

User Manual

Electrolytic Marking Unit

ÖSTLING

EU 80



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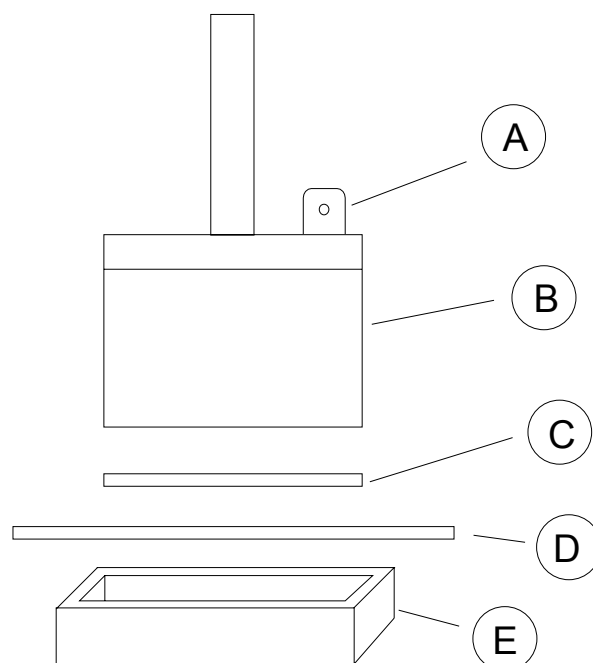
3.0 Programming procedure

- Plug the banana plug with the red cable in the red plug insert (Pos. 5a).
- Attach the other end of the red positive cable with the connector on the marking head (Pos. A).
- Plug the banana plug with the blue cable in the black plug (Pos. 5b).
- Put the other end of the blue negative cable on an electrically conductive base, or directly on the product.
- Plug in the power cord (Pos. 8) with 230 V AC- alternating current.

3.1 Preparing the marking head

Prepare a piece of black felt in the same size as the surface of the marking head. Fit a piece of conductive net (Pos. D) so that the net covers the edge of the marking head (Pos. B) approximately 15 mm. Now place the felt (Pos C) on the marking head, and place the conductive net over the felt in order that you may fasten the cassette felt (Pos. E) with the net. Slip an o-ring over the net and around the marking head so that everything is secure.

- Pos. A Connection to positive cable
- Pos. B Marking head
- Pos. C Felt
- Pos. D Conductive net
- Pos. E Cassette



3.2 Moistening the felt with electrolyte

Before you use the marking head we recommend that you rinse it with clean water so that the felt is soaked. After you have wrung out the felt to get rid of excess water, you may operate with the electrolyte.

3.3 Stencils

In order to make your own stencils quickly and professionally, ask about our customized stencil printing systems. This includes the Östling PT 220, 550, and a 24 pin printer as well as all software.

4.0 Marking process

- Turn on the machine (Pos. 6).
- Set your desired voltage (Pos. 1 - Pos. 3) the voltage you choose will be lit.
- Place the product to be marked on a base plate or other device. Place the Stencil on the product. After that push the prepared marking head lightly on the product. The marking time normally takes 1 - 1,5 seconds for black marking.

Hint: After marking it is a good idea to rinse the marking head and stencil with clean water.

Attention: If you notice the etching quality begin to slip, re-check the felt and the conductive net. Under normal use the felt will begin to collect carbon. For this reason replace the felt as needed.

5.0 Maintenance

Regular maintenance of the marking machine is not necessary. If you do experience difficulty, however, please turn to our service department. Unauthorized opening of the machine will void the warranty.

6.0 Accessories

In order to make a more efficient operation we offer a marking station for the hand operated unit. This consists of a base plate with T - nuts, two jiggings for attaching your product, and an X-Y-Z stencil holder.

With this hand marking station, the product is laid on the affixed jiggings and the stencil is affixed properly with the X-Y-Z stencil holder.

For further technical help you may turn to our technicians in order that they may answer your specific questions about different marking heads and other accessories such as customized construction or integrating the unit into your assembly line.

7.0 Troubleshooting

7.1 Problem: No mark

Try the following:

- Is the power cord plugged in ?
- Are all the cables properly installed ?
- Has a voltage been set ?
- Is the circuit breaker (Pos. 7) on the back side in order ?
- Is the marking head soaked with electrolyte ?

Please observe:

- Electrolytic marking works for electrically conductive surfaces only.
- Lacquered, anodized, or other protected surfaces cannot be marked electrolytically

7.2 Problem: Mark is unclear

- Make sure that the stencil is clean.
- Rinse the stencil with water to get rid of oxides.
- Make sure that the surface to the product is clean. Clean off excess dirt or oil with a dry cloth before you begin marking.

7.3 Problem: Black marks around the mark

The stencil has not been handled properly. It has been nicked and has a hole or is torn in some other way. In order to correct the problem the best solution is to replace the stencil. In an emergency, you may cover the holes with adhesive tape until another stencil arrives.

Please call us when:

- you experience technical difficulties.
- you would like sample materials marked.
- you would like more information regarding accessories such as different marking heads, felt, electrolyte, conductive net, or you need any other assistance.
- you would like information about additional ÖSTLING products such as pin marking, pad printing, laser marking, or inkjet printing.

8.0 Electrolytes

Type of marking	Current	Marking Power	Felt	Material	Electrolyte	Remarks
Black marking	AC	8	Black with conductive net	Stainless steel	6744, 70 ,72 ,SP1	
				Steel	676, 74 ,67/10/3, 676R74	
				Chrome , Nickel	75	
				Zinc coated	639	
				Tungsten Carbide	332/2	
White marking	AC	8	Black with conductive net	Black oxidized (Homp steamed)	114 Soft 119 Medium 117 Strong	Neutralize with N8

Electrolyte must be discarded after the marking process is complete !

