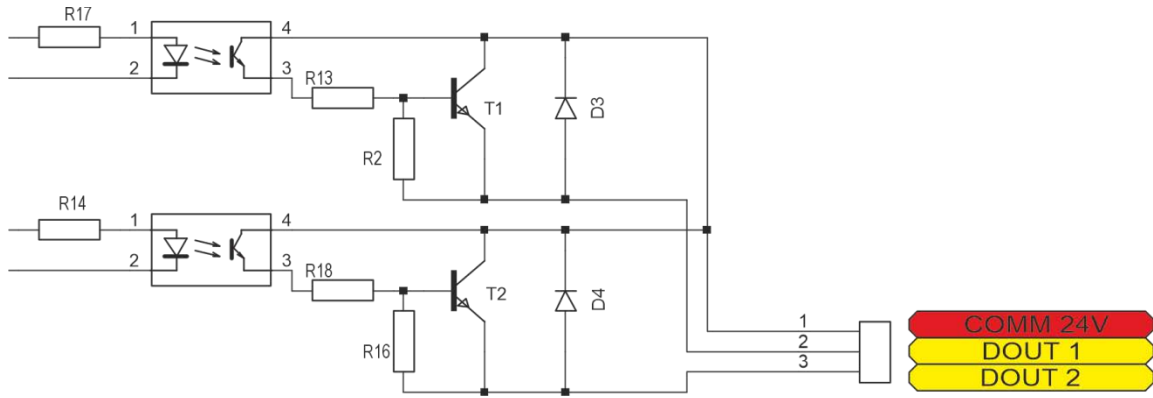
Digital Output generator ON



12.) Signal "DOUT 2"

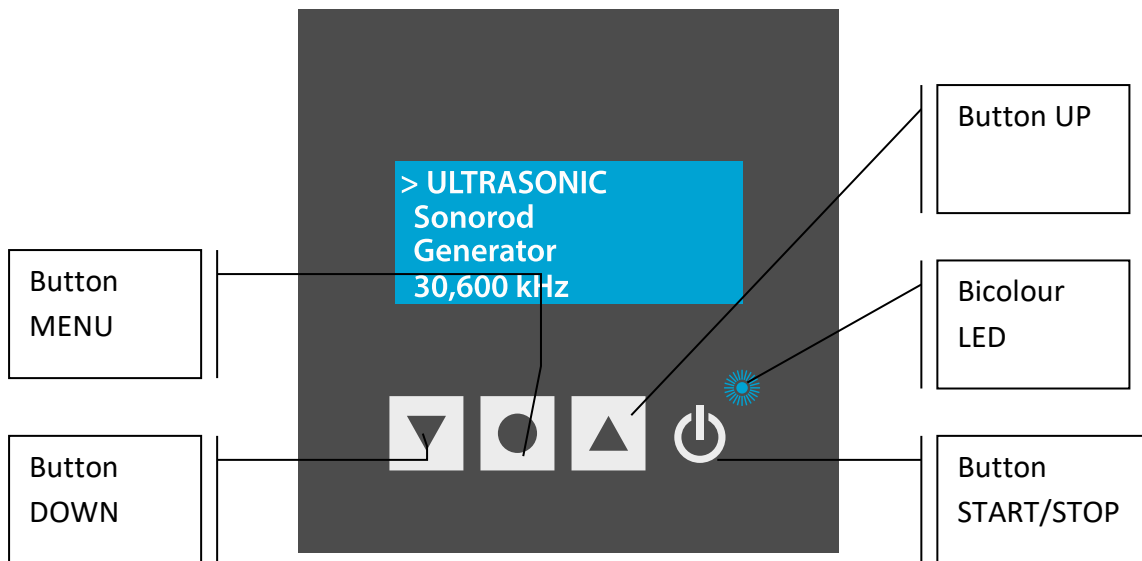
PIN 12

Digital Output generator ERROR function when the internal fan is running.



OPERATION

Operator elements and display on the front panel



Bicolour LED: Lights up **blue** when generator is switched on and works properly

Lights up **red** in the event of an error

START/STOP button: The generator is switching on and off by pressing this button.

Button UP ▲ and Down ▼: For moving up and down to select parameter and between menu windows.

Button Menu ●: Multifunction button:

1. By pressing the button MENU you can change current parameter.
2. By press+hold for 5 seconds you will WRITE TO MEMORY all present settings of the generator.

The LCD display

1.Initializing window display:

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

```
>Power 2000 W
Amplitude 100%
Freq 20.200 Hz
P= 0W I= 0 mA
```

Power – setting for maximal power (in W)

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

Freq - Frequency – setting for starting frequency (in kHz) - it should be higher (I.e. 100Hz) than the working resonance frequency of the load and when generator starts - it shifts down towards the exact resonance frequency.

P – Actual Output Power Value (in Watts)

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

2. Energy window

>Energy	0Ws
Energy+	0Ws
Energy-	0Ws
Last En	0Ws

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 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)

3. System window

>Modbus Addr	6
Speed	115200 b
Button	Push
Firmware	2.06

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

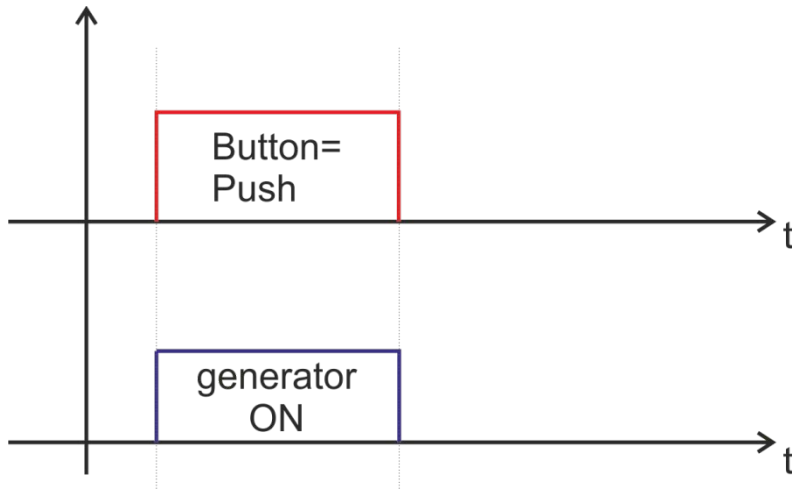
Speed – communication speed

Button – setting the functionality of the button

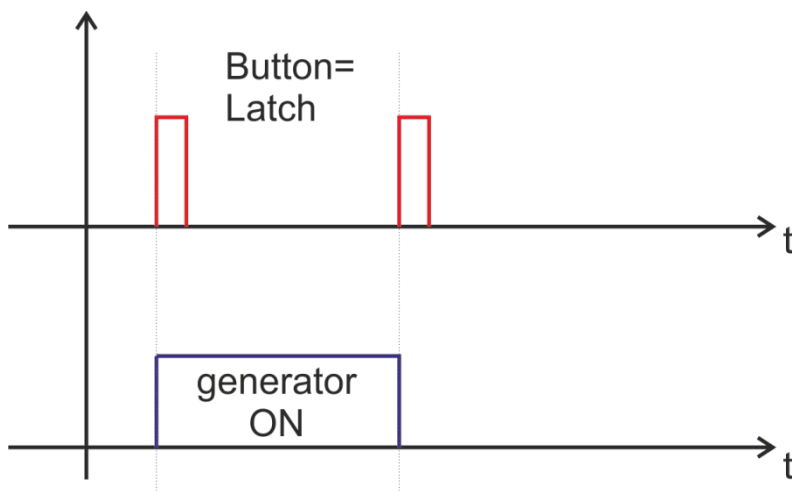
There are 4 options:

OFF – the button is off.

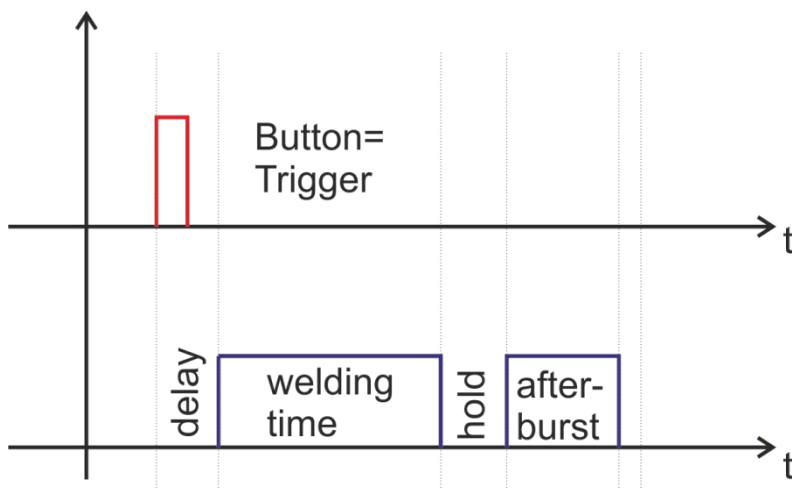
PUSH – the button works as a test button – while pushed the generator is on, while released the generator is stopped. See the picture below:



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



TRIGGER – pushing the button once the welding cycle starts.



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

4. Time window

>Time	0s
Peak+	0s
Peak-	0s
Last time	0.0s

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)

5. Delay, Hold and Afterburst window

>Delay	0s
Hold	0s
Afterburst	0s
Last time	0.0s

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).

6. LCD Tune window

>Imax	2.34A
Start tune	
Reg	300
Freq	20.108kHz

Imax – The output current by the set output power

Start tune – Starts the autotuning process by pressing the MENU ● button of the display. If better starting frequency is found the **Freq** value will be replaced with new one, or else the **Freq** value will remain the same.

Reg – regulator value (in seconds)

Freq - Frequency – setting for starting frequency (in kHz) - it should be higher (I.e. 100Hz) than the working resonance frequency of the load and when generator starts - it shifts down towards the exact resonance frequency. By Start tune new or better starting frequency could

be found. . If better starting frequency is found the **Freq** value will be replaced with new one, or else the **Freq** value will remain the same. The new value could be saved by **Write to memory** if desired.

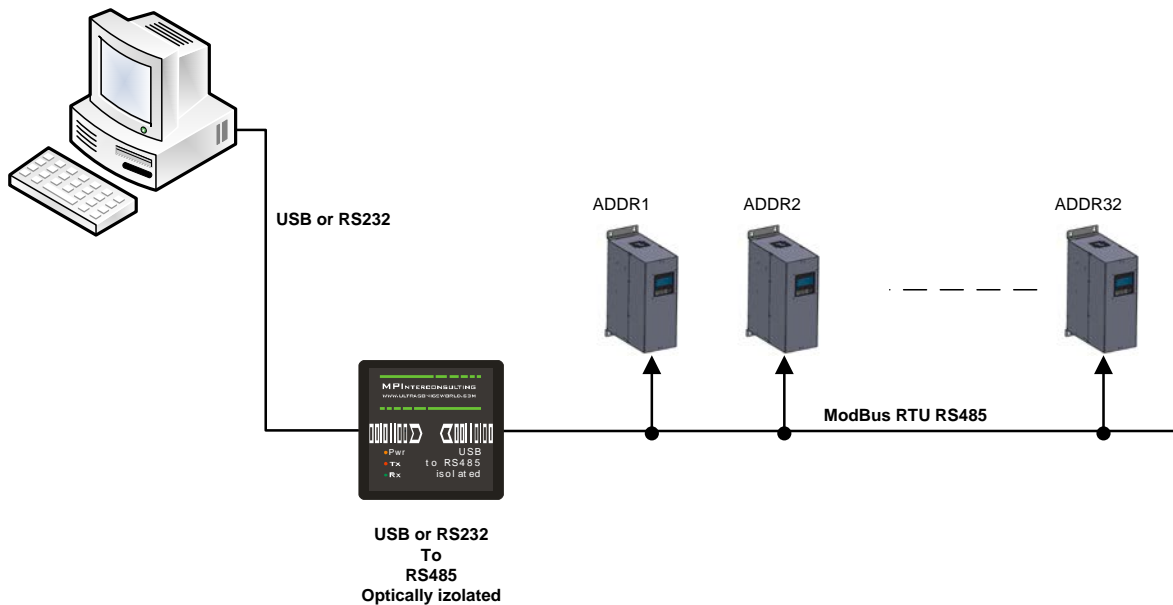
7. Write to memory window



This window appears when you press AND HOLD the MENU ● button for 5 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.



Before starting the software for the generator, you need to follow and execute the following steps

Install the software in the sequence as follows:

1. Unrar the SONOWELD 6kW install.rar

2. Start the setup.exe.

3. Follow the installation process.

Now you are ready to start the executable file, "[sonoweld 6kW.exe](#)", of the software of your generator.

- A) First action (regarding all generators and all software we are offering), after activating specific generator software, is to connect your PC with ultrasonic generator using our RS485-USB adapter.
- B) Then you need to select and activate proper operating COM port from the generator software tabs. This will open communication between your PC and your ultrasonic generator.
- C) Then you need to select initial setting conditions regarding expected frequency range.
- D) Then you need to make Scanning to see where ultrasonic load is able to operate.

ADJUSTING THE GENERATOR USING THE PC SOFTWARE

COM Tab

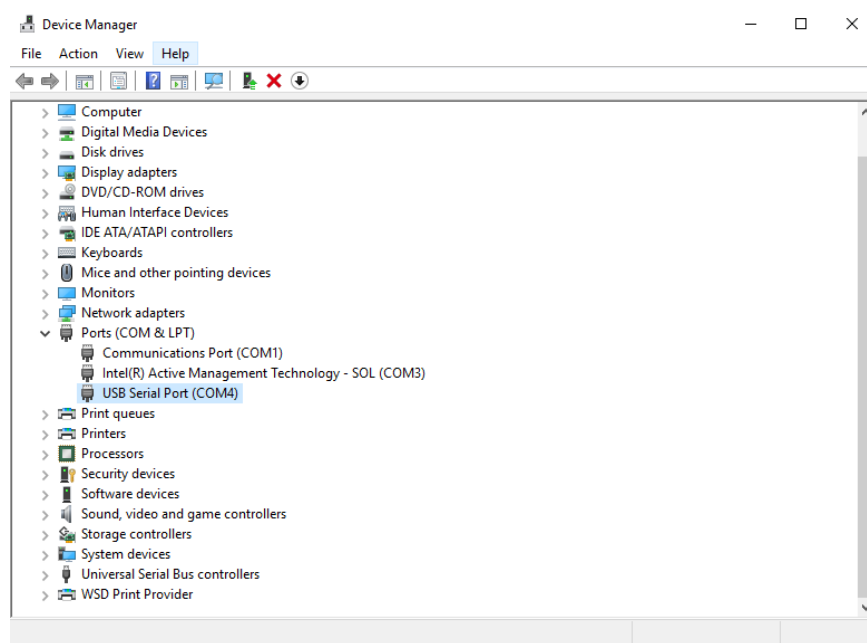
Start with **COMM tab**, and select proper COM port.

NOTE: Every new generator has 5 modbus address by default.

To connect the generator to the labview software we need to cover the following three conditions:

To know the Modbus address of the generator. Every new generator has 6 modbus address by default.

To know the exact COM port where the USB to RS485 driver is installed. Go to the Device Manager of your PC and find the USB Serial Port(The USB adapter must be plugged to one of the USB ports of your PC).



To set the correct communication baud rate.

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).

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”. After scanning (the yellow bar will become full in a few seconds), you will find the address (es) of the available generator(s) you will drive. Check if the value of the address in “MODBUS address” field is correct and if needed change it with the value shown in the table below the button “SCANNING FOR GENERATORS”. Beat counter will become alive and will start changing the figures. Connection (lime-green) 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” and then press the button ASSIGN NEW MODBUS ADDRESS.

DO NOT FORGET TO CHANGE THE MODBUS ADDRESS IN THE FIELD 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 glows green (YES).

Go to the first

“CONTROL” tab



7. Go to CONTROL 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 Start frequency.

9. 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).**

10. 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.

Amplitude – The actual voltage over the transducer (in % of the maximum allowed)

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.

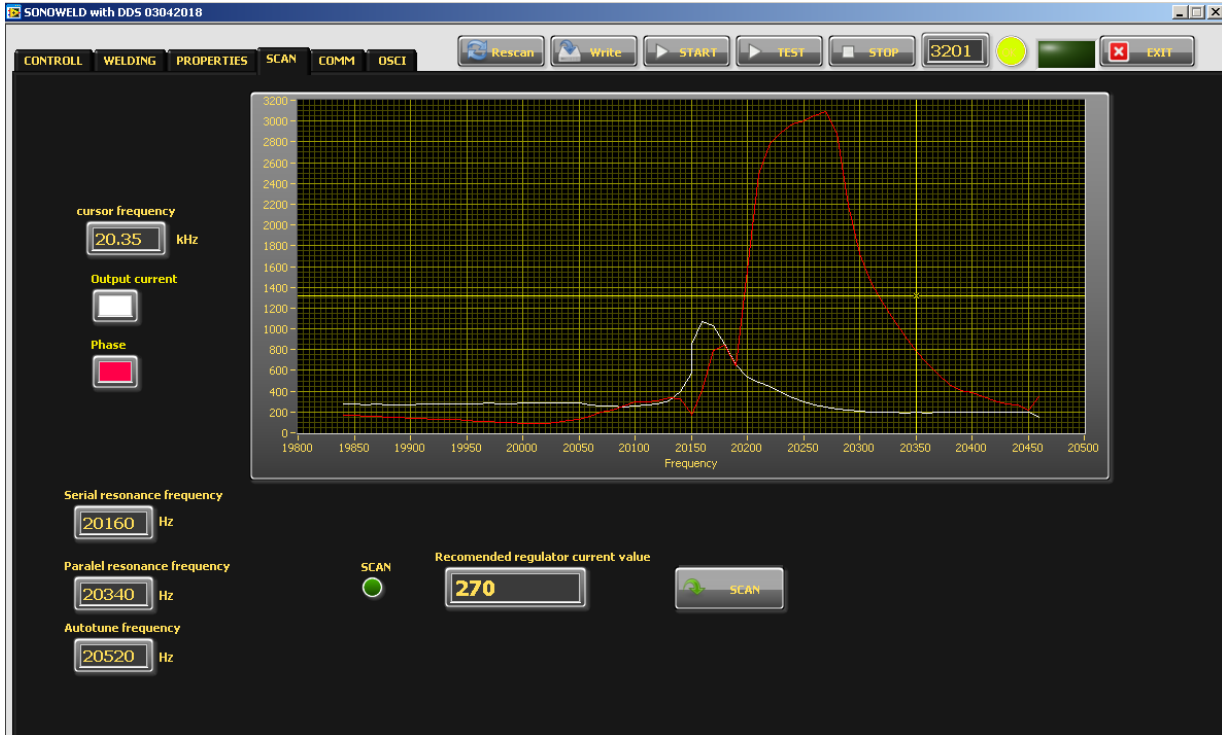
Amplitude – The actual voltage over the transducer (in Volts)

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.



11. 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 in the CONTROL Tab you need to select, the value in the Autotune Frequency box(it is about 200 Hz higher than the parallel resonance frequency).** Click the WRITE button on top of the window to write in generator's memory all present settings.

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

13. Go to

PROPERTIES tab.



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

15. Start the generator, by pressing button "TEST". The generator will keep on working until pressing button "STOP".

16. Start the Welding cycle, by pressing button "START".

Current Ramp – This is a type of regulator of the speed of growing of the current, which starts regulating when I_{max} is close to the set limit in case when the phase set value is still not reached (in ru). When Current Ramp value is small – the current grows fast, when Current Ramp is big – the current grows slow.

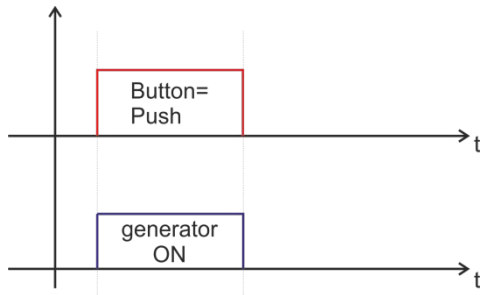
Nominal power - The nominal power of the generator(in kWatts).

Umax – the maximum output voltage(in % where 1000V RMS= 100%).

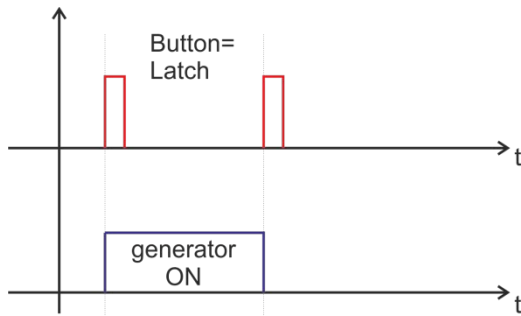
TEMPERATURE TRESHHOLD-External Temperature Limit – setting of the External Temperature Limit (in °C). The generator could generate error signal, when the temperature is over the set limit.

The limit for the **External temperature** is set in Labview software in PROPERTIES Tab in **Temperature Treshold**.

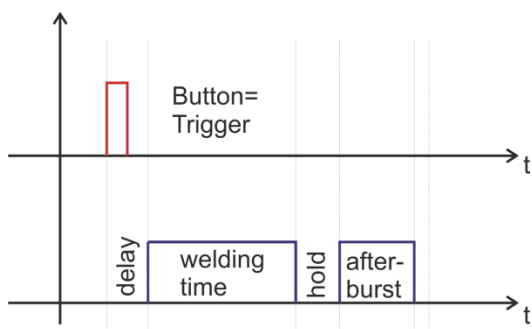
PUSH – the button works as a test button – while pushed the generator is on, while released the generator is stopped. See the picture below:



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



TRIGGER - pushing the button once the welding cycle starts.



OUTPUT VOLTAGE SELECTOR

LOW - When selecting LOW output voltage the corresponding lamp lights up in green

MEDIUM - When selecting MEDIUM output voltage the corresponding lamp lights up in green

HIGH - When selecting HIGH output voltage the corresponding lamp lights up in green

OSCI tab.



There is an inserted 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. After recording is finished, when the button read is pressed, the data from generator is uploaded in the Labview software and is visualized graphically.

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).

Ramp Frequency – This is the ramp that sets the speed of shifting the frequency down- big ramp set value – slow speed, small ramp set value – fast speed.

Ramp Amplitude –This is the ramp that sets the speed of growing the amplitude- big ramp set value – slow speed, small ramp set value – fast speed.

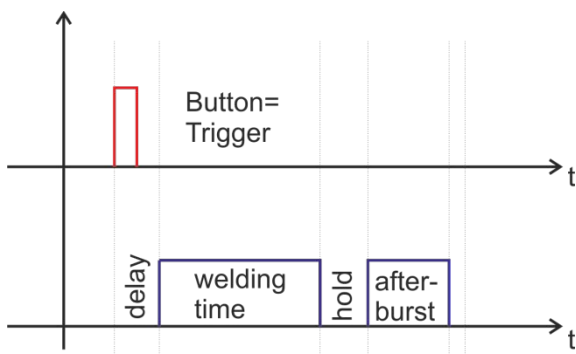
SETTING THE WELDING CYCLE PROPERTIES

1. Go to

WELDING Tab.



Before setting the welding regime you need to Select TRIGGER Mode for the button – you can do it in PROPERTIES Tab or from the Display.



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.

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) :

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)

HF-DA RELAY MODE

# weld	time	peak power	energy
1	61.98	80	1760

DC Power scale factor: 2.5 ru

Nominal power: 1 kW

Umax: 60 %

Startup phase: 3 ru x 100

Current ramp: 3 ru

HOT START: ON

AUTOTUNE AFTER SCAN: ON

HF relay mode: ON generator, ON process, ON solenoid

Button or REM 24V mode: TRIGGER

Power: 11 W

Firmware: 2.04

Password: 1234

Average power: 12 W

Temperature threshold: 80 °C

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.

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

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
- Starting frequency selected may be too LOW
- 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.

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
- Starting frequency selected may be too LOW

Troubleshooting:

- Rescan and re-adjust the generator as described in this manual

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
- Starting frequency selected may be too LOW – below the resonance frequency
- Span selected may be too LOW
- 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
- 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

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**,

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**

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:

Frequency	SONOWELD 6000 20 kHz	
Operating voltage	3N 380V +/- 15%	
Power consumption	10 A	
Maximum output	6,000 W	
Circuit Breaker protection	16 A	
Dimension casing	W x H x D/mm/ 186x422x277	Weight 12 kg
Operating Temperature range	-10 to +40°C	Protection class 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 authorisation 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

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.