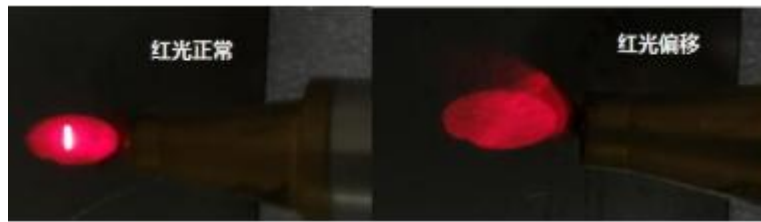


# How to do calibration for laser welding machine



Correct

Not Correct

## caution:

1. Only when the red light is a line can be debugged by the following methods. If the red light is a point, please refer to the line change point processing plan, because it may be biased when it does not swing.
2. If you see a group of light instead of a line from the protective mirror, consider whether the mirror is broken
3. Be sure to confirm that the 15V power supply status is normal

## Adjustment plan

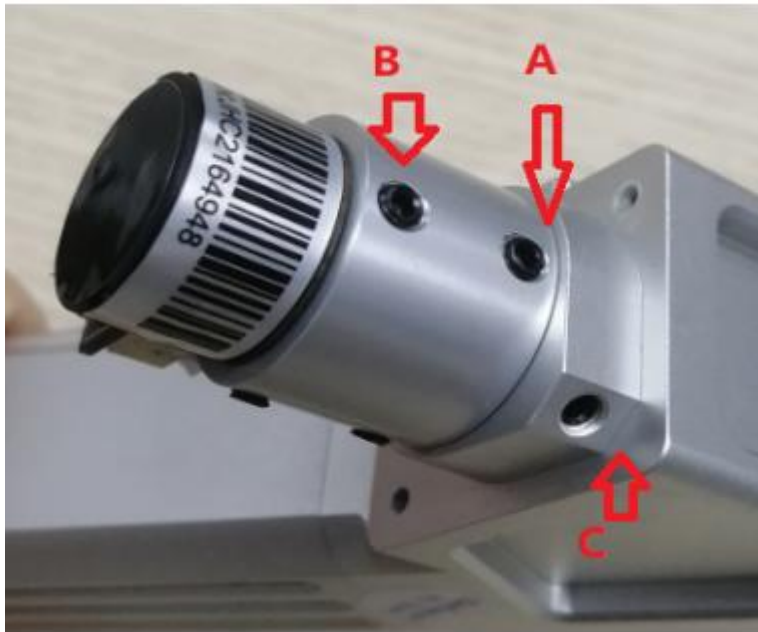
### 1. Software settings (left and right adjustment)

Fine-tune by setting the laser center offset in the interface, followed by {1. Setting}-{2. Change the laser center offset value, the negative value is to the right, the positive value is to the left, the latest version can adjust the maximum value  $+3/-3$  }. This solution can be fine-tuned left and right. If this method still cannot be adjusted, use mechanical adjustment.

### 2. Mechanical adjustment (up, down, left and right)

Before making mechanical adjustments, be sure to set the center offset of the settings to 0

#### 4. First look at the structure (SUP20S/T)



If The left and right there are too much difference:

Loosen C, turn the locking ring, pay attention to the amplitude when turning, and apply a little force (do not turn the motor part, that is, the position with the SN code label)

Upward adjustment: ① Loosen the screw under B and tighten the B screw

② Loosen the screw A, and tighten the screw under A

Downward adjustment: ① Loosen the screw below A and tighten the screw A

② Loosen screw B and tighten the screw under B