User Manual

Hand-held Laser Wire Feeder

WF5-ET-MD

MEGMEET

Hand-held Laser Wire Feeder

User Manual

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Megmeet Welding Technology Co.,Ltd.provides customers with all-around technical support,users can contact local dealers or company headquarters.

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Preface

Thank you for purchasing hand-held laser wire feeder (hereinafter referred to as wire feeder) produced by Megmeet Welding Technology Co., Ltd.

This manual provides users with installation wiring, function description, daily maintenance and other relevant precautions. Please read this user manual carefully before installing, so as to ensure the correct installation and operation of wire feeder, and give full play to its superior performance. Please keep properly and send the manual to the user of wire feeder.

Megmeet Welding conducts product development and innovation continuously. If the contents, parameters and pictures in this user manual are inconsistent with the real object, the actual product shall prevail. It is subject to change without prior notice. Megmeet has the right of final interpretation of the user manual.

Safety Precautions

Safety definition

DANGER Please operate as required, otherwise it may result in death or serious injury.

CAUTION Please operate as required, otherwise it may result in moderate or minor injury or damage to property.

Before using this product,please read this manual carefully for correct use.

During the design and manufacturing period of wire feeder, safety has been fully considered. To ensure that you can use the wire feeder safely, prevent yourself and others from being hurt, and avoid major incidents, please be sure to comply with the precautions in this manual when using.

Installation Precautions

DANGER

- Please install it on an incombustible object otherwise it may result in fire disaster.
- Do not place near combustible materials, otherwise it may result in fire disaster.
- Ensure that the area around the equipment is clean, orderly and free of oil, and pile up workpieces, tools and wastes according to regulations;
- It is forbidden to install in an environment with explosive gases, otherwise it may result in explosion.
- Wiring must be done by professionals, otherwise it may result in electric shock.
- The power supply of this device is 220V AC. Please ensure that the input power is earthed safely, otherwise it may cause equipment damage and personal injury.
- Ensure that the input power is completely disconnected before wiring. Otherwise it may result in electric shock.
- Install the shell before powering on the wire feeder. Otherwise it may result in electric shock.
- Do not touch the terminal with your hands when the wire feeder is electrified.Otherwise it may result in electric shock.
- Parts must be replaced by a professional. Do not leave thread ends or metal objects in the machine. Otherwise it may result in fire disaster.
- After replacing the control panel, it is necessary to set the parameters correctly before running. Otherwise it may result in the damage of property.
- Cables must be wrapped with insulating tapes and aren’t allowed to expose. Otherwise it may result in electric shock.

CAUTION

- Do not stress the operation panel and cover plate in the process of handling. Otherwise falling may result in personal injury or property damage.
- To ensure the security of laser welding, it is necessary to use proper external warnings, including but not limited to laser

safety signs and interlocking devices.

- Do not install near water pipes or other places where water droplets may splash. Otherwise it may result in property damage.
- Do not drop foreign matters such as screws, gaskets and metal rods into the wire feeder. Otherwise it may result in fire disaster and property damage.
- Do not install the wire feeder if it has damage or incomplete parts. Otherwise it may result in fire disaster and personal injury.
- Keep the working environment bright, turn on the light to prevent pupil dilation and avoid the risk of eye damage.

Precautions for Use

DANGER

- Operators must get pre-job training, grasp the structure and performance of laser welding machine, be familiar with the operation procedures and obtain the license qualification before operating.
- Wear labor protection equipment in accordance with regulations. Protective glasses must be worn near the laser beam. It is strictly prohibited to emit laser light at non-processed products or the human body.
- Only personnel with safe operation knowledge and welding skill can perform welding to ensure safety.
- When the equipment is turned on,operator shall not leave the post without authorization or entrust someone with custody. If necessary, stop the machine.
- It is necessary to keep fire extinguishers within easy reach.Turn off the laser or optical brake without processing. It is prohibited to place paper, cloth or other flammable materials near unprotected laser beams.
- Wire feeder shall not be used for any purpose other than matching with our welding device.
- Installation, debugging and maintenance of the wire feeder must be performed by professionals.
- Do not touch live parts, otherwise there is a risk of electric shock. Do not adopt the cables with insufficient sectional area, exposed conductors, or damaged cables.
- Do not remove the shell during use.
- Please use undamaged gloves with good insulation and use the sound insulation equipment to avoid noise.
- Pay attention to safety protection in high-place operation.
- Power off welder and distribution box when the device isn’t used.
- When welding in a narrow or confined space, the welding personnel must accept the supervision of the inspectors and fully ventilate or use respiratory protection appliance, otherwise it may result in asphyxia due to lack of oxygen.
- Harmful laser radiation will occur in the welding process, please wear laser protective glasses. Otherwise, it will harm your health.
- Do not weld pressure vessels such as gas pipes with gas,sealed tanks with gas.
- Do not weld near combustible matters or in the vicinity of combustible matters.
- Please put a fire extinguisher near the welding operation site.
- Do not touch the rotating parts of the wire feeder at work. Otherwise it may lead to human injury.
- Set up protective barriers around the welding site to prevent laser from harming others.

CAUTION

The requirements of operational environment are as follows:

Installation environment: smooth, no vibration and impact.

Working environment temperature: -10 ~ +40℃.

Scope of transportation and storage temperature: -20℃～+60℃

Working humidity: <70% RH.

The dust, metallic dust and corrosive gases in ambient air don’t exceed normal content.

Scrapping Attentions

When scrapping a welding machine,please note:

1. Please treat it as industrial waste;
2. The electrolytic capacitor in the main circuit and the electrolytic capacitor on the printed circuit board may explode when burned;
3. Toxic gases will be produced when plastic parts such as front panels are burned.

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Chapter 1 Product Overview

1.1 Product Introduction

Hand-held laser wire feeder can be used with LUX-1500/2000 series hand-held laser welding power source.

1.2 Introduction of Main Functions

The wire feeder is an automatic mechanized wire feeder with the following main functions:

1. Light and convenient, simple operation;
2. It is mainly used in automatic wire feeding of laser welding power source;
3. Control system is through microcomputer;
4. High-precision fully enclosed low-speed motor, double drive wire feeding structure makes wire feeding more powerful and not stuck,with the high wire feeding precision;
5. Wire feeding specifications of 1.0mm, 1.2mm, 1.6mm.

1.3 Hand-held Laser Wire Feeder Diagram

Figure 1-1 Hand-held laser wire feeder

1.4 Boundary Dimension and Net Weight

Dimension and net weight of the hand-held laser wire feeder are shown in Table 1-1, Figure 1-1.

Table 1-1 Boundary dimension of hand-held laser wire feeder

Name	Model	Boundary dimension (Length * width * height) mm	Net weight (kg)
Hand-held laser wire feeder	WF5-ET-MD	600*252*473	16.9

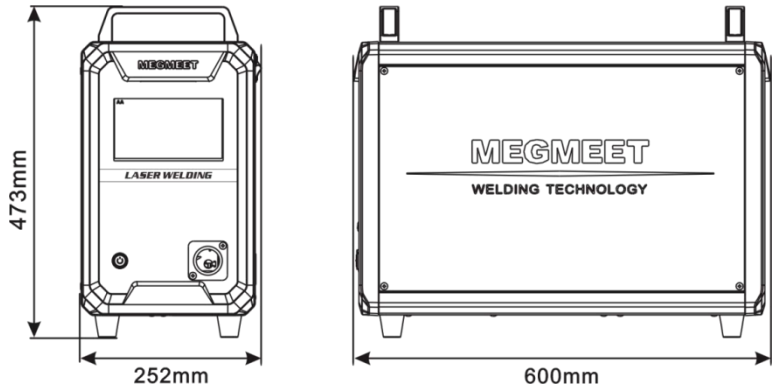


Figure 1-2 Boundary dimension of hand-held laser wire feeder

1.5 Technical Specification

Table 1-2 Technical specification of hand-held laser wire feeder

Parameter Name	Unit	Numerical value
Rated power of wire feeder motor	W	80
Rated voltage of wire feeder motor	V	24
Wire feeding speed	cm/min	15～600
Diameter of wire feeding roller	mm	V1.0/1.2/1.6/SP optional
Maximum load bearing of wire spool shaft	Kg	20

Chapter 2 Installation and Wiring

2.1 System Composition

Hand-held laser welding system consists of following parts: Hand-held laser welding power source, hand-held laser wire feeder, gas cylinder, wire feeder tube, laser welding torch, wire feeding signal control cable, safety ground lock signal cable and wire feeder power cable, etc. As shown in Figure 2-1.

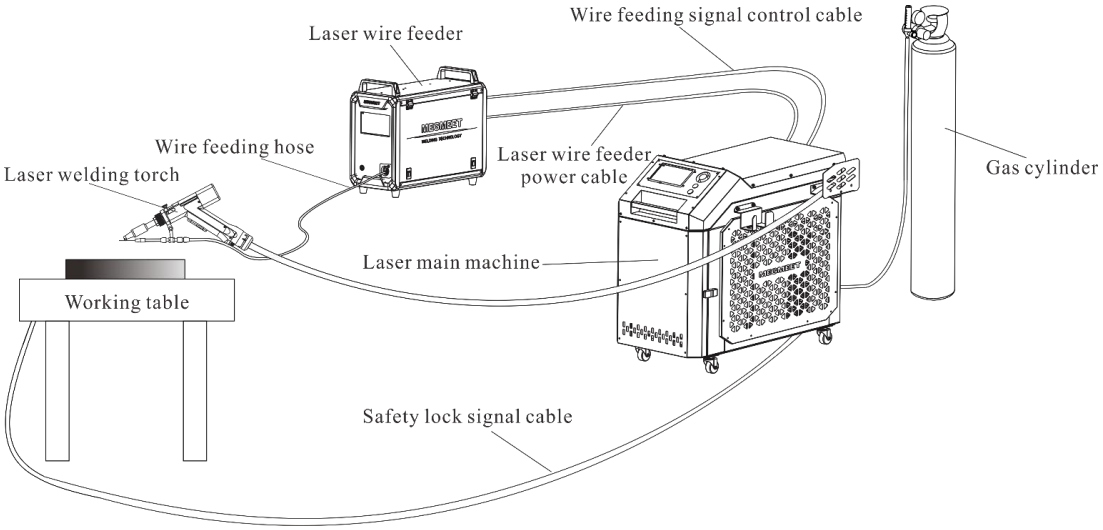


Figure 2-1 Schematic diagram of hand-held fiber laser welding system

2.2 Front View of Wire Feeder

4. Wire feeder display screen displays the wire feeding parameters during welding;

5. Power switch with self-locking function is at the lower left corner. Press it to switch on the wire feeder and press again to switch off the wire feeder;

6. Wire feeding tube connector is at the lower right corner, which is used to connect the wire feeding tube, as shown in Figure 2-2.

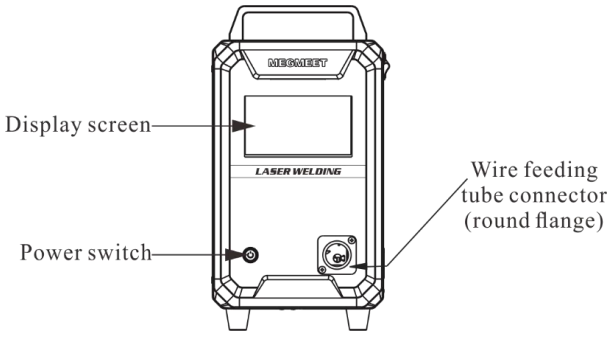


Figure 2-2 Front view of wire feeder

2.3 Description of Control Cable Pins

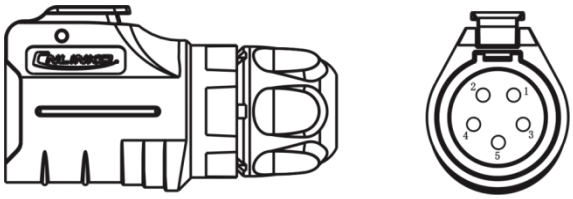


Figure 2-3 Definition of 5-core control cable socket pins

Table 2-1 Wiring definition of hand-held laser wire feeder

Pin position number	Function	Notes
1	N/A	When two control signals are connected, wire feeder starts to feed. When they are disconnected, wire feeder stops wire feeding.
2	control signal+	
3	N/A	
4	Control signal-	
5	N/A	

2.4 Connection of Wire Feeder

Steps

1．Connect the control cable to the connector of wire feeding signal control cable at the rear of laser welding power source, and check the stability;

2．Connect the power cable at the rear of wire feeder to the power connector 220VAC 2A at the rear of laser welding machine, and check the stability, as shown in Figure 2-4.

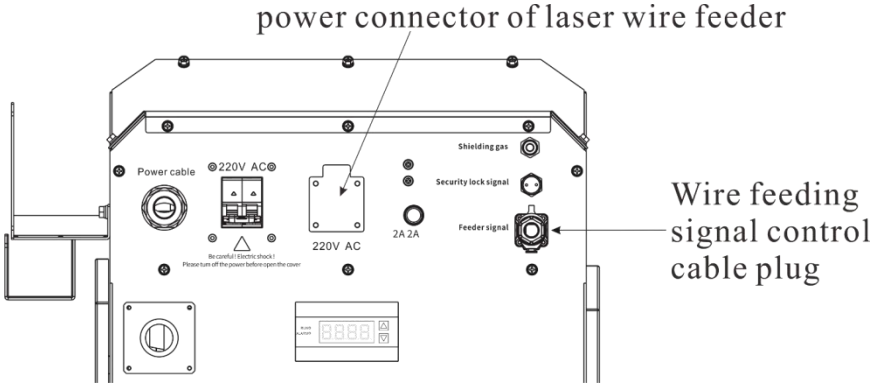


Figure 2-4 Connection diagram of laser welding power source(laser main machine)

3．Connect the other end of control cable to the connector of wire feeder control cable , and check the stability, as shown in Figure 2-5.

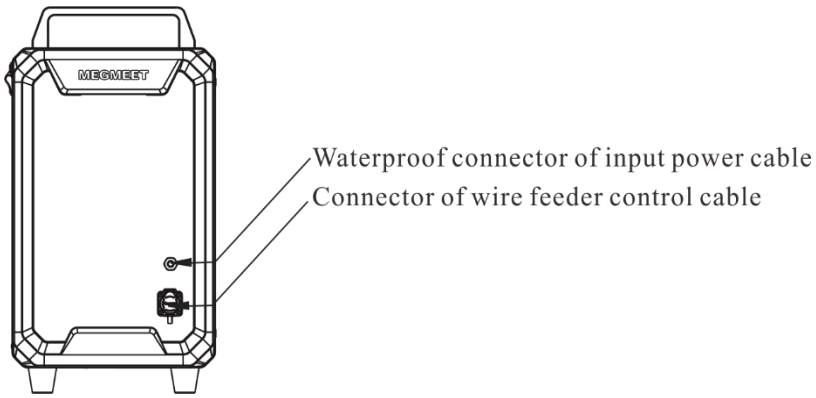


Figure 2-5 Rear view of hand-held laser wire feeder

2.5 Install or Replace the Wire Feeding Rollers

Open the pressure bar of roller, turn the roller counterclockwise to fix the nut, remove nuts and remove roller, replace it with the required roller, and re-install the nuts, and close pressure bar.

Steps

1．There are two pcs of rollers, and the models of both sides are different, corresponding to different diameters. Please install them accordingly. If 1.2 welding wire is installed, the 1.2 side of roller is on the outside, as shown in Figure 2-6;

2．When the wire is carbon steel or stainless steel, a roller with a V-shaped groove shall be used; when the wire is made of aluminum, a pinch roller with a U-shaped groove shall be used.

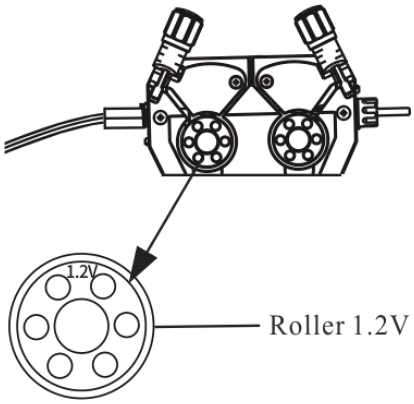


Figure 2-6 Schematic diagram of wire feeding roller installation

2.6 Installation and Connection of Wire Feeding Tube

Steps

Loosen the lock screw at the wire feeding motor,and then insert the wire inlet copper tip of wire feeding tube from the wire feeding tube to the proper position to lock, as shown in Figure 2-7.

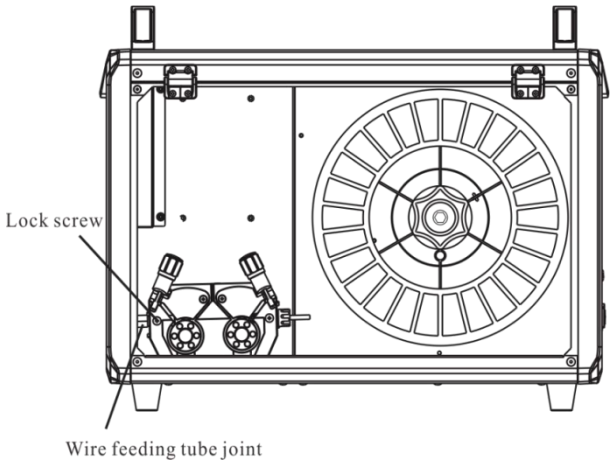


Figure 2-7 Connection diagram of wire feeding tube

2.7 Installation of Wire Spool

Steps

1．Install the wire spool on the wire spool shaft and tighten the damper cover clockwise；

2．Adjust the damper of rotation of the wire spool shaft with the hex wrench to avoid non-smooth wire feeding, as shown in Figure 2-8;

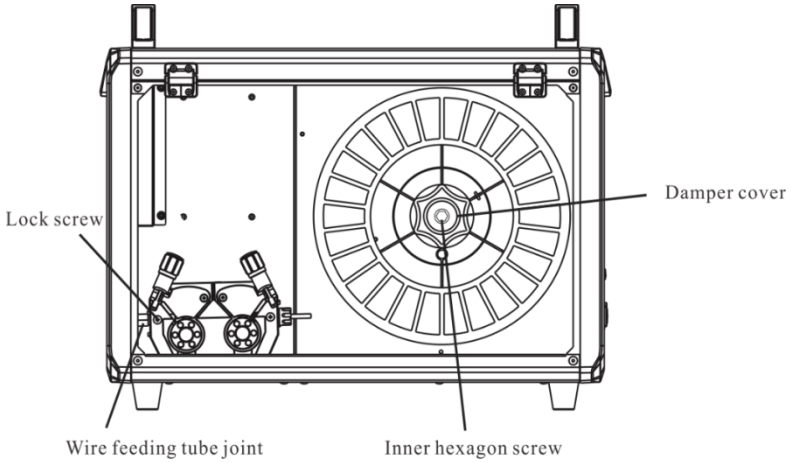


Figure 2-8 Schematic diagram of wire spool shaft

3．Loosen two adjustable pre-tightening force pressure rods and flick the pinch roller;

4．Pull out the wire from a wire spool, insert the wire from the wire feeding inlet of wire feeding motor, pass through the mid-guide wire tube, press welding wire into the wire feeding groove of roller, press down pinch roller, lock the adjustable pre-tightening force pressure bar, and press the wire tightly.

Note

1. The maximum load bearing of the spool shaft is 20KG. Overweight of wire spool may lead to unstable wire feeding or failure to send to the wire feeder;

2. If aluminum welding wire is used, the guide wire nozzle of wire feeding motor shall be replaced with a graphite guide

wire nozzle, and the U-shaped roller shall be replaced. As shown in Figure 2-9.

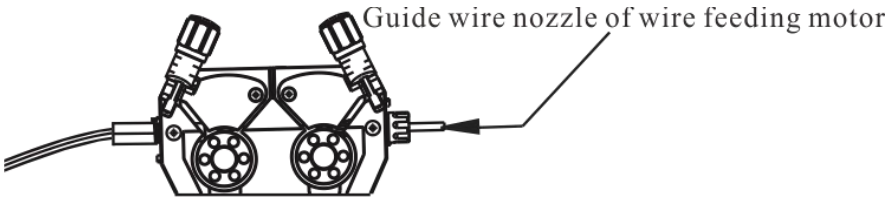


Figure 2-9 Schematic diagram of guide wire nozzle position

2.8 Adjustment of Wire Pressure Bar

If screw cap rotates clockwise, the pressure increases. If screw cap of wire pressure bar rotates counterclockwise, the pressure decreases. Different wires match different pressures, and the wire pressure bar shall be adjusted to the appropriate scale value, as shown in Figure 2-10.

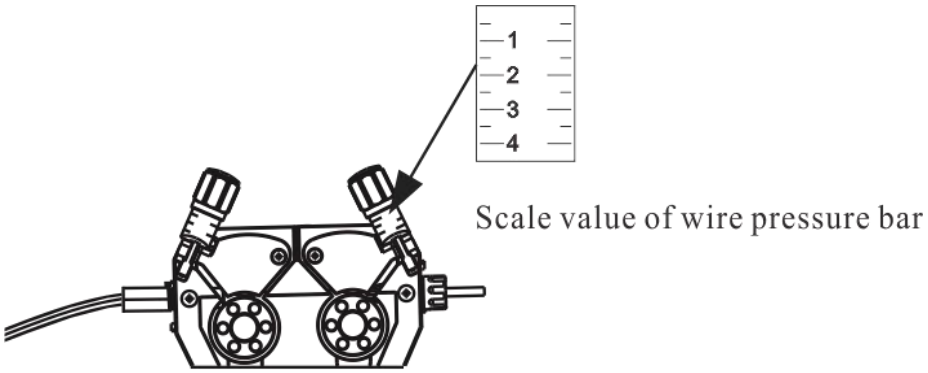


Figure 2-10 Adjustment diagram of wire pressure bar

Chapter 3 Function Description and Operation

3.1 Home Page Description of Continuous Mode

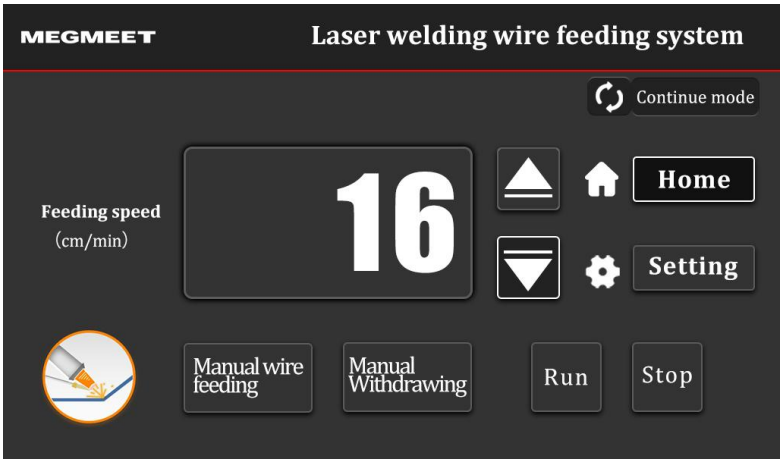
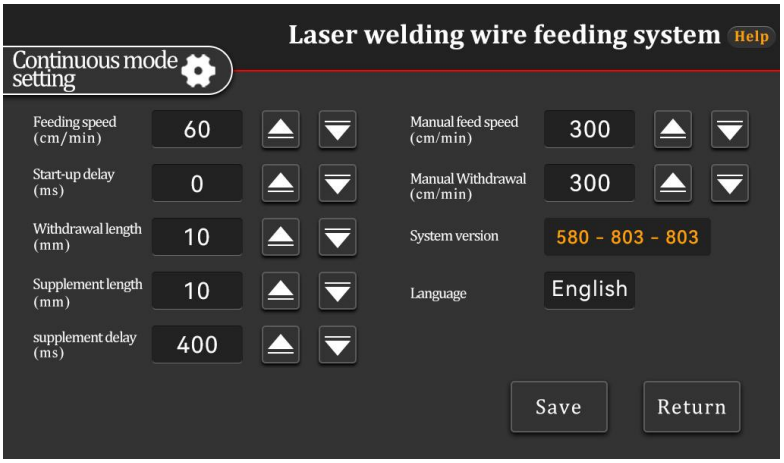


Figure 3-1 Continuous mode - Home page

Name	Parameter description	Notes	Default value
Continuous mode	The current working mode of laser welding machine is continuous light output, which is mainly used for laser welding in general scenes. Click to switch to pulse mode.	N/A	/
Wire feeding speed	Length of wire feeding in unit time.	Click the number to directly change the speed, or click to adjust, with the range of 15 ~ 600cm/min.	/
Wire feeding indicator light	It indicates the current wire feeding status. When the wire is fed, the "indicator light" changes from gray to orange, and the text changes from "welding stop" to "welding start", indicating that wire feeder works normally.	The "indicator light" shows orange only when welding. "Manual wire feeding" and "manual withdraw" cannot change the "indicator light" status.	/
Manual wire feeding	When the key is pressed, wire feeding length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300
Manual withdraw	When the key is pressed, withdraw length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300
Operation	After clicking, the motor works normally, and wire feeder starts wire feeding.	N/A	/
Stop	After clicking, the motor the current action, and wire feeder cannot feed wire or withdraw	N/A	/

3.2 Setting Mode Description of Continuous Mode



Name	Parameter description	Notes	Default value
Continuous mode settings	Currently in continuous mode settings page.	All parameters on this page can be adjusted through clicking ▲▼.	/
Wire feeding speed	Length of wire feeding in unit time.	It is the same as “wire feeding speed” on home page, which controls the wire feeding speed during welding, with the range 15～600cm/min.	/
Startup delay	The interval between trigger of the welding torch and start delay of wire feeder.	Range: 0～2000ms.	0
Withdraw length	The length of wire that is withdrawn by the wire feeder when welding stops.	Range: 0～100mm/min.	10
Compensated length of wire feeding	Length of wire feeding before welding starts.	Wire feeder compensates the length of wire feeding after withdrawing, with the range 0～100mm, which is consistent with the "withdraw length" in principle.	10
Delay in wire feeding compensation	The interval between wire feeding compensation and welding wire withdraw.	Range: 0～2000ms.	0
Manual wire feeding speed	When the key is pressed, wire feeding length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300
Manual withdraw speed	When the key is pressed, the withdraw length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300

Figure 3-2 Continuous mode - Settings page

3.3 Home Page Description of Pulse Mode

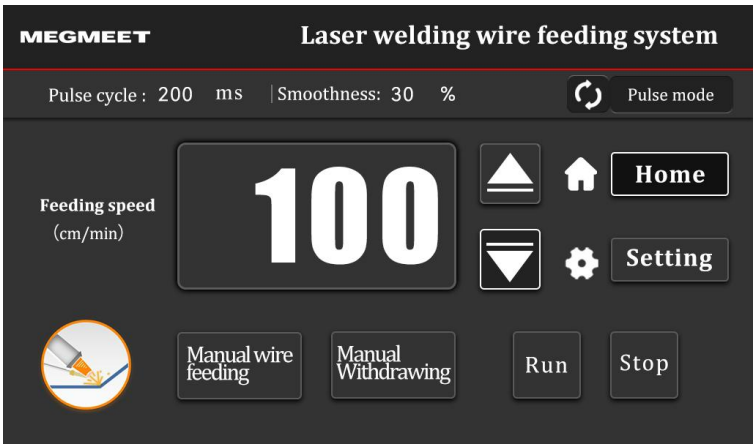


Figure 3-3 Pulse mode - Home page

Name	Parameter description	Notes	Default value
Pulse mode	Current working mode of laser machine is pulse light output, which is mainly used for fish-scale welding. Click to switch to continuous mode.	N/A	/
Pulse cycle	Time interval between two adjacent pulses in a periodically repeating pulse sequence.	Control the size of single fish-scale pattern. The larger the cycle, the larger the single fish-scale pattern. With the range of 100 to 1000ms, it is adjusted through setting page.	500
Smoothness	A transition between two adjacent pulses in a pulse cycle.	Control the interval between two fish scales. The smaller the value, the more obvious the whole effect. With the range of 25 to 80, it is adjusted on the settings page.	30
Average speed	Average length of wire feeding per unit time in pulse mode.	Click the number to directly change it, or click to adjust. This speed is not affected by "pulse cycle" and "smoothness", with the range of 15 to 150cm/min.	60
Wire feeding indicator light	It indicates current wire feeding status. When the wire is fed, the "indicator light" changes from gray to orange, and the text changes from "welding stop" to "welding start", indicating that the wire feeder works normally.	The "indicator light" shows orange only when welding. "Manual wire feeding" and "manual withdraw" cannot change the "indicator light" status.	/
Manual wire feeding	When the key is pressed, wire feeding length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300
Manual withdraw	When the key is pressed, withdraw length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300
Operation	After clicking, the motor works normally, and wire feeder starts wire feeding.	N/A	/
Stop	After clicking, the motor stops current action, and wire feeder cannot feed wire or withdraw.	N/A	/

3.4 Setting Page Description of Pulse Mode

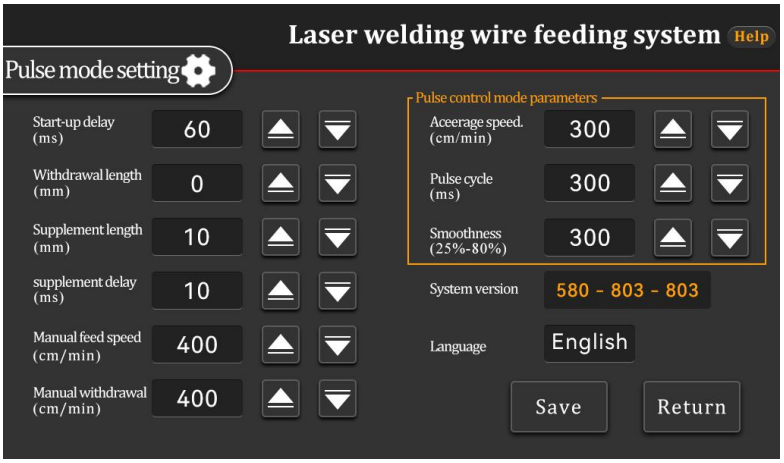


Figure 3-4 Pulse mode - Settings page

Name	Parameter description	Notes	Default value
Pulse mode settings	Currently in pulse mode settings page.	All parameters on this page can be adjusted through clicking ▲▼.	/
Average speed	The average length of wire feeding per unit time in pulse mode.	Average speed controls overall wire feeding speed of pulse mode, which is affected by the pulse cycle and smoothness, with the range of 15 to 150cm/min.	60
Pulse cycle	Time interval between two adjacent pulses in a periodically repeating pulse sequence.	Control the size of single fish-scale pattern. The larger the cycle, the larger the single fish-scale pattern. The range is 100～1000ms.	500
Smoothness	A transition between two adjacent pulses in a pulse cycle.	Control the interval between two fish scales. The smaller the value, the more obvious the whole effect. The range is 25～80.	30
Startup delay	The interval between the trigger of the welding torch and the start of the wire feeder.	Range: 0～2000ms.	0
Withdraw length	The length of wire that is withdrawn by wire feeder when welding stops.	Range: 0～100mm/min.	10
Compensated length of wire feeding	Length of wire feeding before welding starts.	Wire feeder compensates the length of wire feeding after withdrawing, with the range 0～100mm, which is consistent with the "withdraw length" in principle.	10
Delay in wire feeding compensation	Interval between the wire feeding compensation and welding wire pullback.	Range: 0～2000ms.	0
Manual wire feeding	When the key is pressed, wire feeding length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300
Manual withdraw	When the key is pressed, withdraw length of wire feeder in unit time is displayed.	Range: 15～600cm/min.	300

Chapter 4 Maintenance

4.1 Daily Inspection

🕮 Security Warnings

Daily inspection must be conducted after turning off the power supply of the user's distribution box and the power supply of the machine to avoid personal injuries such as electric shock and burn. (For the appearance that doesn't contact with a conductor, daily inspection isn’t required.)

●Notice for use

1. Daily inspection is very important to keep the high performance and safe operation of the welding device;
2. Daily check the status of wire feeding roller, wire reel shaft and guide wire tube, and clean or replace if necessary;
3. To ensure the high performance of the product, please select the parts provided or recommended by the original manufacturer.

4.2 Regular inspection

🕮 Security Warnings

1. Regular inspection must be performed by professionals to ensure safety;

2. Regular inspection must be conducted after turning off the power supply of the user's distribution box and the power supply of the device to avoid personal injuries such as electric shock and burn.

●Operating instruction

1. In order to prevent the semiconductor components and circuit boards from being damaged by static electricity, please wear anti-static devices or touch the metal parts of enclosure to remove static electricity before touching the conductors and circuit boards in the machine;
2. Do not use solvents other than household neutral detergents when cleaning plastic parts.

●Regular inspection plan

1. Regular inspection must be performed to ensure the long-term normal use of the equipment.
2. Pay attention to regular inspection, including internal inspection and cleaning of the equipment.
3. In general, regular inspection is performed once every six months. If there is a lot of dust or oily smoke at the welding site, regular inspection must be performed once every three months.

4. The recommended regular inspection plan is shown in Table 4-1.

Table 4-1 Regular inspection plan (year of XXXX)

No.	Scheduled inspection date	Actual inspection date	Inspector
1	xxxx-xx-xx		
2	xxxx-xx-xx		
3	xxxx-xx-xx		
…	…		

●Content of regular inspection

(In addition to following items, users can add inspection items according to actual conditions.)

5. Dust removal inside the wire feeder

Remove the side panel of wire feeder, blow the spatter and dust inside the wire feeder with the dry compressed air, and then remove dirt and foreign matter that are difficult to blow off.

6. Inspection of wire feeder

Remove the side panel of wire feeder to check whether the wire feeder has odor, discoloration, overheating signs and whether the joint part is loose.

7. Control cable inspection

Check the control cable for damage, replace it in time, and check whether the connection is tight.

4.3 After-sales Service

●Warranty card

Each device has a warranty card. Please fill in the relevant content on the warranty card.

Please read the warranty card carefully and keep it properly.

●Maintenance

Please contact your local dealer in case of component repair or replacement. Please use parts and components provided by Megmeet Welding Technology Co., Ltd.

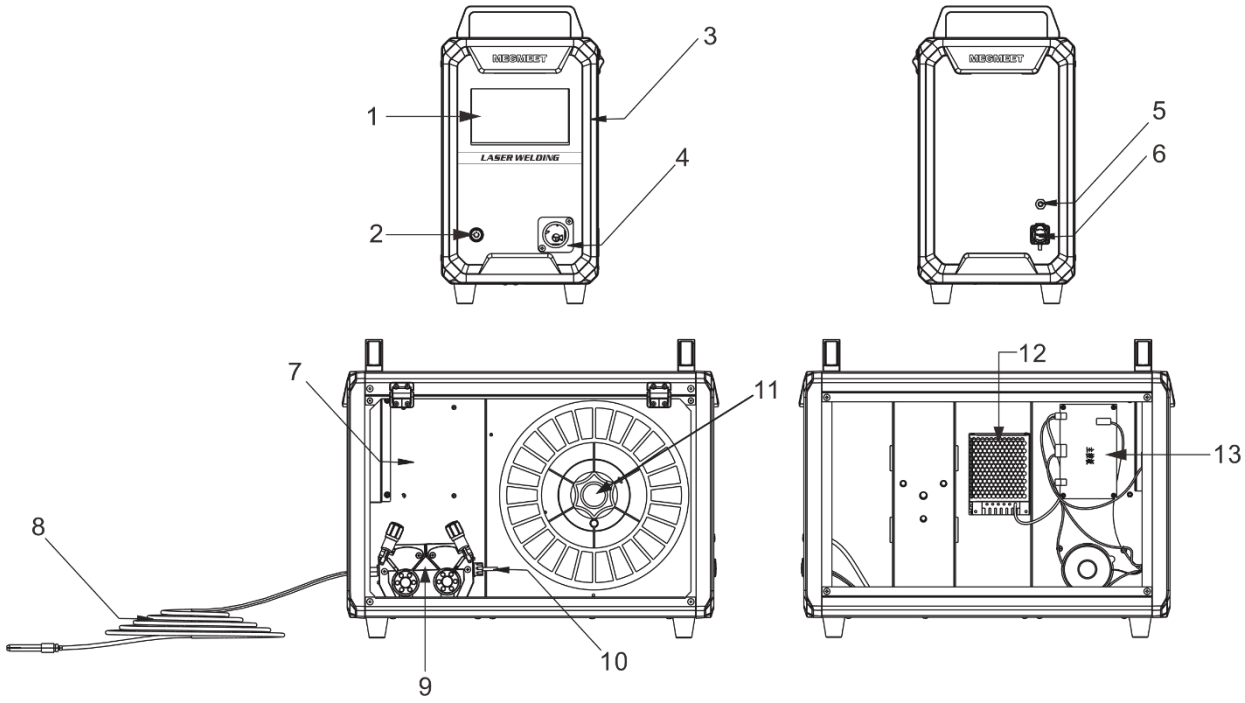
The warranty period of this product is one year, starting from the warranty card or purchase invoice. Abnormal use and artificial damage isn't included in the free warranty coverage.

4.4 Precautions for Scrapping

When scrapping the wire feeder, please pay attention to:

1. An explosion may happen when an electrolytic capacitor is incinerated on a printed plate;
2. Toxic gas will generate when plastic parts are burned. Please treat them as industrial refuse.

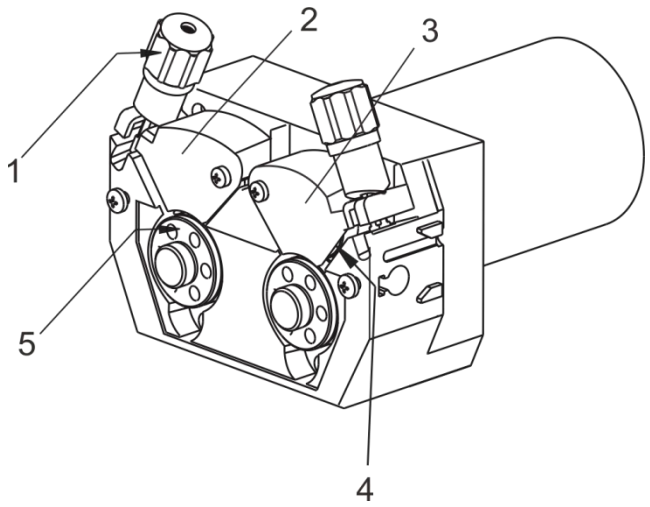
Appendix I Structure Drawing of Wire Feeder



Name	Code
1.Wire feeder display screen	R37060002
2.Metal button power switch	R34010985
3.Handheld laser wire feeder panel	R29061924
4.Wire feeding tube joint (round flange)	R29131753
5.Waterproof connector of Input power cable	R29061593
6.Wire feed signal connector for handheld laser wire feeder	R30041847
7. Handheld laser wire feeder chassis	R29141056
8-1. Wire feeding spring tube assembly-3 meters	R29131751
8-2. Wire feeding spring tube assembly-5 meters	R29131752
8-3. Graphite wire feeding tube assembly-3 meters	R29131757
9.Handheld laser wire feeder motor	R36030037
10.Wire guide wire nozzle	R29131750
11-1.Welding wire spool	R29131754
11-2. Damper cover	R29131849
12.Switching power supply	R00200020
13.Wire feeder main control board	R37060001

Appendix figure 1-1 Structure drawing

Appendix II Structure Drawing of Wire Feeder Motor



Name	Code
1. Pressure bar	R29131822
2. Left pressing arm assembly	R29131847
3. Right pressing arm assembly	R29131848
4. Pressing roller	R29131823
5-1.Wire feeding roller(V type) 0.8/1.0	R29131746
5-2.Wire feeding roller (V type) 1.2/1.6	R29131748
5-3.Wire feeding roller(U type) 1.2/1.6	R29131749

Appendix figure 2-1 Structure drawing

MEGMEET Shenzhen Megmeet Welding Technology Co.,Ltd

Welding Machine Warranty

User Name:	
Detailed address:	
Zip:	Contact:
Phone:	Fax:
Machine Model:	
Power:	Machine Number:
Purchase order:	Date of purchase:
Service company:	
Contact:	Phone:
Maintenance Staff:	Phone:
Repair Date:	
User evaluation of service quality: **Good□□good□so-so□poor** Other comments: User signature:Year,month,day	
Customer Service Center Return Visit Record: □return **visit by phone□letter return visit** Other: Signature of technical support engineer:year,month and day	

Note:This table will be invalidated if the user is not able to have a return visit

MEGMEET Shenzhen Megmeet Welding Technology Co.,Ltd

Welding Machine Warranty

User Name:	
Detailed address:	
Zip:	Contact:
Phone:	Fax:
Machine Model:	
Power:	Machine Number:
Purchase order:	Date of purchase:
Service Company:	
Contact:	Phone:
Maintenance Staff:	Phone:
Repair Date:	
User evaluation of service quality: **Good□□good□so-so□poor** Other comments: User signature:Year,month,day	
Customer Service Center Return Visit Record: □return **visit by phone□letter return visit** Other: Signature of technical support engineer:year,month and day	

Note:This table will be invalidated if the user is not able to have a return visit

Notice to users

1.The warranty scope refers to only the welding power source.
2.The warranty period is 24 months,and under normal use during the warranty period,the welding power source fails or is damaged.Our company repairs free of charge.
3.The start of the warranty period is the date of the manufacture of welding power source,the welding power code is the only basis for judging the warranty period,and the equipment without welding power code is treated according to the warranty.
4.Even within the warranty period,a certain repair cost will be charged if the following occurs:

- Failure of the welding power sourcecaused by not operating according to the user manual;
- Damage to the welding power source due to fire,flood,abnormal voltage,etc.;
- Damage caused when the welding power source is used for abnormal functions.

5.The service fee is calculated according to the actual cost,and if there is another contract,it will be handled on the principle of contract priority.
6.Please be sure to keep this card and present it to the repair unit at the time of warranty.
7.If you have any questions,you can contact the distributor,or contact our company directly.

Shenzhen Megmeet Welding Technology Co.,Ltd
Customer Service Center

Address:4-5th Floor, Block 2,New Materials Industrial Park, No28, Langshan Road, Nanshan District, Shenzhen, Guangdong Province, China
Postal code:518057
Customer Service Hotline:4006662163

Notice to users

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MEGMEET

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Nanshan District, Shenzhen, Guangdong Province, China, 518057