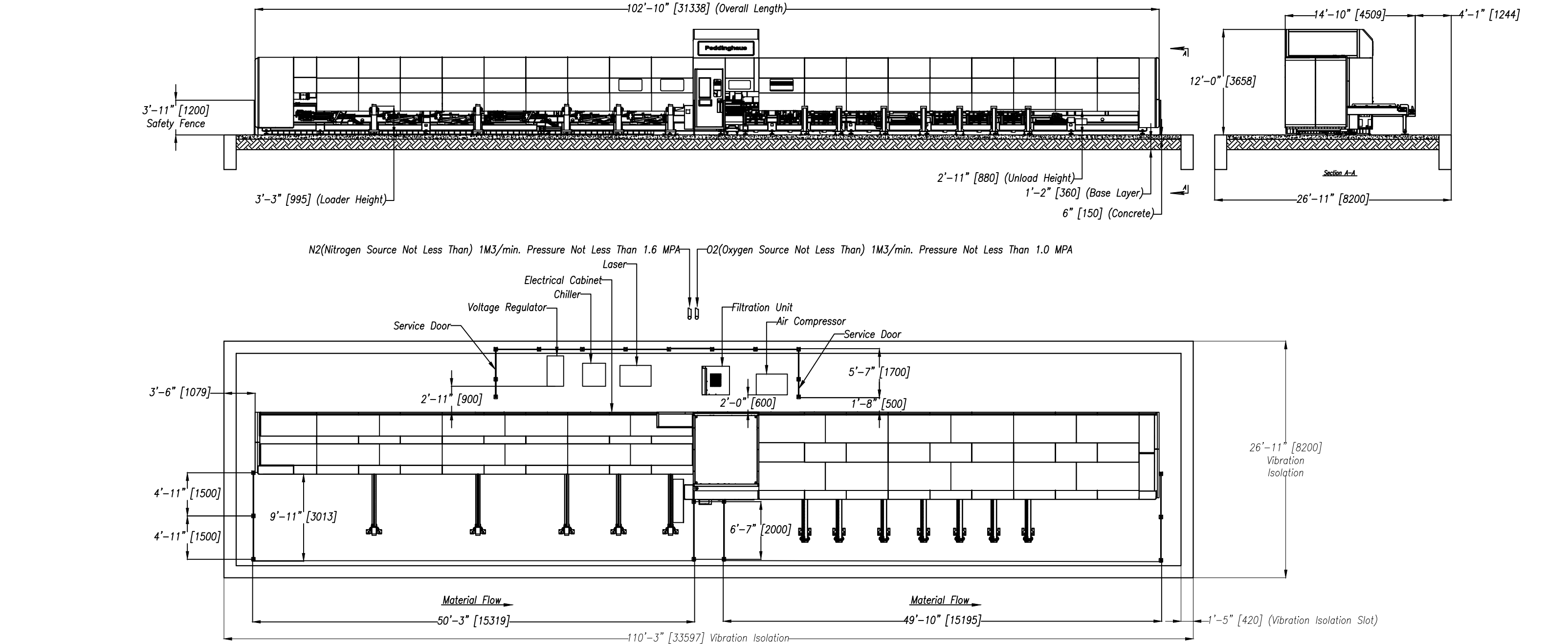
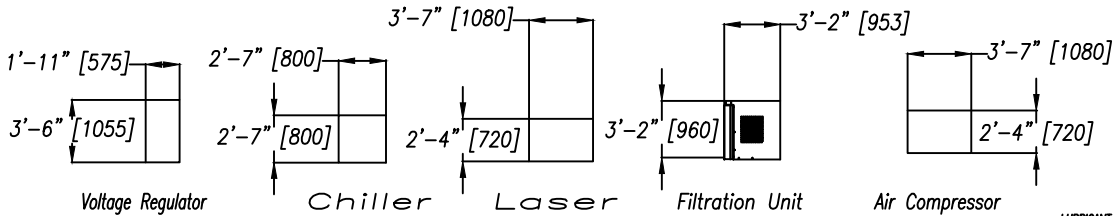




- Introduction:
- 1.) Industrial earthing can be adopted for the construction of laser cutting machine (in case ground earthing network is not provided around the workshop), earthing resistance shall be <4.
 - 2.) The weigh-bearing capacity of ground level shall be 56000kg/m2 at least, The flat level of horizontal ground shall be $\leq \pm 25\text{mm}$.
 - 3.) Requirement of working environment: temperature shall be between 10~40 °C, relevant humidity shall be below 20% - 70%.
 - 4.) Minimum Concrete Thickness 6" [150mm.]
 - 5.) Maximum amplitude of vibrations : Horizontal 0.01mm, Vertical 0.05mm; from peak to peak for frequencies below 15 Hz. Amplitude cannot increase to more than 10 dB per frequency decade if values are higher than 15 Hz.
 - 6.) It is recommended to install the laser in a separate room, and the laser can be installed separately from related auxiliary equipment such as chillers and dust filters. In addition, leave heat dissipation space in the chiller unit, and the distance between the chiller and the wall should be greater than 1.5m; Leave ventilation space at the vent of the dust collector device, and the distance between the dust collector and the wall should be greater than 1m.
 - 7.) It is recommended that air-compressor equipment and fan shall be placed outside the room.
 - 8.) It is recommended that water outlet is installed nearby the chiller as it is convenient for the cleaning of chiller.
 - 9.) A temperature constant room with air conditioner is suggested to install in the workshop to locate the laser source, and the room should have the proper door location which is suitable for maintenance and service .
 - 10.) The requirements of power supply of equipment: equipped with the control loop of separate protection function, and shall be leaded to the area nearby AC stabilized electric power source. Earth terminal (with size 300×100×10)
 - 11.) According to the actual position and size of the cable feeding port, make a cable trench (250mm wide and 250mm deep), and install a cover plate to cover the trench. The surface of the wiring duct should be flat to ensure that the cable will not break. If there is a vibration source near the equipment, an isolation trench should be built near the equipment.
 - 12.) At least 2.5m free space at the right side of the cutting machine for the residue extraction workpiece.
 - 13.) The cement grade shall not below 425#.
 - 14.) The dimensions of all attachments are for reference only, not as acceptance condition; the brand of attachments is subject to the contract.



GAS QUALITY:
O2 99.995% PURE, Clean, Dry, Oil-Free
N2 99.99% PURE, Clean, water free, Oil-Free
and oxygen free (H2O $\leq 100\text{ppm}$, CH4 $\leq 1\text{ppm}$,
OHC $\leq 5\text{ppm}$) Clean, Dry, Oil-Free

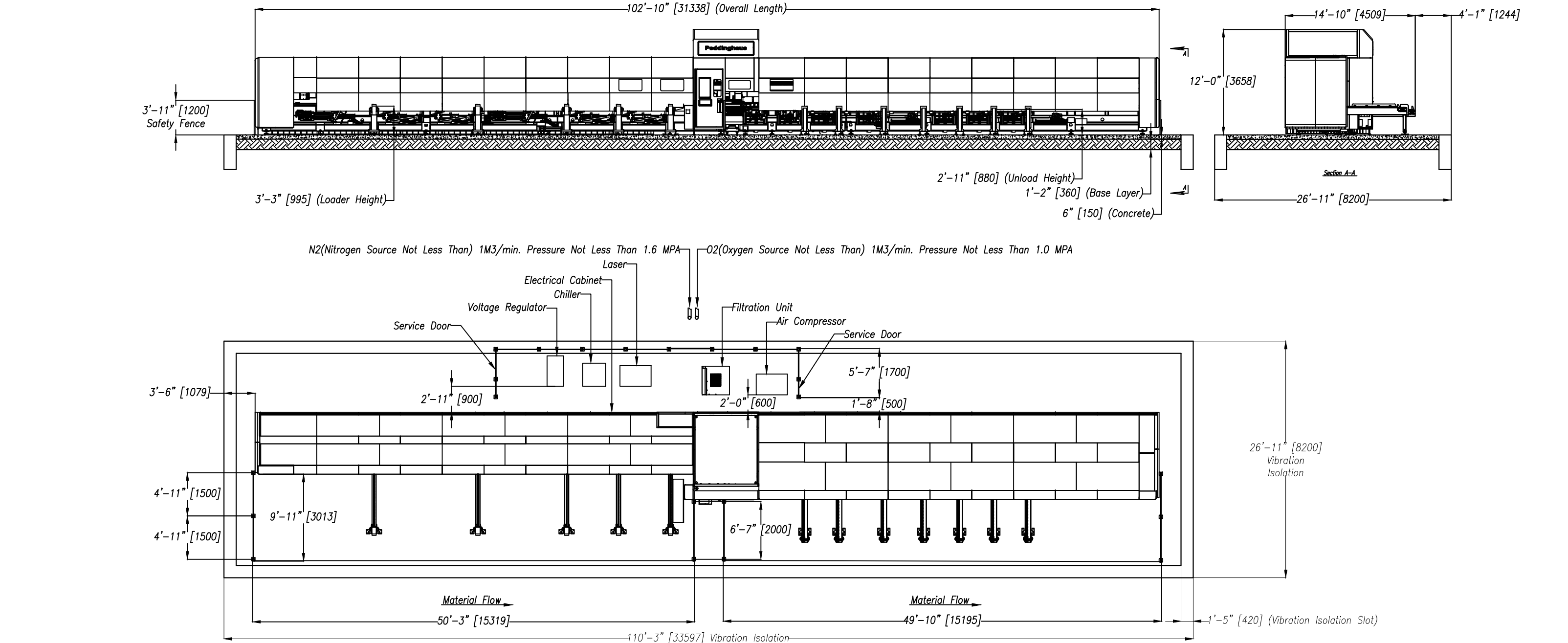
REQUIRED FLOW RATES & INLET PRESSURES
OXYGEN 0-290 psi AT 100 cfm
NITROGEN 0-580 psi AT 170 cfm
AIR Cutting 220 psi AT 74 cfm

Peddilaser Tube 12 KW NOTES:
1.) Primary 480 V, 3 Ph., 60 Hz. [Req'd @ each]
Total K.V.A. for Peddilasers WPC = 151.88 K.V.A. (Distribution Panel)
Total K.V.A. for Stabilizer = 120 K.V.A. (150 Amp Circuit Breaker)
Total K.V.A. for Chiller = 17.25 K.V.A. (32 Amp Circuit Breaker)
Total K.V.A. for Dust Collector = 7.05 K.V.A. (16 Amp Circuit Breaker)
Total K.V.A. for Air Compressor/Dryer = 28.21 K.V.A. (50 Amp Circuit Breaker)
The customer must provide power to all five of the above-listed items through a distribution panel.
2.) Air Requirement (Machine Only): 120 PSIG, not less than 32 SCFM Min. Free Air
3.) Cooling Water (DI Water): Deionized, demineralized, or distilled water (32 Gal. Total)

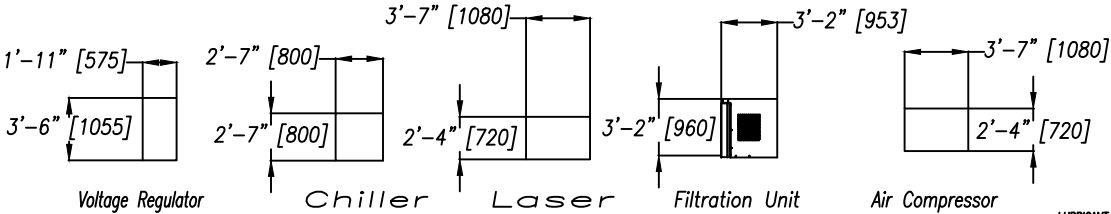
LUBRICANT OIL REQUIREMENTS:
Tellus S2V 32, 48, 68
Filling Capacity: 10L
Note: Any of the three can be used. Once a specific type is determined, there is no need to replace it later.
Used For Gear, Rack and Slider
HYDRAULIC OIL STATION:
Tellus S2 V32 L-HS32
Filling Capacity: 70L
Note: Anti-wear hydraulic oil (Ultra-low temperature)

Note: Anchor Bolts Provided With The Machine.
Note: Heavy-duty regulators for Oxygen and Nitrogen are provided with the machine.
Any customer supplied air compressor must meet the above-stated requirements.

				Peddinghaus Corp.				IMPORTANT Safety Note!			
E				BRADLEY, ILL. U.S.A.				Because of the difficulty to effectively guard the full length of the system it is the customers responsibility to prevent access by unauthorized personnel and to provide safe crossing.			
D				Peddilaser Tube 12036				DRAWN BY: SCALE: 3/16" = 1" DATE: 5-26-26			
C				40'-0" [12M] Sytem				DRWG. NO.			
B				For							
A											
LET.				THIS PRINT IS THE PROPERTY OF PEDDINGHAUS CORP. AND IS NOT TO BE USED IN ANY MANNER DETRIMENTAL TO THE INTERESTS OF SAID COMPANY							
REVISION/C.N.#				BY				DATE			



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OHC $\leq 5\text{ppm}$) Clean, Dry, Oil-Free

REQUIRED FLOW RATES & INLET PRESSURES
OXYGEN 0-290 psi AT 100 cfm
NITROGEN 0-580 psi AT 170 cfm
AIR Cutting 220 psi AT 74 cfm

Peddilaser Tube 20 KW NOTES:
1.) Primary 480 V, 3 Ph., 60 Hz. [Rec'd @ each]
Total K.V.A. for Peddilasers WPC = 199.83 K.V.A. (Distribution Panel)
Total K.V.A. for Stabilizer = 150 K.V.A. (180 Amp Circuit Breaker)
Total K.V.A. for Chiller = 29.38 K.V.A. (50 Amp Circuit Breaker)
Total K.V.A. for Dust Collector = 7.05 K.V.A. (16 Amp Circuit Breaker)
Total K.V.A. for Air Compressor/Dryer = 28.21 K.V.A. (50 Amp Circuit Breaker)
The customer must provide power to all five of the above-listed items through a distribution panel.
2.) Air Requirement (Machine Only): 120 PSIG, not less than 32 SCFM Min. Free Air
3.) Cooling Water (DI Water): Deionized, demineralized, or distilled water (53 Gal. Total)

LUBRICANT OIL REQUIREMENTS:
Tellus S2V 32, 48, 68
Filling Capacity: 10L
Note: Any of the three can be used. Once a specific type is determined, there is no need to replace it later.
Used For Gear, Rack and Slider
HYDRAULIC OIL STATION:
Tellus S2 V32 L-HS32
Filling Capacity: 70L
Note: Anti-wear hydraulic oil (Ultra-low temperature)

Note: Anchor Bolts Provided With The Machine.
Note: Heavy-duty regulators for Oxygen and Nitrogen are provided with the machine.
Any customer supplied air compressor must meet the above-stated requirements.

Peddinghaus Corp.				IMPORTANT Safety Note!	
BRADLEY, ILL. U.S.A.				Because of the difficulty to effectively guard the full length of the system it is the customers responsibility to prevent access by unauthorized personnel and to provide safe crossing.	
PeddiLaser Tube 12036				DRAWN BY:	SCALE: 3/16" = 1"
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