English

VARIMAT 700

Leister Quality System (LQS)

Leister Technologies AG
Galileo-Strasse 10
6056 Kaegiswil
Switzerland

+41 41 662 74 74
leister@leister.com

leister.com

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Congratulations on the purchase of your VARIMAT 700.
You have chosen a first-class hot-air welder.
It was developed and produced in accordance with the latest state-of-the-art technology in the plastics-processing industry.
It has also been manufactured using high-quality materials.

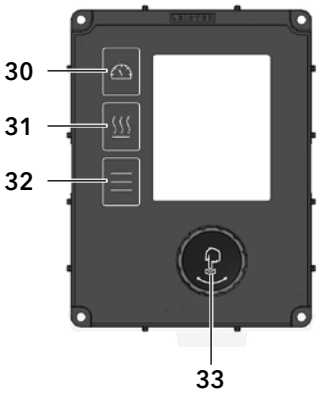
Please always store these operating instructions with the device.

VARIMAT 700 with Leister Quality System (LQS)

You can find more information on the VARIMAT 700 at leister.com

1. Operating Unit

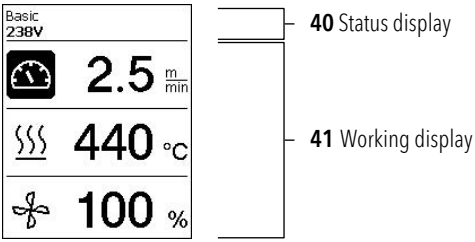
1.1. Function keys



30. Button *Drive On/Off*
31. Button *Heating On/Off*
32. Button *Menu*
33. *e-Drive*

1.2. Display areas

The display is subdivided into two display areas:



1.3. Display description

1.3.1. Status display "Section 1" (40)

Name of the saved value	Welding parameters currently selected. If names consist of more than 6 characters, the first 6 characters are shown first, followed by the remaining characters.
226 V	Current supply voltage at power plug
No. 2	Current file number of the welding data record

1.3.2. Icons for the status display "Area 2" (40)

Warning present

Data recording

Overvoltage

Eco mode

GPS data reception

Undervoltage

WLAN

Stop Device on Alert switched on

Heating

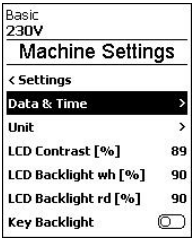
Application protection switched on

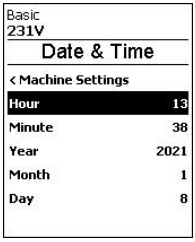
Application protection active

2. Overview of the LQS Settings

2.1. Machine settings

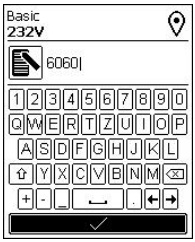
Date & Time

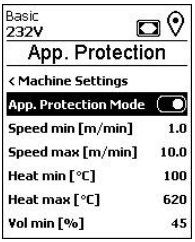




Setting date and time.

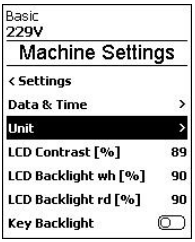
App. Protection

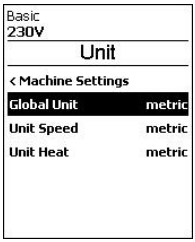




After entering the password (6060), you can activate the Application Protection Mode.
The range of the setpoints can be limited here as required.

Unit





Global unit

Setting the unit used (metric/imperial) for Unit Speed and (°C/°F) for the Unit Heat.

Unit Speed

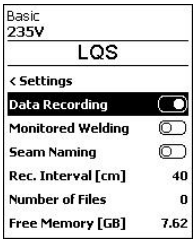
Individual setting of the unit used for speed (metric/imperial).

Unit Heat

Individual setting of the unit used for heat (metric/imperial).

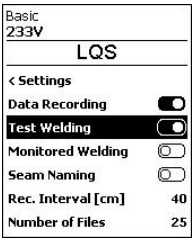
2.2. Settings LQS

LQS



If Data Recording is activated, the welding data is logged.

Test Welding



If Test Welding is switched on, you can make a test weld before the actual welding process.

Monitored Welding

If Monitored Welding is switched on, limit values of the recorded welding parameters are logged.

Stop Device on Alert

If Stop Device on Alert is activated, the drive and the heater are switched off after 30 seconds if the limit value is exceeded. The limit values can be set:

Standard values are:

Speed 4 %
Temperature +/-10 °C
Blower speed 3 %.

Audible Alarm

If the Audible Alarm is switched on, an acoustic alarm sounds when the limit value is exceeded.

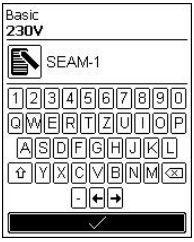
Alarm Speed tol. [%]
Alarm heat tol. [°C]
Alarm vol. tol. [%]

If Stop Device on Alert is deactivated, the limit values can be set individually.

Seam Naming

If Seam Naming is activated, the freely selectable "SeamName" is added to the file name.

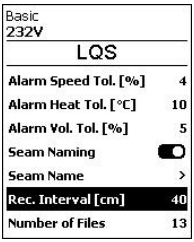
Seam Name



Enter a name affix. This name affix is attached to the file name.

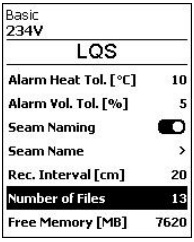
Protocol number: 20210303-SEAM-1

Recording interval



This allows determining the recording interval.
After covering a distance interval, a dataset of welding data is recorded and saved.

Number of Files

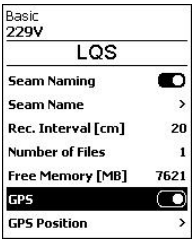


Number of new recording files. These files must be synchronized in order to evaluate them using the myLeister App. Each day, the numbering of the files restarts at 001.

Free Memory Space

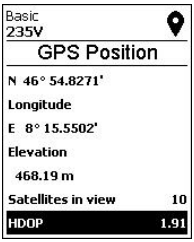
Free memory space on the memory card.
Capacity: at least 8 GB.

GPS



If GPS is activated, position information is recorded by the GPS module.

GPS Position



Current geographic position if the GPS module has sufficient satellite reception and can determine a position.

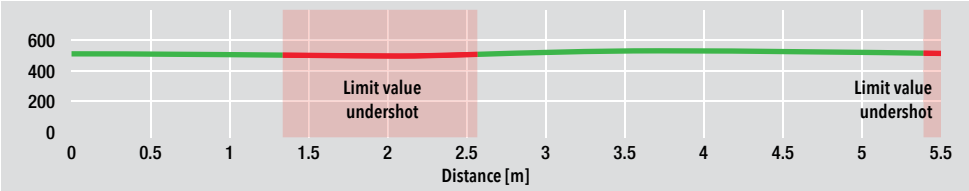
3. Functional Description of Welding Data Recording

- The welding data recording function logs temperature, speed, blower power and supply voltage during the welding process along the weld's length at predefined distance intervals.
- Optionally, if applicable, the additional weight is also logged.
- Limit values can be set for temperature, speed and blower power.
- During welding data recording, the automatic welder logs when a limit value is left and emits an acoustic and visual alarm signal. Monitored welding and Audible alarm must be activated for this.
- The recorded data are analyzed through the separate myLeister App user software.

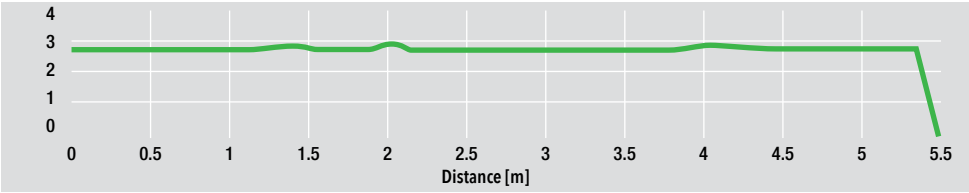
The graphic shown below shows the process of welding with Stop Device on Alert activated. Horizontally, the distance over the weld seam length is listed in each case. Vertically, temperature, speed, blower power and mains voltage are recorded in the relevant diagrams.
In this example, the mains voltage at the end of the welding process is so low that the temperature limit (-10°C) can no longer be maintained. The machine stops the welding process.

Seam number 1 (Stop Device on Alert)

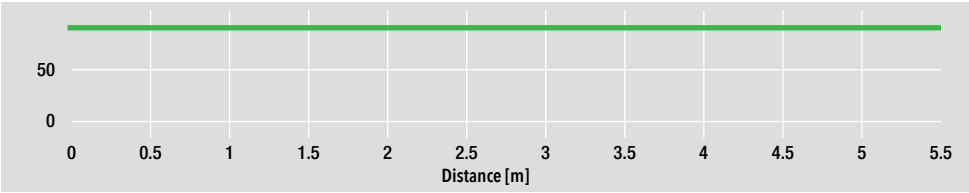
Hot air temperature [°C]



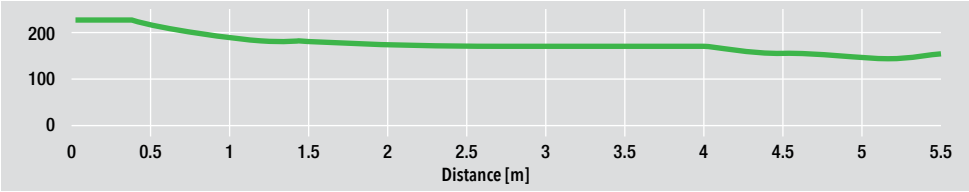
Speed [m/min]



Air volume [%]



Voltage [V]



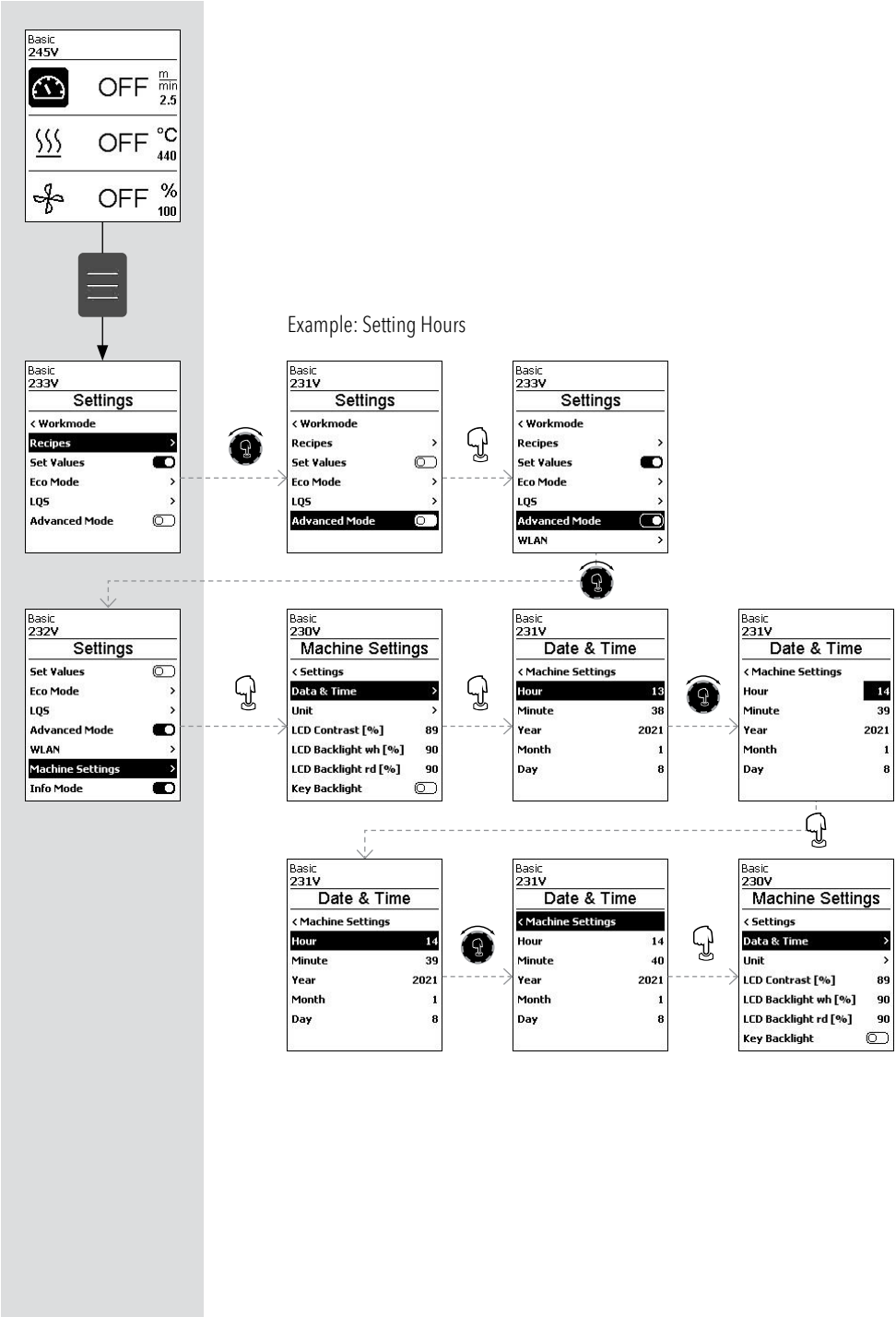
4. Preparing for Welding Data Recording

In the Machine Settings menu, check Unit and Date & Time and adjust, if necessary.

In the LQS menu, the following parameters must be set before the welding data are recorded:

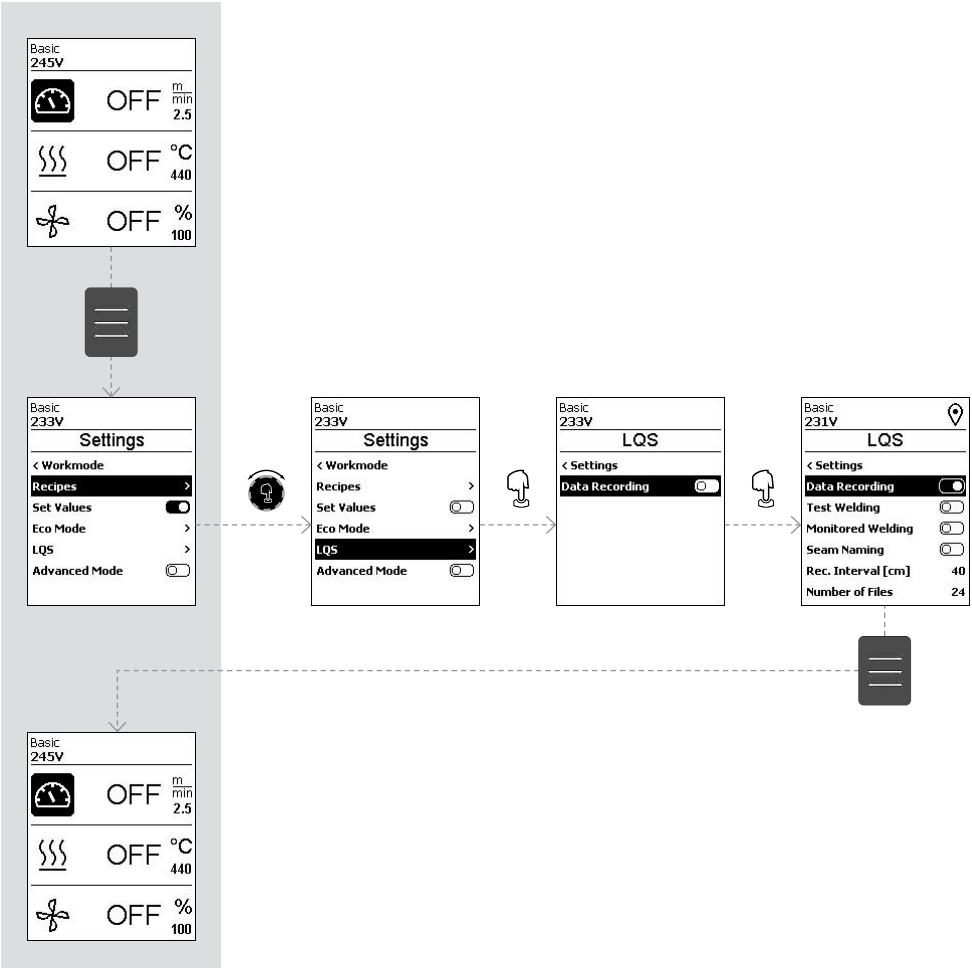
- check whether welding data recording Data Recording is activated
- Optionally, as required: Activate Test Welding, Monitored Welding and Stop Device on Alert
- activate or deactivate the acoustic alarm Audible Alarm as needed
- if Stop Device on Alert is switched off, set limit values for speed, temperature and blower power as required
- optional as needed: Activate or deactivate name suffix Seam Naming
- optional as needed: enter joint name suffix Seam Name
- set distance interval for recording
- Deactivate or activate GPS position recording as needed

4.1. Settings Machine settings

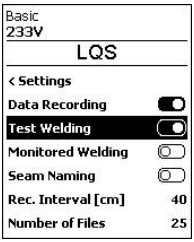


4.2. Settings LQS

4.2.1. Switching on data recording



4.2.2. Test Welding



If Test Welding is switched on, a test weld can be performed before the actual welding process.

4.2.3. Monitored Welding

If Monitored welding is switched on, limit value deviations from the recorded welding parameters are logged.
If you only want to record the welding data without monitoring, you can deactivate Monitored Welding.

4.2.4. Stop Device on Alert

If Stop Device on Alert is switched on, the welding process is stopped after 30 seconds if a limit value deviation occurs. The limit values are automatically adopted according to the table below.

Parameters		Value		Imperial value
Alarm Speed tol.	[%]	2	[%]	2
Alarm Heat tol.	[°C]	10	[°F]	50
Alarm vol. tol.	[%]	3	[%]	3

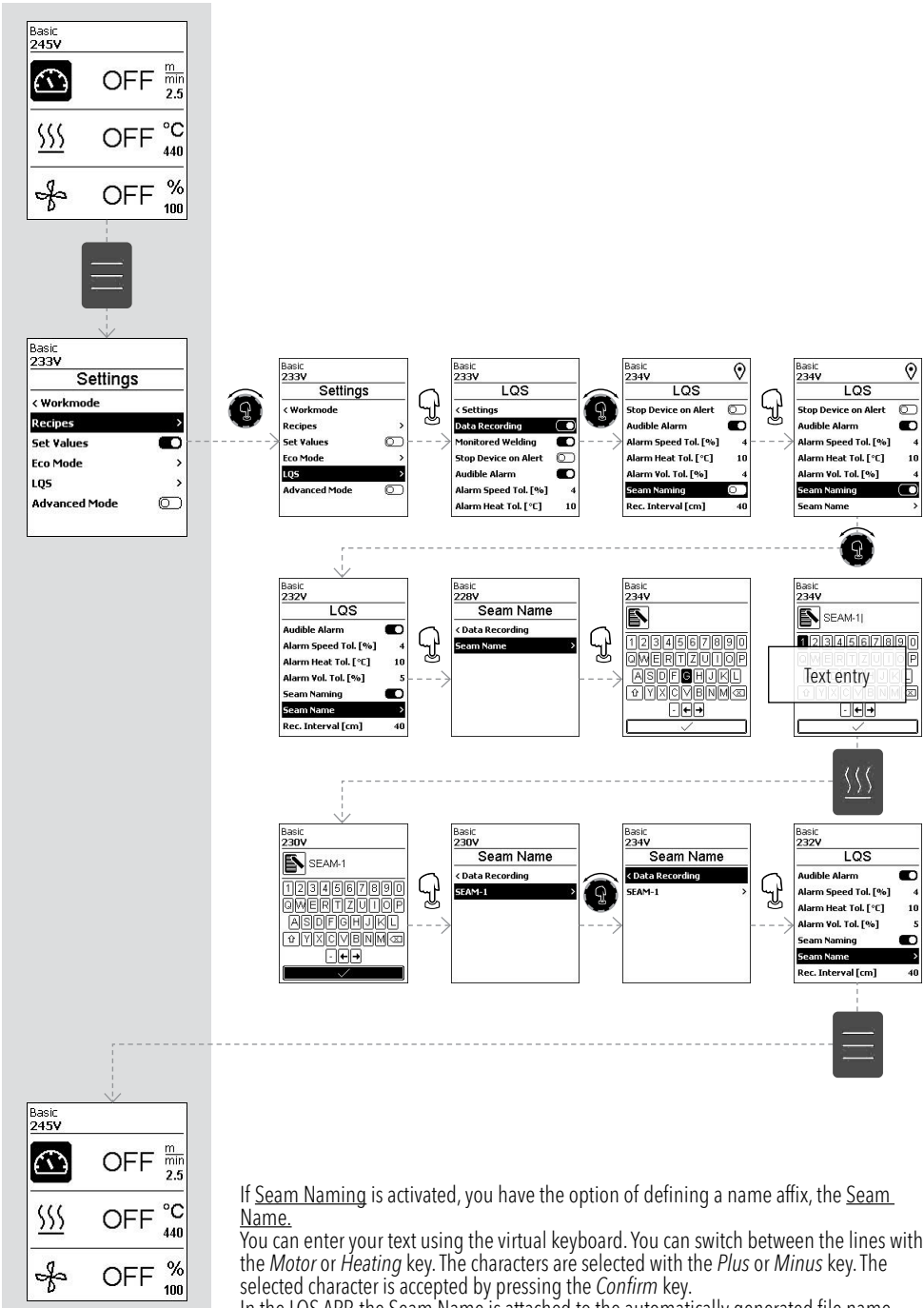
If Stop Device on Alert is switched off, you can set the limit values individually according to the table below.

Parameters		Setting range		Setting range imperial
Alarm Speed tol.	[%]	2–10	[%]	2–10
Alarm Heat tol.	[°C]	5–30	[°F]	41–86
Alarm vol. tol.	[%]	2–10	[%]	2–10
Rec. Interval	[cm]	10–2000	[in]	4–787

4.2.5. Audible Alarm

If Audible Alarm is switched on, an acoustic alarm sounds when the limit value is exceeded.
If you do not want an audible alarm, you can deactivate Audible Alarm.

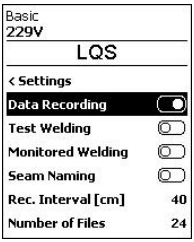
4.2.6. Seam Naming



If Seam Naming is activated, you have the option of defining a name affix, the Seam Name.
You can enter your text using the virtual keyboard. You can switch between the lines with the *Motor* or *Heating* key. The characters are selected with the *Plus* or *Minus* key. The selected character is accepted by pressing the *Confirm* key.
In the LQS APP, the Seam Name is attached to the automatically generated file name.

Protocol number: 20210303-SEAM-1

4.2.7. Recording Interval



You can set the recording interval individually according to the following table. Factory setting 40 cm.

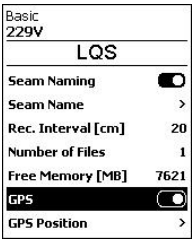
Parameters		Setting range		Setting range imperial
Rec. Interval	[cm]	10–2000	[in]	4–787

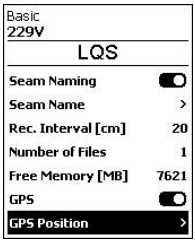
4.2.8. Geographical position

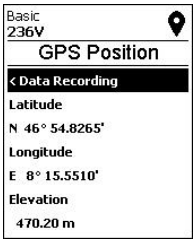
If GPS is switched on, the GPS position data is logged in the data recording file.

In the status line (40), the symbol is displayed when GPS reception is sufficient and position information is available. The symbol flashes when, for example, reception is insufficient and it waits for a valid position information.

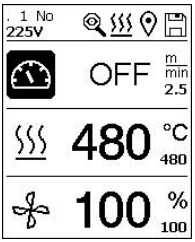
Note: The WLAN connection status is also displayed in the same position in the status line. If a WLAN connection to the myLeister App is present, the symbol is displayed, even when GPS position information is available.







5. Running Welding Data Recording



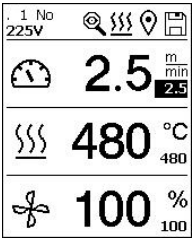
- Set parameters for welding data recording.
- Set the target values for temperature, speed, and blower power (see the device operating instructions).
- Switch on the heater.

In the status line (40), the file number is displayed alternately in the supply voltage display, and the symbol flashes.

If Stop Device on Alert is activated, the symbol is also displayed.

If GPS is activated, the symbol is also displayed.

If the GPS symbol flashes, satellite data is sought. If the GPS symbol is black, GPS data are available. If the GPS symbol remains white, no data can be received.



The drive and recording start as soon as the welding nozzle is inserted into the overlap. In the status line (40), the file number of the file is displayed alternately to the supply voltage display and the symbol is shown.
If a set alarm value is exceeded during the welding process and Monitored Welding is switched on, this state is shown on the screen by a red backlight.

Remove the welding nozzle from the overlap at the end of the weld.
The drive and recording are stopped.
The next log file is being prepared. In the status line (40), the file number of the new file is displayed alternately to the supply voltage display and the symbol flashes.

Finish welding

- After finishing welding work, switch off the heater.
- Wait until Cool down is finished
- Switch off device with main switch.

6. Welding Data Recording

6.1. Representation of limit value exceedance

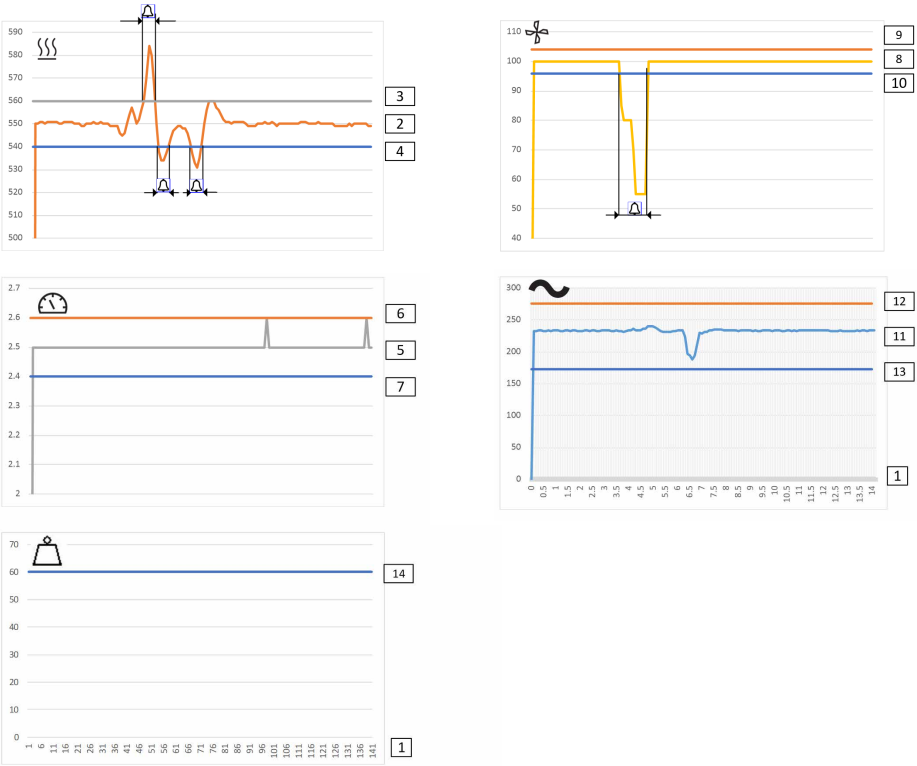
If Monitored Welding is activated, temperature, speed, blower power and mains voltage are continuously monitored during welding to ensure that they are within the defined limit values.

If a limit value is exceeded, this case is displayed on the device and logged in the data file.

The backlight of the display flashes red. If the Audible Alarm is switched on, an additional alarm signal sounds.

If Stop Device on Alert is activated, the welding process is stopped after 30 seconds in the event of a limit value deviation.

The limit values for the mains voltage are firmly defined. If the measured mains voltage is <25% >20%, the welding process is also stopped. Regardless of whether Stop Device on Alert or Monitored Welding is activated.



1. Distance
2. Current temperature limit
3. Maximum temperature limit
4. Minimum Temperature limit
5. Current speed
6. Maximum Speed limit
7. Minimum speed limit
8. Current blower power
9. Maximum blower power limit value
10. Minimum blower power limit value
11. Current mains voltage
12. Maximum permissible mains voltage
13. Minimum permissible mains voltage
14. Additional weight (optional)

If a parameter leaves the respective limit value, the backlight of the display changes to red. If Audible Alarm is activated, an additional alarm signal sounds. If Monitored Welding is activated, the limit deviation is logged in the data file. If Stop Device on Alert is activated and the limit value deviation takes longer than 30 seconds, the welding process is interrupted.

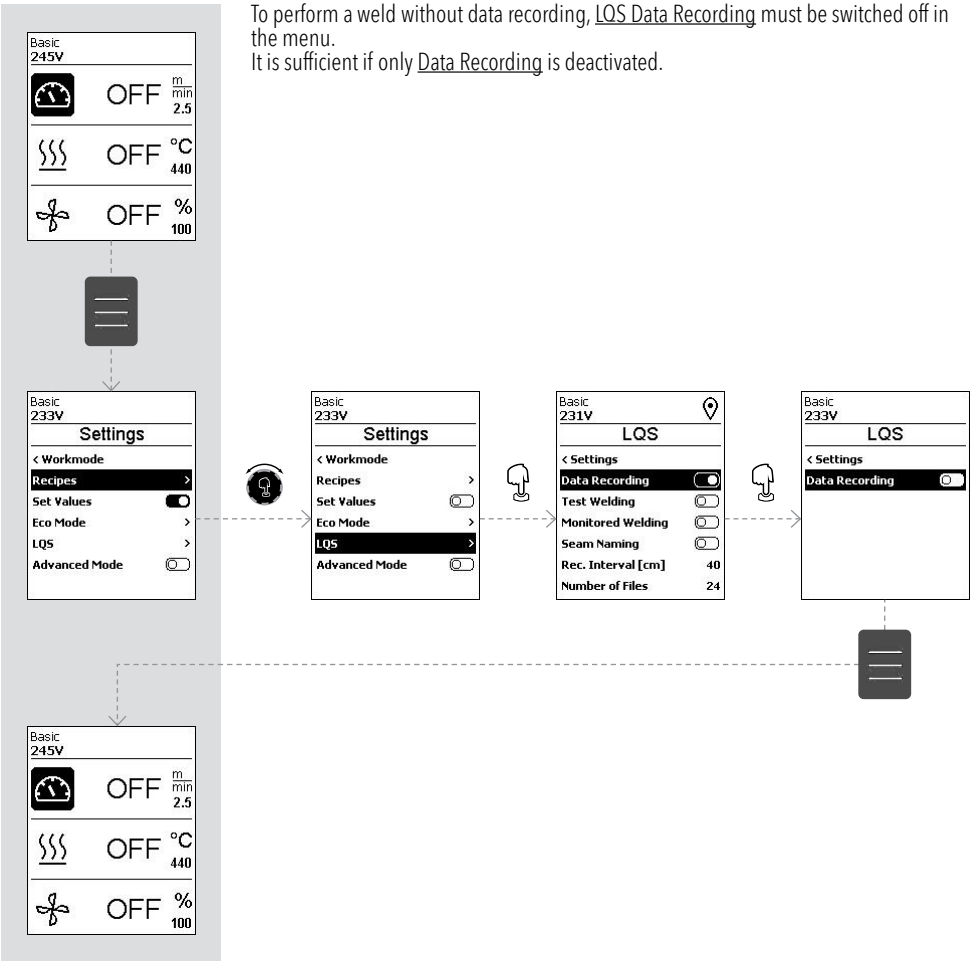
6.2. Welding data files

A welding data file is created for each welding process. The welding process starts when the welding nozzle is swiveled in and ends when the welding nozzle is retracted. A weld consists of at least one welding process.

The name of the welding data file consists of the device identifier, date, time, a serial number, and optional file name affix.
The serial number starts with 001 at the start of each new day and can be a maximum of 999.

7. Welding Without Recording of Data

To perform a weld without data recording, LQS Data Recording must be switched off in the menu.
It is sufficient if only Data Recording is deactivated.



8. Behavior of Data Recording in Case of Power Outage

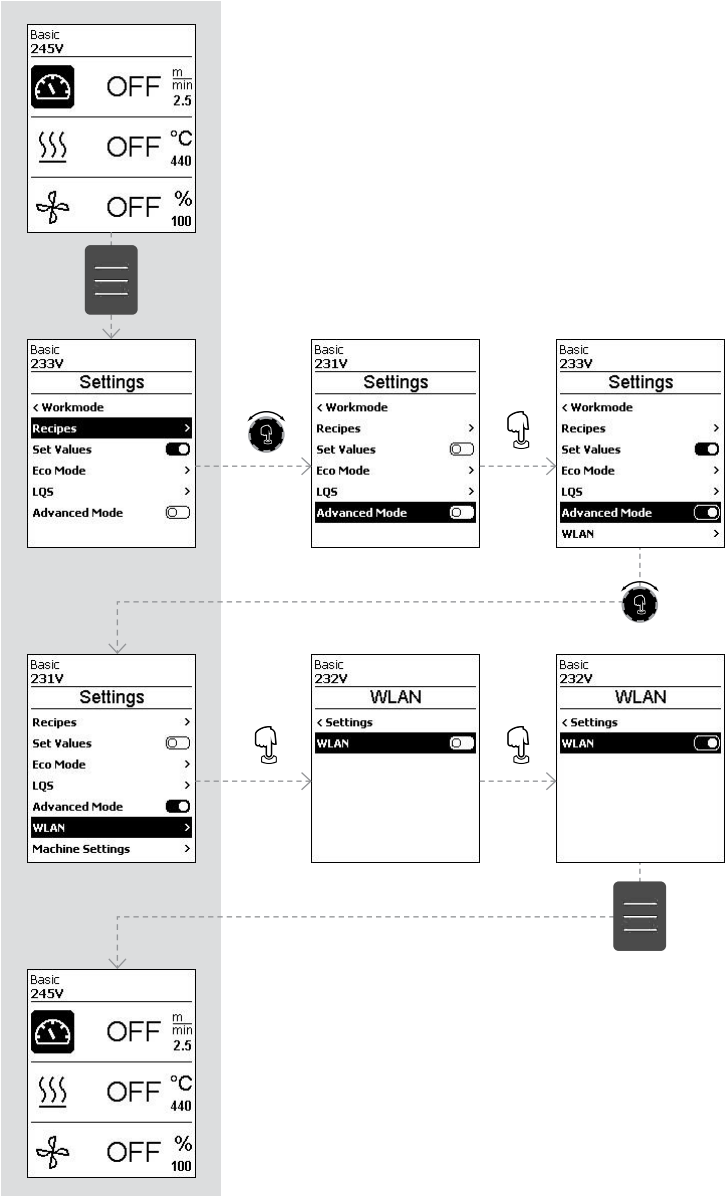
Condition of device prior to power outage	Duration power outage	Condition of device after power outage
Drive and heater are switched on (welding process and data recording).	≤ 5 sec	The device continues to run without a restart safeguard with the same settings as before the outage. Data recording continues and the data is added to the file that was created before the power outage.
Drive and heater are switched on (welding process and data recording).	> 5 sec	The device starts up and the start display appears on the screen. The welding data that was recorded before the outage is contained in the log file.
The device is not welding.	–	The device starts up and the start display appears on the screen.

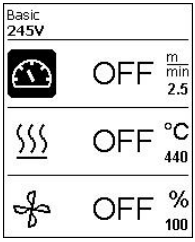
9. Data Synchronization

The welding data files recorded by the automatic welder are read by the myLeister App and synchronized. The WLAN module of the automatic welder must be switched on for this purpose.

Important: Synchronize data regularly with the myLeister App. Otherwise, unsynchronized welding data can be lost on the device, e. g. in the event of a malfunction of the operating unit.

9.1. Switching on the WLAN module





WLAN connection status display

The data exchange between the automatic welder and the myLeister App is carried out via the myLeister App.
In the status line (40), the symbol is displayed when the automatic welder is connected to the myLeister App.

10. Warnings and Error Messages

- If there is a warning, the user can continue to work. More detailed information on the warning can be accessed via the keypad in the Settings menu under Warnings.
  Important: If one of the warnings listed below occurs, data recording cannot be used.
- If an error occurs, the unit turns off the heater and the drive is no longer released.

Display	Error code / Warning message	Error description
0200 0100	Unknown HMI Version	An error occurred during the initialization of the operating unit [1]
0200 0080	Date/Time	An error occurred during the initialization of the date and time function.
0200 0040	Date/Time	The current date and time information is invalid.
0200 0020	Memory Full	Memory card for data recording is full. The symbol flashes in the status line (40) during data recording.
0200 0008	Memory Card Access	A problem with the memory card occurred during data recording. In this case, welding data is no longer recording, but welding continues. The symbol flashes in the status line (40).
0200 0004	WLAN Module Access	There is a problem with the WLAN module [2]
0200 0010	GPS Module Comm.	The GPS module is not sending any data [3]

[1] In this case, the basic functions of device operation are available to the user, allowing them to weld without data recording.

[2] Data recording can be used when these warnings are displayed. In these circumstances, it must be ensured that data cannot be transferred from the device to the myLeister App due to the problem.

[3] Data recording can be used when these warnings are displayed. It must be ensured that no position data is in the data file when the GPS is activated.

Error code / Warning message	**Action**
Unknown HMI Version	Switch off the device and restart after a few seconds [4]
Date/Time	Switch off the device and restart after a few seconds [4]
Invalid Date/Time	Set date and time in the Settings menu under Machine Settings at Date & Time.
Memory Full	Synchronize date with the myLeister App [4]
Memory Card Access	Switch off data recording in the menu and restart: ▪ Switch the drive off. ▪ In the Settings menu under LQS, set Data Recording to 0. ▪ After a few seconds, reset Data Recording to 1 and exit menu. ▪ Restart the drive. (Heating must also be switched on.) ▪ The log file is prepared. The warning should no longer be displayed in the status line (40). If the warning is still generated: ▪ *Switch off drive* and *heater*. ▪ Switch off the device with the *main switch*. ▪ Restart the device after a few seconds. ▪ Restart *heater* and *drive*. ▪ The log file is prepared. The warning should no longer be displayed in the status line (40) [4]
WLAN Module Access	Switch off the device and restart after a few seconds [4]
GPS Module Comm.	Switch off the device and restart after a few seconds [4]

[4] If the warning is still displayed, contact the Leister Service Center.

11. Quick Guide LQS App

App version
myLeister 2.10.0

About this document
This quick guide describes the most important steps on the following topics:

- Initial Start
- Set up Cloud work mode Shared
- Devices
- LQS Functions
- Recipes
- Tools
- Documents
- Settings

11.1. First start

When first starting the app, you will be requested to accept the end user licensing agreement and the data protection statement.

Read both documents carefully and acknowledge them to enable you to use the app.

Registration/Login
- As soon as you have accepted the end user licensing agreement and the data protection statement, you are prompted to log in.
- If you already have a Microsoft, Google, or Facebook user account and would like to use this account for the app, please log in with this user account.
- If you want to create a new user account, please select Register now.

In the new window, enter the following information:
- E-mail address: Enter a current valid e-mail address. You will receive a confirmation e-mail sent to this e-mail address.
- Click on Send verification code.
  Check the mailbox of the e-mail address indicated. The confirmation e-mail contains a code.
- Enter the code in the input field and press Check code to complete the process.
- New password: Assign your password.
- Confirm new password: Enter the selected password again.
- First name: Enter your first name here.
- Last name: Enter your last name here.
- Display name: Enter your first name and last name here.
- Industry sector: Enter here the industry sector in which your company is active.
- Click on Create to complete this process.

Your private cloud will then be configured in the background. You alone have access to these data. Your work mode will be set to Private Cloud.

If you already have a myLeister user account, you can simply log in and you will have access to your cloud data.

Update your existing LQS app with work mode Local
If you have used an existing LQS installation in local mode on your terminal and this installation has now been updated to the new myLeister App, you can skip the login when starting and continue working with your local data as usual.

Important
In this work mode, your data is only located on your workstation.
To protect yourself against data loss, we recommend that you regularly back up your data from your workstation.

Important
Subsequent transfer of local data to the cloud is impossible.

11.2. Update existing LQS app with Cloud work mode

If you have used an existing LQS installation in Cloud mode on your terminal and this installation has now been updated to the new myLeister App, you will automatically be logged in with your user data. Your existing cloud data will automatically be stored in a shared cloud. All users with the respective authorizations will also be transferred.

Furthermore, a private cloud will set up for you to which only you have access. Your work mode will automatically be set to shared cloud so that you have direct access to your existing LQS data.

11.3. Configuring the Cloud Sharing work mode

With the Cloud Sharing work mode, you can share your data with different users. You can invite new users or remove existing users.

- To use the Cloud Sharing work mode, go to Settings > Create account for company.
- You can then add under the Item Company the company name, address, city, zip code, and country. Complete the process by clicking OK.

As the creator of the shared cloud, you are automatically defined as the administrator.

If you work with the shared cloud, you can manage your company and the users under Settings > Account. Only users with administrator rights can manage all sections.

11.4. Managing the company and users

Company
As administrator, you can manage the company information.
- Click on Company. The window that opens contains the information about the company that you can now adjust accordingly.

User management
As the administrator, you can register other employees of your company as users. Create an individual user account for each employee.

The user administration can be found under Settings > Account.

- Click on User Management.
- Click on Add Users.
- Enter a current valid e-mail address for the new user.
- Option Administrator: Select this option if the new user is also supposed to have administrator rights. You can also assign or withdraw this right to or from existing users at a later time.
- Complete the process with Save.

The employee must then perform the following tasks:

- An invitation mail will be sent to the e-mail address indicated.
  The user receiving this invitation must activate the link contained in the e-mail. This will link the user to the registration page.
- Once on the registration page, he must proceed as follows:
  If the user received the invitation mail via his Microsoft, Google or Facebook user account, he must click on the corresponding account icon and log in.
  If the user received the invitation mail via the e-mail address of his existing myLeister user account, he must log in directly with his user name and password.

This action completes the registration process for the new user.
In all other cases, the user selects Register now and registers.

In the new window, the following information must be entered:
- E-mail address: Enter the e-mail address to which the confirmation e-mail was sent.
- Click on Send verification code. Check the mailbox of the e-mail address indicated.
- To complete the process, enter the code you received in the confirmation e-mail and complete the process with Check code.
- New password: Assign your password.
- Confirm new password: Enter the selected password again.
- First name: Enter your first name here.
- Last name: Enter your last name here.
- Display name: Enter your first and last name.
- Industry sector: Enter here the industry sector in which your company is active.
- Click on Create to complete this process.

Delete user
As administrator, you can delete the user from your shared cloud.
- Click on User Management.
- Click on the user name that you wish to remove from the shared cloud.
- Click on Delete to complete this process.

The deleted user can now no longer access the data in the shared cloud. The data created by the user remain.

Logout
You must sign out if another employee wishes to work with the app at the workstation using his user account.

Change user
Perform the following steps to change users:
- Click on the menu with the user name.
- Click on Logout.
- The start screen is displayed.
- Log in using your user name and password.

Work mode Local
The local work mode is now only available on terminals that have updated an LQS installation with local data to the myLeister App.

If you work in local work mode, you do not need to log in as a user.

Important
In this work mode, your data is only located on your workstation.
To protect yourself against data loss, we recommend that you regularly back up your data from your workstation.

Important
Subsequent transfer of local data to the cloud is impossible.

The following functions are available to you:
- Register devices.
- Synchronize data files from the device and retrieve archives from the device.
- Evaluate and edit raw welding data.
- Manage
- LiveView
- Toolbox

12. myLeister App User Interface

12.1. LQS

Here you can see your registered devices. Even deleted devices are listed here.

Any welding data recorded can be transferred from the welding device to the app with the LQS functions. These data can then be evaluated for quality assurance/monitoring purposes and saved as a PDF report.

12.2. Devices

You can see all active, registered devices under Devices. With the button, you can add new devices.

12.3. Recipes

With the recipe function, welding parameter combinations can be saved in the app and synchronized via the cloud. These recipes can then be transferred to compatible welding devices. Profiles configured on welding devices can be transferred to the app.

12.4. LiveView

The LiveView offers the possibility of displaying and monitoring the set welding parameters and the effective parameters of the welding device in real time, both during and after a welding operation. In addition, warnings and error messages are displayed.

- Select the desired welding device.
- Click on LiveView. This option is only active if the selected device is active and supports the LiveView function.

The LiveView of the selected welding device opens. You now see the current parameters as well as warnings and error messages.

By clicking on Settings, the setting overview of the device opens. Now, you can adjust all relevant settings. The settings will then be transferred to the welding device when you exit the menu.

12.5. Configuration Management

The NFC function can be used to communicate with devices that support NFC.
This function is only available with Android devices. The VARIMAT 700 does not support NFC.

12.6. myLeister AR App

The myLeister AR App enables you to display the Leister welding tools* as an interactive application and Augmented Reality application (AR) on your mobile devices. Let us show you the various application possibilities on your Leister equipment with the touch of a button. Turn the Leister products virtually on their own axis and view all details from any perspective.

12.7. Settings

LQS settings

Before you begin evaluating the data, adjust the settings for the LQS function.

Company logo for the header of the PDF report

You can add a company logo, which is displayed in the header of the PDF report. For optimum presentation of the logo, the logo graphic should display an aspect ratio of 10:1.

- Select Add + . Then, select the graphic for the logo in the dialog window that opens.
- To remove a logo that has been added, select Delete .

PDF report title

Select which title should be displayed on the PDF report.

- Activate the desired title for the report.

Graphics

- If you wish to include the graphics in the report as attachments, activate this option.

CSV Export Settings

If you synchronize the data files from the device to the workstation, you can create a CSV file from these data files.

- Activate this option if you wish to create a CSV file from the raw data file.

Windows:

- If no memory location has been defined, a dialog window opens in which you must specify the memory location of the CSV files.
- Click on Change path, if you wish to export the CSV files in a different path.

Android:
The CSV files are automatically saved in the internal device memory under Documents > myLeister > Leister LQS > CSV Files.

iOS:
The CSV files are automatically saved on the iCloud drive in the folder myLeister > LQS > CSV Files.

Note: Select this option, **before** you synchronize the data files from the device.

Construction Projects

Here you can manage your construction projects.

- Click on Construction projects.
- Click on Add to create a new construction project.
- In the new window, you can enter the following information:
  - Description: Indicates the name or transcription of the construction project.
  - Street, city, zip code, country: Information about the address of the construction project.
  - Option Active: This option is selected as standard.

If you no longer wish the evaluated site data to be displayed in the list of construction projects, de-select Active.

- Click on Save to complete the process.

Machine Settings

Here you can find the settings for the registered devices.

Date and Time

Define whether date and time on the connected welding devices should be synchronized automatically with the system date and system time on the terminal.
They are updated once daily during a welding data synchronization process. The automatic update is only carried out for devices with HMI firmware version 1.06 and higher.

Selecting the language (Windows version only)
This option enables you to change the language of the myLeister App. As standard, the app chooses the language according to the workstation operating system.

- To change the language, select a language from the list.
- Restart the app.

General Settings

Notifications
This is where you can switch notifications from the app (notes, etc.) on and off. Error messages will continue to be displayed even if notifications are switched off.

Preferred card provider (for coordinates, etc.)
This is where you can select which card provider should be used for coordinate visualization (e.g., for the coordinate links in the PDF report).

12.8. Help

You can find more information about the myLeister App in the help menu.

13. Registration of Devices

To enable the myLeister App to communicate with a welding device and for all available functions to be activated, this device must be registered once in the myLeister App.

Click on the menu Devices on Search devices.
After a short time, the device will be listed with the note Device added and a plus sign.
Click on the device and in the machine settings Register device.
A code will be shown on the device display. Enter this numeric code in the app window and confirm by clicking on Register device.

Additional functions are now available with the registered device. The availability of the functions depends on the model and/or firmware status of the device:

Inventory Number
Under the item Inventory number, a unique identification can be assigned to the device.

Enter the desired designation in the text field and save the input.

Delete Device
Click in the Device menu on the device you wish to remove.
Then click on Delete device. Confirm the subsequent security prompt.

Note: Data of this device in the app will **not be deleted.** The device continues to be shown in the LQS menu.

For more information, see Chapter 14. LQS Functions.

14. LQS Functions

Before starting with the LQS function, configure the function in the settings:

- Follow the steps in the section Settings under LQS Settings.

If you selected the LQS menu, you are shown all devices you registered.

14.1. Synchronizing data from the device.

Click on ✓ and then on 🔍. The device from which you wish to synchronize the welding data and which is currently connected to the app is now highlighted.

Click on ⟳. It can only be synchronized if the device in question is indeed available. Otherwise the button cannot be activated.

14.2. Restoring an archive of the device

- Click on the device from which you wish to synchronize the data, on ⧉.
- In the dialog window, select the archive folder from which you wish to retrieve the data.
  Start restore data with Restore.

14.3. Evaluating welding data

Before evaluating the welding data, you must synchronize the date of the device in accordance with Section 📖 14.1.

- In the list of devices, click on the device from which you wish to evaluate the welding data.
- All data files will now be listed. They are sorted by date and time, starting with the most recent file. Data files yet to be evaluated are shown in bold print.
- Click on the name of the raw data file and continue by clicking on Evaluate ✎.
- You will now be guided through the evaluation steps.
  At the top of the screen, you can find information concerning the selected data file and the step you are currently performing.

Protocol
This is where you enter all the information to create a protocol. Mandatory fields are marked in red. Here, you have the possibility of adding a construction project or manage your construction project. Just click on Add +.

Graphics
The progress of the parameters recorded, such as temperature, speed and joining force, is displayed over the weld seam length. You can zoom in on the diagram. See Section 📖 Navigation in the graphic diagram.

Note: In the LQS Settings menu, you must select in the tab Graphics the option Add diagrams to PDF report, if you want the charts in the report to be included as an attachment.

Table
The summary of the values of the weld is presented in tabular format.

All recorded values can be displayed under Records.
Where the set limit values were left, the corresponding values are marked in red.
Select the option Brief report if you only want to see and to have documented the values for which the value limits set were not observed.

With Save you can save your evaluation and export it additionally as a PDF or CSV file:

Windows:
A dialog box appears in which you can select the storage location for the PDF or CSV file.

Android:
The selected files are automatically saved in the internal device memory under Documents > myLeister > Leister LQS.

iOS:
The selected files are automatically saved on the iCloud drive in the folder myLeister > LQS.

14.4. Navigating within graphics (Windows version only)

Zooming:
- If you hold the pointer over the diagram and turn the scroll wheel, you can zoom in or out of the graphic. The zoom affects both axes at the same time.
- If you only wish to zoom the horizontal axis, hold the pointer over the distance scale and turn the scroll wheel.
- If you only wish to zoom the vertical axis, hold the pointer over the corresponding vertical scale and turn the scroll wheel.
- Click Zoom Full View to return all graphs to full view.

Show the detailed view:
- If you draw a plane in a diagram, this section is displayed on the left as a detailed view.
- If you wish to delete the detailed view created, select the view and press on the trash can icon.

Note: In the menu Settings > LQS Settings, in the section Graphics, you must select the option Add diagrams in PDF report if you want to have the diagrams in the report as an attachment.

Edit reports
- Click in the main view of the LQS function on .
- Select the construction project from the list.
- All evaluation files are now listed which have been assigned to the selected construction project. They are sorted in descending order by date and protocol number.
- Click on the protocol and continue by clicking on Evaluate.
- You will now be guided through the evaluation steps again. For details, see Section Evaluate welding data.

15. Recipes

With the function Recipes, you manage your preferred welding parameters. Send your parameters to all your registered Leister devices (as a prerequisite, a device must have a compatible WLAN system and compatible firmware). Read your recipes (welding parameters) from your devices and share them through the myLeister Cloud in your group or company.

- Select a registered device from the list.

The left-hand list now shows all the recipes saved for this type of device. The right-hand list shows the recipes that are available on the selected welding device.
If the selected welding device is not active (shaded in gray), the right-hand list is blocked and nothing is displayed.

Use Add + to add recipes to the left list. Please note that no more than 10 recipes can be saved on a welding device. Complete all fields and save the recipe by clicking on ✓.

The created recipes can be moved with the arrows ← and → from the recipe library to the selected device, or from the selected device to the recipe library.

To edit a recipe, it must be selected and then ✎ must be selected.
Use 🗑 to delete a selected recipe.

Recipes moved to the welding device are only transferred to this welding device after the menu is exited with ⇥.

16. Tools

In the Tools menu, you will find helpful functions that can support you in your routine tasks.

Power Cable Tester
Use the power cable tester to check if your power cable is the right size for your device or which power cable is ideal for your device.

- Fill out the nominal power rating of the welding device in W according to the type plate
- Complete the nominal voltage of the welding device in V according to the type plate
- Fill out the mains voltage in V
- Fill out the current mains voltage of the welding device in V if the welding device has a mains voltage display. The standard practice here is to enter the given rated voltage of the welding device minus 10%.

The current through the power cable and the power actually available to the welding machine is then calculated. The maximum possible power cable lengths for different power cable cross sections are also calculated.

Unit Converter
The unit converter helps you converting the globally relevant units of temperature, weight, area and many more.

Process Heat Formulas
The tool process heat formulas provide you with different formulas for evaluating the air heaters or blowers best suited to you and your application.
The myLeister App assists you with a simple configurator, in which you only have to enter the performance values required for your application.

17. Documents (Android and iOS versions only)

Under Documents, you will find all documents that have been created in and exported from the app, such as exported LQS reports.
The documents are stored in directories including the name of the relevant function.

17.1. Account

Under Account, you can find the settings for your myLeister account. You also have the possibility of synchronizing the data created in the app in the cloud.

User administration
This is only available after a shared cloud was created. For more information, consult Section 📖 Setup of the work mode Shared Cloud.

Create company
Use this command to create a shared cloud. For more information, consult Section 📖 Setup of the work mode Shared Cloud.

17.2. Work mode

You can switch between different work modes under Work Mode Settings.

Work mode
Only available if local data are available on the terminal.

Switch between local mode and the cloud. If the cloud mode is activated and you have not yet logged in, you will be asked to log in.

Cloud mode
Only available if a shared cloud has been configured.
Switch between Cloud Private and Cloud Shared work modes.

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Warranty

- The guarantee or warranty rights granted for this device by the direct distribution partner/salesperson apply from the date of purchase. In the event of a guarantee or warranty claim (verification by invoice or delivery note), manufacturing or processing errors will be rectified by the sales partner through replacement delivery or repair. Heating elements are excluded from warranty obligations or guarantees.
- Other guarantee or warranty claims are excluded within the framework of mandatory law.
- Damage resulting from natural wear, overload, or improper handling is excluded from the warranty.
- Devices that have been converted or modified by the purchaser are not covered by any warranty or guarantee.
- Only use original Leister spare parts and accessories; otherwise, any warranty or guarantee claims will be invalidated.

Sales and Service Partners

Leister Technologies AG
Galileo-Strasse 10
6056 Kaegiswil
Switzerland

+41 41 662 74 74
leister@leister.com

leister.com

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