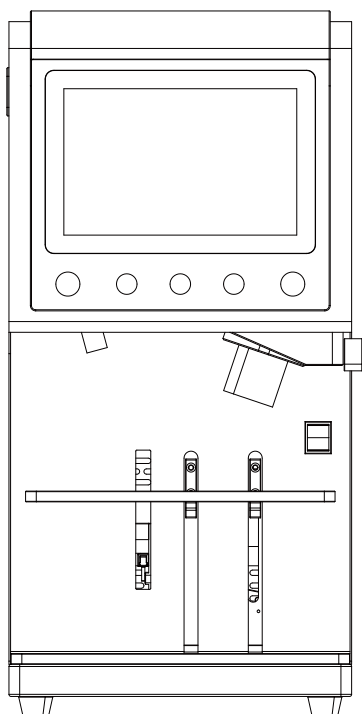


958H

Laser welding machine



使用前请仔细阅读本使用手册

Please read this instruction manual carefully before use



安全注意事项

为了防止给您的人身及财产安全造成损害，为了您可以安全正确地使用本产品，请仔细阅读使用手册，并按照使用手册的步骤进行操作。

注意事项

- ★在操作设备之前，用户务必认真阅读使用手册，严格遵守操作规程。
- ★加工对象及排放物应符合当地的法律、法规要求。
- ★设备所处环境应干燥，无污染、无震动、无强电、无强磁等干扰和影响。工作环境温度10-40℃，工作环境湿度5-95%(无凝水)。
- ★设备工作电压:AC100-240V。
- ★雕刻机及其相关联的其它设备都必须安全接地，方可开机操作。
- ★设备在开机状态下，需全程值守，人员离开前必须切断所有电源，防止异常状况发生，如有发生请立即断电处理!
- ★严禁在设备中放置任何不相干的全反射或漫反射物体。
- ★设备应远离对电磁干扰敏感之电气设备，可能对其产生电磁干扰。
- ★非专业人员严禁拆卸。
- ★持续使用3-5小时后，需断电休息5min左右，散去热量保护内部不易损坏，保持内部清洁。

产品目录

中文

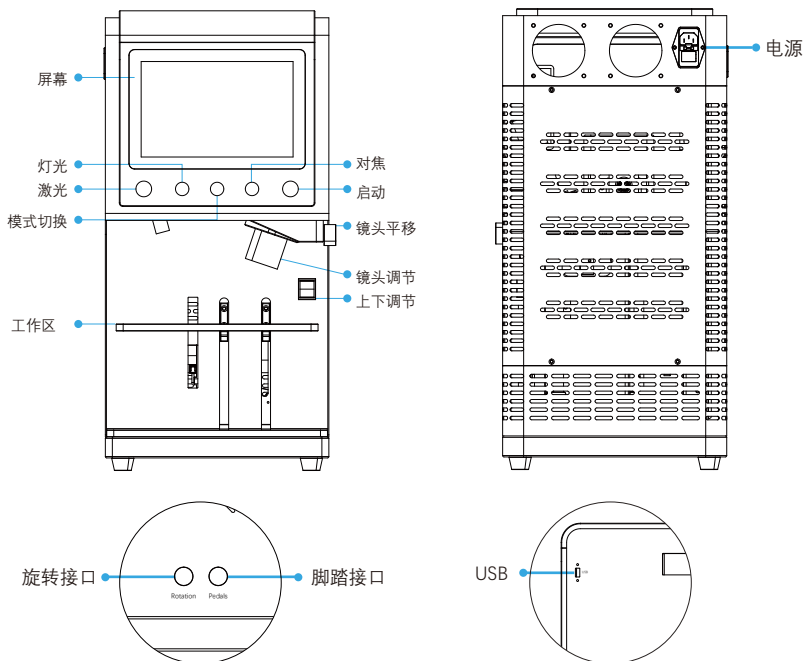
产品介绍	01
软件各功能简介	02
系统语言切换	03
界面切换/显微镜操作	04
● 拆手机后盖	05
● 图纸创建	06
● 雕刻文字	07
● 雕刻矢量文件	08
● 雕刻图像	09
各材质雕刻参数参考	10
常见问题及解决方案	11

English

Product introduction	12
Brief introduction of software function	13
System language switching	14
Display Toggle	15
● Remove the back cover of the mobile phone	16
● Drawing creation	17
● Carved text	18
● Engraving vector files	19
● Engraved image	20
Reference for engraving parameters of each material	21
Frequently asked questions and solutions	22

产品介绍

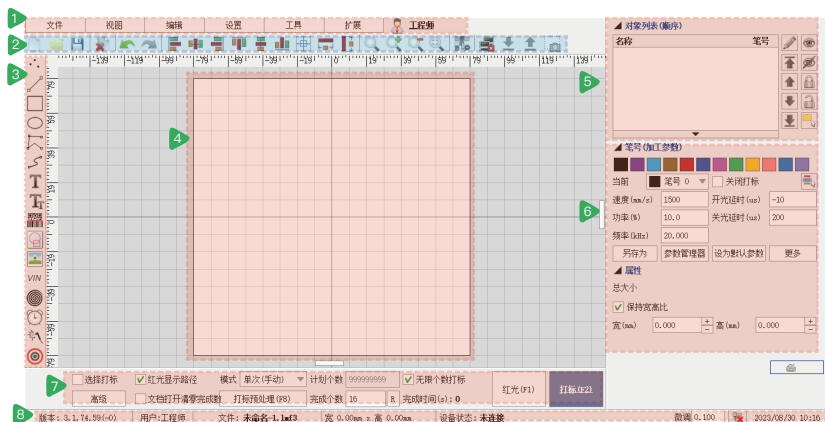
★ 958H各部位说明



型号: 958H	波长: 1064nm
功率: 70W	散热方式: 风冷
电压: AC100-220V	寿命: > 10000H
屏幕尺寸: 200*150mm	打标深度: 0.015-0.5mm
打标线宽: 0.05-0.01mm	打标精度: 0.01mm
产品尺寸: 320*510*660mm	打标速度: ≤10000mm/s
包装尺寸: 410*600*790mm	文件格式: JPG/JPEG/BMP/PNG、PLT/DXF
产品重量: 40kg	光斑形状: 圆点
包装重量: 53kg	操作方式: 内置电脑

软件各功能简介

★ 鼠标在功能图标上停留，会显示该图标对应的说明；



1 菜单栏

5 对象列表窗

2 系统工具栏

6 对象属性栏

3 绘图工具栏

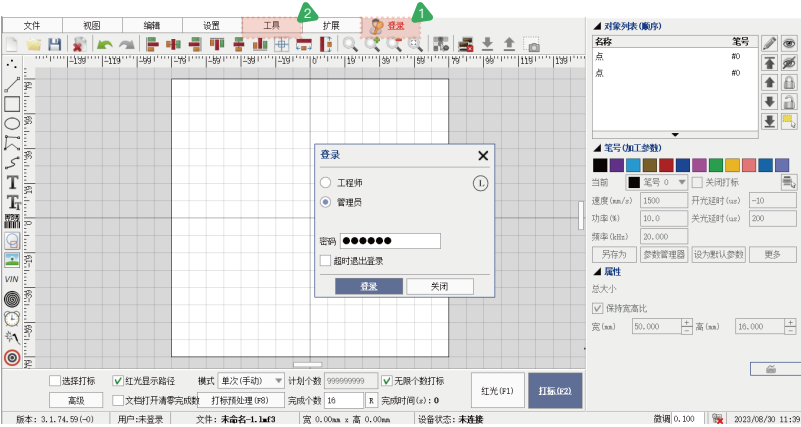
7 标刻控制栏

4 内容显示框

8 状态栏

系统语言切换

★ 包含多种语言



1 点击登录管理员模式  管理员 密码 (111111)

2 点击菜单栏中的工具选择系统



选择对应语言



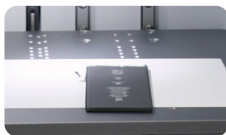
3 修改完成后，关闭机器重新启动一下，则自动显示对应语言。

界面切换/显微镜操作

★ 开始雕刻前注意调焦，两个红外线光点重合后打出的效果更佳（允许有偏差）

激光焊接操作

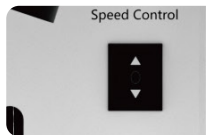
- 1 将需要焊接的物品放在工作平台上，按下自动对焦（也可通过手动对焦进行焦点重合效果更好）



工作平台上



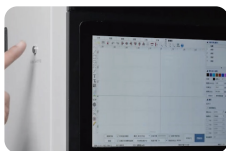
自动对焦



手动对焦

- 2 操作界面画下需要焊接的图形，可通过红光预览对位

- 3 按下界面切换按钮，进行画面切换



操作界面



显微镜界面

- 4 转动镜头调节与平移可调节镜头清晰度与位置



清晰度调节

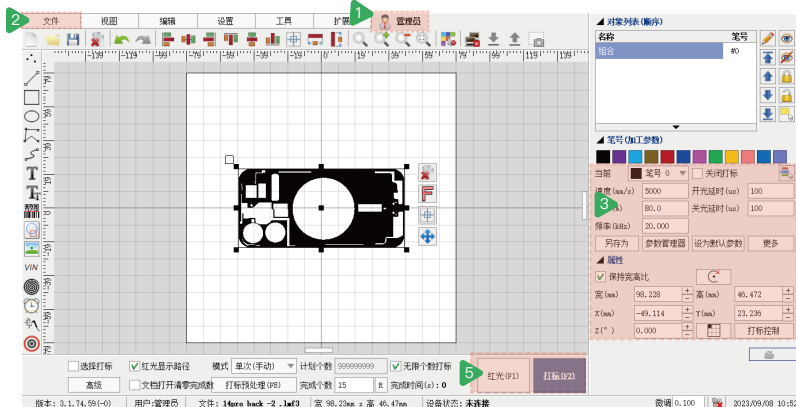


位置调节

- 5 踩下脚踏开关或者按下启动按钮进行激光焊接

拆手机后盖

★ 开始雕刻前注意调焦，两个红外线光点重合后打出的效果更佳（允许有偏差）



1 登录管理员模式  **管理员**

2 点击：文件-打开-DrawingG-选择手机品牌-选择手机型号-打开

3 调好参数，打标速度:3000-5000、功率:95，根据手机进行调整。

4 沿固定条放置好手机，按下Focus对焦。

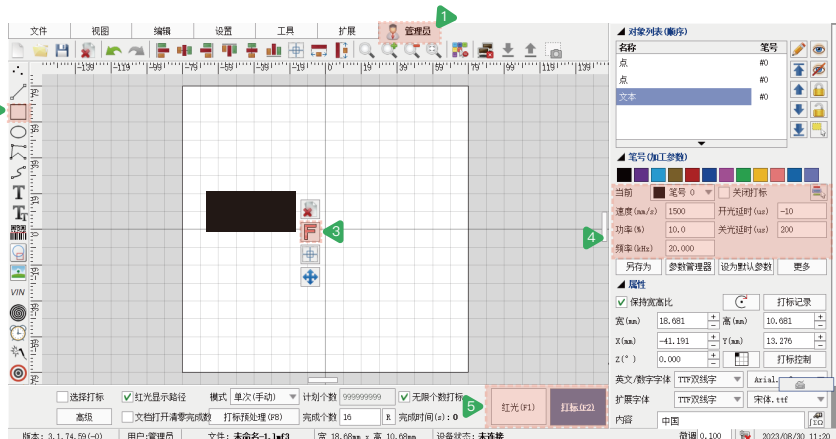
5 按下F1(红光预览) 检查红光是否与手机重叠



6 按下F2开始打标  （可打开排气开关进行排烟）

图纸创建

★ 开始雕刻前注意调焦，两个红外线光点重合后打出的效果更佳（允许有偏差）



1 登录管理员模式  管理员

2 点击矩形工具  创建一个与屏幕尺寸大小的矩形，可通过属性栏输入宽高尺寸

3 点击填充菜单  填充菜单里面勾选启用功能 ☒ 启用 让空心矩形变成实体。

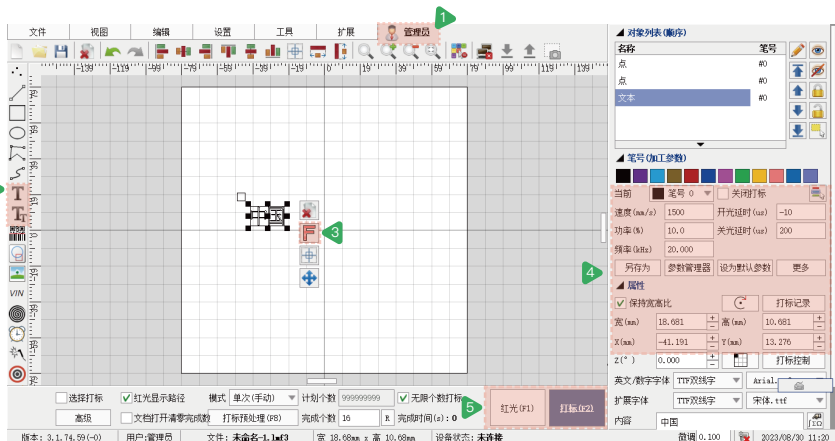
4 在属性栏调整好功率和速度以及雕刻内容的大小尺寸。

5 雕刻前先预览内容位置  红光(F1) 确认内容大小位置后  打标(E2)

注意：参数数据仅供参考，拆手机支架/屏幕等参数请根据实际情况调节！

雕刻文字

★ 开始雕刻前注意调焦，两个红外线光点重合后打出的效果更佳（允许有偏差）



1 登录管理员模式  管理员

2 点击静态文本或组合文本  

（静态文本：可输入固定文本内容）

（组合文本：组合文本类型包括静态文本、时间、日期、扫描枪、序列号、数据库、

换行符、挂接文本、随机码、串口通讯和网络通讯。）再次点击内容显示区域，弹出输入框就可以输入需要雕刻的内容。

3 点击填充菜单  填充菜单里面勾选启用功能  启用 让空心字体变成实心字体。

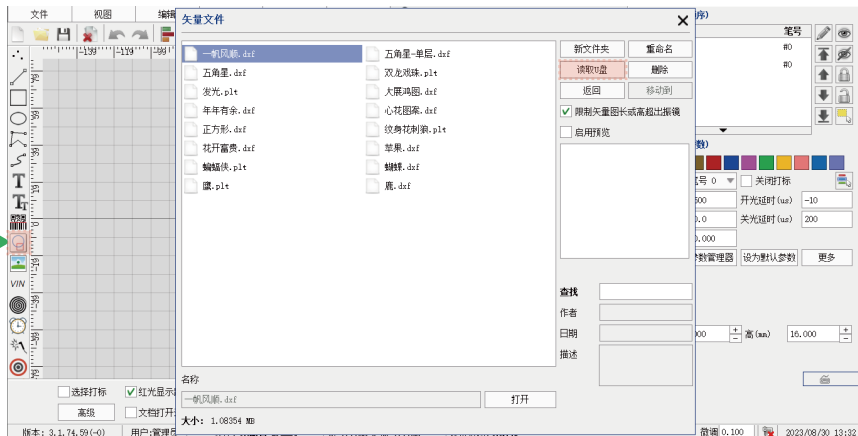
4 在属性栏调整好功率和速度以及雕刻内容的大小尺寸。

5 雕刻前先预览内容位置  确认内容大小位置后



雕刻矢量文件

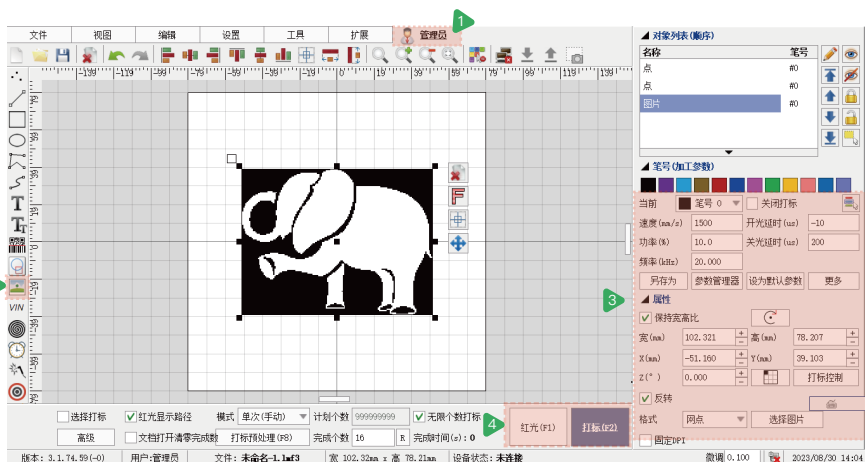
- ★ 开始雕刻前注意调焦，两个红外线光点重合后打出的效果更佳（允许有偏差）
(矢量文件支持格式：DXP/PLT)



- 1 登录管理员模式  **管理员**
- 2 点击绘图工具栏中的矢量文件图标  选择需要打开的矢量文件
(U盘导入矢量文件：点击矢量文件中右上角的读取U盘，打开U盘中的矢量文件即可)
- 3 点击填充菜单  填充菜单里面勾选启用功能  让空心字体变成实心字体。
- 4 在属性栏调整好功率和速度以及雕刻内容的大小尺寸。
- 5 雕刻前先预览内容位置  确认内容大小位置后 

雕刻图像

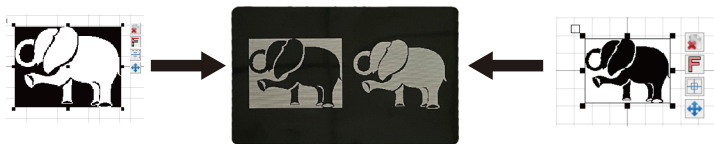
- ★ 开始雕刻前注意调焦，两个红外线光点重合后打出的效果更佳（允许有偏差）
（图像文件支持格式：JPG/JPEG/PNG/BMP）



- 1 登录管理员模式  管理员

- 2 点击绘图工具栏中的图像文件图标  然后在内容显示框中随意点击一下弹出图像窗口
（U盘导入图像文件：点击图像文件中右上角的读取U盘，打开U盘中的图像文件即可）

- 3 在属性栏调整好功率和速度以及雕刻内容的大小尺寸。格式选择（网点）格式 
☒ 反转 反转：基于图像内容，白转黑、黑转白（黑色部分打标，白色部分不打标）



默认参数：速度1000 功率90

- 4 雕刻前先预览内容位置  确认内容大小位置后 

各材质雕刻参数参考

文字、矢量文件

材料	线间距	功率	速度
金属	0.03~0.001	100	500~800
漆面材料	0.08、0.01	50~100	800~1000
塑料	0.1~0.05	30~100	1000~1500
皮革	0.08~0.01	50~100	1000~1500

每一种材质我们先用最浅的参数测试雕刻，打完看效果再重新调整参数以达到最佳理想效果，材料不移动的情况下，我们可以重复雕刻(线间距越大、功率越低、速度越小，打出来痕迹越浅。反之越深)，上述参数只是参考，请根据实际效果和要求来自行更改参数。

图片（普通位图）

材料	图片设置	功率	速度
金属	格式（网点） 反转（根据图像内容自由勾选）	100	500~800
漆面材料		50~100	800~1000
塑料		30~100	1000~1500
皮革		50~100	1000~1500

每一种材质我们先用最浅的参数测试雕刻，打完看效果再重新调整参数以达到最佳理想效果，材料不移动的情况下，我们可以重复雕刻，上述参数只是参考，请根据实际效果和要求来自行更改参数。

常见问题及解决方案

· 机器通电无反应

未通电:检查插座、开关、机身电源插座等确保已插接到位且正常通电:
检查面板上面的Power电源键, 确保该键按下且键身灯光亮起

· 雕刻效果很浅或没有痕迹

- 1.对焦不准:阅读使用手册对焦部分进行准确对焦。
- 2.雕刻速度:过快, 灼烧时间过短所致, 阅读使用手册雕刻参数部分重新调整参数
- 3.图片过浅:导入的图片要清晰, 线条过细, 颜色过浅会直接影响雕刻效果
- 4.雕刻物摆放:被雕物体倾斜放置, 焦距是固定的, 所以被雕物体要放平, 与机身平行反之则焦距不准, 导致雕刻效果异常。

· 不出光, 漏光等;

解决方案: ①检查电源是否正常供电, 110V或者220V.

②是否对应机器的电压.

③更换配件或者电源.

· 电脑开机不正常, 出现以下问题;

- a.进入加载页面或者进入修复页面.
- b.电脑指示灯闪烁, 无法正常开机.
- c.电脑闪屏.
- d.显示屏不亮.

解决方案: ①检查电源线是否松动.

②电脑指示灯是否亮蓝灯.

③更换显示屏或者电脑.

· 板卡出现以下问题;

- a.板卡驱动丢失, 无法找到软件.
- b.板卡参数丢失.
- c.客户误删参数软件, 无法运行.

解决方案: ①查看板卡是否正常亮灯.

②板卡信号线是否有松动.

③重新插拔信号线.

④更换板卡.



Safety Precautions

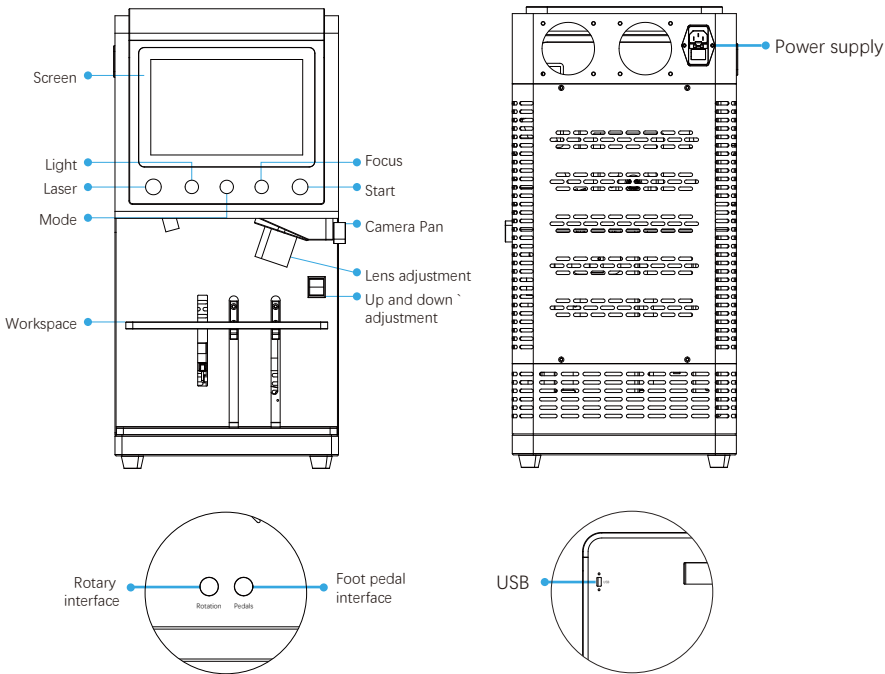
In order to prevent damage to your personal and property safety, and to use this product safely and correctly, please read the user manual carefully and follow the steps in the user manual.

Matters needing attention

- ★ Before operating the equipment, users must read the manual carefully and strictly abide by the operating procedures.
- ★ Processing objects and emissions should comply with local laws and regulations.
- ★ The environment where the equipment is located should be dry, free of pollution, vibration, strong electricity, strong magnetism and other interference and influence. The working environment temperature is 10-40°C, and the working environment humidity is 5-95% (no condensation).
- ★ Equipment working voltage: AC100-240V.
- ★ The engraving machine and other related equipment must be safely grounded before it can be powered on.
- ★ The equipment needs to be on duty at all times when it is powered on. All power supplies must be cut off before personnel leave to prevent abnormal conditions from occurring. If any abnormality occurs, please cut off the power immediately!
- ★ It is strictly prohibited to place any irrelevant total reflection or diffuse reflection objects in the device.
- ★ The equipment should be kept away from electrical equipment that is sensitive to electromagnetic interference and may cause electromagnetic interference to it.
- ★ Disassembly by non-professionals is strictly prohibited.
- ★ After 3-5 hours of continuous use, you need to cut off the power and rest for about 5 minutes to dissipate heat to protect the interior from damage and keep the interior clean.

Product introduction

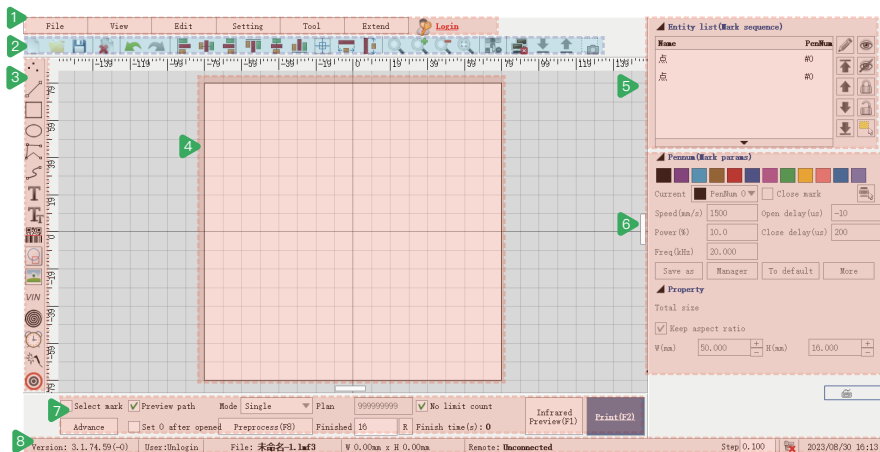
★ Description of each part of 958H



Model: 958H	Wavelength: 1064nm
Power: 70W	Cooling: Air-cooled
Voltage: AC100-220V	Lifespan: >10,000 hours
Screen Size: 200*150mm	Marking Depth: 0.015-0.5mm
Marking Line Width: 0.05-0.01mm	Marking Accuracy: 0.01mm
Product Dimensions: 320*510*660mm	Marking Speed: ≤10,000 mm/s
Packaging Dimensions: 410*600*790mm	File Formats: JPG/JPEG/BMP/PNG, PLT/DXF
Product Weight: 40kg	Spot Shape: Dot
Packaging Weight: 53kg	Operation: Built-in Computer

Brief introduction of software function

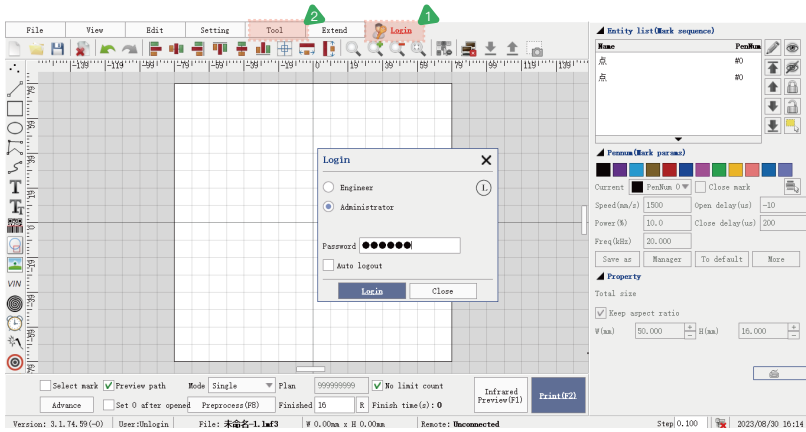
- ★ When the mouse stays on the function icon, the corresponding description of the icon will be displayed;



- 1** Menu Bar
- 2** System toolbar
- 3** Drawing toolbar
- 4** content display box
- 5** object list window
- 6** Object property bar
- 7** Mark control bar
- 8** Status Bar

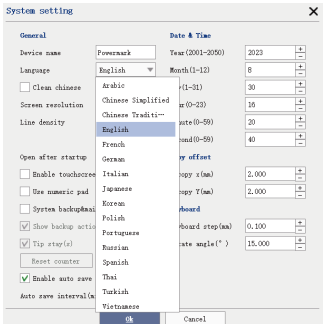
System language switching

★ Include multiple languages



1 Click to log in to administrator mode  **Login** Password (111111)

2 Click Tools Select System in the menu bar
Select the corresponding language



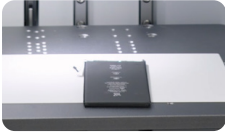
3 After the modification is completed, shut down the machine and restart it, and the corresponding language will be automatically displayed.

Display Toggle

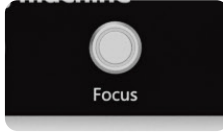
- ★ Pay attention to the focus before starting to engrave, the effect will be better when the two infrared light spots overlap (deviations are allowed)

Laser welding operations

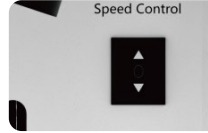
- 1 Place the object to be welded on the work surface and press autofocus. (You can also use manual focus for better focusing.)



On the work platform



Autofocus



Manual focus

- 2 Draw the graphics to be welded on the operation interface, and the alignment can be previewed by red light

- 3 Press the interface switch button to switch the screen



Operation interface



Microscope interface

- 4 Rotating lens adjustment and panning can adjust the lens clarity and position



Clarity adjustment

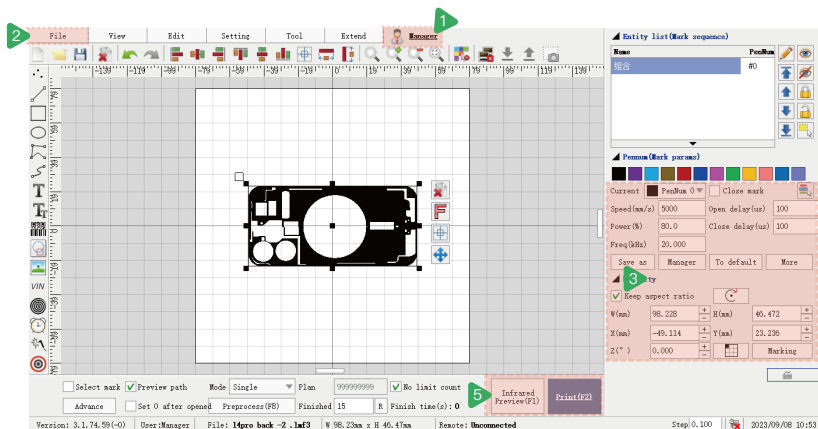


Position adjustment

- 5 Step on the foot switch or press the start button to start laser welding

Remove the back cover of the mobile phone

- ★ Pay attention to the focus before starting to engrave, the effect will be better when the two infrared light spots overlap (deviations are allowed)



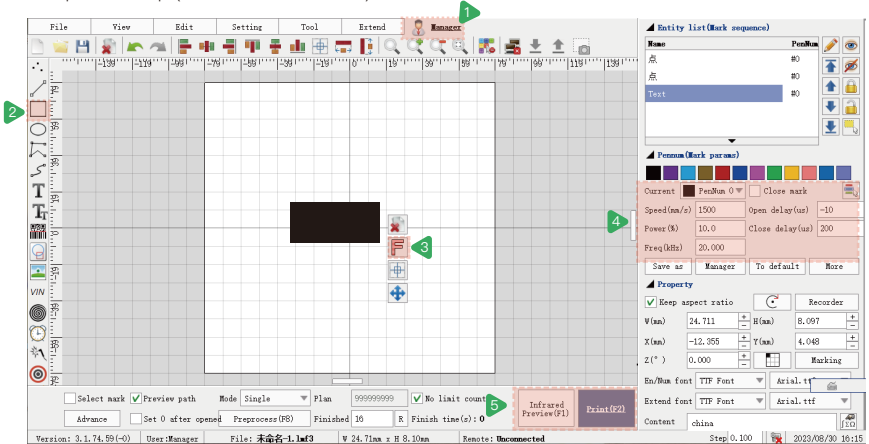
- 1 Click to log in to administrator mode 
- 2 Click: File–Open–DrawingG–Select the mobile phone brand–
Select the mobile phone model–Open
- 3 Adjust the parameters, marking speed: 3000–5000, power: 95, adjust according to the mobile phone.
- 4 Place the phone along the fixing bar and press Focus to focus.
- 5 Press F1 (Red light preview) to check whether the red light overlaps with the phone



- 6 Press F2 to start marking 
(you can turn on the exhaust switch to exhaust smoke)

Drawing creation

- ★ Pay attention to the focus before starting to engrave, the effect will be better when the two infrared light spots overlap (deviations are allowed)

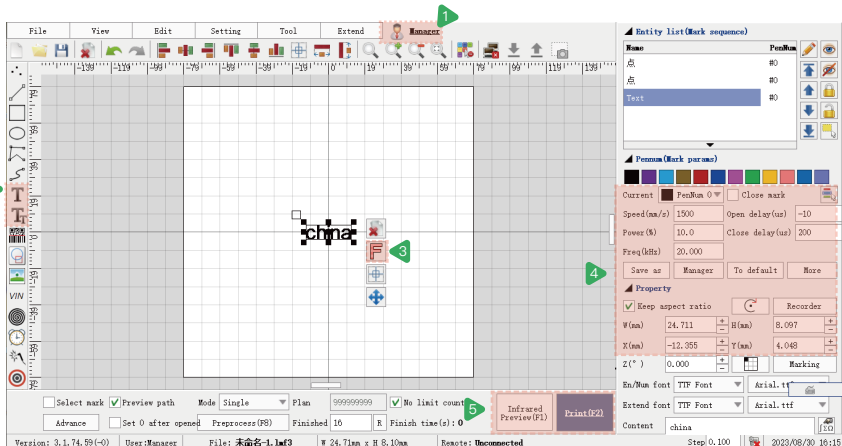


- 1 Click to log in to administrator mode 
- 2 Click the Rectangle tool  Create a rectangle the same size as the screen. You can enter the width and height in the property bar.
- 3 Click the Fill menu  In the Fill menu, check Enable.  Make the hollow rectangle solid.
- 4 Adjust the power, speed and size of the engraving content in the property bar.
- 5 Preview content location before engraving 
After confirming the content size and position 

Note: The parameter data is for reference only. Please adjust the parameters such as mobile phone holder/screen according to the actual situation when disassembling it!

Carved text

- ★ Pay attention to the focus before starting to engrave, the effect will be better when the two infrared light spots overlap (deviations are allowed)



1 Click to log in to administrator mode  **Manager**

2 Click on static text or combined text  
 (Static text: fixed text content can be entered)
 (Combined text: Combined text types include static text, time, date, scanner, serial number, database, Line breaks, hook text, random codes, serial communication and network communication.) Click the content display area again, The input box pops up and you can enter the content that needs to be engraved.

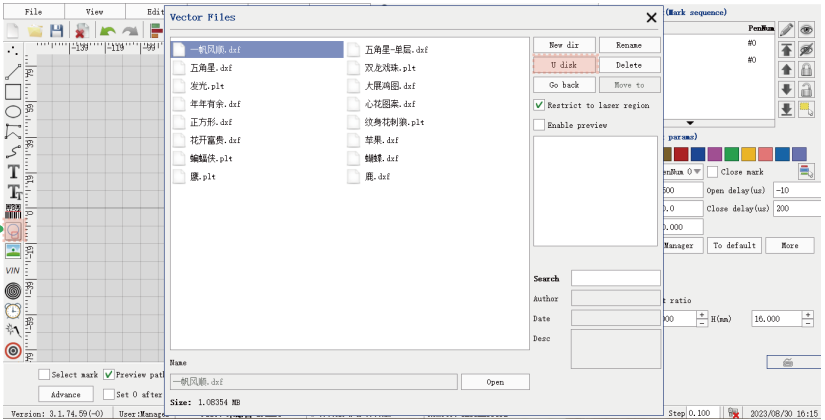
3 Click fill menu  Fill in the menu and check Enable function 
 Convert hollow fonts to solid fonts.

4 Adjust the power and speed as well as the size of the engraving content in the property bar.

5 Preview content location before engraving 
 After confirming the content size position 

Engraving vector files

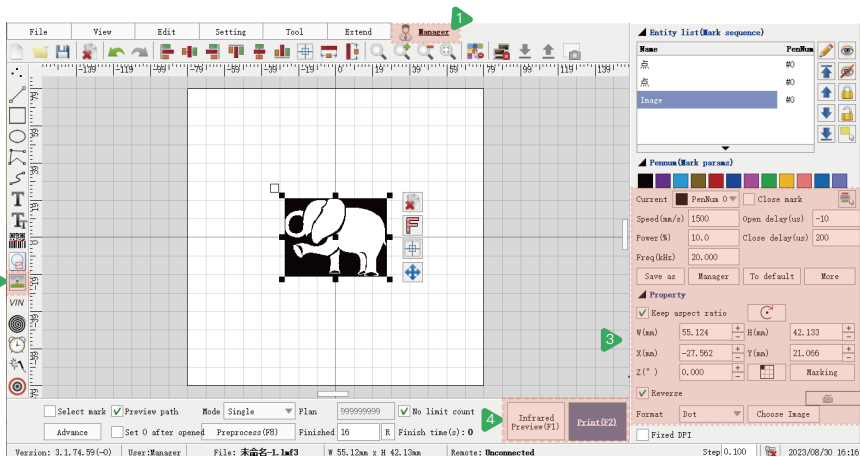
- ★ Pay attention to focus before starting engraving, the effect will be better when the two infrared light spots overlap (deviation is allowed) (Vector file support format: DXP/PLT)



- 1 Click to log in to administrator mode 
- 2 Click the vector file icon in the toolbar  Select the vector file to open
(To import vector files from U disk: click Read U Disk in the upper right corner of the vector file and open the vector file in the U disk)
- 3 Click fill menu  Fill in the menu and check Enable function 
Convert hollow fonts to solid fonts.
- 4 Adjust the power and speed as well as the size of the engraving content in the property bar.
- 5 Preview content location before engraving 
After confirming the content size position 

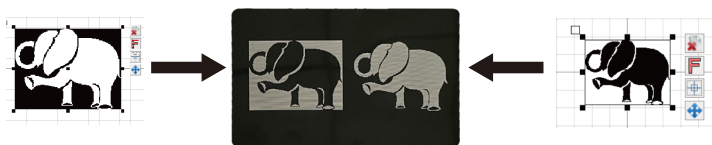
Engraved image

- ★ Pay attention to the focus before starting engraving, the effect will be better when the two infrared light spots overlap (deviation is allowed) (image file support format: JPG/JPEG/PNG/BMP)



- 1 Click to log in to administrator mode  **Manager**
- 2 Click the image file icon in the toolbar  Then click randomly in the content display box to pop up the image window (U disk to import image files: click on the upper right corner of the image file to read the U disk, and open the image file in the U disk)
- 3 Adjust the power and speed and the size of the engraved content in the property bar. Format selection (site) Format Dot

☒ Reverse Inversion: based on image content, white to black, black to white (marking on black parts, not marking on white parts)



Default parameters: speed 1000 power 90

- 4 Preview content position before engraving

After confirming the content size position



Reference for engraving parameters of each material

Text, vector files

Material	line pitch	power	speed
Metal	0.03~0.001	100	500~800
Paint material	0.08、0.01	50~100	800~1000
plastic	0.1~0.05	30~100	1000~1500
leather	0.08~0.01	50~100	1000~1500

For each material, we first test the engraving with the shallowest parameters, and then readjust the parameters to achieve the best ideal effect after checking the effect. Materials vary. While moving, we can engrave repeatedly (the larger the line spacing, the lower the power, the smaller the speed, the shallower the marks will be. Vice versa, the deeper), The above parameters are just for reference, please change the parameters by yourself according to the actual effect and requirements.

Picture (normal bitmap)

Material	picture settings	power	speed
Metal	format (dot) Reverse (freely check according to the image content)	100	500~800
Paint material		50~100	800~1000
plastic		30~100	1000~1500
leather		50~100	1000~1500

For each material, we first test the engraving with the shallowest parameters, and then readjust the parameters to achieve the best ideal effect after checking the effect. Materials vary. In the case of moving, we can repeat the engraving, the above parameters are just for reference, please change the parameters by yourself according to the actual effect and requirements.

Frequently asked questions and solutions

- The machine does not respond when powered on

Not powered on: Check the sockets, switches, power sockets on the body, etc. to ensure they are plugged in and powered on normally:

Check the Power button on the panel to make sure it is pressed and the light on the button is on.

- The engraving effect is very light or no traces

1. Inaccurate focus: Read the focus section of the user manual to get accurate focus.
2. Engraving speed: too fast, caused by too short burning time. Read the engraving parameter section of the user manual to readjust the parameters.
3. The picture is too light: The imported picture must be clear. The lines are too thin and the color is too light, which will directly affect the engraving effect.
4. Place the engraving object: If the object to be engraved is placed at an angle, the focal length is fixed, so the object to be engraved should be placed flat. Otherwise, the focus will be inaccurate and the engraving effect will be abnormal.

- No light, light leakage, etc.;

Solution: ① Check whether the power supply is normal, 110V or 220V.

②Whether it corresponds to the voltage of the machine.

③Replace accessories or power supply.

- The computer does not boot properly and the following problems occur;

- a. Enter the loading page or enter the repair page.
- b. The computer indicator light flashes and cannot be turned on normally.
- c. Computer splash screen.
- d. The display screen does not light up.

Solution: ① Check whether the power cord is loose.

②Whether the computer indicator light is blue.

③Replace the display screen or computer.

- The following problems occur with the board;

- a. The board driver is missing and the software cannot be found.
- b. Board parameters are lost.
- c. The customer deleted the parameter software by mistake and could not run it.

Solution: ① Check whether the board lights up normally.

② Check whether the board signal cable is loose.

③Reinsert and unplug the signal cable.

④Replace the board.

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本说明书中展示的所有图示仅用作示例说明用途，实际外观请以所购买的产品为准。由于产品不断升级，部分参数可能有所更改，更改后的参数恕不另行通知，请以本产品铭牌参数为准。

Disclaimer With the technical update of the product, the content of the product instruction manual of the same model as this product may be changed, and the updated part will not be notified in advance.

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Due to continuous product upgrades, some parameters may be changed. The changed parameters will not be notified. Please refer to the nameplate parameters of this product.



Repair electronics Expert

Professional R&D and production of LCD screen repair equipment