

# WEN MARKER

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

INSTALLATION N° P07086035NG



EDITION : EN  
REVISION : C  
DATE : 06-2021

Instructions for use

REF : **8695 4147**

*Original instructions*

**LINCOLN**<sup>®</sup>  
**ELECTRIC**

**Thank for the trust you have expressed by purchasing this equipment, which will give you full satisfaction if you follow its instructions for use and maintenance.**

**Its design, component specifications and workmanship comply with applicable European directives.**

**Please refer to the enclosed CE declaration to identify the directives applicable to it.**

**The manufacturer will not be held responsible where items not recommended by themselves are associated with this product.**

**For your safety,there follows a non-restrictive list of recommendations or requirements, many of which appear in the employment code.**

**Finally we would ask you kindly to inform your supplier of any error which you may find in this instruction manual.**

# CONTENTS

**A - SAFETY INSTRUCTIONS.....1**  
    1 - GENERAL SAFETY INSTRUCTIONS.....1  
    2 - AIRBORNE NOISE .....1

**B - DESCRIPTION .....2**

**C - ASSEMBLY AND INSTALLATION.....3**  
    1 - CONDITIONS OF INSTALLATION.....3  
    2 - CONNECTION .....3  
    3 - ELECTRICAL CONNECTION.....4

**D - OPERATOR MANUAL .....5**  
    1 - OPERATOR CONTROLS .....5  
    2 - ADJUSTMENTS.....5

**E - MAINTENANCE.....6**  
    1 - SERVICING.....6  
    2 - SPARE PARTS .....8

**PERSONAL NOTES .....10**

# REVISIONS

## REVISION B

06/21

DESIGNATION	PAGE
To change logos	

## REVISION C

06/21

DESIGNATION	PAGE
Addition of <b>HPC III</b>	

# A - SAFETY INSTRUCTIONS

## 1 - GENERAL SAFETY INSTRUCTIONS



Before using the process, make sure you read the manual, particularly the general safety instructions and those specific to this process



The machine must be operated by a person trained in its use and hazards



For general safety instructions, please refer to the specific manual supplied with the equipment, reference 8695 7050



Special security instructions are also recommended in the documentation of the options or the extraction table.



Machine **maintenance** must be carried out **with all the energy supplies switched off**. The disconnection and padlocking of all energy sources is **mandatory**.



## 2 - AIRBORNE NOISE

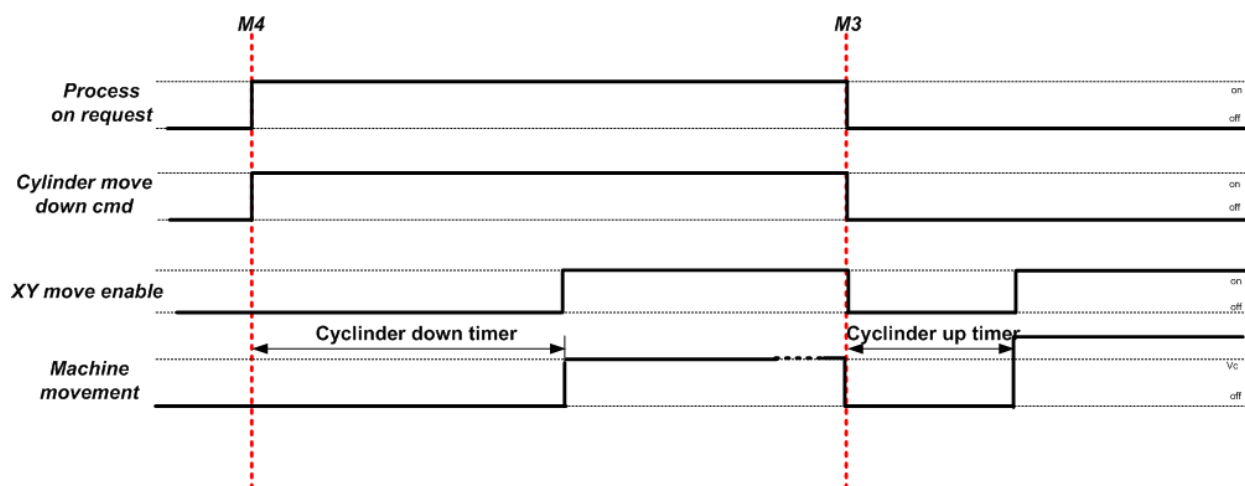
The acoustic level of the marker is below 65 dBA (CEN/TC 255 N)

## B - DESCRIPTION

All marker options include:

- the marker
- the pneumatic raising and its control
- the cables and pipes necessary for its operation
- air lubrication

Operating cycle:



# C - ASSEMBLY AND INSTALLATION

## 1 - CONDITIONS OF INSTALLATION

The marker goes on the master carriage, to the right or left of the tool.

Assembly is carried out in the factory or by a fitter approved by **LINCOLN ELECTRIC**.

## 2 - CONNECTION

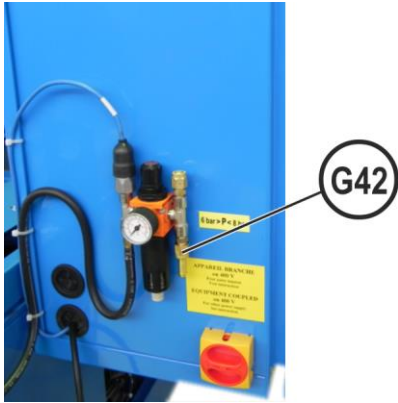


<b>PNEUMATIC SUPPLY</b>			
A compressed air source equipped with a regulator capable of supplying the recommended flow rates and pressure must be provided. The air must be clean and free of oil and grease.			
AIR QUALITY CLASS: as per standard ISO 8573-1			
<b>Solid pollutant class</b>	Classe 3	Particle size 5µm	Mass concentration 5mg/m <sup>3</sup>
<b>Water class</b>	Classe 3	Max. dew point under pressure -20°C	
<b>Total oil class</b>	Classe 4	Concentration 5 mg/m <sup>3</sup>	
	<b>Supply pressures</b>	<b>Maximum pressures</b>	<b>Fully flow rates used m3/h</b>
	6 Bar	8 Bar	0.9

Lubrication is provided in the installation

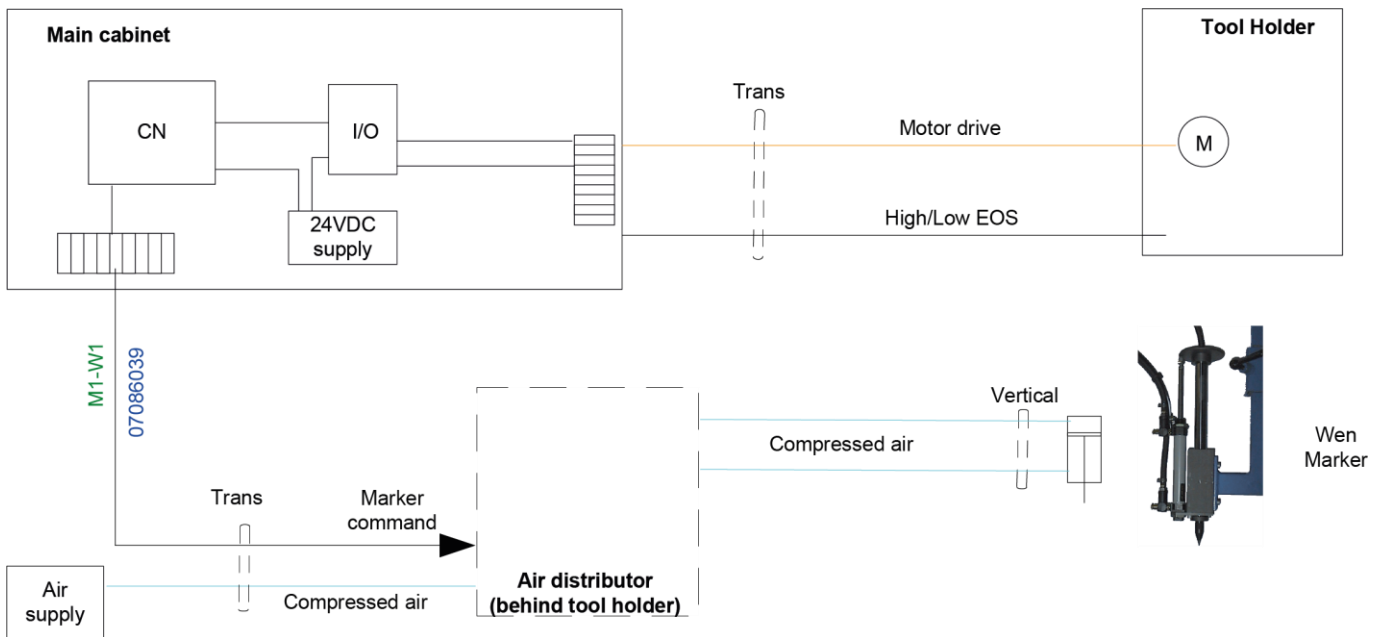
### LAYOUT OF CABLES AND FLEXIBLE PIPES

The customer should provide the means for supporting and keeping away from mechanical, chemical, or thermal damage, the cables and flexible pipes from their source to the entry of the cable support chain.



Connect the compressed air pipe to the filter located on the side of the electric unit on **G42**

## 3 - ELECTRICAL CONNECTION





# D - OPERATOR MANUAL

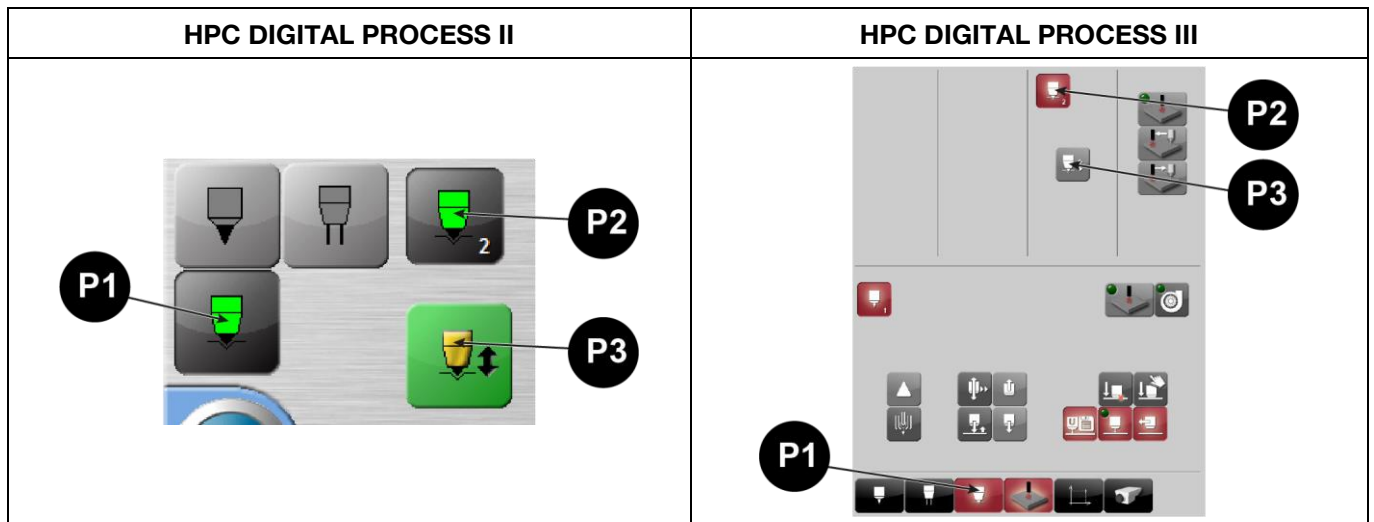
## 1 - OPERATOR CONTROLS

### 1.1 MANUAL CONTROLS FROM THE UI

The marking system is controlled from the UI:

- 86954944 => **HPC DIGITAL PROCESS II**
- 86954995 => **HPC DIGITAL PROCESS III**

To select the marker manually, press **P1**, then **P2** corresponding to the selected marker, and then **P3** to select the downward movement of the marker. Press **P3** once again to move up the marker. The XY movement is a jog movement.



### 1.2 SELECTING MARKING IN A PROGRAM

The marker may be selected either by adding a code S3xxxx to each marking or by manually selecting the marker (**P1**, then **P2**) at the start of a standard form.

## 2 - ADJUSTMENTS

The up or down movement speed is adjusted by means of the flow controllers located on the cylinders.

# E - MAINTENANCE

## 1 - SERVICING

- So that the machine continues to provide good service for as long as possible, a certain minimum of care and maintenance is necessary.
- The frequency of this maintenance work is given on the basis of the production of one work station per day. Maintenance should be more frequent if production is greater

Your maintenance department may photocopy these pages so that it can follow up maintenance dates and operations (tick as appropriate).

### Weekly

Date of maintenance :     /     /



- Check the oil level in the lubricator.

#### LUBRICANT :

For ordinary use, we recommend a pneumatic oil without detergent or aggressive additive, with viscosity of 2 to 3.5 degrees Engler at 50°C and aniline point from 90 to 105. Reference recommended:

TOTAL : Azolla32 or ZS32

SHELL : Tellus S22 or Olna 22

ESSO : Spinesso 22

MOBIL : DTE light

B.P. : HLP 22 or 32

#### FILLING :

For series 35, depressurize the system. Remove the filler cap. Fill to 10 millimetres from the upper edge of the tank using appropriate lubricant.



It is also possible to fill by dismounting the tank. In this case, make sure, after filling, that the tank is properly screwed and watertight before putting the system under pressure.

#### ADJUSTMENT :

To adjust the oil flow-rate, apply pressure then provide an air escape in order to consume air and set the button until the desired flow-rate is obtained. The flow-rate is controlled using the display dome. On average, we suggest a flow-rate of one or two drops per minute.

# monthly

Date of maintenance :    /    /

	<p>- Check the proper working of the gas circuit: pressure gauge, pressure reducer valve, solenoid valve, valve, fittings etc. NB: any piping with the slightest sign of fatigue, wear or damage must be replaced by an identical standardised pipe.</p>
	<p>- Check the condition of all electrical cables, particularly close to the torches and the cable drag chain (change them if required).</p>
	<p><b>Filter pneumatic circuit :</b></p>
	<p>To keep the filter maximally effective and prevent head loss, it must be cleaned regularly. Standard filters have a semiautomatic purge for clearing any build-up in the tank. Standard filters have a semiautomatic purge for clearing any build-up in the tank.</p>
	<p>That semiautomatic purge operates when the air is cut off in the upstream pipe.</p>
	<p>In the event of continuous operation, provide for a periodic manual manoeuvre of the purge</p>
	<p>The filter must be cleaned whenever a visible concentration of impurities and/or excess pressure loss are observed</p>
	<p>Alcohol may be used for cleaning. Then blow the inside the filtering element.</p>
<p>Before reassembly, apply 1000 bulles leak tester or soapy water on the thread. <b>Never apply greasy material in any form (oil or grease).</b></p>	

## 2 - SPARE PARTS

### How to order

The photos or sketches identify nearly every part in a machine or an installation

The descriptive tables include 3 kinds of items:

- those normally held in stock: ✓
- articles not held in stock: ✗
- those available on request: no marks

(For these, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.)

For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

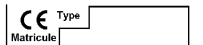
For example:

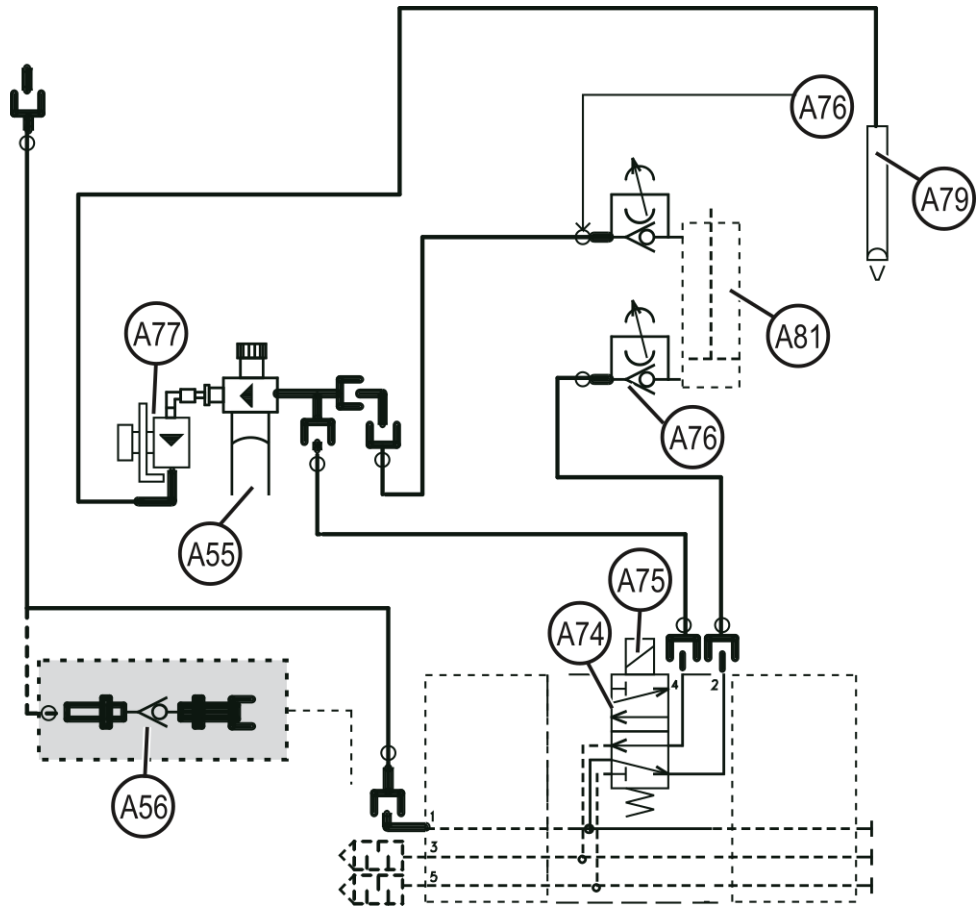
Item	Ref.	Stock	Order	Designation
1	W000XXXXXX	✓		Machine interface board
2	W000XXXXXX	✗		Flowmeter
3	9357 XXXX			Silk-screen printed front panel

✓	normally in stock
✗	not in stock
	on request

- For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE :
	Number:



✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
A74	W000139140	✗		Distributeur 5/2 1/8"
A75	W000381947	✗		Solenoid valve coil
A76	W000401471	✗		Regulator banjo 1/8"
A77	W000366577	✗		Regulator + pressure gauge
A79	W000138821	✗		Marker body
	W000138823	✗		Sriber
A81	W000372759	✗		Cylinder D20 C100
A55	W000401472	✗		G1/4 MODULAIR lubricator
A56	W000401473	✗		Check valve

➤ For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE :
	Number:

