

LEISTER®

English

LQS

myLeister

Quick Guide



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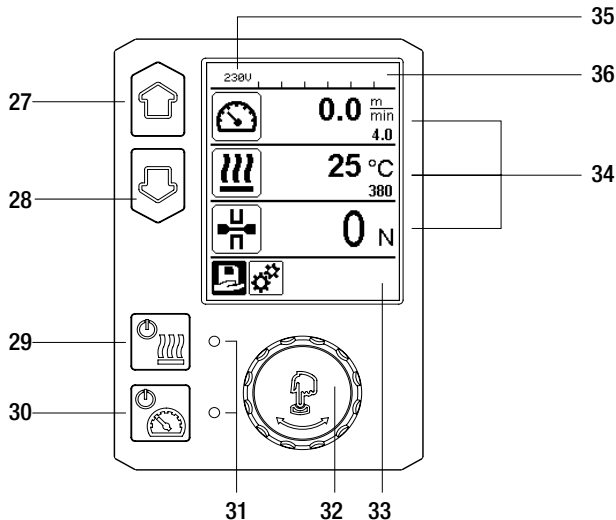
Operating Instructions for Welding Data Recording

(Translation of original operating instructions)



Read the operating instructions for the respective device carefully before use. This document is the operating instructions for the additional welding data recording function and is intended to supplement the device operating instructions.

1. Operating Unit



- 27. "Up" key
- 28. "Down" key
- 29. Key for heating "On/Off"
- 30. Key for drive "On/Off"
- 31. Status LED
- 32. "e-Drive"
- 33. Function display
- 34. Working display
- 35. Status display "Section 1"
- 36. Status display "Section 2"


1.1. Display Description


Status display "Section 1" (35)

Name of the saved value	Description
230 V	Profile currently selected. If names consist of more than 6 characters, the first 6 characters are shown first, followed by the remaining characters.
001	Network voltage currently present on the mains plug
	Current file number of the welding data record


Status display "Section 2" (36)

 **Warning present**
(see Chap. Warning & Error Messages)


 **Key lock**
(only with active key lock)

 **Data recording**
(see Chap. Running Welding Data Recording)

 **Undervoltage**

 **Heating**
(only with activated heating)

 **WLAN**
(see Chap. Data Synchronization)

 **Overvoltage**

 **GPS**

1.2. Working Display Overview

Machine Setup

Unit:

Setting the unit used (metric/imperial) for Unit Speed, Unit Heat, and Unit Force

Unit Speed:

Individually setting the unit used for speed (metric/imperial)

Unit Heat:

Individually setting the unit used for heat (metric/imperial)

Unit Force:

Individually setting the unit used for force (metric/imperial)

LCD Contrast:

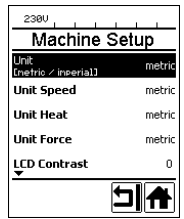
Adjusting the LCD contrast

LCD Backlight:

Setting the display background illumination

Key Backlight:

Setting the keyboard background illumination



Welding Data Record

Date & Time:

Setting the date and time

Data Recording:

The welding data is logged when "Data Recording" is activated.
Factory setting deactivated

Seam Naming:

When "Seam Naming" is activated, the "Seam Name" is attached to the file name.
Factory setting deactivated

Seam Name:

Entering a name affix

Init. Value Record.:

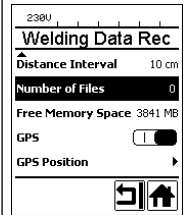
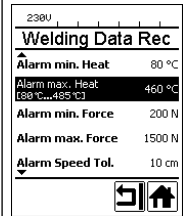
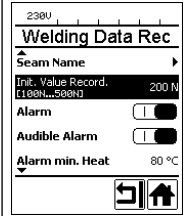
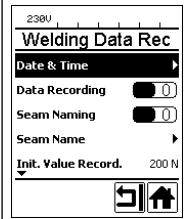
Setting the threshold value for the welding data record

Alarm:

When "Alarm" is activated, the actual values are monitored with the alarm limit values, shown on the display, and recorded.
Factory setting activated

Audible Alarm:

When "Audible Alarm" is activated, an acoustic signal is emitted if the actual value exceeds or falls below the alarm limit value.
Factory setting activated



Alarm min. Heat:**Alarm max. Heat:**

Setting the alarm limit values for temperature

Alarm min. Force:**Alarm max. Force:**

Setting the alarm limit values for force

Alarm Speed Tol.:

Setting the speed tolerance alarm

Distance Interval:

Setting the distance interval. After covering a distance interval, a welding data record is entered and saved

Number of files

Number of new recording files. These files must be synchronized for you to be able to evaluate them using the myLeister app.

Free Memory Space:

Free memory space on the memory card.

Capacity: min. 8 GB

GPS:

When "GPS" is activated, information on location is entered from the GPS module.

Factory setting activated

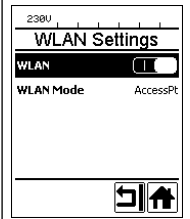
GPS Position:

Current geolocation, as long as the GPS module has sufficient satellite reception and can determine a location

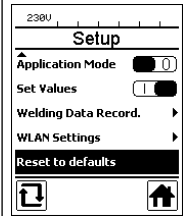
WLAN:

When "WLAN" is activated, the recorded welding data can be transferred to the myLeister app.

Factory setting activated
The "WLAN Mode" must be set to "AccessPt"

**Reset to defaults**

If the "Reset to defaults" menu is selected and confirmed by selecting the relevant function, all customer-specific welding parameters will be deleted. Settings that have been changed via the Setup menu will be reset to the factory settings



2. Functional Description of Welding Data Recording

The welding data recording function logs the speed, temperature, and welding force during the welding process along the welding seam length at predefined distance intervals.

Alarm values can be set for every speed, temperature, and welding force. The automatic welder logs any deviations from an alarm value and emits an acoustic alarm signal as welding data is recorded (alarm value monitoring and the acoustic alarm signal must be activated).

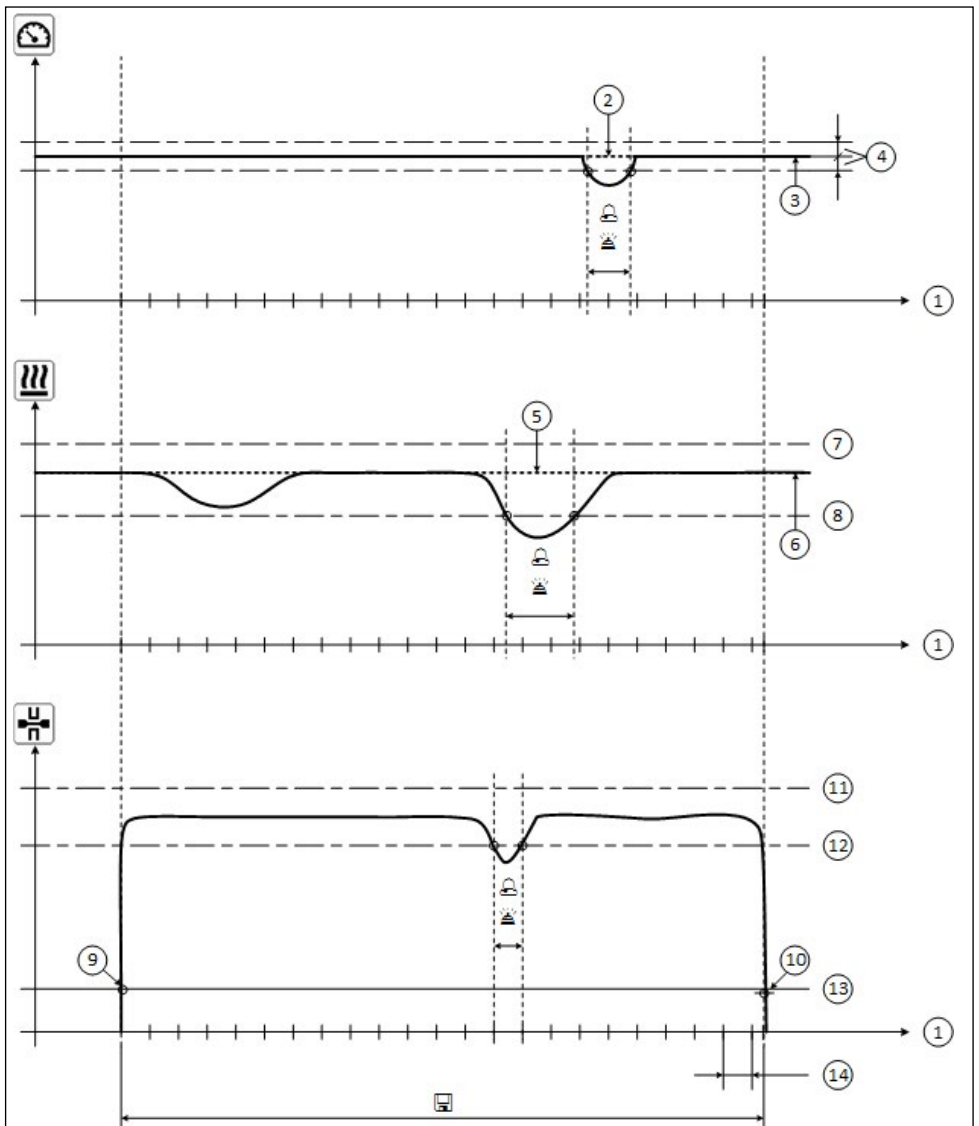
The recorded data is evaluated by the separate "myLeister app" user software.

3. Preparing for Welding Data Recording

The following parameters must be set in the Settings menu before welding data is recorded:

- Check date and time and correct as required.
- Check that welding data recording is activated.
- Optionally, as required: Activate or deactivate name affix.
- Optionally, as required: Enter collective name affix.
- Set threshold value of the force for start/end of recording, as required.
- Check that alarm is activated.
- **Important:** If the **alarm is deactivated**, the alarm values will not be monitored and the events will not be logged in the welding data file.
- Activate or deactivate acoustic alarm, as required.
- Set alarm thresholds for minimum and maximum temperature.
- Set alarm thresholds for minimum and maximum force.
- Set alarm threshold for speed tolerance.
- Set distance interval for recording.
- Activate or deactivate GPS location detection, as required.

The graphic displayed below shows a diagram of the welding process. The horizontal axis displays the distance plotted along the length of the welding seam in each case. The vertical axis records the speed, temperature, and force in the respective diagrams and shows how they relate to the adjustable parameters.



- | | | |
|--------------------------|---------------------------------|---|
| 1. Distance | 6. Current temperature | 10. End of the welding process |
| 2. Speed setpoint | 7. Max. temperature alarm | 11. Max. force alarm |
| 3. Current speed | 8. Min. temperature alarm | 12. Min. force alarm |
| 4. Speed tolerance alarm | 9. Start of the welding process | 13. Force threshold value for recording |
| 5. Temperature setpoint | | 14. Distance interval |

🔔 If a value deviates from the corresponding alarm value, this is logged in the log file when "Alarm" is activated.

🔊 A warning signal is sounded when "acoustic alarm" is activated.

📄 Data is recorded over the distance.

The settings range for each parameter is collated in the following table.

3.1. COMET 700

Parameter		Setting range		Setting range
Threshold value for recording	N	100–500	lbf	22–112
Alarm min. Temperature ¹	°C	70–485	°F	158–905
Alarm max. Temperature ²	°C	70–485	°F	158–905
Alarm min. Force ³	N	100–1250 ⁶	lbf	22–281 ⁶
Alarm max. Force ⁴	N	100–1250 ⁶	lbf	22–281 ⁶
Alarm Speed Tolerance	cm	5–20	in	2–8
Distance Interval	cm	10–2000	in	4–787

3.2. GEOSTAR G5/G7 LQS

















Parameter		Setting range		Setting range
Threshold value for recording	N	100–500	lbf	22–112
Alarm min. Temperature ¹	°C	80–460	°F	176–860
Alarm max. Temperature ²	°C	80–460	°F	176–860
Alarm min. Force ³	N	100–1750 ⁵	lbf	22–393 ⁵
Alarm max. Force ⁴	N	100–1750 ⁵	lbf	22–393 ⁵
Alarm Speed Tolerance	cm	5–20	in	2–8
Distance Interval	cm	10–2000	in	4–787

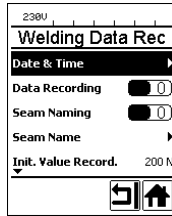
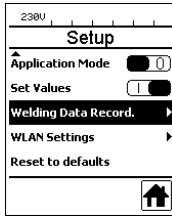
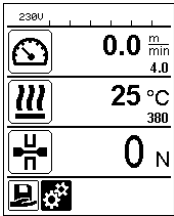
3.3. TWINNY T7

Parameter		Setting range		Setting range
Threshold value for recording	N	100–500	lbf	22–112
Alarm min. Temperature ¹	°C	100–590	°F	212–1094
Alarm max. Temperature ²	°C	100–590	°F	212–1094
Alarm min. Force ³	N	100–1250 ⁶	lbf	22–281 ⁶
Alarm max. Force ⁴	N	100–1250 ⁶	lbf	22–281 ⁶
Alarm Speed Tolerance	cm	5–20	in	2–8
Distance Interval	cm	10–2000	in	4–787





1. "Alarm min. Temperature" may not be greater than "Alarm max. Temperature".
2. "Alarm max. Temperature" may not be smaller than "Alarm min. Temperature".
3. "Alarm min. Force" may not be greater than "Alarm max. Force".
4. "Alarm max. Force" may not be smaller than "Alarm min. Force".
5. ⚠ Mechanical damage could occur if the maximum welding force of 1500 N / 337 lbf is exceeded.
6. ⚠ Mechanical damage could occur if the maximum welding force of 1000 N / 225 lbf is exceeded.

4. Setting the Date and Time for Welding Data Recording





- In the **function display (33)**, rotate the "e-Drive"  to select the Settings menu .
 - Press "e-Drive"  briefly.
 - Select "Welding Data Record." in the "Setup" menu by rotating the "e-Drive"  and pressing it briefly.
 - Rotate the "e-Drive"  to select "Date & Time" and press "e-Drive"  briefly.
 - To set the hours by rotating the "e-Drive" , select "Hour" and press "e-Drive"  briefly.
Rotate the "e-Drive"  to set the value and press "e-Drive"  briefly.
 - To set the minute, year, month, and day by rotating the "e-Drive" , select the corresponding menu item and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to set the value and press "e-Drive"  briefly.
- In the **function display (33)**, rotate the "e-Drive"  to select the symbol "Return to working display" .
- The applied settings are saved by the device.







5. Setting the Parameters for Welding Data Recording

- In the **function display (33)**, rotate the "e-Drive"  to select the **Settings menu** .
- Press "e-Drive"  briefly.
- Select "Welding Data Record." in the "Setup" menu by rotating the "e-Drive"  and pressing it briefly.

Switching on data recording:

- Rotate the "e-Drive"  to select "Data Recording" and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to select "I" and press "e-Drive"  briefly.



Switching on the name affix for the welding seam (optionally, as required):



- Rotate the "e-Drive"  to select "Seam Naming" and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to select "I" and press "e-Drive"  briefly.

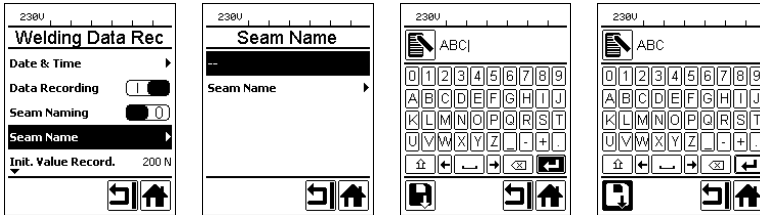
Setting the welding seam name (optionally, as required):

- Rotate the "e-Drive"  to select "Seam Name" and press "e-Drive"  briefly.





The current name is displayed on the top line. "--" means that a name has not been defined.

Rotate the "e-Drive"  to select "Seam Name" and press "e-Drive"  briefly.

Enter the desired name (see Chap. "Entering Names or Passwords"), confirming this afterwards by selecting the **symbol**  and by pressing the "e-Drive" .



Setting the threshold value for recording:

- Rotate the "e-Drive"  to select "Init. Value Record." and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to set the value and press "e-Drive"  briefly.

Switching off alarm value monitoring (optionally, as required):

- See **Switching on data recording** for the setting procedure.

Important: When the alarm is switched off, then exceeded alarm values will also **not** be recorded.

Switching off the acoustic alarm (optionally, as required):

- See **Switching on data recording** for the setting procedure.

Setting the minimum temperature alarm:

- See **Setting the threshold value for recording** for the setting procedure.

Setting the maximum temperature alarm:

- See **Setting the threshold value for recording** for the setting procedure.

Setting the minimum force alarm:

- See **Setting the threshold value for recording** for the setting procedure.

Setting the maximum force alarm:

- See **Setting the threshold value for recording** for the setting procedure.

Setting the speed tolerance alarm:

- See **Setting the threshold value for recording** for the setting procedure.

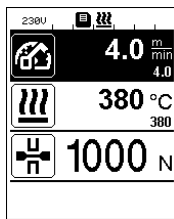
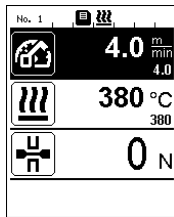
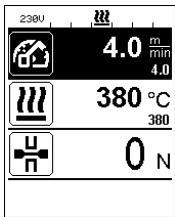
Setting the distance interval:

- See **Setting the threshold value for recording** for the setting procedure.

Switching off GPS (optionally, as required):

- See **Switching on data recording** for the setting procedure.
- In the **function display (33)**, rotate the "e-Drive"  to select the **symbol "Return to working display"** .


6. Running Welding Data Recording



- Set the parameters for welding data recording (see Chapters "Preparing for Welding Data Recording" and "Setting the Parameters for Welding Data Recording").


- Set the setpoints for temperature and speed (see Chapter "Speed and Temperature Setting Before Welding" in the device operating instructions).

- Switch on the heating and drive.

In the **status line (35)**, the file number is displayed alternately in the network voltage display and the  symbol flashes.

- Activate clamping arm.

Recording begins as soon as the force exceeds the set threshold value.

In the **status line (35)**, the file number is displayed alternately in the network voltage display and the  symbol is shown.

- If a set alarm value is exceeded during the welding process, this is shown in the display when alarm value monitoring is switched on.


(See Chapter "Displaying Alarm Value Transgressions in the Welding Data Record During the Welding Process")

In such cases, make changes depending on the situation


(see Chapter "Speed and Temperature Setting During Welding" in the device operating instructions).

Release the clamping arm at the end of the welding seam.

Recording ends as soon as the force falls below the set threshold value.

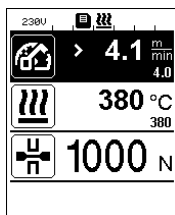
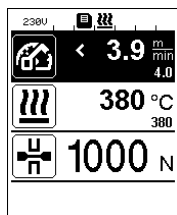
The next log file is prepared. In the **status line (35)**, the file number of the new file is displayed alternately in the network voltage display and the  symbol flashes.

Finishing welding

- Switch off the drive after the welding tasks are completed.
- Switch off the heating.
- Wait until the  symbol is no longer flashing.
- Switch off the device using the main switch.

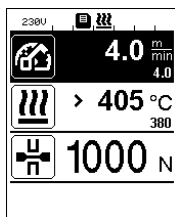
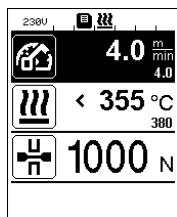
7. Displaying Alarm Value Transgressions in the Welding Data Record During the Welding Process

When "Alarm" is activated, the speed, temperature, and force are continuously monitored during the welding process to check that these values remain within the defined alarm values. If an alarm value is exceeded, this is indicated on the device.



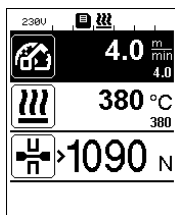
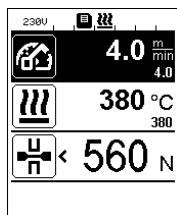
Speed:

- If the speed falls below the lower tolerance value,
 - the speed display will flash.
 - a "<" symbol will be displayed in front of the actual value.
 - a warning signal will sound if the acoustic alarm is activated.
- If the speed exceeds the upper tolerance value,
 - the speed display will flash.
 - a ">" symbol will be displayed in front of the actual value.
 - a warning signal will sound if the acoustic alarm is activated.



Temperature:

- If the temperature falls below the min. alarm value,
 - the temperature display will flash.
 - a "<" symbol will be displayed in front of the actual value.
 - a warning signal will sound if the acoustic alarm is activated.
- If the temperature exceeds the max. alarm value,
 - the temperature display will flash.
 - a ">" symbol will be displayed in front of the actual value.
 - a warning signal will sound if the acoustic alarm is activated.



Force:

- If the force falls below the minimum alarm value,
 - the force display will flash.
 - a "<" symbol will be displayed in front of the actual value.
 - a warning signal will sound if the acoustic alarm is activated.
- If the force exceeds the maximum alarm value,
 - the force display will flash.
 - a ">" symbol will be displayed in front of the actual value.
 - a warning signal will sound if the acoustic alarm is activated.

8. Welding Data Files for Welding Data Recording

A welding data file is created for each welding process. A welding process begins when the clamping arm is activated and ends when the clamping arm is released.











A weld seam consists of at least one welding process. It can also consist of several welds, if this is necessary during the 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.

9. Welding without Data Recording

In order to weld without data recording, data recording must be switched off in the Setup menu.

- In the **function display (33)**, rotate the "e-Drive"  to select the **Settings menu** .
 - Press "e-Drive"  briefly.
 - Select "Welding Data Record." in the "Setup" menu by rotating the "e-Drive"  and pressing it briefly.
 - Rotate the "e-Drive"  to select "Data Recording" and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to select "0" and press "e-Drive"  briefly.
- In the **function display (33)**, rotate the "e-Drive"  to select the **symbol "Return to working display"** .

10. Power Supply Interruption











Condition of device prior to power supply interruption	Duration of power supply interruption	Condition of device after power supply interruption
The drive and heating are switched on (welding process and data recording).	≤ 5 sec	The device continues running without restart protection with the same settings as before the interruption. Data recording continues and the data is added to the file that was created before the power supply was interrupted.
The drive and heating are switched on (welding process and data recording).	> 5 sec	The device starts up and the start display appears on the display. The welding data that was recorded before the interruption is contained in the log file.
The device is not in the welding process.	—	The device starts up and the start display appears on the display.

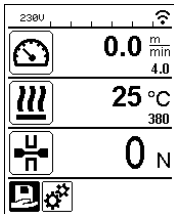
11. Data Synchronization

The welding data files recorded by the automatic welder are read by the "myLeister app" and synchronized. For this to take place, the WLAN module of the automatic welder must be switched on.

Important: Data must regularly be synchronized with the "myLeister app". Otherwise, unsynchronized welding data can be lost from the device; for example, if the operating unit is defective.


11.1. Switching on the WLAN module:

- In the **function display (33)**, rotate the "e-Drive"  to select the **Settings menu** .
 - Press "e-Drive"  briefly.
 - Select "WLAN Settings" in the "Setup" menu by rotating the "e-Drive"  and pressing it briefly.
 - Rotate the "e-Drive"  to select "WLAN" and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to select "I" and press "e-Drive"  briefly.
- In the **function display (33)**, rotate the "e-Drive"  to select the **symbol "Return to working display"** .













WLAN connection status display:

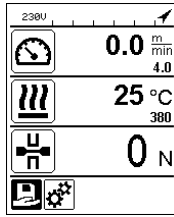
The data exchange between the automatic welder and the myLeister app starts from the myLeister app.

The  symbol is displayed in the **status line (35)** when the automatic welder is connected to the "myLeister app".

11.2. Switching off the WLAN module:

- In the **function display (33)**, rotate the "e-Drive"  to select the **Settings menu** .
 - Press "e-Drive"  briefly.
 - Select "WLAN Settings" in the "**Setup**" menu by rotating the "e-Drive"  and pressing it briefly.
 - Rotate the "e-Drive"  to select "WLAN" and press "e-Drive"  briefly.
- Rotate the "e-Drive"  to select "0" and press "e-Drive"  briefly.
- In the **function display (33)**, rotate the "e-Drive"  to select the **symbol "Return to working display"** .

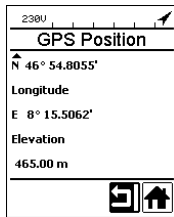
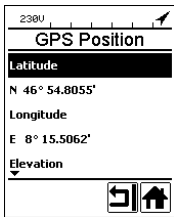
12. Geolocation



GPS location status display:

- The symbol is displayed in the **status line (35)** when GPS reception is sufficient and location information is available. The symbol flashes if, for example, reception is insufficient and valid position information is required.

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



Requesting the current geolocation:

- In the **function display (33)**, rotate the "e-Drive" to select the **Settings menu** .
- Press "e-Drive" briefly.
- Select "Welding Data Record." in the "Setup" menu by rotating the "e-Drive" and pressing it briefly.
- Rotate the "e-Drive" to select "GPS Position" and press "e-Drive" briefly.

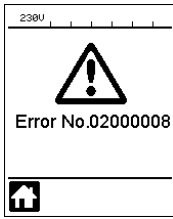


13. Warnings and error messages

- If there is a warning pending, the user can continue to work. You can access more detailed information about the warning in question via the **function display (33)** by selecting "Show Warnings" in the Settings menu.

Important: If one of the listed warnings occurs, data recording cannot be used.

- If a warning occurs while welding, this can be displayed with the **"Up" key**.
- If an error occurs, the heating is switched off and the drive is no longer released.

Message type	Display	Error code/warning message	Error description
Warning		Unknown HMI Version	An error occurred when initializing the operating unit. ¹
		Date/Time halted	An error occurred when initializing the date and time function.
		Invalid Date/Time	The current date and time information is invalid.
		Memory Full	Memory for data recording is full. The symbol flashes in the status line (35) during data recording.

		Memory Card Access	<p>A problem with the memory card occurred during data recording. In this case, welding data is no longer displayed but the welding continues.</p> <p>The  symbol flashes in the status line (35). The message opposite also appears in the display. The message can be acknowledged by briefly pressing the "e-Drive" .</p>
		WLAN Module Access	There is a problem with the WLAN module. ²
		GPS Module Comm.	The GPS module is not sending any data. ³
<p>1. In this case, the basic functions of device operation are available to the user, allowing them to weld without data recording.</p>			
<p>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.</p>			
<p>3. Data recording can be used when these warnings are displayed. It must be ensured that location data is not held in the data file when GPS is activated.</p>			

Take the relevant course of action to resolve the reported warning:

Error code/ warning message	Measure
Unknown HMI Version	Switch off the device and restart after a few seconds. ⁴
Date/Time halted	Switch off the device and restart after a few seconds. ⁴
Invalid Date/Time	Set the date and time in the Settings menu under "Welding Data Record." with "Date & Time".
Memory Full	Synchronize data with the myLeister app. ⁴
Memory Card Access	<p>Switch off data recording in the menu and restart:</p> <ul style="list-style-type: none"> - Release the clamping lever and switch off the drive. - Set "Data Recording" to 0 in the Settings menu under "Welding Data Record". - After a few seconds, set "Data Recording" to 1 again and exit the menu. - Restart the drive. (The heating must also be switched on.) - The log file is prepared. The warning should no longer be displayed in the status line (35). <p>If the warning is still displayed:</p> <ul style="list-style-type: none"> - Switch off the drive and heating. - Switch off device using the main switch. - Restart the device after a few seconds. - Restart the heating and drive. - The log file is prepared. The warning should no longer be displayed in the status line (35). 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
<p>4. If the warning is still displayed, contact the Leister Service Center.</p>	

14. myLeister app quick guide

(Translation of the Original Operating Manual)

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

- First start
- Setting the “Joint cloud” operating mode
- Devices
- LQS functions
- Formulas
- Tools
- Settings

14.1 First start

When first starting the app, you will be requested to accept **end user licensing agreement** and the data protection declaration. Read both documents carefully and acknowledge them, otherwise the app cannot be used.

Registering / Logging in

As soon as the end user licensing agreement and the data protection declaration have been accepted, the invitation to login appears.

If you already have a Microsoft, Google+ or Facebook user account and would like to use this account for the app, log in using this user account.

- If you want to create a new user account, select “Sign up now”.
- In the window displayed, you must enter the following information:
- “Email Address”: Enter a current valid e-mail address.
You will receive a confirmation mail sent to this e-mail address.
 - Click on “Send verification code”.
Check the mailbox of the e-mail address indicated. The e-mail contains a code.
 - Enter the code in the input field and press “Verify code” to complete the procedure.
 - “New Password”: Assign your password.
 - “Confirm New Password ”: Enter the selected password again here.
 - “Given name”: Enter your first name here.
 - “Surname”: Enter your surname here.
 - “Displayname”: Enter your first name and surname here.
 - “Industry sector”: Enter the industrial sector in which your company is active here.
 - Click on “Create” to complete the procedure.

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

If you already have a myLeister user account, you can simply log in and your data stored in the cloud will be downloaded.

Updating an 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 on the new myLeister app, you can skip login when starting and continue working with your local data as usual.

Important:

In this work mode, your data are only located on your workstation.
Create a regular back-up of your workstation.

Important:

Subsequent transfer of local data to the cloud is impossible.

Updating an existing LQS app with work mode Cloud

If you have used an existing LQS installation in cloud mode on your terminal and this installation has now been updated on the new myLeister app, you will automatically be logged in with your user data. Your existing cloud data will automatically be stored in a joint cloud. All users with the respective authorizations will also be adopted. Furthermore, a private cloud will be set up for you to which only you have access. Your work mode will automatically be set to "Joint cloud" , so that you have direct access to your existing LQS data.

14.2. Configuring cloud work mode *Joint cloud*

With the *Joint cloud* work mode, you can share your data with different users. You can invite new users or remove existing ones.

- To use the joint cloud work mode, you must click on "Create company" under Settings > Account.
- You can then add the company name, address, city, zip code, and country under "Company". Complete the procedure by clicking on OK.

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

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

Managing the company and users**Company:**

As the administrator, you can manage the company information.

- Click on "Company". The window that opens contains the information concerning the company that you can now adapt accordingly.

User administration:

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

User management can be found under Settings > Account.

- Click on "User administration".
- Click on "Add User".
- Enter a current valid e-mail address for the new user.
- "Administrator" option: 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 procedure by clicking on "Save".

The employee must then perform the following tasks:

- An invitation mail will be sent to the e-mail address indicated.

The user receiving the invitation must activate the link contained in the e-mail. By doing so, he accesses 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 there.
 - 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 procedure for the new user.

- In all other cases, the user selects “Sign up now” and completes the registration procedure.

In the window displayed, the following information must be entered:

- “Email 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.
- Enter the code indicated in the e-mail received and press “Verify code” to complete the procedure.
- “New Password”: Assign your password.
- “Confirm New Password”: Enter the selected password again here.
- “Given name”: Enter your first name here.
- “Surname”: Enter your surname here.
- “Displayname”: Enter your first name and surname here.
- “Industry sector”: Enter the industrial sector in which your company is active here.
- Click on “Create” to complete the procedure.

Removing users:

As the administrator, you can remove users from your joint cloud.

- Click on “User administration”.
- Click on the user name that you wish to remove from the joint cloud.
- Click on “Delete” to complete the procedure.

The removed user no longer has access to the data in the joint cloud. The data created by the user remain.

Logging out:

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

Changing users

Perform the following steps to change users:

- Click on the menu with the user name.
- Click on “Sign out”.
- The start screen is displayed.
- Log in using your user name and password.

Work mode *Local*

The local work mode is only available in terminals which have updated a LQS installation with local data on 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 are only located on your workstation.
Create a regular back-up of 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 recipes
- LiveView
- Toolbox

14.3. Devices

Registering devices

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

- Click on “Search Machines” in the “Devices” menu.
- After a short time, the device will be listed with the note “Add device” and a plus sign.
- Click on the device and select “Register Machine” in the device settings.
- a code will be shown on the device display. Enter this numeric code in the app window displayed and confirm by clicking on “Register Machine”.
- The device will now be listed without the note “Add device” and without a plus sign.

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

Inventory number

Under the “Inventory number” item, an identification can be assigned to the device.


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

LiveView

LiveView offers the possibility of displaying and monitoring the welding parameters set and the effective values of the welding device in real time both during and after a welding operation. Warnings and error messages are also displayed.

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

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

- By clicking on settings , the device's settings overview opens. All relevant settings can be adjusted here. The settings will then be transferred to the welding device when you exit the menu.

Removing a device

- Click on the device to be removed in the "Devices" menu.
- Then click on "Remove device". Confirm the subsequent security prompt.

Note:

The data from this device in the app will not be deleted. The device becomes visible again in the LQS menu.

LQS functions

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

- For more information, see the "LQS functions" section.

Formulas

Welding parameter combinations can be saved in the app and synchronized via the cloud using the "Formulas" function. These recipes can then be transferred to compatible welding devices. Profiles configured on welding devices can be transferred to the app.

- For more information, see the "Formulas" section.


14.4. LQS functions

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


- Perform the steps as described in the "Settings" section under "LQS settings".

When you have selected the "LQS" menu, all your registered devices will then be listed.

Synchronizing data from the device




- Click on  on the device from which you wish to synchronize data. Synchronization is only possible if the device in question is also available. Otherwise, the button is not available

Retrieving an archive from the device


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

Start the data retrieval by clicking on “Restore”.

Evaluating welding data

- 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 according to date and time, with the most recent file at the top.
Data files yet to be evaluated are shown in bold print.
- You can also mark the data file as sample welding  or faulty welding .
- If necessary, you can mask the files designated as sample welding or faulty welding.
To do this, select the “Hide test weld” option and/or “Hide failed weld” at the top right.
- Click on the name of the raw data file and continue by clicking on “Analyze” .
- 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 managing your construction project. To do this, click on “Add” .

Graph

The progress of the parameters recorded, such as temperature, speed and joining force, is displayed over the seam length. You can zoom in on the diagram. See the section on “Navigating within the graphic”.

Note:

In the “LQS settings” menu, you must select the “Add graph to PDF-Report” option in the “Graphics” section if you wish to include the diagram in the report as an appendix.



Table

The summary of the weld seam is presented in tabular format.

All values recorded can be displayed under “Records” .

Values marked in red indicate cases where the limit values set have not been observed.

Select the “Short report” option if you only want to see and to have documented the values for which the value limits set were not observed.

- With “Add seam” , you can add up to three other weld seams from the same day to the protocol.
- With “Save” , you can ensure your evaluation and export it as a PDF and/or CSV file:

Windows:

A dialog window is opened in which you can select the 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 myLeister > LQS > folder.

Navigating within the graphic (Windows version only)

Zooming in/out:

- 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 on the horizontal axis, hold the pointer over the distance scale and turn the scroll wheel.
- If you only wish to zoom on the vertical axis, hold the pointer over the corresponding vertical scale and turn the scroll wheel.
- Click on “Zoom to fit”  to display all diagrams in full again.



Representing 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 “Settings > LQS settings” menu, you must select the “Add graph to PDF-Report” option in the “Graphics” section if you wish to include the diagram in the report as an appendix.

Editing reports

- Click on  in the main view of the LQS function.
- Select 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 according to date and protocol number.
- Click on the protocol and continue by clicking on “Analyze” .
- You will now be guided through the evaluation steps again. For more details, see the “Evaluating welding data” section.


14.5. Formulas


The “Formulas” function enables you to manage your favorite welding parameters yourself. Send your parameters to all your registered Leister devices (as a prerequisite, a device must have a compatible WiFi system and compatible firmware). Read your recipes (welding parameters) from your devices and share them within your group or company via the myLeister Cloud.



- 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 (grayed out), the right-hand list is blocked and nothing is displayed.

“Add”  enables you to add recipes to the left-hand 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 recipes created can be moved from the recipe library to the selected device or vice versa using the arrows  and .

To edit a recipe, it must be selected and then  must be selected.

A selected recipe can be deleted using .

Recipes moved to the welding device are only transferred to the device if the menu is exited by clicking on .

14.6. Tools

The “Tools” menu contains helpful functions that can support you in your routine tasks.

Network cable checker

The “Network cable checker” enables you to check if your power cable is the right size for your device or which power cable is ideal for your device.

- Enter the rated output of the welding device in W as per the nameplate
- Enter the rated voltage of the welding device in V as per the nameplate
- Enter the supply voltage in V
- Enter the current supply voltage of the welding device in V if the welding device has a supply 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” assists you in converting the globally relevant units of temperature, weight, area and much more.

Process heat formulas

The “Process heat formulas” tool provides 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.

14.7. 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.

14.8. Settings

14.8.1 Account

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

User administration:

Only available if a joint cloud has been configured. More information can be found in the Configuring cloud work mode Joint section.

Create company:

This command enables you to configure a joint cloud. More information can be found in the Configuring joint cloud work mode section.

14.8.2 Working mode

You can switch between the different work modes via the work mode settings.

Working mode:

Only available if local data are available on the terminal.

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

Cloud mode:

Only available if a joint cloud has been configured.



Switch between "Private cloud" work mode and "Joint cloud".

14.8.3 LQS settings

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

Company logo for header of PDF report (width to height ratio 10:1):

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 appendices, activate this option.

CSV export settings:

If you synchronize the data files from the device on 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 determine the memory location of the CSV files.
- Click on "Change path" if you wish to export the CSV files via 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 myLeister > LQS > CSV files folder.

Note:

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

Construction project:

You can manage your construction projects here.

- Click on “Construction project”.
- Click on “Add” to create a new construction project.
- In the window displayed, you can enter the following information:
 - Description: Indicates the name or transcription of the construction project.
 - Street, City, Postal Code, Country: The information concerning the address of the construction project.
 - “Active” option: The 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 procedure.

14.8.4 Machine settings

Here you can find the settings for the registered devices.

Date and time:

Define whether the date and time on the connected welding devices should automatically be synchronized with the system date and system time on the terminal.

They are updated once a day during a welding data synchronization procedure. The automatic update is only carried out for devices with HMI firmware version 2.06 and above.

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.
- Start the app again.

14.8.5 General settings

Notifications

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

Preferred map provider (for coordinates, etc.)

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



Your authorised Service Centre is:

A large, empty rectangular box with a thin black border, intended for the user to write the name and address of their authorized service center.

↳ Sales and service center

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