



THUNDER LASER SYSTEMS



User's manual for NOVA-24

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Original Instruction



Introduction

This manual has been designated as the thunder laser systems, laser cutting machine installation and user guide; The manual is divided into five chapters, Including general information instructions, safety instructions, the key components of every laser cutting systems and the installation steps, operation instructions and maintenance instructions from THUNDERLASER Company.

Frist, it should be emphasized that the installation of each system must meet the requirements, and make it consistent with the installation requirements of THUNDERLASER. If not, the machine will not working properly, poor performance, life shortened, maintenance costs increased and even machine damage .

The note is for getting a specific requirement of system installation, and we hope every customer try to understand these notes before installation and usage, thus you can correctly install and use. If you meet any installation problems, you can contact our technical staff and customer service staff. (At the same time, you can also refer to the machine installation video that we posted on youtube. The specific URL is

<http://www.thunderlaser.com/how-to-use-your-laser-machine/how-to-setup-your-nova-laser-cutter.html> Or
<https://www.youtube.com/watch?v=NpLo1LONQx8&list=PLjSZrgjcrhs7QucNN-3jx7rZapDGfjG-5>.)



Contents

Chapter1	General	5
1.1	General Information	5
1.2	Designated.....	6
1.3	Disposal remarks	6
1.4	Technical Data / Device Specification	7
1.5	Manufacturer's Label.....	9
Chapter2	Safety	10
2.1	General Safety Information.....	10
2.2	Laser Safety Information.....	11
2.3	Safety Precautions when Operating the Device	12
2.4	Warning and Information Labels.....	13
Chapter3	Process of Installing	16
3.1	Unpacking	16
3.2	Location	17
3.3	Before Installation.....	18
3.4	Exhaust System – Requirements	20
3.5	Air System – Requirements	20
3.6	Water Cooling System – Requirements.....	21
3.7	Computer – Requirements.....	22
3.8	Connections.....	23
3.8.1	Connecting the Mains.....	23
3.8.2	Connecting the Computer.....	24
3.8.3	Connecting the Exhaust System	25
3.8.4	Connecting the Air System.....	27
3.8.5	Connecting the Cooling System	29
Chapter4	Operation.....	30
4.1	Machine View	30
4.2	ON/OFF Switch	35
4.3	How to setup the software.....	36
4.3.1	Software installation.....	36
4.3.2	Make connection between PC and machine	38
4.4	How to use the display	42
4.4.1	Function of the Buttons	42
4.4.2	The main interface.....	44
4.4.3	Speed button.....	45
4.4.4	Max Power buttons	45
4.4.5	Set the Layer Parameters.....	45
4.4.6	Z/U button	46
4.4.7	File button	47
4.5	How to use the different nozzles laser head cone.....	50
4.6	How to replace the 4 inch and HR laser head	51



4.7	How to adjust focus distance by manual or auto	53
4.8	How to use the TL-Timer	56
4.9	How to use air-assist control	58
4.10	How the heat alarm system works	60
4.11	The First Time Running the Laser	61
4.12	Workstation Area Indication	64
4.13	How to use the Rotary axis Attachment	65
4.14	For Laser Engraving	67
Chapter5	Maintenance	68
5.1	Cleaning the Laser Machine	68
5.2	Cleaning the Optical Parts	69
5.2.1	Cleaning the Focus Lens	69
5.2.2	Cleaning the Mirrors	71
5.2.3	Cleaning Laser Combiner	73
5.3	Maintain the X/Y/Z Rails	74
5.4	Check the Beam Path	75
5.5	Change Cooling Water for The Water Chiller	76
5.6	Maintenance Plan	77



Chapter1 General

1.1 General Information

Please read and follow this Operation Manual carefully, before installation and operation. Damage to persons and/or material can result from not following individual points of the Operation Manual!

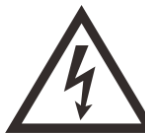
Operation of the system is only permitted with equipment and spare parts supplied or listed in the spare parts and consumables lists.

Auxiliary equipment must be adjusted to the base machine (any queries to dealer or manufacturer).

The following symbols are used for easier understanding of the Operation Manual:



Caution: Warning and caution to keep in mind when operate the laser.



Caution: This component is under voltage. In these areas strictly observe the safety instructions regarding electricity. Care is to be taken in particular during maintenance and repair work.



Caution: In this area pay attention to the possible dangers of the laser beam.



Caution: Indicates the potential for fire danger when operation the laser. Do not run the laser machine when unattended



Tips: Helpful note or information on individual components of the device that simplify the use or make it more understandable.



1.2 Designated

The THUNDER LASER NOVA-24 is used for engraving and cutting of signs, stamps and suchlike.

A wide variety of materials such as rubber, acrylic, coated metal, tin, special steel, anodized aluminum, cork, cardboard, glass, leather, marble, several plastics and wood can be processed on the laser.



1. The engraving process must only be performed with a perfectly adjusted machine.
2. For cutting applications with 40 W the use of the cutting table is absolutely necessary.
3. Use of the system in other areas is against the designated use. The manufacturer does not admit liability for damage to personal and/or equipment resulting from such use.
4. The system must only be operated, maintained and repaired, by personnel that are familiar with the designated field of use and the dangers of the machine!
5. Non-observance of the instructions for operation, maintenance and repair described in this Operation Manual excludes any liability of the manufacturer if a defect occurs.
6. Caution when processing conductive materials (carbon fibers), Conductive dust or particles in the ambient air might damage electrical components and lead to short circuits. Bear in mind that those defects are not warranted.

1.3 Disposal remarks



Do not dispose the machine with domestic waste!

Electronic devices have to be disposed according to the regional directives on electronic and electric waste disposal. In case of further questions, please ask your supplier. He might take care of proper disposal.



1.4 Technical Data / Device Specification

Mechanics

Working area	23.6"x 15.7"/ 600 x 400 mm
Table Size	27.6"x 20.9"/ 700 x 530 mm
Z Axis Height	6.1 inch /155 mm
Max. Height of work piece (Motorized Table, Standard laser head)	6.1 inch / 155 mm
Max. Height of work piece (No Motorize Table, Standard Laser head)	1-2.1 inch /27-55mm
Max. Engraving speed	39 inch/sec. / 1000 mm/sec.
Standard	
Cutting speed	depending on material, thickness, laser power
Motor	Easy Servo Motor
Drive	Hybrid Servo Drive
Work piece table	Solid metal (Honey comb table)
Max. load of work piece table	20 kg
Net Weight	130kgs
(287lbs)	
Lenses available (focal distance)	2, 0"
Focus lens diameter	20mm
Reflector diameter	25mm
Beam combiner diameter	20mm

Dimensions

W x D x H	42.1"x 31.1"x 21.3"/ 1070 x 790 mm x 540 mm
Max Part Size (W x L x H)	
Front Door Closed	27.6"x 20.9"x 8.3"/ 700 x 530 mm x 155 mm
Pass-Through Door	27.6" x∞"x 0.6"/ 700 x∞mm x 10 mm

Features

Standard:

Open cover protection, Red Dot Pointer, Auto Focus, heat alarm system ,Motorized Table, Pass-Through Door, Air pump, Water chiller, Exhaust Fan, Honey Comb Table, 2,0"(50.8mm)Focus Lens, Easily Adjustable Home Position, LCD Display, 3D Engraving, "No Water "protection, Emergency Stop, Maintenance mode, TL-Timer, The warning light,.

Optional:

Rotary Attachment, High Resolution head (up to 1000DPI, while standard laser head Max is 500DPI), High air compressor set (Includes water filter).

Control System

Laser power	Adjustable from 1 - 100% (typically 5-100%)
Interface Hardware	USB: connect to PC and U-disk Ethernet: connect to PC
Interface Software	RDWorksV8
Operating Modes	Optimized raster, vector, and combined mode
Buffer Memory	128 MB Standards

Laser Equipment

Laser Type	Sealed CO2 Glass Laser Tube
	Laser Power: 40W, 60W
Wavelength	10, 6μm
Red dot pointer	Laser Power < 1mW
Wavelength	630nm – 680nm

Cooling System

Air Cooling System	Air-Cooled
Water Cooling System	Water Cooled

Electricity, Power, Breaker

Electricity Requirement	110 to 240 volts, 50 or 60 Hz, Single phase
Power consumption	1100W (Assembly 40Watt Laser Tube) 1200W (Assembly 60Watt Laser Tube)
Tube)	
Recommended break	10A, 230V (40W/6W Laser Tube) 10A, 115V (40W/6W/ Laser Tube)

Ambient Conditions

Ambient temperature	+15°C to +35°C / 59°F to 95°F
Humidity	40% to max. 70%, not condensing

Laser Safety

Laser class	CDRH Laser Safety Laser Class 4
approved	CE compliant FDA






1.5 Manufacturer's Label

The manufacturer's label is located on the back of the device (see Figure below).



It is recommended to enter data such as serial number and year of manufacture into the Manufacturer label below so that you always have this data handy if you have problems with your device or require spare parts.

		THUNDER LASER CUTTER			
DONGGUAN THUNDER LASER EQUIPMENT CO.,LTD					
Shatian Town, Shatian Dadao, Mintian, Dongguan City, Guangdong Province, China					
Rated voltage:		Complies with 21 CFR 1040.10 and 1040.11 except for deviations pursuant to Laser Notice No. 50, dated June 24, 2007			
Phase:		This Product Complies With EN 60825-1:2014.			
Rated frequency:		Class 2 Laser Product			
Full load current:		www.thunderlaser.com			
Weight:		MADE IN CHINA			
Lasertype:					
Model/Type:					
Serial Number:					
Manufactured:					

Chapter2 Safety

2.1 General Safety Information

All personnel involved in installation, set-up, operation maintenance and repair of the machine, must have read and understood the Operation Manual and in particular the "Safety" section. The user is recommended to generate company-internal instructions considering the professional qualifications of the personnel employed in each case, and the receipt of the instruction/Operation Manual or the participation at introduction/training should be acknowledged in writing in each case.

Safety-conscious of Working

The machine must only be operated by trained and authorized personnel.

The scopes of competence for the different activities in the scope of operating the machine must be clearly defined and observed, so that under the aspect of safety no unclear questions of competence occur. This applies in particular to activities on the electric equipment, which must only be performed by special experts.

For all activities concerning installation, set-up, start-up, operation, modifications of conditions and methods of operation, maintenance, inspection and repair, the switch-off procedures that may be provided in the Operation Manual must be observed.

Safety Information for the User and/or Operating Personnel



1. No working methods are permitted that affect the safety of the machine.
2. The operator must also ensure that no unauthorized persons work with the machine (e.g. by activating equipment without authorization).
3. It is the duty of the operator, to check the machine before start of work for externally visible damage and defects, and to immediately report changes that appear (including behavior during operation) that affect the safety.
4. The user must provide that the machine is only operated in perfect condition.
5. The user must guarantee the cleanness and accessibility at and around the machine by corresponding instructions and controls.
6. Principally, no safety components may be removed or disabled (already here we emphasize the imminent dangers, for example severe



burns, loss of eye-sight). If the removal of safety components is required during repair and service, the replacement of the safety components must be performed immediately after completion of the service and repair activities.

7. Preparation, retooling, change of work piece, maintenance and repair activities must only be performed with equipment switched off, by trained personnel.
8. It is forbidden to perform unauthorized modifications and changes to the machine. It is emphasized, that any unauthorized modifications to the machine are not permitted for safety reasons.

2.2 Laser Safety Information



1. To assess the potential dangers laser systems pose, they are classified into 2 safety classes, thunder laser NOVA-24 is a device of Class 4. This is guaranteed by the protective housing and the safety installations.

Please note that improper and warranty operation of the device can override the status of Safety Class 4 and can cause the emission of harmful radiation.

2. This laser engraving system contains a carbon dioxide (CO₂) laser of Class 4 that emits intensive and invisible laser radiation. Without safety precautions the direct radiation or even diffuse reflected radiation is dangerous!

3. Without safety precautions, the following risks exist with exposure to laser radiation:

Eyes: Burns to the cornea

Skin: Burns

Clothing: Danger of fire

4. Never try to modify or disassemble the laser and do not try to start up a system that had been modified or disassembled!

5. Dangerous radiation exposure can result from the use of operation or adjustment equipment other than that described here, and if different operational methods are performed.



2.3 Safety Precautions when Operating the Device

In your thunder laser NOVA-24, a closed safety system is integrated which immediately stop a job when the protection cover is opened. Consequently an incomplete engraving can occur if the cover is opened during operation. Therefore, first press the "PAUSE" button, if you want to interrupt an engraving process.

Please remember the following safety precautions when working with this device:



1. CO2 Fire extinguishers should be placed near laser. Always keep a properly maintained and inspected fire extinguisher on hand.
2. Do not store any flammable materials in the inside of the device. Particularly leftovers of produced materials have to be removed to prevent fire hazard.
3. Please maintain Free air-flow surrounding this system. At all times, do not cover during operation.
4. Stay with the laser. Do not leave the laser unattended when it is working, small scraps can ignite and without supervision can destroy the machine if not checked.
5. Use Air Assist. Always use the system's Air Assist feature when vector cutting.



1. These lasers emit invisible radiation; safety glasses should be worn when maintenance these machines for your protection.
2. Adjustment of the beam path must be performed only by especially trained personnel. An improper setting can lead to uncontrolled emission of the laser radiation.



1. Do not disable limit switches or safety features as this can invalidate warranties and cause damage to you and the machine.
2. Before processing materials the user must verify, whether harmful materials can be generated and whether the filter equipment of the exhaust system is suitable for the harmful materials. We emphasize that it is the responsibility of the user, to consider the national and



regional threshold values for dust, fogs and gases when selecting the filters and the exhaust system. (The values for the maximum workplace concentration must not be exceeded.)

3. PVC (polyvinyl chloride) must under no circumstances be processed with the laser.

Should you have further questions before starting work, please feel free to write us an email at: tech@thunderlaser.com

2.4 Warning and Information Labels



The warning and information labels are attached in such positions of the device that could represent a source of danger during set-up and operation. Therefore, follow the information on the labels. If labels are lost or damaged, they must be replaced immediately.





ATTENTION

1. The user should read the related operating manual carefully before operating. Non-trained people are forbidden to operate machine.
2. Forbidden to operate if the water doesn't circulate to avoid parching the laser tube.
3. The operator is forbidden to leave during operation and must cut off switch when work finishes.
4. The operator must observe carefully during the working of the machine, if something is exceptional should cut off all the switches.
5. There are laser light and high pressure in the machine, non-professionals are forbidden to disassemble machine.
6. Make sure the wire connects well with the ground before operating.
7. Forbidden to open any cover to avoid unnecessary damage during working.
8. Keep the machine in the dry place, non-pollution, non-corrosing, non-strong electricity, strong magnetism, etc.
9. The temperature of water should be 15-30°C, prevent water king up in winter and too hot in summer (suggest to use pure water).
10. The machine uses the laser (strong laser radiate). It is forbidden to keep something inflammable and explosive around the machine.
11. Forbidden the things unconnected diffuse reflection around the machine for fear the laser light reflects the person or incentive directly (advice to use fire hose box in location of working).

Thank you for your cooperation!



CAUTION - CLASS 2 LASER RADIATION WHEN OPEN DO NOT STARE INTO THE BEAM

CAUTION - CLASS 4 INVISIBLE LASER RADIATION WHEN OPEN AVOID EYE OR SKIN EXPOSURE TO DIRECT OR SCATTERED RADIATION



CAUTION
Dangerous voltage!
Take care to avoid coming into contact with electricity!

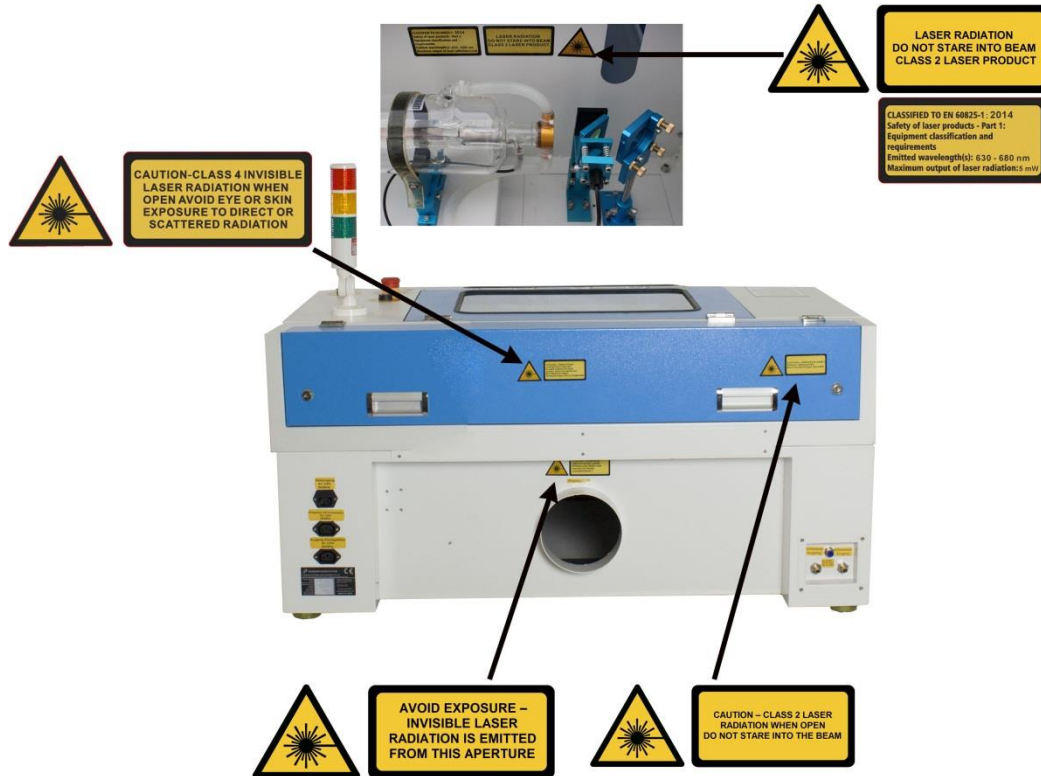


CAUTION - CLASS 2 LASER RADIATION WHEN OPEN DO NOT STARE INTO THE BEAM

CAUTION - CLASS 4 INVISIBLE LASER RADIATION WHEN OPEN AVOID EYE OR SKIN EXPOSURE TO DIRECT OR SCATTERED RADIATION



CAUTION
Dangerous voltage!
Take care to avoid coming into contact with electricity!





Chapter3 Process of Installing

3.1 Unpacking

You receive your THUNDER LASER NOVA-24 packed in a wooden box, which contains the laser machine and additional accessories. The following steps give you an overview of the unpacking and assembly of the laser. Please follow these steps carefully.



Keep the packing box. You will require it in case of a return.

Dispose all waste according to the applicable waste disposal law.

1. Put the wooden box on a flat and spacious room for unpacking.
2. Remove the machine box; carefully remove the foam material, which protects the viewing window of the cover and around the machine.
3. Take out the key, open the door of the laser, Remove the accessories box which contains all accessory parts required for the installation of the laser machine.
And check if there's anything damaged or missed during shipping.
4. You will see an attachment table on the machine; please check whether the accessories are all on the table.
5. Please keep the keys and the warranty certificate well (and please show us your warranty certificate if you need tech support for the machine failure, then we will provide you the best technical service).
6. Remove the sponge and nylon cable ties from inside the machine, and then start to install the machine (below chapters are installation details)



3.2 Location

Before you install the laser system, you should select an appropriate location. Follow the guidelines shown below:



1. Avoid locations where the system is exposed to high temperatures, dust and high humidity. (The humidity must not exceed 70% and the temperature must not be close to the dew point.)
2. Avoid locations, where the system is exposed to mechanical shocks.



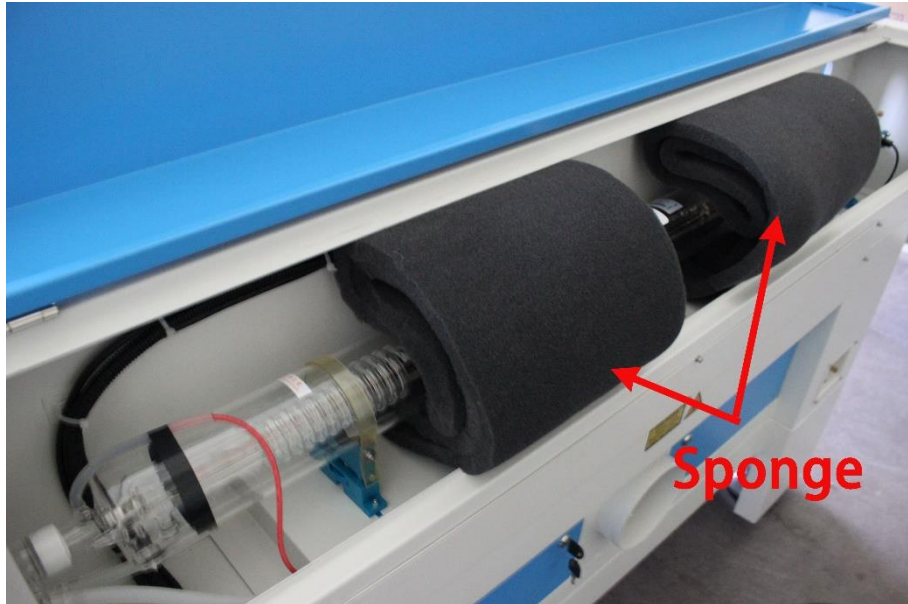
1. Breaker protection: Do not connect other devices via the laser breaker, as the laser system requires the full amperage.
2. DO NOT open any of the machine's access panels while the unit is plugged in. Opening a panel may expose the operator to the unit's AC input power.
3. DO NOT make or break any electrical connections to the system while the unit is turned on.



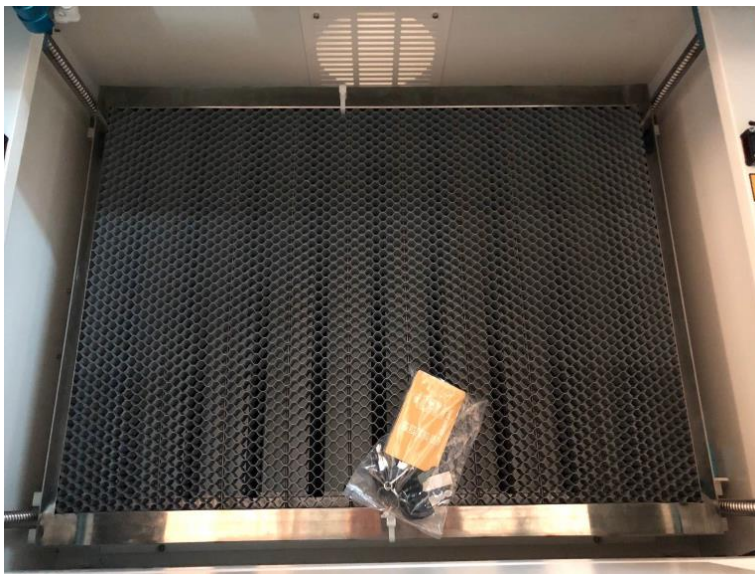
1. Avoid locations with poor air circulation; select a location close to ventilation (if available). Select a location, whose room temperature is between 15 °C and 25 °C (59° – 77° F).
2. This is fundamental to maintain consistent and reliable operation of a CO2 laser, Metal RF or Glass tube and the machine itself. Avoid higher ambient temperatures and strong exposure of the engraver to the sun. Use blinds, if required.
3. Mechanical shock and vibration of the laser will have detrimental effects on the performance and life expectancy of the machine. It will manifest (over a period of time) with a noticeable decrease in performance and increased maintenance required, possibly even damage. Setting your Thunder Laser up in a suitable temperature controlled, dust free, moisture free, level, stable surface (a level concrete floor) with the recommended extraction is critical to the ongoing performance of the machine. It is also a warranty condition.

3.3 Before Installation

1. Take out the sponge around the laser tube. Like below:



2. Take out the nylon cable ties around the honey comb plate.
Remove the transparent bag out of the front of honey comb plate, Like below:



The transparent bag has a set of machine door key, USB flash drive, and an engraving test sample.
The USB flash drive stores software package and the document such as User's Manual and Material Parameters and so on.



The engraving test sample shows you the setting of "Reverse compensation setting" for this machine, save those setting by Config(s)>>system setting>>Optimize>>Scanning(Reverse compensation) in your rdworks. so you can get the better result on scan mode of X_swing.(see the on page for specifics)

3. Open the emergency switch (must do it for the first time to use the machine).

Like below



The mains cable is in the tool box that came with the machine.



3.4 Exhaust System – Requirements

To guarantee the right ventilation during the engraving and the cutting. The device must be equipped with a fine exhaust fan (generation of rubber dust), if you use a carbon filter (neutralization of smells) will be better for exhaust effect. A good exhaust fan of the outgoing air is also required when cutting plastics or engraving wood.



Connection - see section 3.7.3 connecting the Exhaust System.



Do not start the machine without an adequate exhaust system.

3.5 Air System – Requirements

To guarantee do not catch fire and too much smoke during the engraving and the cutting. The device must be connecting with the laser to make sure the laser is safe during the work.



Always use the system's Air Assist feature when vector cutting.

3.6 Water Cooling System – Requirements

To guarantee do not lead to the glass laser tube break once it reach a certain temperature during the engraving and the cutting. The device must be running and connecting with the laser to make sure the laser tube is safe during the work.





Do not run the machine without an adequate water cooling system.

3.7 Computer – Requirements

The following recommendation represents the minimum requirements. When using a more powerful computer the graphics are generated and displayed faster and the computing times and the data transfer to the laser are reduced. To use the newest software version, you might have to abide other requirements.

- Windows 10 (32 bit or 64 bit)
- Windows 8 (32 bit or 64 bit)
- Windows 7 (32 bit or 64 bit)
- Windows Vista (with Service Pack 1 or later)
- Windows XP (with Service Pack 2 or later)
- 1024 MB of RAM, 400 MB of hard disk space
- Pentium® 3 or 4 processor or AMD Athlon™ XP
- 1024 x 768 or better monitor resolution
- 1 free USB interface
- 1 free Ethernet interface
- Mouse



3.8 Connections



Perform the connections exactly in the order described; otherwise electrostatic charging can damage your computer and/or the electronics of the laser system.

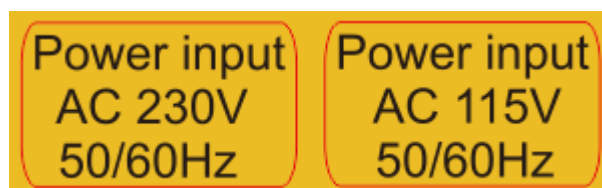
3.8.1 Connecting the Mains

Connect one end of the mains cable with the connection socket at the rear side of the laser device (see Figure below) and the other end with a protected power outlet.

Mains voltage and operating voltage must correspond (AC 230V 50/60 Hz or AC 115V 50/60 Hz) – see information label beside the connection socket.



Under no circumstances switch on the device if the voltages do not correspond.

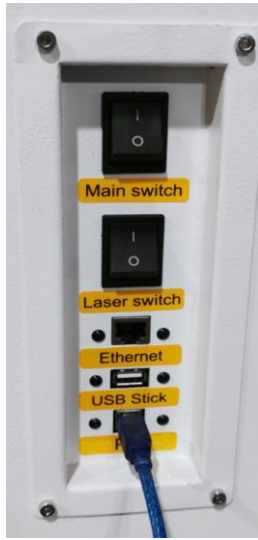




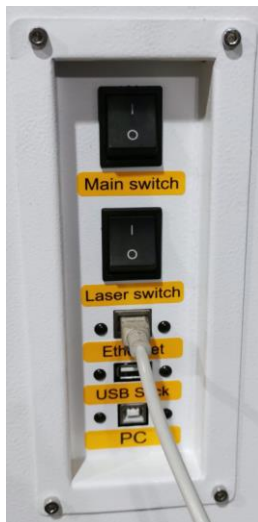
The mains cable is placed the front of the honey comb table.

3.8.2 Connecting the Computer

Connecting the Computer and the machine by using the USB cable. Like below:



Connecting the Computer and the machine by using the Ethernet cable. Like below:



The USB and Ethernet cable are placed inside the toolbox.



3.8.3 Connecting the Exhaust System

How to set up the exhaust system

Insert one side of the gray exhaust pipe into the fan inlet and the other side into the fuselage behind the exhaust tank. Insert one side of the gray exhaust pipe into the fan outlet and put the other side of the pipe outside where you work (If the machine is far from the outside of the room that the gas manufactured by the machine cannot be discharged; then you might need an dust/fume filter, it can keep the air quality of your working environment well). Please refer to the following pictures about how to install the exhaust pipe:



Also you can refer to the video on how to set up your Nova laser machine in our website <http://www.thunderlaser.com/how-to-use-your-laser-machine/how-to-setup-your-nova-laser-cutter.html>



The input voltage must correspond (AC 230V 50/60 Hz or AC 115V 50/60 Hz) – see information label beside the connection socket.



Output: Exhaust fan
AC 230V
50/60Hz

Output: Exhaust fan
AC 115V
50/60Hz



Do not connect the air compressor or the water chiller to the above interface, if connect them to the above interfaces that cause in failure of the machine, the warranty does not covered.

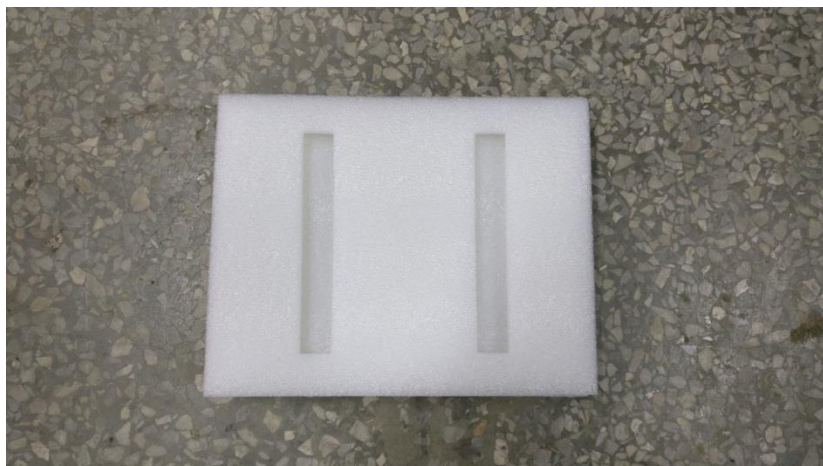


3.8.4 Connecting the Air System

First of all, Install a air blowing mouth (copper) to the air system, then connect the hoses (white side) to the mouth, the other side to the machine. After that, please connect the power cable (of the air system) to the machine. Like below:



A customized anti-shock foam that came with the air pump can be placed under the air pump.





The input voltage must correspond (AC 230V 50/60 Hz or AC 115V 50/60 Hz) – see information label beside the connection socket.



Output: Air compressor
AC 230V
50/60Hz

Output: Air compressor
AC 115V
50/60Hz

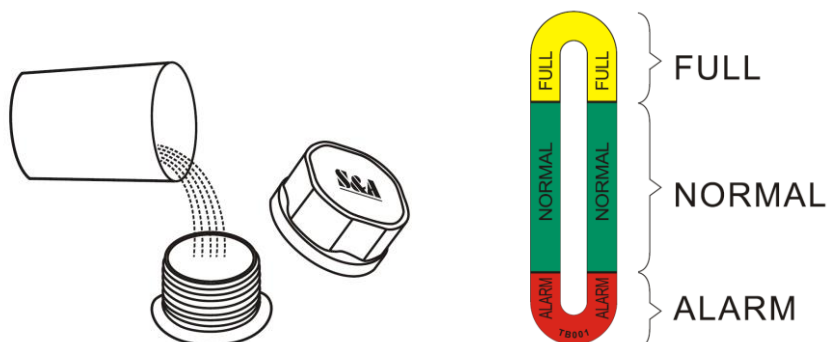


3.8.5 Connecting the Cooling System

- ① Open the Toolbox, and then take out the water pipes, water-error signal cable and chiller power cable.
- ② One of the water pipes, please connect to the water chiller where marked as "OUTLET", the other side of the pipe connect to the machine where marked as "Water IN".
- ③ The other pipe, please connect to "INLET" of water chiller and "Water OUT" of machine.
- ④ The Water-error signal cable, please connect to "ALARM OUTLET" of water chiller and machine.
- ⑤ The chiller power cable, please connect to the chiller.



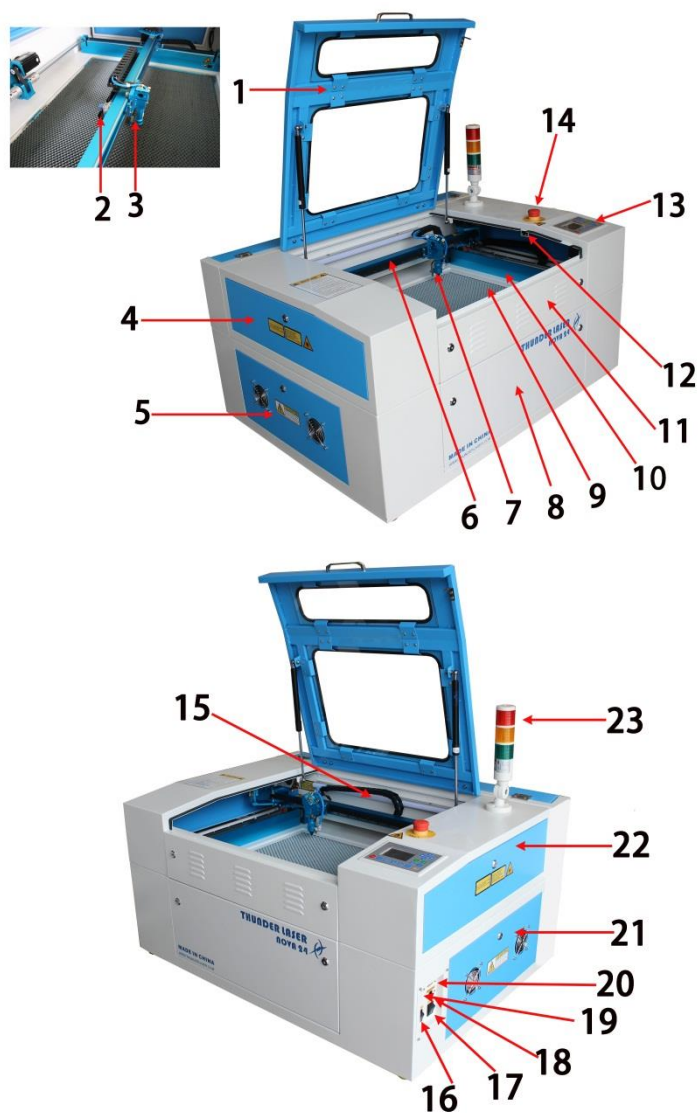
- ⑥ Add pure(distilled) water into the chiller until the water level in the green area showing on the gauge. Run chiller for a period of time, the water will fill into the laser tube on the machine, please re-add water to keep the water level in the green area.

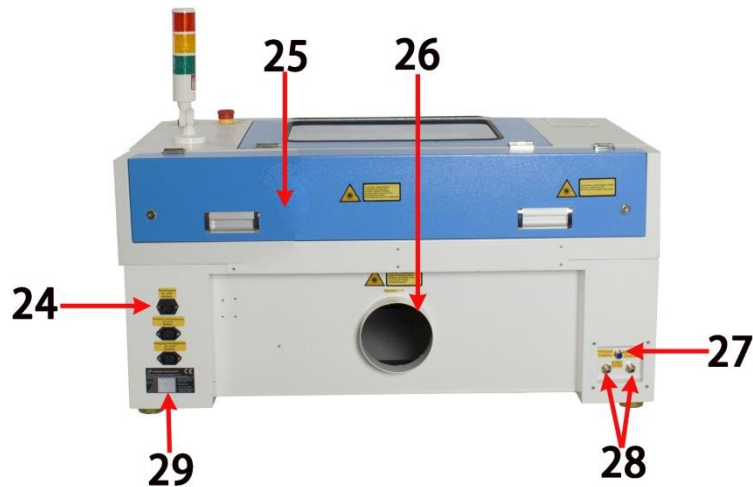




Chapter4 Operation

4.1 Machine View





- | | |
|---------------------------------|---------------------------------|
| 1. Top lid | 16. Laser power switch |
| 2. Hand valve Pneumatic Fitting | 17. Main power switch |
| 3. Auto focus sensor | 18. Ethernet port |
| 4. Left-up side door | 19. U-disk connection port(USB) |
| 5. Left side door | 20. PC connection port(USB) |
| 6. X-axis | 21. Right side door |
| 7. Laser heads | 22. Right-up side door |
| 8. Front door | 23. Indicate light |
| 9. Honey comb table | 24. Power supply socket |
| 10. Y-axis | 25. Laser tube cover |
| 11. Front up door | 26. Exhaust hose |
| 12. Flap protection sensor | 27. Blow air port |
| 13. Control panel | 28. Water in and water out |
| 14. Emergency stop switch | 29. Manufacturer's label |
| 15. LED lamp | |

1. Top lid

If the Top lid is opened, no data is processed. When the protection cover is opened during working, the motion system is stopped and the laser source is turned off. During processing of commands the protection cover must only be opened after pressing the "Pause "button.

2. Hand valve Pneumatic Fitting

It's used for adjust that blow air amount.

3. Auto focus sensor

Used for the automatic focusing of the work table.

4. Left-up side door



Open this door for cleaning the second reflective mirror or align that laser beam

5. Left side door

There is laser power supplier, Ammeter, TL-Timer etc. please open this door for checking these parts, but must pay attention to the electric current.

6. X-axis

The motion system is that performs the mechanical movements in X direction. The X-axis is visible in the working area.

7. Laser head

Laser beam and red dot pointer are all come out from the laser head, and the Auto Focus switch is installed on the laser head, too. The bottom of laser head is parallel to the bottom of the autofocus switch.

8. Front door

Open this door for cleaning the waste after working.

This door is locked by using two outside locks.

9. Honey comb table

The honey comb plate to be processed is put onto the working table. Put the material on the working table for engraving & cutting

10. Y-axis

The motion system is that performs the mechanical movements in Y direction. The Y-axis is visible in the working area.

11. Front up door

Open this door for take out the honey comb table and it's convenient to put that material on working table

This door is locked by using inside screws and outside locks.

12. Flap protection sensor

This is where Open flat protection exist. Laser will stop working once the cover is opened during working.

13. Control panel

You can control the X-axis, Y-axis and Z-axis manually by the display panel, it also shows the working time, power, speed and the whole working time and affords many function options(please view this chapter 4.3 for detail).

14. Emergency stop switch

Once there's an accident happen (laser catch fire, laser out leakage) during working, please turn off this switch immediately. It will be cut off the laser power and motion



power immediately.

15. LED lamp

It's used for lighting the working table once turn the Main switch on.

16. Laser power switch

The laser power will be on while you turn it on

17. Main power switch

The laser machine will be start while you turn it on

18. Ethernet port

This Ethernet port is for connecting computer.

19. U-disk connection port(USB)

You can save the file as a U-disk File by press "SaveToUFile" on the software, then save it to the u-disk and insert the u-disk to the port of laser machine, then use the control panel to select and control it to work

20. PC connection port(USB)

This USB is for connecting computer.

21. Right side door

There are laser controller, driver(Hybrid Servo Drive and Micro Stepper Drive), power suppliers (both 24v DC and 36vDC), the main connecting cables and cooling fan here, please open this door for checking these parts, but must pay attention to the electric current. if you need to repair, please contact with professional maintenance staff.

22. Right-up side door

Maintenance for the Emergency stop button if required

This door is locked by using outside locks.

23. Indicate light

The light is always keeping green color while the laser does not work or working but the lid is closed.

The light will turns to red color while the lid/cover is opened during working.

24. Laser supply socket

To connect the main power and the extend power according the label information. And in the main power socket have the fuses.

25. Laser tube cover

There are installed the laser tube, red dot pointer device, beam combiner and the first reflective mirror mount.



26. Exhaust hose

This is for installing the exhaust device.

27. Blow air port

This port is for connecting hoses of the air compressor.

28. Water in and water out

Both ports are for connection with water pump or water chiller.

29. Manufacture's Label

It's Show you the laser information like serial number or manufacturing date etc.

4.2 ON/OFF Switch

The mains and the laser supply power ON/OFF switch

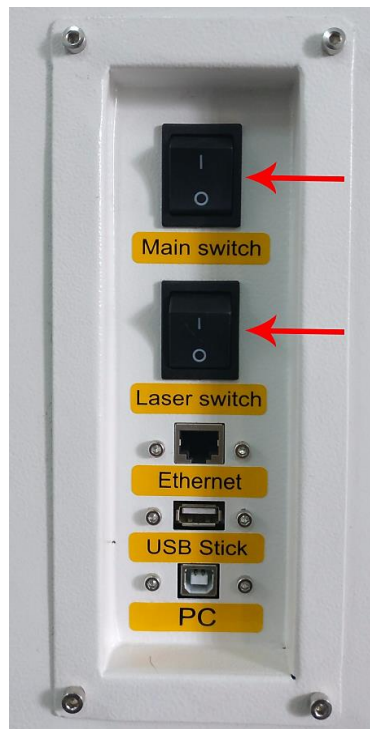
The following conditions must be fulfilled for correct start up:

Unrestricted freedom of motion of the mechanics

No materials under the engraving table

Protection covers closed

When turn on the power of machine, and note that turn on the main switch first and then the laser supply power switch



If all covers are closed, immediately after being switched on, the device starts the referencing process. When the referencing process is completed correctly, an acoustic signal sounds and the device is ready for operation. The operation panel will display the home screen when the laser is completed resets.



Before switching on the device, the user must make sure that no objects of any kind are located inside the operating space, which could limit or obstruct the mechanics of the device.

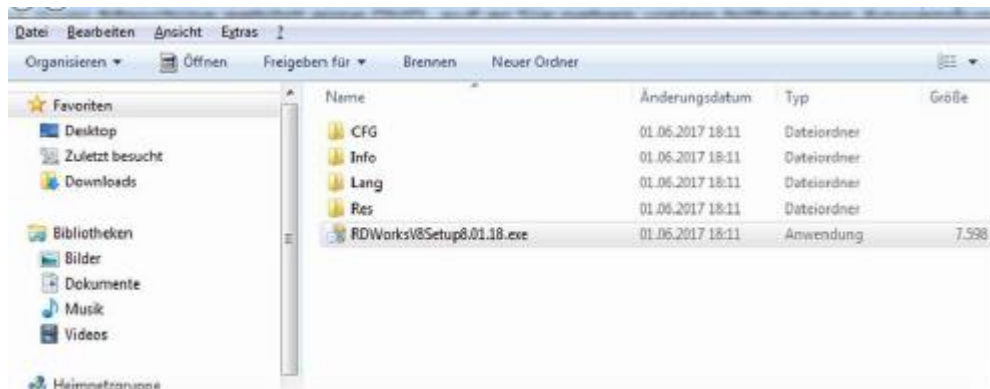


4.3 How to setup the software

4.3.1 Software installation

Your machine comes with a USB flash drive, which you will find many helpful application videos and instructions as well as the software for your machine.

To install the software, insert the USB flash drive into your PC and open the "Software" folder on the USB flash drive.



In this folder you will find the installation file "RDWorksV8Setup8.01.43.exe". Run this file by double-clicking on your PC.

Follow the installation menu until the window "Welcome to use" opens, like below.



If you use USB cable connection, please install the USB driver.

The type of the program offers different possibilities:

1. LaserWork: If you select this option, the laser software RDworksV8 will be installed on your computer.
2. CorelDraw_Laser: If you work a lot with Corel Draw, you can transfer your images and drawings directly to RDworksV8.

How to install the coreldraw plugin for RDworksV8, click below link for instruction

<https://www.thunderlaser.com/troubleshooting/software-problem/how-to-install-the-coreldraw-plugin-for-rdworks.html>



3. AutoCAD_Laser: Select this option to install a plugin that can transfer the drawings directly from AutoCAD to RDWorksV8.

4. EngraveLab_Laser: Select this option and install a plugin that can transfer the drawings directly from EngraveLab to RDWorksV8.

Origin (zero point): This is specified by the machine and must always be selected "top-left" for Thunderlaser machines.

Size unit: Here you can choose between millimeters and inches.

Select installation path: Here you can select a different installation directory for your laser software. We recommend that you use the default settings, otherwise some operating systems may restrict the functionality of the software due to misinterpreted access rights.



After selecting your options, click "Install" and then brings up a window "Install Finish!".

You can confirm this and then end the installation process.

A "RDWorksV8" icon will be automatically added to your Desktop, you are now ready to use the RDworksV8.



Trouble shooting for RDworks installation.

If you were unable to install the RDworks, it's possible that your Anti-Virus software is blocking installation.

Please disable all Virus and Spyware Protection Features. After the RDworksV8 has been installed go back into your Anti-Virus software and re-enable the setting that was disabled.



4.3.2 Make connection between PC and machine

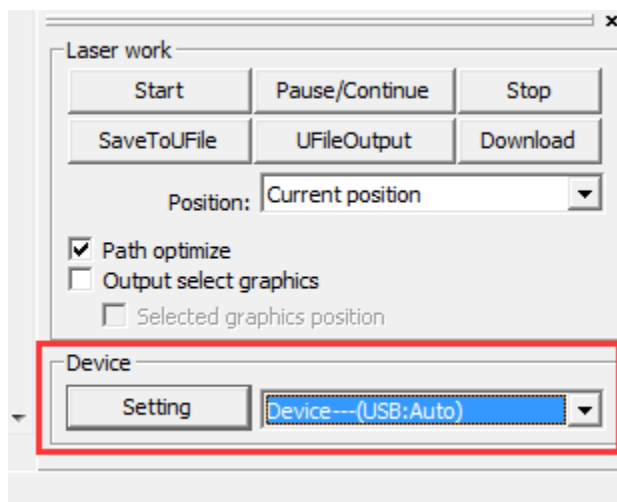
- USB cable connection

Make sure that you have the USB driver installed during the installation process.



Make sure that you have your PC connected to the machine via USB cable,

Open RDworks, from right bottom corner of the software, set up the Device by Setting>>Device --- (USB: Auto).



Your PC is now connected to the machine.



When connecting the machine and the PC for the first time, it may take a few minutes for the operating system to recognize the machine and install the driver.

- Ethernet cable connection

Make sure that you have your PC connected directly to the machine via Ethernet cable,



The machine is already assigned an IP address when delivered:
192.168.1.100

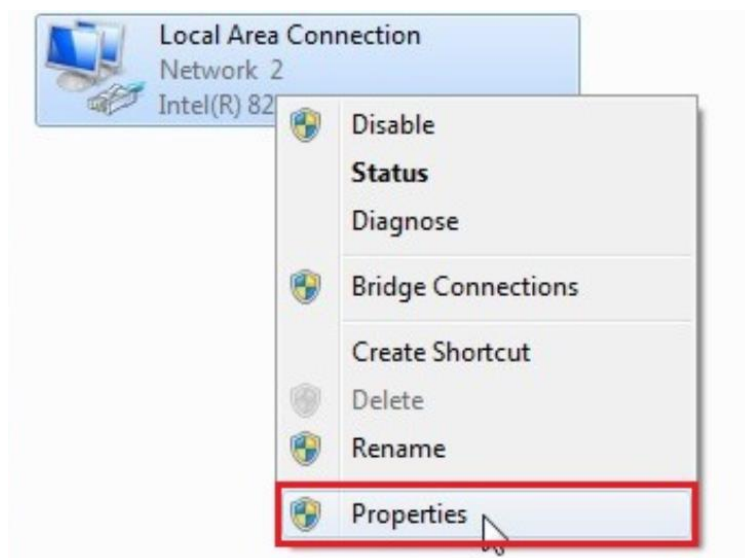
Now set up your PC so that it is in the same network and can communicate with the machine.

Please follow the instructions below for the setup process (For Windows7):

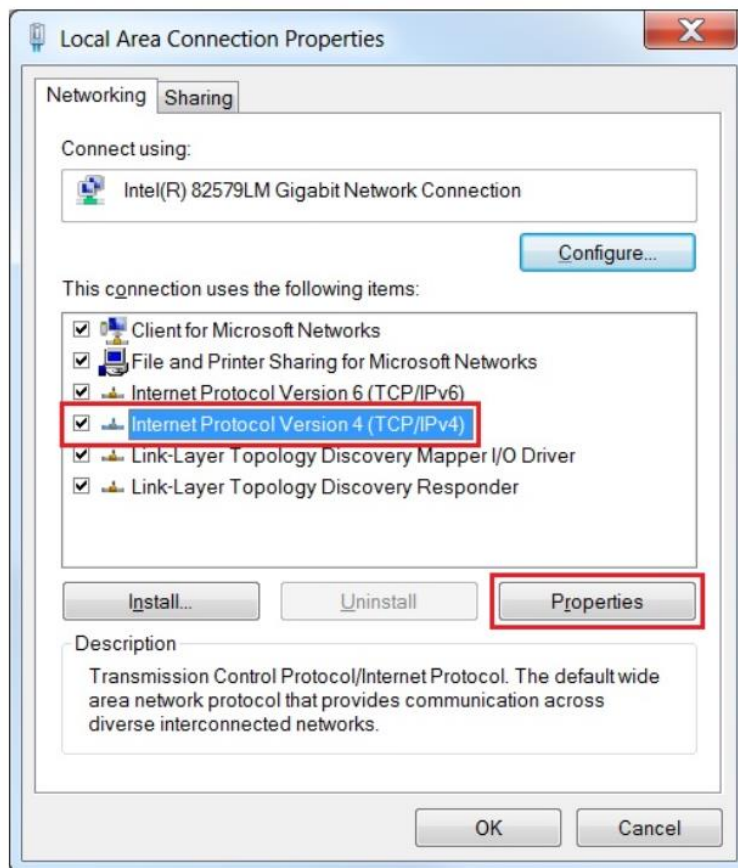
- 1). Click Windows Start > Control Panel.
- 2). Click **Network and Internet > Network and Sharing Center**. In the left pane, click **Change adapter setting**.



- 3). Right click **Local Area Connection** and then select **Properties**.



- 4). Under **Networking** tab, choose **Internet Protocol Version 4 (TCP/IPv4)** and then click **Properties**



5). In "Internet Protocol Version 4 (TCP/IPv4) Properties" window, Select "Use the following IP address:"

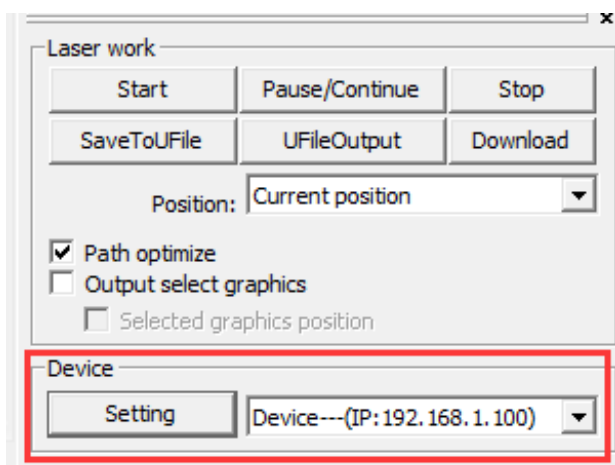
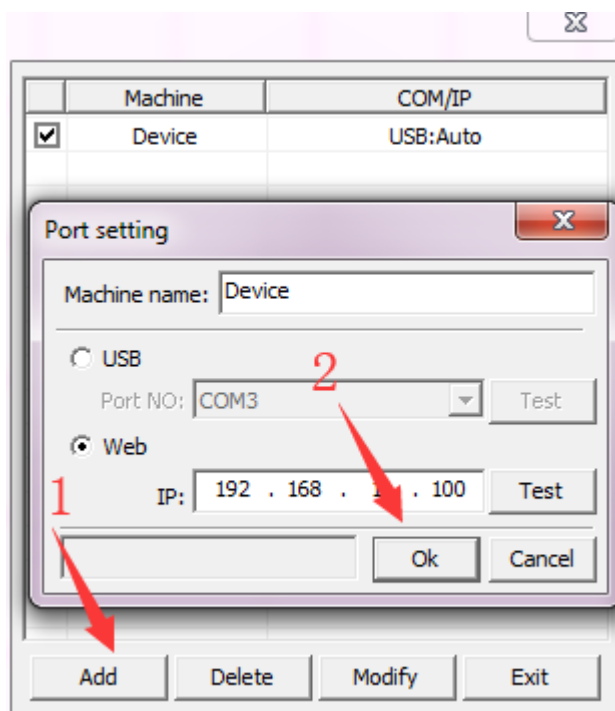
Type IP Address: 192.168.1.1

And Type subnet mask: 255.255.255.0

Then click OK.

With this you have successfully created the prerequisites so that the machine and the PC can communicate via LAN.

Now open your RDWorks from right bottom corner of the software, set up the Device by Setting>>Device --- Add a "Device---(IP:192.168.1.100)".



Now RDWorks communicates with your laser machine via LAN.




4.4 How to use the display


4.4.1 Function of the Buttons




- ✧  Arrow buttons: control the movement of the laser head.(also can be used to change the parameters in the control panel)

- ✧  Z/U button: The Z/U key can be pressed when the system is idle or the work is finished. On pressing this key, it will show some entries in the interface, each entry includes some functions, Z axes move, U axes move, each axes to go home etc.









- ✧  Reset button: Reset the machine.

- ✧  Pulse button: Pulse a laser beam.

- ✧  Speed button: Set the speed of the current running layer, or *set the arrow*



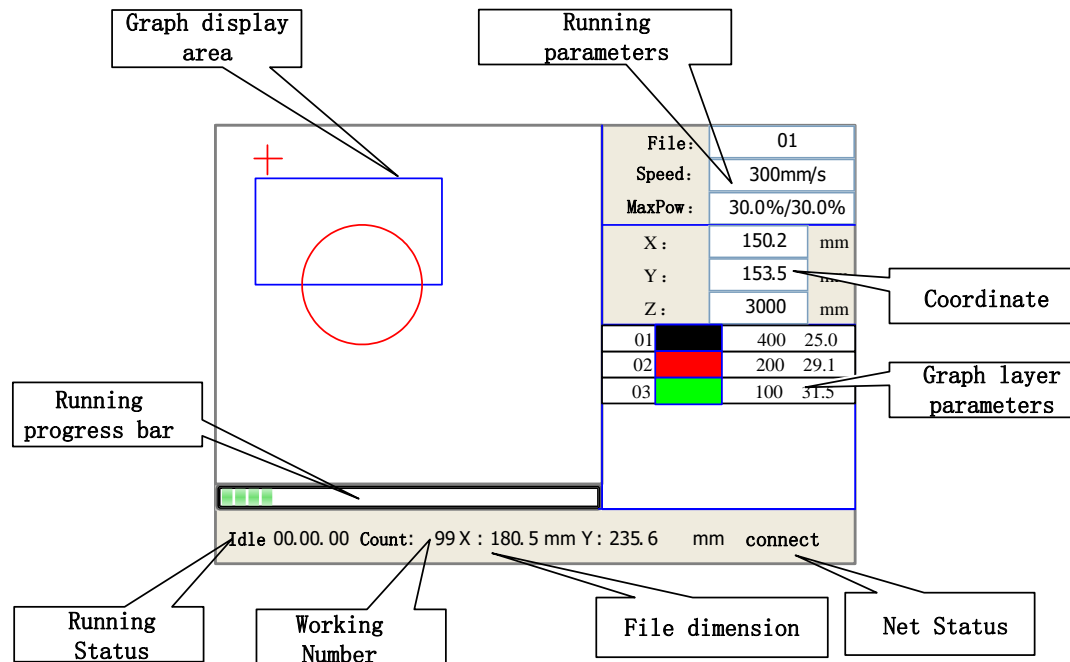
buttons' move speed.

- ✧  Min-Power button: Set the min laser power of the current running layer.
- ✧  Max-Power button: Set the max laser power of the current running layer, or set the power of "pulse" button.
- ✧  File button: The management of the memory and U disc files.
- ✧  Start-Pause button: run/pause the current job.
- ✧  Origin button: set the starting point for the laser head.
- ✧  Frame button: To track by the current file's frame.
- ✧  Esc button: To stop work, or return to the last menu.
- ✧  Enter button: confirm your selection.



4.4.2 The main interface

When the system is powered on, the screen will show as below:



- Graph Display Area: To display the whole file's track, and display the running track.
- Running parameters: To display the running file's file number, speed, max power etc.;
- Coordinate: To display the current coordinate of X,Y and Z axes
- Graph layer parameters: To display the layers' information of the current file, such as max or min power, speed etc.. When system is idle, dblclick the layer, then users can change the layer's parameters and the changing would be saved.
- Running Status: To display the current status of the machine, such as Idle, Run, Pause, Finish, etc.;
- Running Progress Bar: To display the progress bar of the current running file;
- Working Number: To accumulate the work number of the current file.
- File Dimension: To display the dimension of the current file;
- Net status: To display the connecting status of the Ethernet.

When work is Idle or finished, all buttons can be clicked, users can select a file to run, set some parameters, preview to a select file etc. But, when work is running or paused, some buttons don't respond when they are clicked.



4.4.3 Speed button

Speed: mm/s

Modified press Enter



The speed can be set from 1~1000mm/s.

4.4.4 Max Power buttons

MaxPower1: %

MaxPower2: %

Press Z/U move item

Modified press Enter



The max power can set the power for pulse button to shoot the laser beam, and max power2 is only for the double laser tube machine.

4.4.5 Set the Layer Parameters

After selecting a file to preview on the main interface, user can click "Enter" button to modify the parameter for the file from the machine.



01		400	25.1
02		200	29.1
03		100	31.5

Layer0:

Speed: mm/s

MinPower1: %

MinPower2: %

MaxPower1: %

MaxPower2: %

Press Z/U move item
Modified press Enter

4.4.6 Z/U button

The Z/U button can be pressed when the system is idle or the work is finished. On pressing this button, it will show some entries in the following interface:

Z move	Language+
U move	IP setup+
Axis reset+	Diagnoses+
Manual Set+	Screen Origin+
Laser Set+	
Origin set+	
Set factory para	
Set default para	
Auto Focus	

- Z Move: When the green block is on “Z Move” item, to move the Z-axis table up and down by pressing left and right arrow button.



- U Move: When the green block is on “U Move” item, to control the rotary attachment to turn by pressing left and right arrow button.
- Axis Reset+: When the green block is on this item, you can manually reset the axis if needed.
- Set default para: To recover all manufacturer parameters and user parameters for your machine
- Auto Focus: To use the auto focus function.
- Language: The item “Language” helps you to select a appropriate langue which is displayed on the panel:
- IP Setup: The machine is already assigned an IP address as 192.168.1.100, and the IP address on software should be the same while communicate
- Diagnoses: the “Diagnoses” interface shows some system input information, such as limiter status, the status of the water protecting, and the status of the door protection etc..

4.4.7 File button

1). Memory File

On the main interface, if “File” button is pressed, it will show as below:

File:	Count:	<input type="button" value="Read mem file"/> <input type="button" value="Udisk+"/> <input type="button" value="Other+"/> <input type="button" value="Run"/> <input type="button" value="Track"/> <input type="button" value="Work time"/> <input type="button" value="Clear count"/> <input type="button" value="Delete"/> <input type="button" value="Copy to udisk"/>	File:	01	
01	400		Speed:	300mm/s	
02	200		MaxPow:	30.0%/30.0%	
03	100		X:	150.2	mm
			Y:	153.5	mm
			Z:	3000	mm
Idle 00.00.00 Count: 99 X: 180.5 mm Y: 235.6 mm connect					

When showing this menu, the system would read the memory file firstly, the file name and the work times would be listed in the area, and the selected file is previewed in the bottom right area. “Y+/-” keys could be used to move the cursor on the file name list. When the cursor is on a target file name, presses the “Enter” key, the selected file will be previewed on the main interface, and then if “Esc” key is pushed, the preview will disappear.

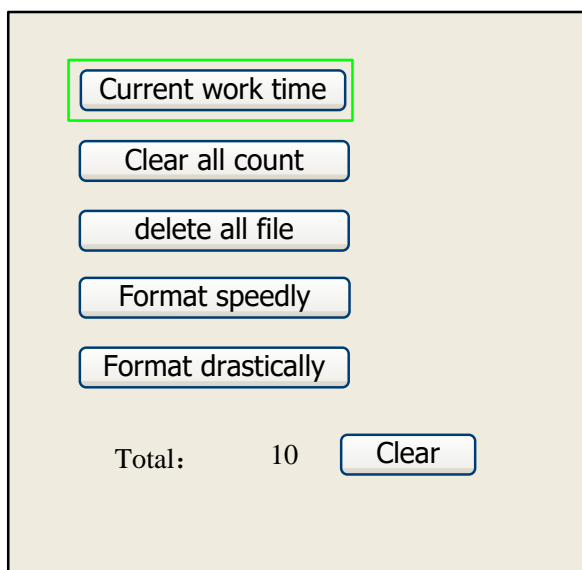
“X+/-” keys could be used to move the cursor left and right. All the item show as below:

- **Read mem file:** read the memory file list;
- **Udisk:** read the U disk file list;



- **Other:** the other operation of the memory files;
- **Run:** To run the selected file;
- **Track:** To track the selected file, and the track mode is optional;
- **Work time:** To forecast the running time of the selected file, and the time is accurate to 1ms;
- **Clear count:** To clear the running times of the selected file;
- **Delete:** To delete the selected file in the memory;
- **Copy to Udisk:** To copy the selected file to Udisk;

If the “Other” entry is pressed, the system will show as below:

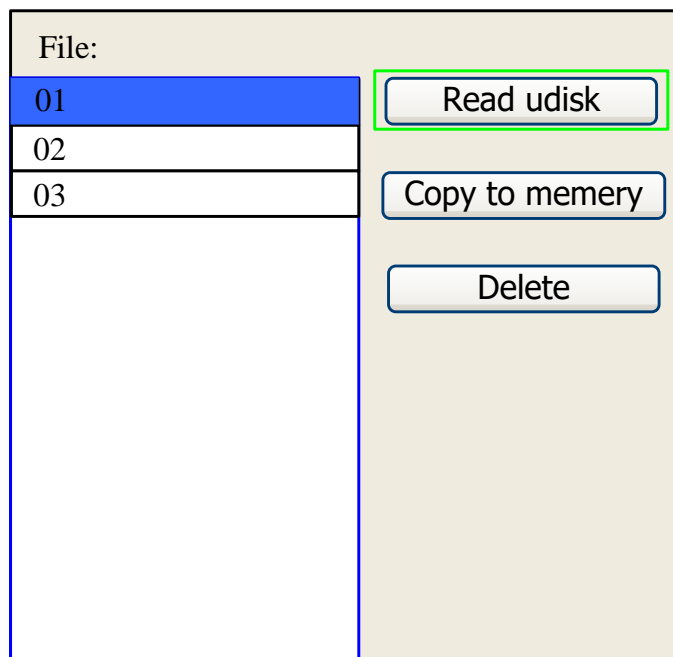


- **Current work time:** To forecast the running time of the current file(the current file No. is showed on the main interface), and the time is accurate to 1ms.
- **Clear all count:** To clear the running times of every file in the memory
- **Delete all file:** To delete all memory files
- **Format speedily:** To format memory speedily, and then all the files in memory will be deleted.
- **Format drastically:** To format memory drastically, and then all the files in memory will be deleted.

Total: the total running times of all the files.

2). U-Disk File

If the “U-disk+” entry is pressed, you can copy your file from USB flash drive to your machine.



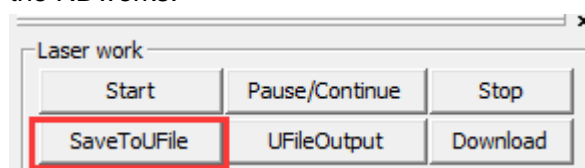
- **Read Udisk:** read the file list in the Udisk;
- **Copy to memory:** copy the target Udisk file to the memory;
- **Delete:** delete the selected Udisk file;



The controller can only compatible with USB 2.0 and at most 16G USB flash drive.

For USB flash drive, you can use the one came with the machine to copy the file to your machine

The file should be .rd file and it's created by the "SaveToUFile" key on the RDworks.





4.5 How to use the different nozzles laser head cone

The standard laser head is equipped with a 2 "(50.8mm) focusing lens and focuses the laser beam to a diameter of about 0.14mm (when using a glass laser tube).

With this laser head, you can perform fine engraving work (such as letters with 1.5mm height) and cut materials up to 10mm thickness with good quality (depending on the laser power of the machine).

The standard laser head is supplied with 2 air nozzles laser head cone.



A nozzle has a very narrow outlet (approx. 2mm), which provides high air flow to blow directly on the cutting gap. This nozzle is excellently suited for cutting wood, as this prevents soot formation in the cutting gap.

The other nozzle has a large outlet (approx. 6 mm), which provides the air assist to blow the material more slowly and not directly on the cutting gap. This nozzle is excellently suited for cutting acrylic, as this prevents white mark in the cutting edge. Besides, when engraving wood, for example, particles that have been removed and smoke / gases are gently distributed and extracted in the working area. So you get a clean, almost unaffected by smoke traces engraving.



The 6mm nozzle laser head cone are placed inside the toolbox.

4.6 How to replace the 4 inch and HR laser head

Both 4 inch laser head and HR laser head are option item.

The 4 inch laser head is suitable for cutting materials with a thickness > 10mm.

With this look, you can achieve vertical cuts in 20 or 30mm thick materials, such as PU foam, acrylic or wood.

The High Resolution head can focus the laser beam much finer than the standard laser head.

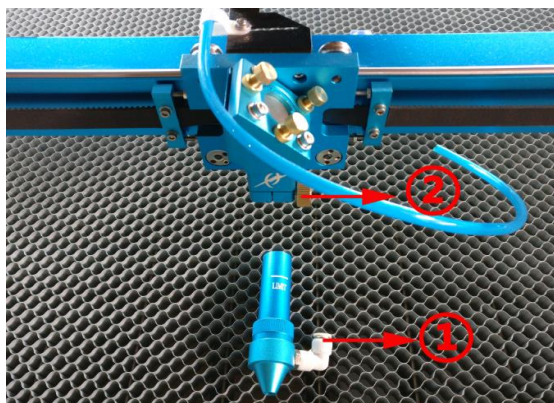
This allows very delicate engraving or extremely precise cuts in films, cardboard or paper.

For cutting materials thicker than 1mm, the HR head is not suitable.

1) How to replace the 4 inch laser head

1. Move the table down till there's enough space to take the standard head out and install the 4" laser head.

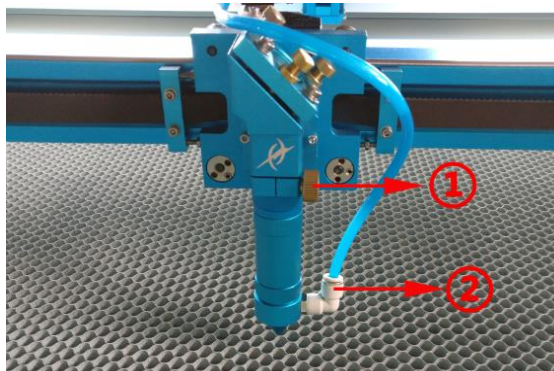
2. Remove the standard head like below:



① Take out the air hose

② Loosen the screw

3. Install the 4" laser head like below:



① Fix the laser head

② Connect the air hose

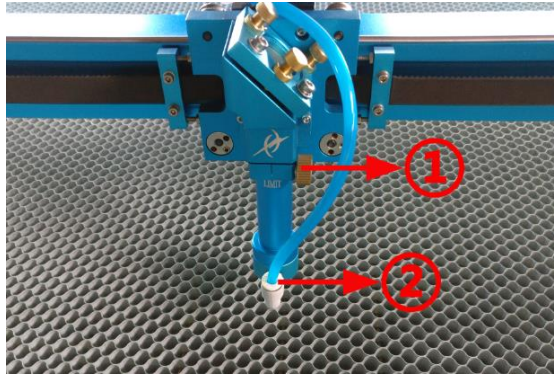


Please always insert the 4" laser head as far as it will go.

2) How to replace the HR laser head

1. Move the table down till there's enough space to take the standard head out and install the HR head.

2. Install HR head, like below:



① Fix the laser head

② Connect the air hose



Since HR head is sensitive for focus distance, it's suggested to adjust the focus by manual rather than auto focus.

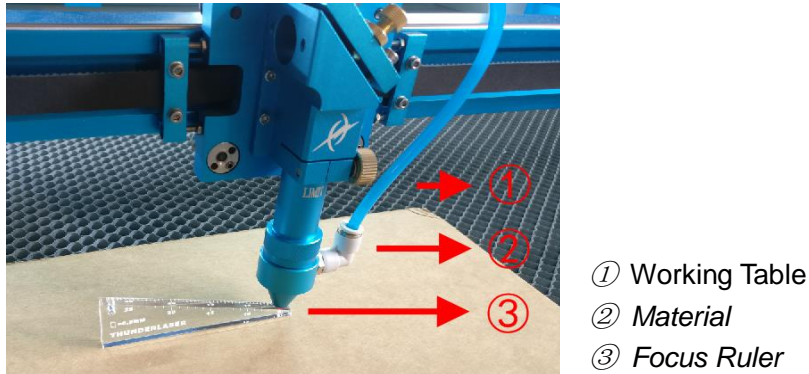
4.7 How to adjust focus distance by manual or auto

1) How to adjust focus distance by manual

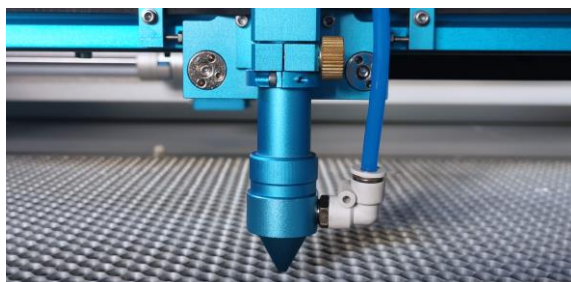
1. Standard laser head:

The focus distance between the standard laser head and the material is 6mm.

Find the 6mm thickness Acrylic Focus Ruler for help to adjust the focus directly like below:



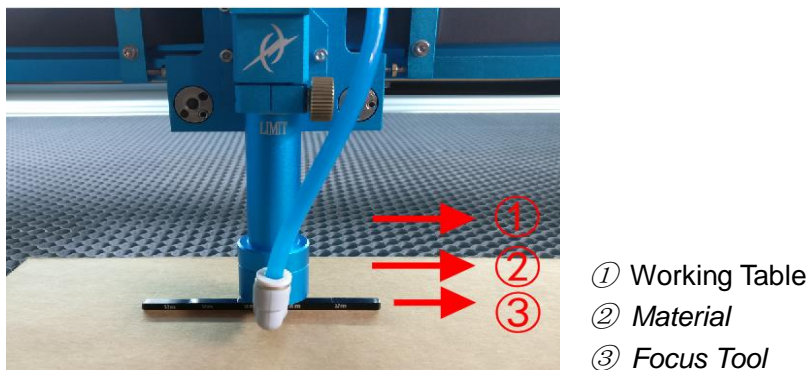
Please note that the limit line of the head, this limit line indicates the max height of laser head, and keep the limited line inside the laser head mount. So as to protect the laser head from crashing into the honey comb table while z-axis does reset/auto focus



2. HR laser head

The focus distance between the HR laser head and the material is 3.5mm.

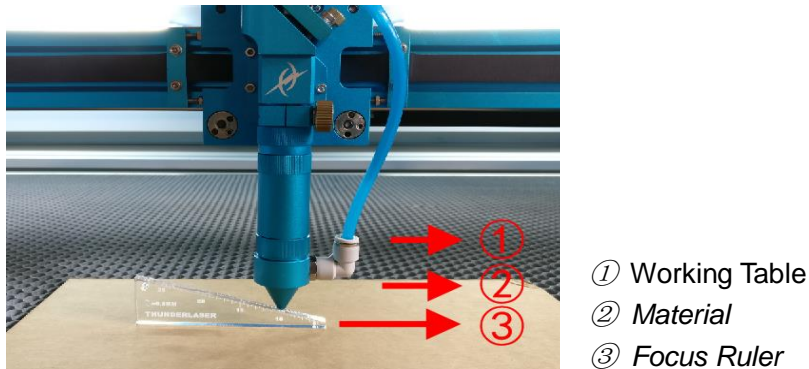
Since HR head is very sensitive for focus distance, thus we've tested and made a special focus tool (with a best distance) for each HR head, like below:



3. Four inch laser head

The focus distance between the 4" laser head and the material is 10mm.

4" laser head is not so sensitive for focus distance; you can set the distance about 10mm~12mm with the help of focus ruler, like below:



Please always insert the 4" laser head as far as it will go.

2) How to adjust focus distance by Auto

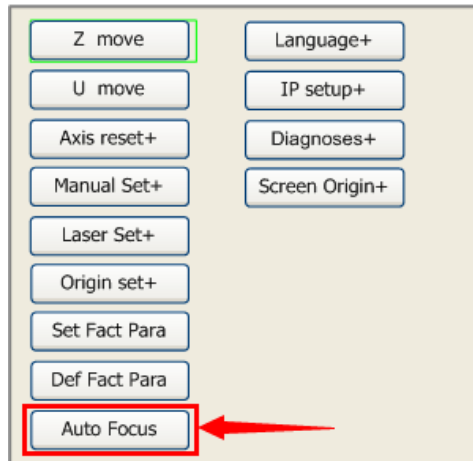
The Standard laser head will be provided with a stop ring. Always insert the laser head as far as it will go, so that the correct focus distance is set during automatic focusing.



Move the table down till there's enough space, then place the material between the auto focus sensors.

Make sure you always insert as far as the laser head stops by the ring.

After that, go into Z/U button>>Select Auto Focus.



Do not use “auto focus” function while using HR laser head or 4” laser head.

Do not use “auto focus” function while using the transparent material.

Also you can refer to the video instruction below:

<http://www.thunderlaser.com/how-to-use-your-laser-machine/how-to-use-auto-focus.html>



4.8 How to use the TL-Timer

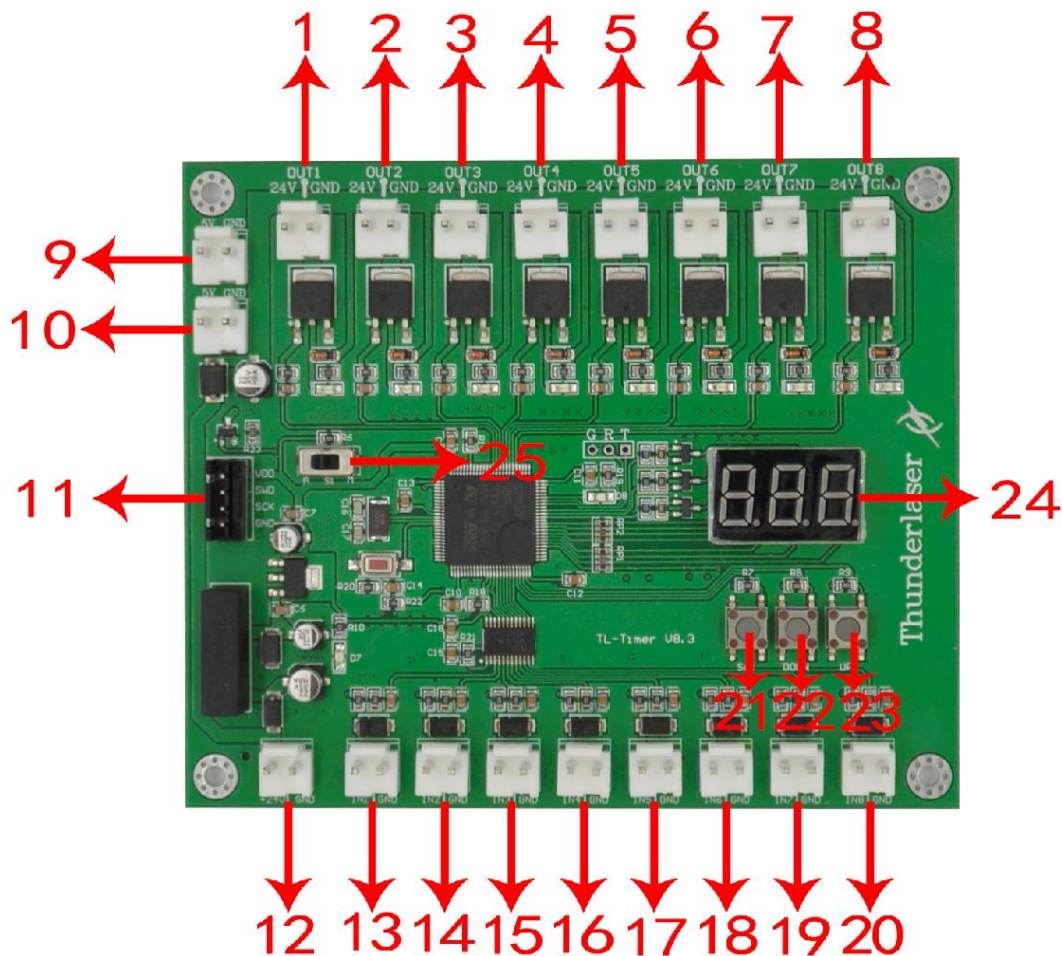
The TL-Timer is an additional tool for laser machines.

It will control laser machines periphery like air pump, exhaust fan, warning lights, heat alarm detector, electrical locks and lot of other stuff automatically.

This will increase the ease of use of your laser machine.

Please note the different types of connection, which makes the TL-Timer able to work with each kind of laser controller.

About TL-Timer controller interface and buttons description:



1. OUT1: Control the green light of warning light; When the machine is not at work, the warning light is in green color;
2. OUT2: Control the red light of warning light; When the machine is working or getting around alarm message on LCD panel, the warning light turns red;
3. OUT3: Control the exhaust fan; Delay shutdown is set to 15 second (Factory default settings, change it if required) ;
4. OUT4: Control air assist with "Low volume"; Delay shutdown is set to 10 second (Factory default settings, change it if required) ;
5. OUT5: Control air assist with "High volume"; Delay shutdown is set to 10 second



- (Factory default settings, change it if required) ;
6. OUT6: Control the fire alarm system; When A high temp is detecting on working area, the alarm system will be active, the warning light alarms and the machine stops working immediately;
 7. OUT7: Control the power for rotary device;
 8. OUT8: Spare interface;
 9. 5V DC Voltage Power Output 1, control the power for red light pointer.
 10. 5V DC Voltage Power Output 2, spare interface;
 11. Upgrade interface;
 12. 24V DC Voltage Power Input;
 13. In1, "Working state" interface
 14. In2, Reset interface;
 15. In3, Air-assist mode selection;
 16. In4, Control air assist with "Low volume";
 17. In5, Control air assist with "High volume";
 18. In6, Temperature detection
 19. In7, Rotary connection state detection
 20. In8, Spare interface
 21. "Set" button, select each "OUT" interface and confirm the setting;
 22. "DOWN" button, reduce time of delay shutdown;
 23. "UP" button, increase time of delay shutdown
 24. LED lights display, set the delay time for viewing each interface and enter
 25. Auto and manual mode switch;

The TL-Timer is installed inside the lower right hand door panel, see below.

Operation:

Normal use:

The TL-Timer is selected Auto mode as factory setting.

Under Auto mode, when the laser is not at work, air assist and exhaust fan won't be on; When the laser is working, the air assist and exhaust fan starts, after the job finished, the air assist will stop after 10 second, exhaust fan will stop after 15 second.

Under Manual mode, when the laser is powered on, the air assist and exhaust fan will be on all the time

Each "OUT" interface has a freely adjustable delay time from 0-99 seconds.

Set up delay time:

Generally, there's only need to set up the delay time for air assist and exhaust fan, so they can be delay to shutdown according to your need. The default for air assist is 10 second, and for exhaust fan is 15 second.

Click "Set" button to select from OUT1 to OUT8 interface and the LED light display will show you the delay time in second for each interface. On each interface, click "down" or



“up” button you can change the value, then click “Set” button to confirm and go into the next interface. On the OUT8 interface, click again the “Set” button, the display will be off and exit the delay time setup.

4.9 How to use air-assist control

The Air-assist control is an additional tool for laser machines.

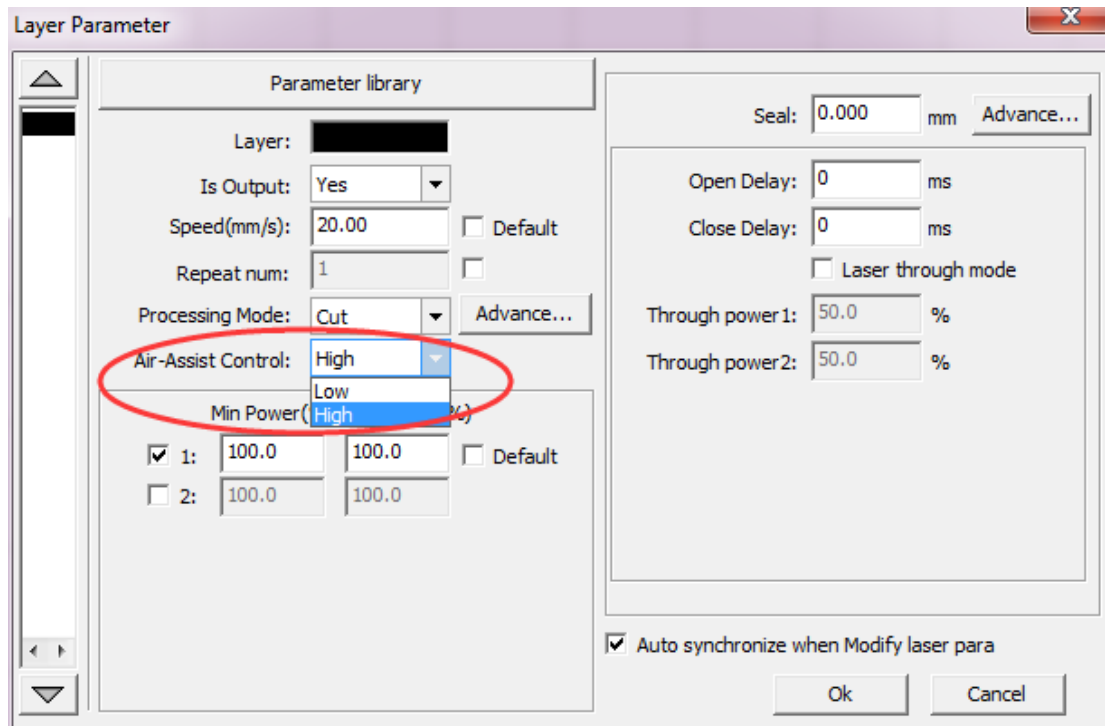
Generally, cutting needs the air assist with high air-volume but engraving needs the air assist with low air-volume.

Air-assist control is available in high- and low-volume for engraving and cutting-jobs via software-setting, this will increase the ease of use of your laser machine.



1) How to select the air assist with high volume or low volume?

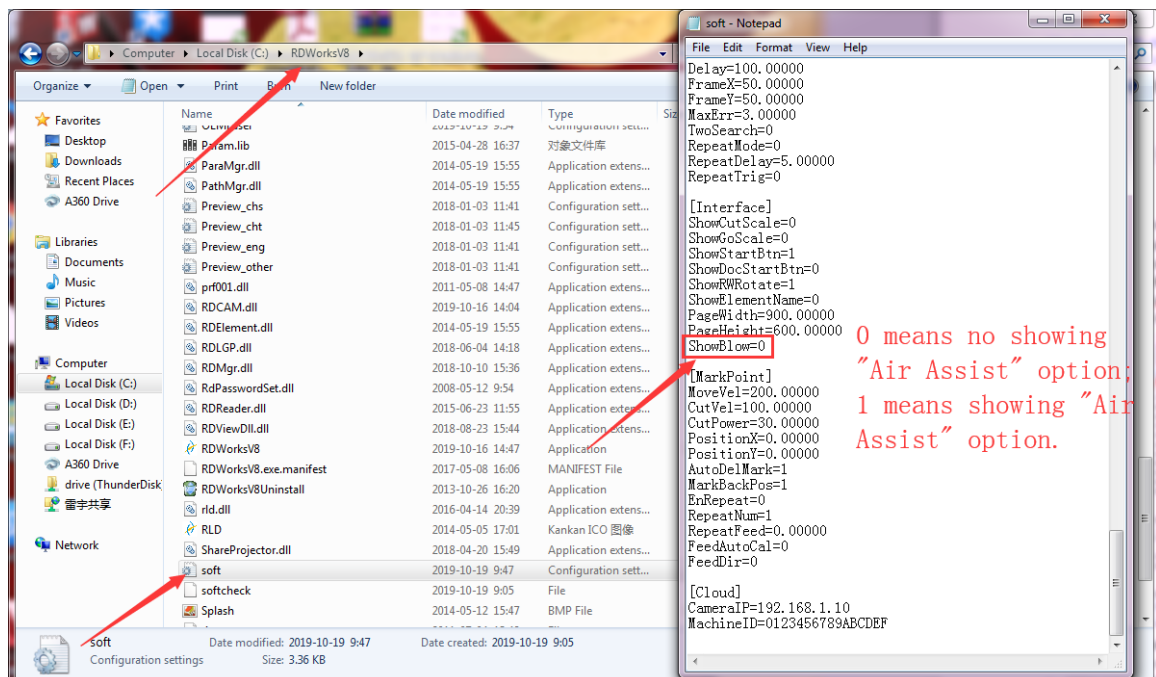
In RDwork software, high volume or low avolume is selected on the “Air Assist Control” option. We suggest select “High” for cut mode and select “Low” for scan mode(engraving mode).



You can also set default for “Air-Assist Control” option, so in cut mode, it will select High volume automatically, and in scan mode(engraving mode), it will select Low volume automatically.

How to set default for “Air-Assist Control” option?

Go into the RDworks’s root directory>>open the text file of “soft”>>change the setting of “ShowBlow”>>save the text file, like below.



2) How to adjust air volume if require?

For High volume mode,

1. Make sure machine is not at work and laser switch is off
2. Click the left green button to start the air-assist with high volume
3. Check the air volume under the laser head
4. On left flow control valve, loose the locked nut then rotate the adjusting screw to control the air volume to mean your requirements.
5. Fix the locked nut after finished.

And for Low volume mode, you do it the same.



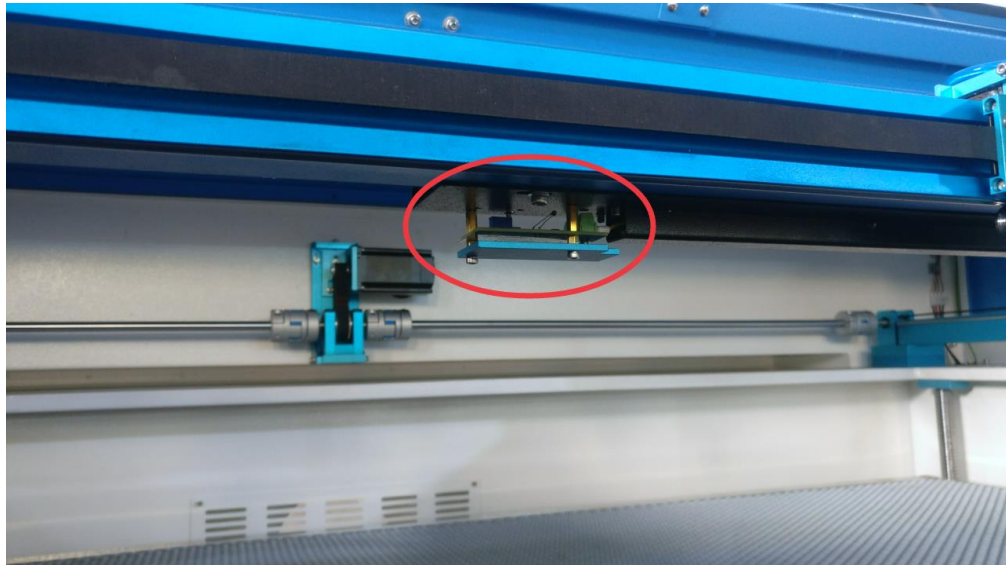
It will be the best if using big air compressor instead of air pump for air-assist.



4.10 How the heat alarm system works

The heat alarm system is an additional tool for laser machines.

Some materials such as acrylic, wood and so on, can easily catch fire, particularly during cutting, the heat alarm system have a temperature sensor board which will react the abnormal temperature(higher than 55°C/131°F) on material processing chamber. It will trigger at a certain temperature to stop laser processing and give a warning sound, so operator can active fire control in time to reduce the potential losses and risks.



4.11 The First Time Running the Laser



To be safe, never ever run the laser system unattended.



According to international standard, “O” means close; “I” means open for the rocker switch below

Yours first engraving tests

The following steps describe how to successfully engrave a first pattern. Please follow the individual steps:

1. First switch on the water chiller.
2. Switch on you Laser and wait for a beep to note the machine is initialized, and the laser head will do the reset and find the home from top left corner.**DO NOT** click “ESC” button to stop the system initialization.



When turn on the power of machine, and note that turn on the Main switch first and then the Laser switch.



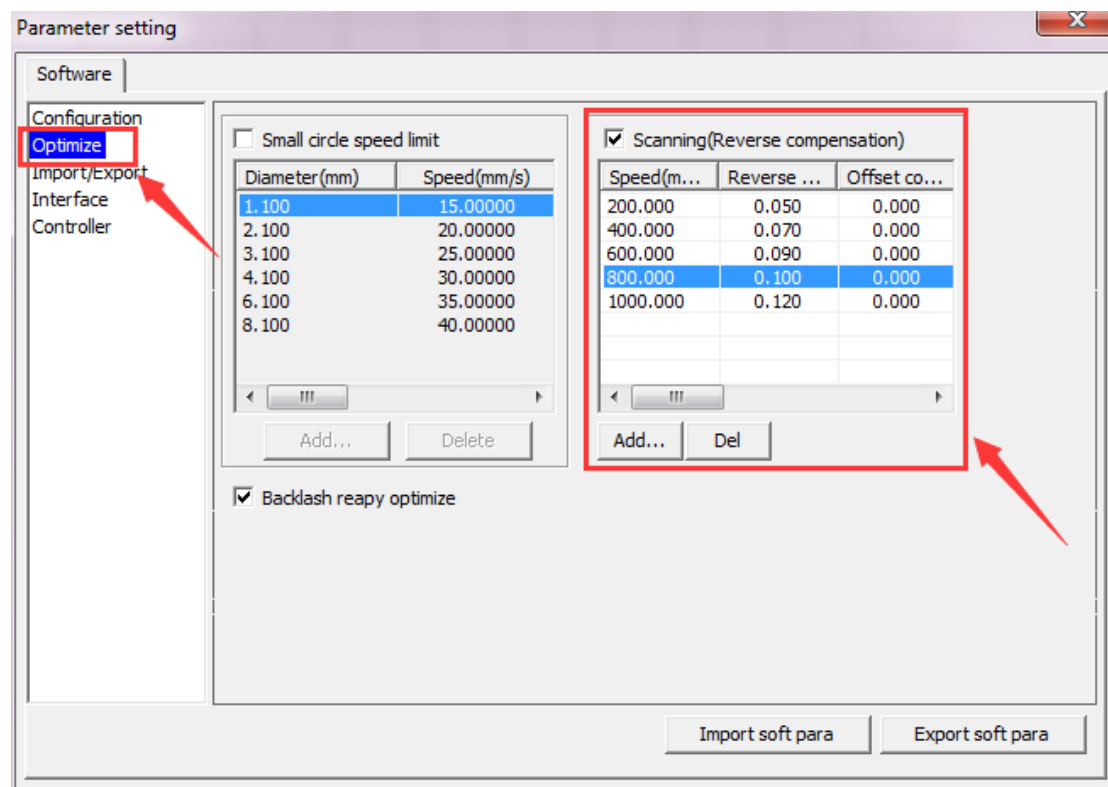
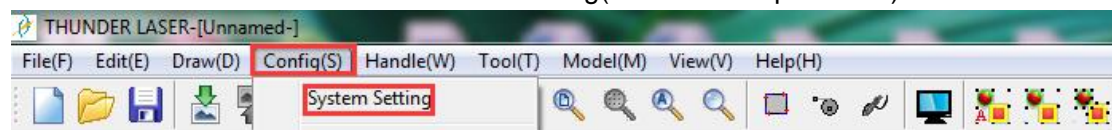
3. After machine finish resetting, adjust the height of working table, place the material usually on the top left corner of the working table.

- ① Click Z/U button;
- ② Select “Z move”;
- ③ Left arrow to move down;
- ④ Place the material;
- ⑤ Right arrow to move up;

4. With the help of the focus ruler, adjust the focus distance to 6mm between the bottom of laser head and the material manually by move up and down the working table.

Open the software RDworksV8. First to set up the values on the “Scanning(Reverse compensation)” check box.

5. Open Config(s)>>system setting>>Optimize>>Scanning(Reverse compensation), and there are some default values on the “Scanning(Reverse compensation)” check box.



The particular values are showing with a picture in the USB flash drive and on the Anodized aluminum piece that came with your machine.

Save those setting on the “Scanning(Reverse compensation)” check box.

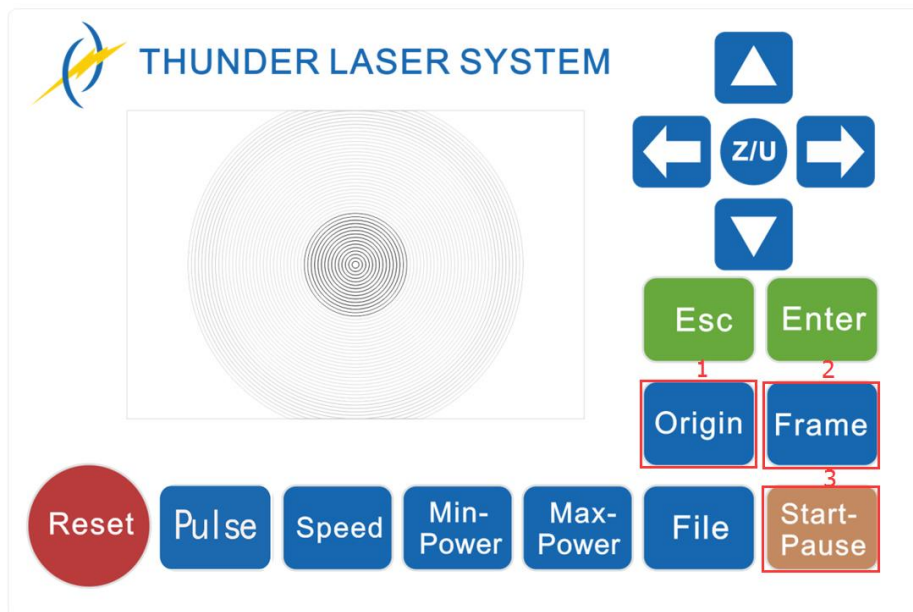
6. Create sample text for engraving directly on RDworks, then set up the parameter and download the file to your machine.

More details for how to use software please watch the instruction video below.

<https://www.thunderlaser.com/video/how-to-use-your-laser-software.html>



7. Click “Original” and “Frame” on the display, please make sure that the material is in the right location and there is enough space for working.



- ① Control arrow button to move the laser head;
- ② Click “Origin” button to select the start point;
- ③ Click “Frame” button to be sure the working area;
- ④ Click “Start-Pause” to run the program;

8. Please check the water cooling system is working properly; the water is running into and filling the laser tube. Please do not start your work if the laser tube isn't full of water, because that may led to laser tube damage due to the high temperature.

9. Finally press the “Start-Pause” button in the display, to start the engraving process.

10. While the laser is engraving, you can generate the next graphic.

11. When the engraving is complete, the laser machine will give out the notification sound and the laser head will go back to the original point, and the warning light will return to the green light, then you can repeat engraving.



4.12 Workstation Area Indication

Side view



**workstation
area
occupied
by
operators**

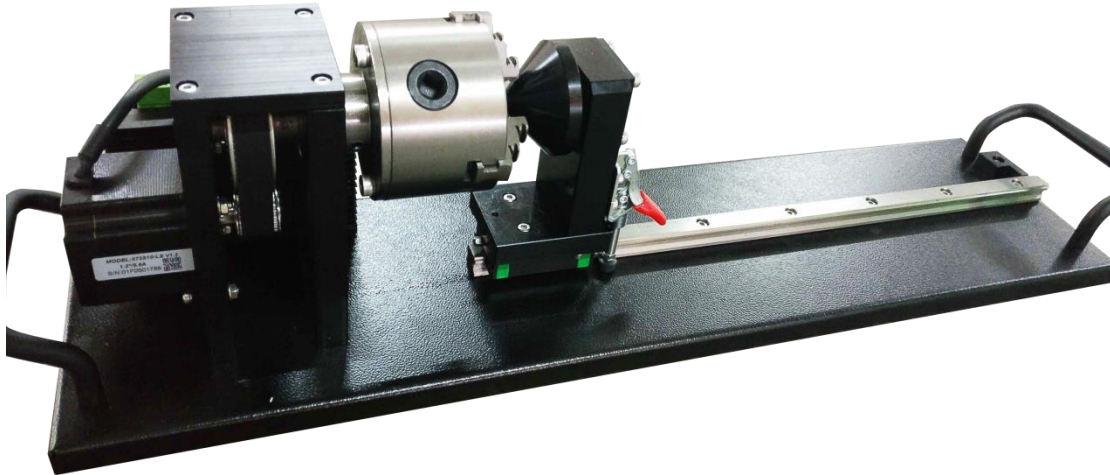
Plan view



**Workstation area occupied
by operators**



4.13 How to use the Rotary axis Attachment



To install and set-up the rotary axis attachment proceed as described as follows:

1. Move the working table to the lower position then switch off the laser and open the top lid.
2. Put the rotary axis attachment onto the working table and align the rotary attachment with the x-axis are parallel, with the jaw chuck closest to where the rotary attachment plugs in.
3. Connect the rotary axis attachment via the control cable with the connector of the motion system. The connector is located inside the right front of the laser. Connected it to this interface and fixed, and then you have finished the device connection. Like below:



4. Before you mount the object into the rotary axis attachment, measure the diameter of the object at the position to be engraved with a sliding caliper or a similar tool. Write down this value. For example: 80mm.
5. Adjust and fix the slider to make the work piece fitting into the rotary axis attachment.
6. Set your focus manually, carefully and safely. It is not recommended to use the auto



focus with a rotary axis attachment for the simple reason that you are not working with a flat object. Set your origin

7. Generate a graphic with the help of the graphics software. The graphics size must be adjusted until less than the dimensions of the work piece.
8. Select "Output", and then input the diameter of the object and the circle pulse. How to set up the parameter for "enable rotate engrave", please click below link for the instruction

<https://www.thunderlaser.com/uncategorized/rotary-axis-attachment-has-a-wrong-cylindrical-engraving-cutting-size.html>

9. Select "Download", click "Origin" and "Frame" on the LCD display, please make sure that the material is in the right location and enough space for working.
10. Finally press the "Start-Pause" button in the LCD display, to start the engraving or cutting process.

Also you can refer to the video of how the rotary axis works in our website:

<https://www.thunderlaser.com/how-to-use-your-laser-machine/how-the-rotary-axis-works.html>

4.14 For Laser Engraving

The engraving depth can easily be varied through the laser power or the speed. To increase the engraving depth, reduce the speed or increase the power setting. This way you increase the amount of energy per area unit. Engraving too deep, however, reduces the quality of the details. With coated materials the required power depends of the kind and thickness of the coating. With power set too high the individual lines become too thick and a sharp picture cannot be achieved. The resolution of the graphics should usually be at 500 dpi. The dpi setting (number of laser dots per inch) depends on the material. The lower this setting is, the lower the resolution of the engraved picture will be. This, however, reduces flaming and increases the energy of a pulse, which can improve the overall result (e.g. when engraving some sorts of plastic materials).

1. Plastics

Plastics for engraving are available in many different colors and thicknesses and with many different coatings and surfaces. The majority of available plastics can be well engraved and cut with the laser. Plastics with a micro-porous surface seem to give the best result, because less surface material needs to be removed. As most plastic materials have a low melting point, a low pip setting should be selected to reduce the danger of melting.

2. Acrylic

There are two different types of acrylic – cast and extruded. The cast acrylic becomes white or mat after engraving, the extruded acrylic remains clear. Use extruded acrylic for engravings that are filled with paint and cast acrylic for normal engravings. Cast acrylic can be best engraved without protection foil. It is better to engrave the entire surface with a low energy setting.

3. Engrave the rubber stamp

The various mixtures and densities of rubber plates cause a slightly varying engraving depth. The settings in the overview table give a good indication. Since engraving a standard rubber material requires a relatively high laser power, the laser power is principally set to 40% or more high and only the speed is varied. Due to their lower density, so-called micro porous rubber materials allow a significantly higher engraving speed. Test the rubber first, to find out the correct speed setting.

The RDWorksV8 software using the engraving function, you can choose “Ramp Effect” or common engraving, once you choose “Ramp Effect” and you will need to set a minimum power lower than Max Power, generally we set it to about 15%, and input a value with the Ramp Length what you want, but if you want to make it better, you may need to test different kinds of power and speed by yourself, then you can get the best result.

Engraving rubber produces a considerable amount of dust and terrible gas. Therefore a well-dimensioned exhaust system and its regular maintenance are very important.



Chapter5 Maintenance

5.1 Cleaning the Laser Machine



Caution – use of controls or adjustments or performance of procedures other than those specified here in may result in hazardous laser radiation exposure.

Before starting cleaning and maintenance work always switch off the device and unplug the mains plug.

Always keep the system clean, as flammable parts in the working area or exhaust area rise the fire hazard.



You should check at least once a day, whether dust has accumulated in the engraving system. In case of soiling the machine must be cleaned. The cleaning interval strongly depends on the material that is being processed and the operating time of the device. Please bear in mind that only a clean machine guarantees optimal performance and reduces the service costs.

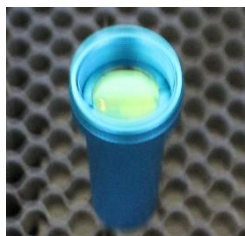
General Cleaning Notes:

1. Make sure, that the device is switched off and unplugged. Open the protective cover.
2. Move the working table into a position in which it is easiest for you to clean the surface with a window cleaning agent and paper towels.
3. Thoroughly remove all loose dirt particles and deposits in the interior of the machine.
4. Clean the cover of the laser tube.
5. You can clean the viewing window with a cotton cloth. Do not use paper towels as they could scratch the acrylic.



5.2 Cleaning the Optical Parts

The lens has a durable multi-coating and won't be damaged by correct and careful cleaning. You should inspect the focus lens and the mirrors and the beam combiner according the maintenance plan. If you discover a veil of haze or dirt, you must clean them.



It is suggested to clean the mirrors/lens before work every day in order to run the machine at max efficiency.

Follow the instructions below for the cleaning of optical parts:

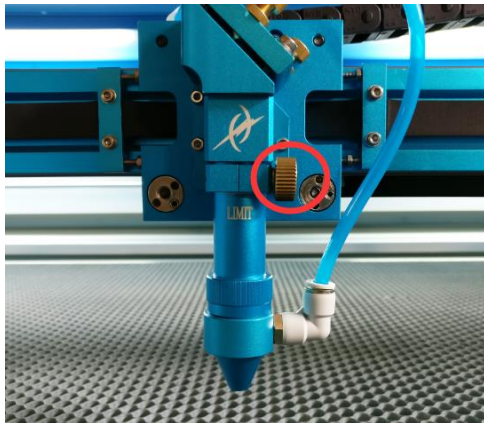
5.2.1 Cleaning the Focus Lens

1. Move the engraving table to a distance approx. 10 cm under the lens holder.
2. Move the working head into the center of the working surface and put a cloth under the lens holder (so that the lens is not damaged if it accidentally falls out of its holder).
3. Now you can unscrew the lens holder.
4. Once positioned over a clean lens cleaning tissue, remove the lens from the lens holder by carefully turning the lens holder and letting the lens and the O-ring drop onto the cleaning cloth.
5. Examine the O-ring and, if necessary, clean it with a cotton bud and a lens cleaning tissue/cloth.
6. Remove the coarse dust as good as possible by blowing air onto the lens surface.
7. Check the surface and if necessary clean the lens with the lens cleaning liquid and lens tissue.
8. Hold the lens assembly by its edge with a lens cleaning tissue and use a drop of lens cleaning liquid from the little bottle which you received as an accessory delivered with the laser. While holding the lens on an angle, flush both surfaces of the lens, to wash away coarse soiling.
9. Put the lens on a clean lens cleaning tissue. Put some lens cleaning liquid on one side of the lens. Leave the liquid to take effect for approximately one minute and then gently wipe it away with lens cleaning tissues soaked with lens cleaning liquid.
10. Finally, dry this side of the lens with dry lens cleaning tissues and repeat the cleaning process on the other side of the lens. Never use a cleaning tissue twice. Dust accumulated in the cleaning tissue could scratch the lens surface.
11. Examine the lens. If it is still soiled, repeat the cleaning process until the lens is clean.
12. Carefully insert the lens into the lens holder. Ensure, that the rounded side (= convex)

- of the lens is facing upwards. Then put the O-ring on top of the lens.
13. Carefully assemble the lens in reverse order.

How to take out the focus lens, please just as following the picture indicated:

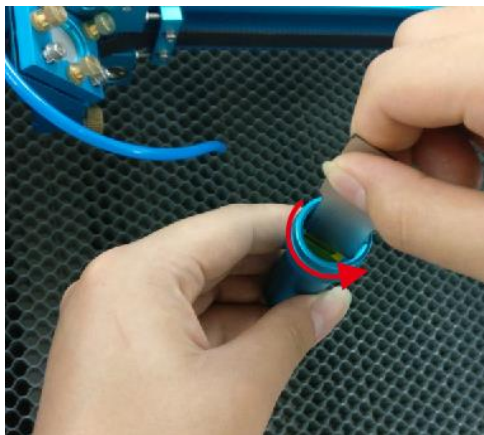
1. Remove the laser head



2. Divide the laser head



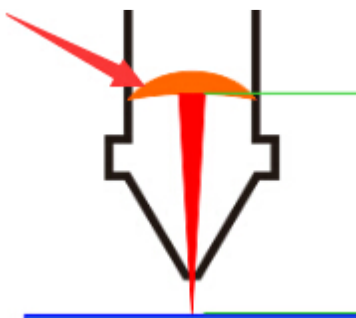
3. Remove the focus lens with the tool



4. Clean the lens with lens cloth



Note: The direction of focus lens mounting please refer to below picture:





5.2.2 Cleaning the Mirrors

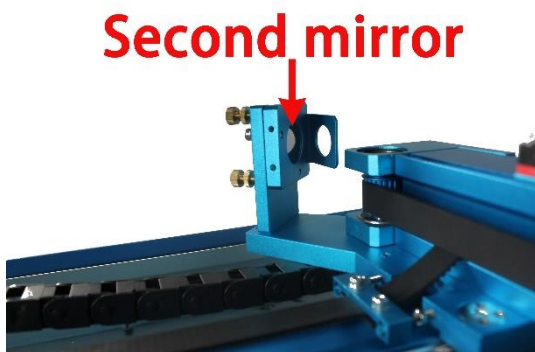
There are three mirrors in the operating area of the laser, which may have to be cleaned if they are soiled. To clean the reflector, follow the instructions below.

The Mirror#1



The mirrors are easily get dirty. And this will reduce the efficiency of the laser beam. Meanwhile, laser energy absorbed by the mirror may cause heat and destroy the mirrors too. For the first mirror, you can clean them directly.

The Mirror#2



Make sure the power of the laser machine is turned off while cleaning. The 2nd mirror is installed on the left side of X rail. For the second mirror, you can clean them directly.

The Mirror#3



Cautions:

1) Mirrors must be cleaned carefully by using lens cleaning paper/lens cleaning cloth to

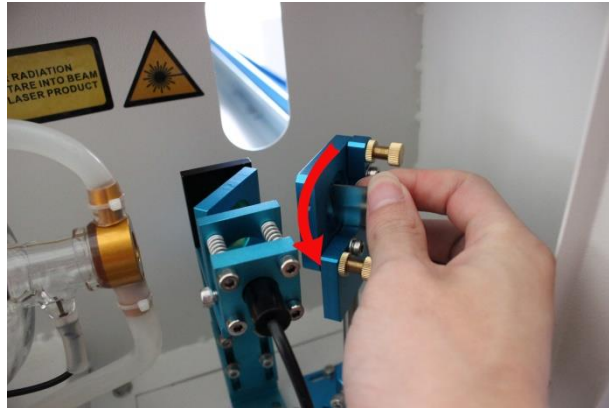
avoid scratching the surface.

2) Do not touch the surface of the mirrors/lens after cleaning

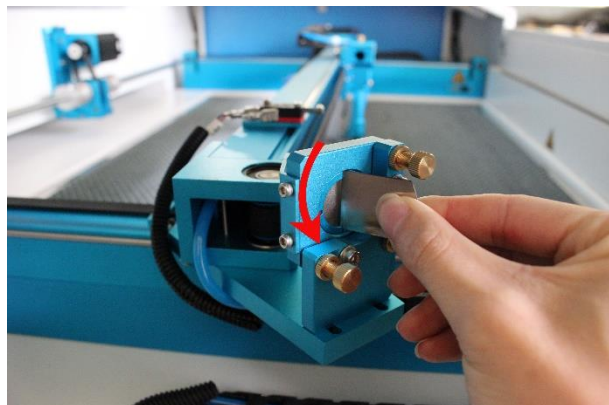
3) The concave side of the lens must be on the bottom when installed

How to take out the mirror#1 #2 and#3, and please just as following the picture indicated:

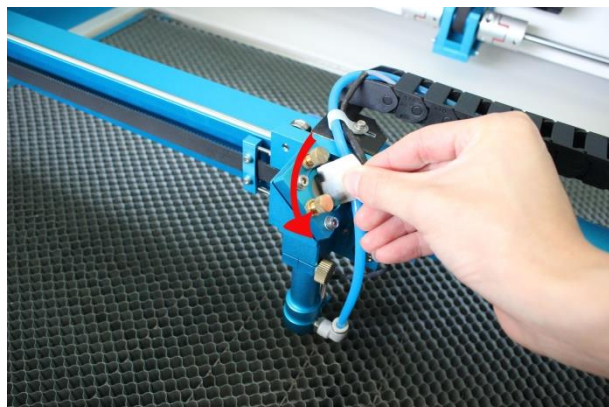
1. The mirror#1



2. The mirror#2

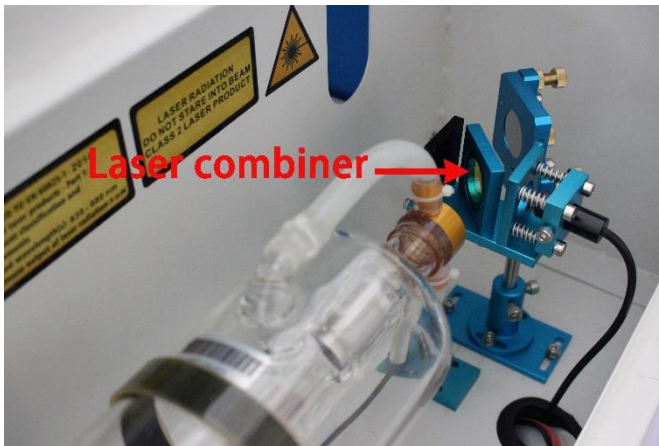


3. The mirror#3





5.2.3 Cleaning Laser Combiner



- ① The beam combiner must be cleaned carefully by using lens cleaning paper/lens cleaning cloth to avoid scratching the surface.
- ② Do not touch the surface of the beam combiner after cleaning.
- ③ For the beam combiner, you can clean them directly.



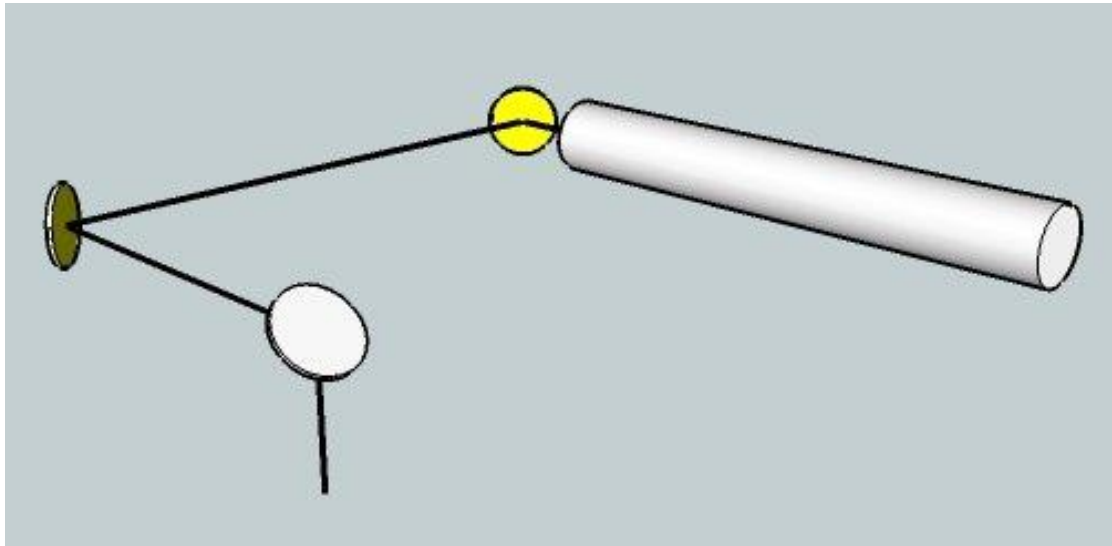
5.3 Maintain the X/Y/Z Rails



It is suggested to add lubricant oil (or Rust Preventative Grease) to the rails/screws at least every two weeks.



5.4 Check the Beam Path



After being used for a long time, the beam path might be deflective. This will reduce the efficient of the laser beam or even cause no laser beam. At this moment, you will need to re-adjust the beam path again.

If you need to know that about adjust the laser beam path of the video on YouTube released by our company and please link to the URL:

<http://www.thunderlaser.com/how-to-use-your-laser-machine/how-to-adjust-the-laser-beam-path.html>



5.5 Change Cooling Water for The Water Chiller



It is suggested to change the water at least once every month

Make sure the laser tube is filled with water before starting the machine. It is advised to add water every 3 days.

The quality and temperature of the cooling water affects the life time of the laser tube.

You need to use pure(distilled) water and control the temperature below 35℃ (95°F) .



5.6 Maintenance Plan

1. DAILY CHECK LIST

- ① Check Mirrors and lens for condensation and make sure it is clean after work
- ② Check exhaust grille to ensure there is no blockage for exhaust fan
- ③ Check coolant water level
- ④ Check air filter on compressor
- ⑤ Ensure cooling fans on sides are free from debris
- ⑥ The air blower must be checking and cleaning if required.

2. WEEKLY CHECK LIST

- ① Clean filters on water chiller
- ② Clean debris from under laser bed
- ③ Clean X & Y & Z axis rails and lubricate as required
- ④ Clean Acrylic/Tempered glass covers in lid
- ⑤ The beam combiner must be checking every weekly, and cleaning if required.

THE END