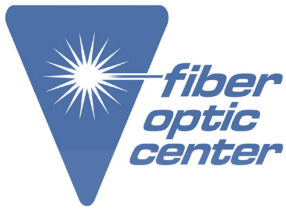


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**Manufacturer:**

Dymax

Product Name:

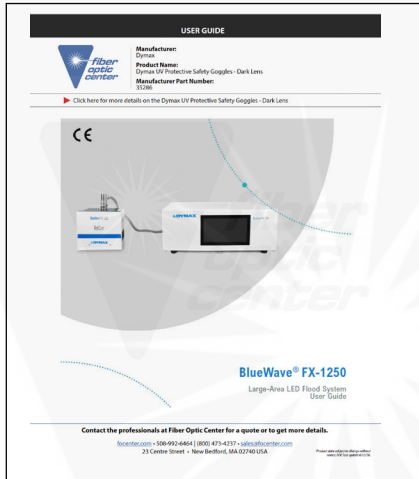
Dymax UV Protective Safety Goggles - Dark Lens

Manufacturer Part Number:

35286

▶ [Click here for more details on the Dymax UV Protective Safety Goggles - Dark Lens](#)

Click the thumbnail below to navigate to the User Guide



[BlueWave® FX-1250](#)



[BlueWave® MX-150
LED Spot-Curing Emitters](#)

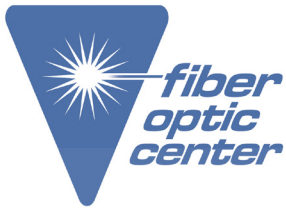
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**Manufacturer:**

Dymax

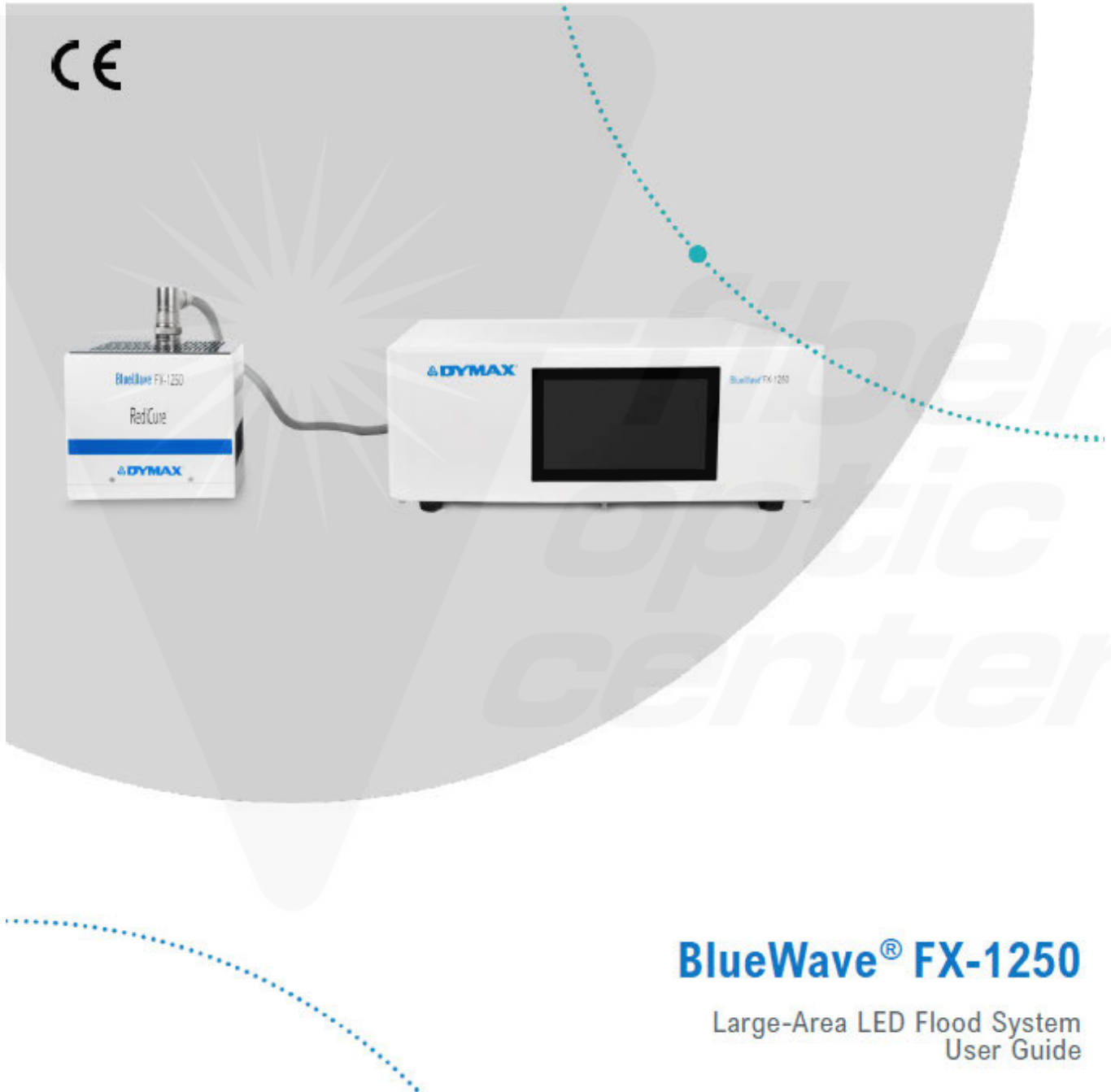
Product Name:

Dymax UV Protective Safety Goggles - Dark Lens

Manufacturer Part Number:

35286

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BlueWave® FX-1250

Large-Area LED Flood System
User Guide

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Introduction

This guide describes how to set up, use, and maintain the BlueWave® FX-1250 LED flood-curing system safely and efficiently.

Intended Audience

This user guide is meant for experienced process engineers, technicians, and manufacturing personnel.

WARNING! Under NO circumstances should the interconnect cable from the controller to the LED emitter be connected or disconnected while power to the unit is on. This procedure is usually called "hot swapping" and should not be performed as it could cause damage to the controller or the emitter. Always power down the equipment before disconnecting or connecting any of these devices.

Safety



WARNING! If you use this UV light source without first reading and understanding the information in the **UV Light Safety Guide**, SAF001, injury can result from exposure to high-intensity light. To reduce the risk of injury, please read and ensure you understand the information in that guide before assembling and operating the Dymax UV LED light source.



To use the BlueWave FX-1250 system safely, it must be set up and operated in accordance with the instructions given by Dymax. Using the system in any other manner will impair the protection of the system. Dymax assumes no liability for any changes that may impair the protection of the BlueWave FX-1250 system.

This device falls under IEC 62471 Risk Group 3 for UVA and Blue Light emissions:



WARNING! UV emitted from this product. Avoid eye and skin exposure to unshielded products.



WARNING! Possibly hazardous optical radiation emitted from this product. Do not look at operating lamp. Eye injury may result.



WARNING! Possibly the thermal exhaust hole temperature from emitter will be high, please don't touch the heatsink by hand



WARNING! The BlueWave FX-1250 is designed and certified to operate with the Dymax supplied 16 Amp, 1.5 mm², 3 conductor power cord. Do not use any other non-standard power cord.

WARNING! The BlueWave FX-1250 is designed and certified to operate as instructed within this document. Alteration of the system or its component installation may pose a shock hazard.

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Product Overview

The BlueWave FX-1250 is a high-intensity LED flood system used for curing light-curable materials. The unit is designed to be integrated into a larger system, such as an automated manufacturing system, or used with a light shielding enclosure to create a bench-top curing station.

The BlueWave FX-1250 can be used for manual and automated process applications and is composed of a controller and LED flood emitter, which is available in three different wavelengths: VisiCure (405 nm), PrimeCure (385 nm), and RediCure (365 nm).

The controller portion consists of an integrated control module and power supply. It allows complete control of an LED emitter, including setting intensity, timing, operation, and programming, while reporting the identity, operating parameters, and status of the emitter. It is designed to be used with any of the three LED emitter wavelengths. It is available in one channel (1CH) and two channel (2CH) configurations. The 2CH supports any two emitters, regardless of wavelength, working at the same time.

System Name	BlueWave FX-1250
Controller Model	BlueWave FX-1250 1CH BlueWave FX-1250 2CH
Emitter Model	BlueWave FX-1250 RediCure BlueWave FX-1250 PrimeCure BlueWave FX-1250 VisiCure

The BlueWave FX-1250 functions as a flood-curing system with a 127 mm x 127 mm (5 in x 5 in) irradiated curing area.

The unit can be operated in admin mode (unrestricted control) or production mode (restricted control) which allows for process management via access restrictions.

The unit can be controlled as well by Programmable Logic Controller (PLC) for automation applications.

LED technology within the BlueWave FX-1250 LED Flood System allows for instant on/off activation without the need for a warm-up period and is also rated for continuous operation.

Figure 1.
BlueWave FX-1250 LED Flood Curing System



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Controller Main Components

The interactive parts of the controller include the Display Screen, Power Switch, Power Input Receptacle, Output CH1, Output CH2, RS232 Receptacle, RS485 Receptacle and PLC Interface.

Figure 2
Controller Front Panel



Display Screen: Controls the operation of the controller and displays the operation parameters.

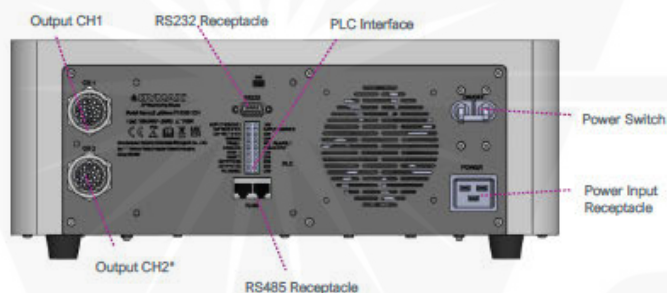
Power Switch: Controls the controller's power.

Power Input Receptacle: Used to connect the power cord.

Output CH 1, CH2: Used to connect the interconnect cable. There is no difference between the two receptacles, and they can be connected interchangeably.

RS485 & RS232 Receptacle: Used to communicate with a UVCS V3.0 conveyor. No connection is required when the controller is used alone.

Figure 3
2CH Controller Back Panel



*Note: Figure 3 is of a 2CH controller. 1CH controllers do not have Output CH2

Table 1.
Labels

Warning Labels	Product Information Label	High Temperature Caution Label	Emitter Wavelength Label (RediCure, PrimeCure, or VisiCure)

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Unpacking

Unpacking and Inspecting Your Shipment

Upon arrival, inspect all boxes for damage and notify the shipper of box damage immediately. Open each box and check for equipment damage. If parts are damaged, notify the shipper and submit a claim for the damaged parts.

The parts below are included with your purchase configuration.

Inspect the glass for any damage or residue on the surface. Carefully clean the glass with the alcohol swab. Take care not to touch the glass with bare hands, as any residue left on the window can adversely affect performance on the unit.

Parts Included

The parts below are included with your purchase configuration

Controller Only*

- BlueWave FX-1250 1CH or 2CH Controller (model as selected at time of purchase)
- Power Cord
- BlueWave FX-1250 LED Flood System User Guide
- UV-Light Safety Guide (SAF001)
- Terminal Block (attached to the controller, but not plugged in, with jumper wires installed)
- Footswitch
- Safety Eyewear

Emitter Only*

- BlueWave FX-1250 Emitter (RediCure, PrimeCure, or VisiCure, model as selected at time of purchase)
- UV-Light Safety Guide (SAF001)

** Orders of individual controllers and emitters must purchase interconnect cables separately.*

Complete Kit

- All parts listed above included
Note: only the 1CH Controller is available in a Complete Kit
- Interconnect Cable (Type I&L)

Figure 4.

Components of a BlueWave FX-1250 -Controller Only
88804/88805/88846/88847/88850/88851

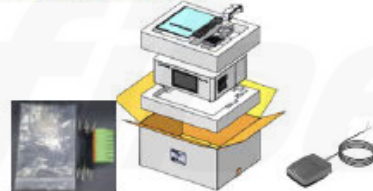


Figure 5.

Components of a BlueWave FX-1250 -Emitter Only
88801/88802/88803



Figure 6.

Components of a BlueWave FX-1250 - Complete Kit
88848/88856/88859/88849/88857/88860/88855/88858/88861



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System Installation

System Assembly

The system includes two major parts, the controller and emitter. The two parts are shipped separately.

To assemble the two parts together, plug one side of the interconnect cable into the controller and the other side into the emitter (Figure 7).

NOTE: Be careful to keep the glass at the bottom of the emitter clean. To avoid leaving fingerprints on the glass, do not touch the glass with bare hands.



WARNING! The BlueWave FX-1250 is designed and certified to operate as instructed within this document. Alteration of the system or its component installation may pose a shock hazard.

System Cooling

The system can be used in various scenarios with additional mounting fixtures or Dymax accessories, i.e., as a bench-top unit with a stand on a chamber, as part of a conveyor, etc. This system should only be operated in a location that provides proper cooling. Location requirements are as follows:

- For proper cooling of the unit, upper intake and lower exhaust must not be blocked.
- Minimum recommended clearance is 8 inches [200 mm].
- Note that the lower exhaust may have one side blocked for installations where two units are side by side. The system will operate safely but run hotter.

Figure 8.

Recommended Cooling Clearance

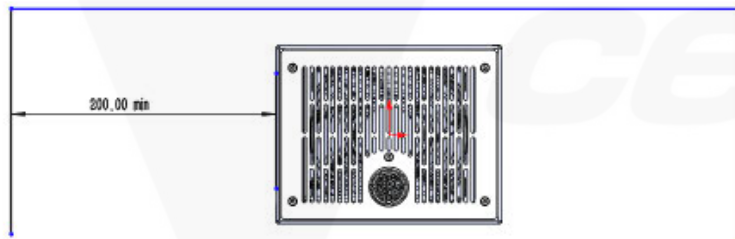


Figure 7.
Interconnect Cable Installed



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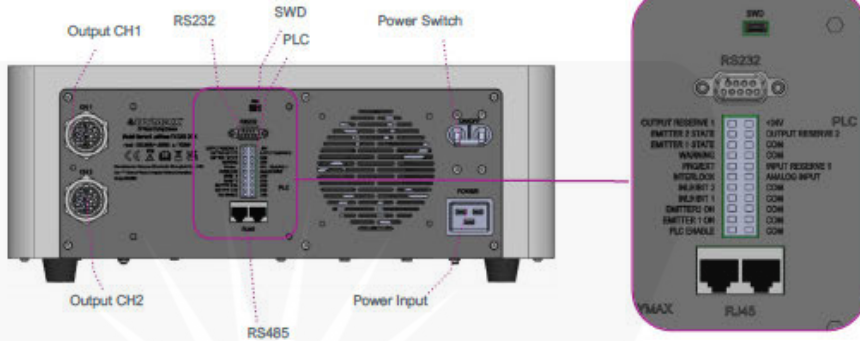
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Wiring and Connections

All the wire and cable connections are located on the rear of the controller or the top of emitter.

Figure 9.
Controller Connections



Power Switch: Turns the unit on and off.

Power Input: The power cord plugs in here. Only use the power cord supplied by Dymax (Figure 10) as the power cord supplied with the controller is specifically designed and certified to work with the controller.



WARNING! The BlueWave FX-1250 is designed and certified to operate with the Dymax supplied 16 Amp, 1.5 mm², 3 conductor power cord. Do not use any other non-standard power cord.

Figure 10.
Power Cord



Figure 11.
Interconnect Cable for Output Channels 1 & 2
84025/84026



Output CH1/CH2: Output power and control signal to emitter. Only use the interconnect cable made by Dymax (Figure 11) as this interconnect cable is specifically designed for this system. One controller in 2CH configuration can support up to two emitters at the same time.

SWD: Burn in or update the software into controller.

RS232: Conduct communication to computer.

PLC: Controlled by PLC program.

RS485: Controlled by internet.

Connections

The interconnect cable has two 15P plugs that connect the controller to the emitter.

Plugging the interconnect cable into the controller: Roll the plug clockwise while inserting to plug the cable in. Roll the plug counterclockwise while removing to unplug the cable (Figure 12).

Plugging the interconnect cable into the emitter: Roll the plug clockwise while inserting to plug the cable in. Roll the plug counterclockwise while removing to unplug the cable (Figure 13).

Figure 12.
Plug Interconnect Cable into Controller



Figure 13.
Plug Interconnect Cable into Emitter



Figure 14.
Key (Left) and Keyway (Right)



Attention: When plugging in the female and male connectors, observe the key and keyway of each connector. The key should align with the keyway (Figure 14).

Plugging the footswitch or light shield into the controller:

1. Using a jumper wire, connect PLC ENABLE (Input Pin 1) to the opposite COM port (2).
 2. Using a jumper wire, connect the INHIBIT (Input Pins 7, 9) for each emitter being used to its opposite COM port.
 3. Connect the footswitch or light shield into the EMITTER ON (Input Pins 3, 5) for each channel into its opposite COM port.
- To control two emitters with a single footswitch, jumper both INHIBITS, and the EMITTER 2 ON, then plug the footswitch into EMITTER 1 ON and the opposite COM port.

Figure 15.
Plug Footswitch into Controller

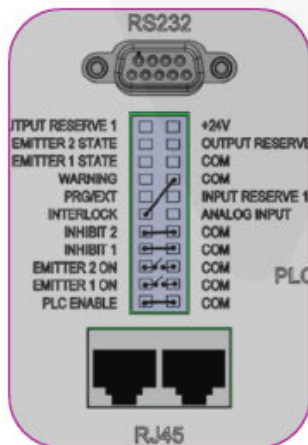
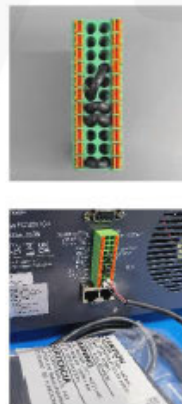


Figure 16.
Example: Footswitch Connection



Note: The Input/Output terminal block is included in the packaging, with the jumper wires inserted. When the terminal block is installed, the controller will enter PLC mode. PLC mode disables commands and parameter setting from the HMI. To set parameters from the HMI, the terminal block must be removed, or the connection between the PLC Enable and COM pins (1 and 2) must be disconnected.

To allow setting of parameters by analog input: start with the standard installation described for the footswitch and light shield. Add an additional jumper between PRG/EXT (13) and COM (18). Connect to Analog Input (12) and COM (16) for input and +24V (22) and COM (18) to add 24V power.

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I/O Interface Summary

Table 2 below shows the summary of all signals on the PLC Connector.

Table 2.

I/O Interface

Signal Name / Description	PIN #	Signal Level	
		Asserted	De-Asserted
INPUTS			
Input Reserve 1	14	Do Not Use	
ANALOG INPUT	12	0 – 10 VDC	N/A
Only used in PLC EXT mode			
Sets Emitter intensity level (0~1V=0% output,1V=10% output, 10V=100% output)			
INTERLOCK	11	0 VDC, GND	(Open)
PLC ENABLE	1	0 VDC, GND	(Open)
Emitter 1 ON	3	0 VDC, GND	(Open)
Emitter 2 ON	5	0 VDC, GND	(Open)
PRG/EXT	13	0 VDC, GND(EXT)	(Open)(PRG)
INHIBIT 1	7	0 VDC, GND	(Open)
INHIBIT 2	9	0 VDC, GND	(Open)
OUTPUTS			
PLC POWER ⁽¹⁾ (24V, 50mA maximum)	22	Always On	
WARNING	15	0 VDC, GND	Open
EMITTER 1 STATE	17	0 VDC, GND	Open
EMITTER 2 STATE	19	0 VDC, GND	Open
Output Reserve 1, Output Reserve 2	21,20	Do Not Use	
RETURNS (These pins are common and may be used interchangeably)			
COM	2,4,6,8,10,16,18	Common Grounds	

(1) PLC power channel is a 24V source available for use to drive PLC logic but must be current limited using pull-down resistors to protect the BlueWave FX-1250 when directly attached to the I/O channels through the PLC connector.

(2) CHASSIS Ground connections do not share a common connection with signal returns and cannot be interchanged with signal returns.

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PLC UV Control

PLC switching may be driven by manual switch, relay, or optical coupler. Only analog intensity uses a voltage input to the PLC.

To use the PLC mode, the **PLC ENABLE** (input pin 1) must be pulled down to low by grounding to the **COM** ground point

The **PLC INTERLOCK** (input Pin 11) disables all the UV output when it is de-asserted. It is pulled down before other control signal in PLC mode.

The **PLC INHIBIT 1** (input Pin 7) and **INHIBIT 2** (input Pin 9) disables each channel's UV output when it is de-asserted. After the **INTERLOCK** is pulled down, the **INHIBIT 1** or **INHIBIT 2** is also pulled down.

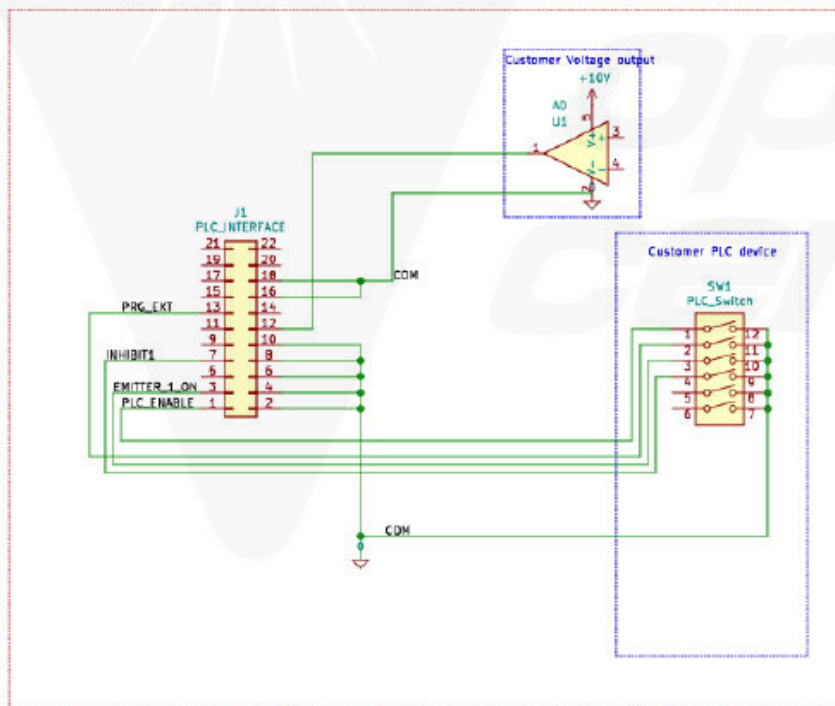
After above signals are pulled down, the PLC can control the UV on/off using the **Emitter 1 ON** (input Pin 3) or **Emitter 2 ON** (input Pin 5). When this input is pulled down by grounding to **COM** ground, the UV LED will turn on.

The PLC can also control the intensity of the UV output.

- When the **PRG/EXT** (input Pin 13) is pulled down low by grounding to **COM** ground, the Intensity will be controlled by the **EXTERNAL ANALOG INTENSITY** input voltage.
- The **ANALOG INPUT** (input Pin 12) is an analog voltage input. The voltage range is 0 to 10VDC.

Any setting below 1 VDC will set the Intensity to 0% and each 1V additional volt increases intensity by 10%. (Example: 1V = 10%, 5V = 50%, 10V = 100%). The example connection for the PLC control signal is shown in Figure 17.

Figure 17.
PLC Connection Example



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Figure 18.
Typical Application 1

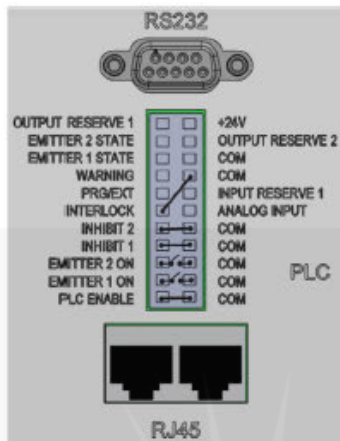
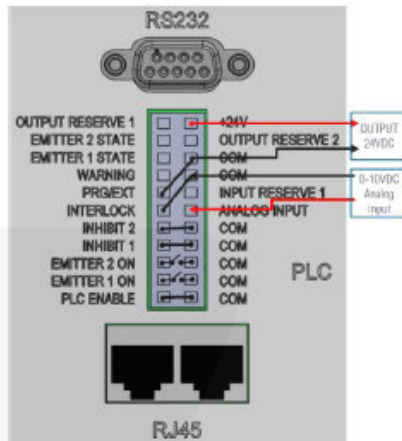


Figure 19.
Typical Application 2



Note: The Input/Output terminal block is included in the packaging, with the jumper wires inserted. When the terminal block is installed, the controller will enter PLC mode. PLC mode disables commands and parameter settings from the HMI. To set parameters from the HMI, the terminal block must be removed, or the connection between the PLC Enable and COM pins (1 and 2) must be disconnected.

Status Output

There are three status outputs. They are driven by an optical coupler. These outputs work in any mode and can be used as status inputs for PLC or any status display/monitor purpose.

- **WARNING** - Output low indicates the unit is working normally.
- **Emitter 1 & 2 State** - Output low indicates the UV LEDs are ON.

An example application of these signals is shown in Figure 20.

PLC Power channel is a 24V source available for use to drive PLC logic but must be current limited using pull-down resistors to protect the FX-1250 when directly attached to the I/O channels through the PLC connector. The support current is 50 mA max.

Figure 20.
Status Outputs Connection Using On-Board 24V Source

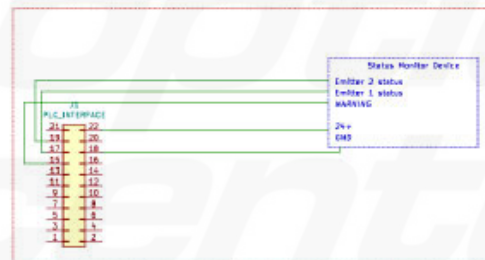
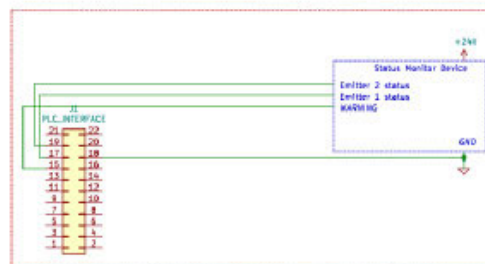


Figure 21.
PLC Status Outputs Using Customer-Supplied 24V Source



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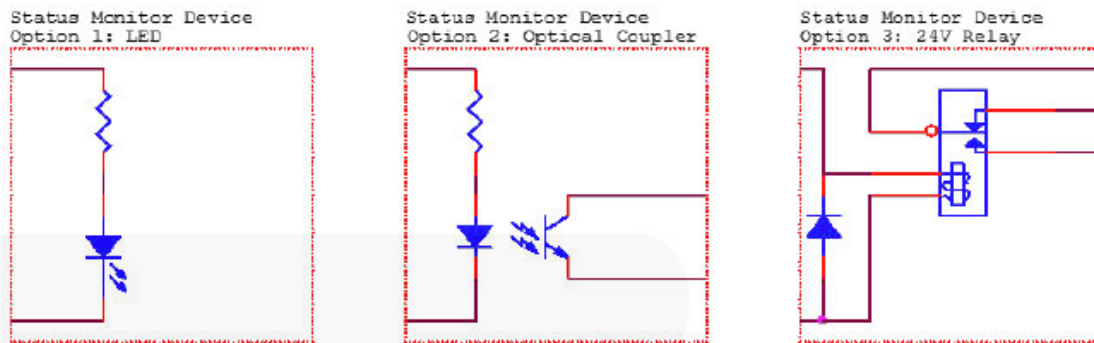
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Figure 22.

Examples of Customer Configurations for Monitoring Outputs



Operation

Start Up

1. Verify all connectors are firmly plugged into the rear panel of the BlueWave FX-1250 controller and emitter.
2. On the rear panel of the controller, move the power switch to the ON position (up direction).
3. The start-up window (Figure 23) will appear for several seconds as the system initializes.

Figure 23.
Start-Up Window



After starting up, the main window (Main Window Settings)

In the main window, the operator can:

1. Set each channel's power and cure time.
2. Start or stop each channel or all channels.
3. Figure 24) appears.

WARNING! Emitters must be installed correctly before power up. If no emitter is installed, the controller is not operable. Power off the controller and install at least one emitter.

5. The system is now ready to have emitter parameters set.

Main Window Settings

In the main window, the operator can:

3. Set each channel's power and cure time.
4. Start or stop each channel or all channels.

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Figure 24. Main Window

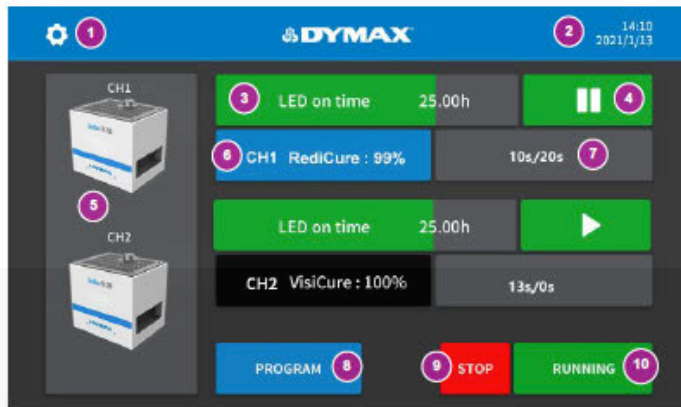


Table 3. Main Window Functions

Number	Name	ICON	Description
1	System setting		Press to enter the system setting window to set the system parameters (clock, calendar, password, LED on time, brightness).
2	Calendar and clock		Display clock and calendar.
3	Progress bar		If the cure time is not zero, the green bar increases to indicate the progress of a cure time count. If the cure time is zero, the green bar does not increase. LED on time displays the total time the LED has been on.
4	Play/Stop button		Each channel controls one emitter. The green color indicates the emitter is on. ▶ is pressed to start the emitter. ⏸ is pressed to stop the emitter. The red indicates the emitter is off when you just plug one emitter. The dark grey indicates no emitter is plugged in. Power off the controller to install an emitter. The red and dark grey play button have no function when pressed.
5	Emitter & parameters		Each channel can be connected to an emitter. It displays the channel number on top.
6	Power and type button		Displays the channel number, emitter type, power set. The display will be one of four colors: Blue – RediCure, Black – VisiCure Grey – PrimeCure Red – NA Press to set the power of this channel. If no emitter is plugged in, the channel displays NA.
7	Timer		Counts down to zero if the cure time is not zero. Counts up if the cure time is zero. Press to set the cure time.
8	Program		Press to save and load stored setting parameters.
9	Stop button		Press to stop all emitters.
10	Run button		Press to start all emitters. When at least one of the emitters is on, the 'RUN' turns to 'RUNNING'.

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Setting the Power

The operation steps are:

1. On the main window, press the power button (Table 3, #6) to enter the power window (Figure 25).
2. Enter the desired value using the pad and press enter. (10%~100%). The new value will display in the bar.
3. If no change is needed, press the back arrow in the top left corner to exit the power window.

Figure 25.
Power Window



Setting the Cure Time

1. On the main window, press the timer (Table 3, #7) to enter the cure time window (Figure 26).
2. Enter the desired value using the pad and press enter (0-9999 seconds). The new value will display in the bar.

Set the cure time to 0 sec. to run the emitter until it is manually stopped.

Set a value greater than 0 sec. to run the emitter automatically for that duration.

Cure times can be set in intervals of 0.1 sec.

3. If no changes are needed, press the back arrow in the left top corner to exit the cure time window.

Figure 26.
Cure Time Window



Running the System

1. After power and cure time have been set, the emitters can be run.
2. Each emitter channel can be operated separately using the play/stop button (Table 3, #4) on the main window.
3. To operate all emitter channels together, the run (Table 3, #10) and stop (Table 3, #9) buttons on the main window can be used to start and stop the emitters.

Program Setting

To save your set values in the main window, press program (Table 3, #8) on the main window to enter the program setting window. You are required to enter the user's password correctly before the program window loads.

There are 16 slots for selection. Their default names are Program # (1-16). Only one slot can be selected at a time.

The operation steps are:

1. Press on a program slot. The program slot will change to blue when selected. The parameters stored in that program slot will display in the white bar.
2. Press the Rename button to rename the slot.
3. Press the Save button to save the current set values (channel number, power, and cure time) to that program slot.
4. Press the Load button to load the slot's value and exit to the main window.
5. Press the Delete button to erase a slot's name and set the stored values of the slot to 0.
6. Press the back arrow in the top left corner to exit the program window.

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USER GUIDE | BLUEWAVE FX-1250

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Settings

Press the system setting button  on the main window. A password input window (Figure 27) will appear. The password must be entered to enter the System Settings window.

Press the input bar on the password input window to activate the keyboard (Figure 28).

The default password is set to "1234".

Figure 27.
Password Input Bar

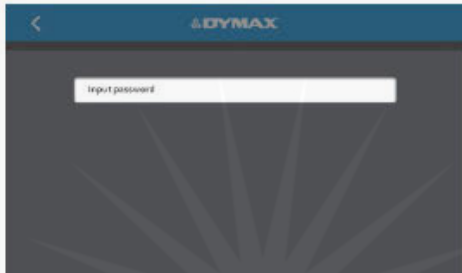


Figure 28.
Keypad for Password Window



Once the password is entered, the System Settings window (Figure 30) will appear.

Figure 29.
Program Window

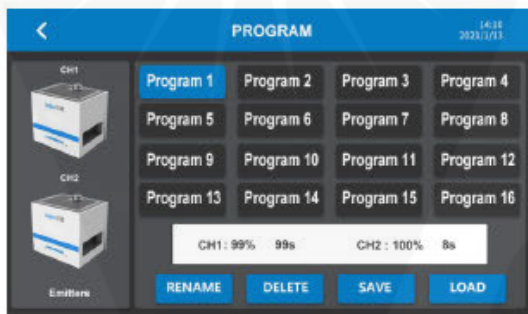


Figure 30.
System Settings Window



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Brightness

1. On the system settings window, press on the brightness dropdown button (Error! Reference source not found.).
2. Move the bar up and down to adjust the brightness of the screen.
3. Press the back arrow in the left top corner to exit.

Clock and Calendar Settings

1. On the system settings window, press the time dropdown arrow.
2. Press the clock in the window to input the date and time by using the pad.
3. Press the back arrow on the top left to exit.

Resetting the Emitters' LED ON Time

The emitter on time appears in the gray bar (Figure 33) on the System Settings window.

Once the emitter is on, the LED on time will begin counting.

If an emitter is changed for a channel, the LED on time must be cleared for it to recount in that channel.

Press the Reset button located to the right of the emitter LED on time to clear it.

Changing the Password

1. Press the change Password button on the system settings window to enter the Change Password window.
2. Press New Password to input the new password.
3. Press "Confirm New Password" and input the new password again. The two input passwords must be the same.
4. Press the back arrow in the left top corner to exit.

System Reset

Press the System Reset button on the System Settings window to:

- Reset the password to the default:1234
- Reset the program names and values to the default

Figure 31.
Brightness Adjustment Bar



Figure 32.
Clock and Time Input Pad

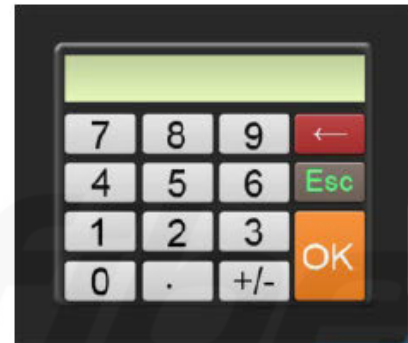


Figure 33.
Emitter On Time

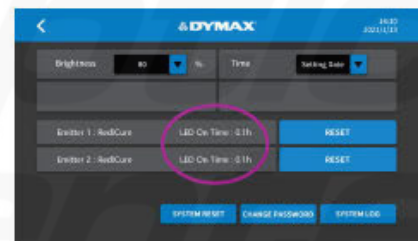


Figure 34.
Change Password Window



System Log

Checking the Alarm History Log

To check the alarm history log, press the Alarm Log window. The error window will appear (Figure 35).

Note: The alarm records are only updated. They can't be deleted. The lines show the date and time of the alarm, and the code to describe the reason for the alarm.

The controller can save a maximum of 100 records. When over 100 alarms have been recorded, the next number is overlaid by the new alarm.

Press the Back arrow to return to the main window.

When the Controller Alarms

When the controller alarms, the controller is forced to enter the Alarm window. The Alarm button appears in the bottom. Press the Turn Off Button (Figure 36) to enter the Alarm Log window.

After the alarm code is checked, press the Back arrow to return to the main window.

An alarm icon will appear on the left of the stop button. Navigate to the log window directly by pressing the button. (Figure 37)

When an alarm occurs, the emitters are stopped, and the controller emits a beep.

Press the Reset button to turn off the beep and disable the alarm.

WARNING! Power off before checking the controller and emitters.

When any emitter's temperature is over 60°C, a warning screen pops up (Figure 38). It is a warning message only.

Press the Turn Off Button to close the warning screen. The warning will also automatically close when the emitter temperature returns to 60°C.

The emitter will automatically shut down if the maximum allowable temperature is reached.

Figure 35.
Error Window



Figure 36.
Alarm Button



Figure 37.
Main Window with Alarm Button

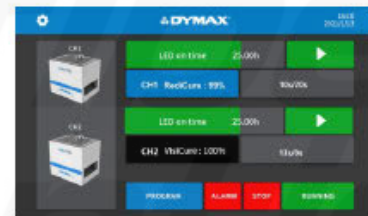


Figure 38.
High Temperature Warning Screen



Table 4.
Alarm Codes and Description

Alarm Code	ALARM message	Cause
0x1000	Ctrl Over Temperature (>50°C)	The controller temperature is too high.
0x2000	EM x (1,2) not installed	Emitter connection has problems after power up.
0x2001	EM x (1,2) fan error	Emitter fan has no speed.
0x2002	EM x (1,2) over temperature (> 69°C)	Emitter temperature is too high.
0x2003	EM x (1,2) over current	Emitter current is too high.
0x2004	EM x (1,2) zero output	Emitter has no current output.

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PLC Mode

There are 2 working modes:

Program: This is the default mode and is operable by the touch screen. Parameters can be stored in the program slots and called for operation. The parameters can be stored in the program slots and called for operation. This is the default mode for the touchscreen.

PLC: The system can be controlled by PLC. This mode is triggered by the PLC ENABLE input signal. Please follow the wiring guide in "PLC UV Control" on page 12.

Once the PLC mode is on, the PLC mode window (Figure 39) displays.

Figure 39.
PLC Mode Window

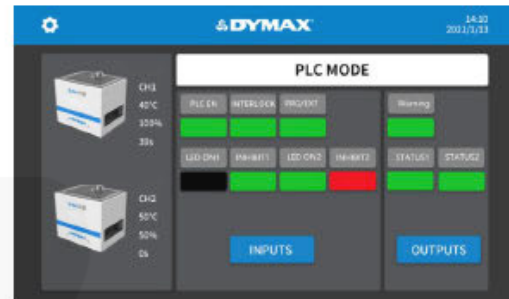


Table 5.
PLC Mode Signals

Signal Name / Description	Pin #	Signal Color	
		Asserted	De-Asserted
INPUTS			
INTERLOCK	11	GREEN	RED
PLC ENABLE	1	GREEN	RED
LED ON1	3, Emitter 1 ON	GREEN	BLACK
LED ON2	5, Emitter 2 ON	GREEN	BLACK
PRG/EXT	13	(EXT), GREEN	(PRG), RED
INHIBIT 1	7	GREEN	RED
INHIBIT 2	9	GREEN	RED
OUTPUTS			
WARNING	15	GREEN	RED
STATUS 1	17, EMITTER 1 STATE	GREEN	BLACK
STATUS 2	19, EMITTER 2 STATE	GREEN	BLACK
CHANNELS			
Emitter & Parameters		Each channel has an emitter. It displays the channel number, emitter temperature, power, and cure time. If no emitter is plugged in, the channel displays NA,0°C,0,0.	

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Spare Parts & Accessories

Accessories

Item	Part Number
Personal Protection Equipment	
Protective Goggles — Green	35286
Protective Goggles — Gray (standard model included with unit)	84126
Face Shield	35186
Accessories	
Interconnect Cable, Type L & L — 2 m , 5 m	84025 , 84027
Interconnect Cable, Type I & L — 2 m , 5 m	84026 , 84028
Extension Cable, Type I & I — 5 m	84306
Extension Cable, Type I & L — 5 m	84307
Footswitch	84124
Radiometer	
ACCU-CAL™ 50-LED Radiometer	40505
Stands & Shields	
Mounting Stand	88844
Three-Sided Acrylic Shield	81016
Light Shield 360° shielding. Swing-up door and slide-out shelf. Not compatible with Dymax shutters.	88845

Components & Spare Parts

Item	Part Number
BlueWave FX 1250 Emitter RediCure (365 nm)	88801
BlueWave FX1250 Emitter PrimeCure (385 nm)	88802
BlueWave FX1250 Emitter VisiCure (405 nm)	88803
BlueWave FX1250 Controller 1CH (China Cord)	88805
BlueWave FX1250 Controller 2CH (China Cord)	88804
BlueWave FX1250 Controller 1CH (North America Cord)	88846
BlueWave FX1250 Controller 2CH (North America Cord)	88847
BlueWave FX1250 Controller 1CH (No Cord)	88850
BlueWave FX1250 Controller 2CH (No Cord)	88851
Power Cord, BlueWave FX-1250, 2M, China	84020
Power Cord, BlueWave FX-1250, 2M, North America	84061
Power Cord, BlueWave FX-1250, 2M, EU	84023
Power Cord, BlueWave FX-1250, 2M, UK	84024
Glass Replacement Kit	83015
PLC I/O Terminal Block (22 pin)	84062

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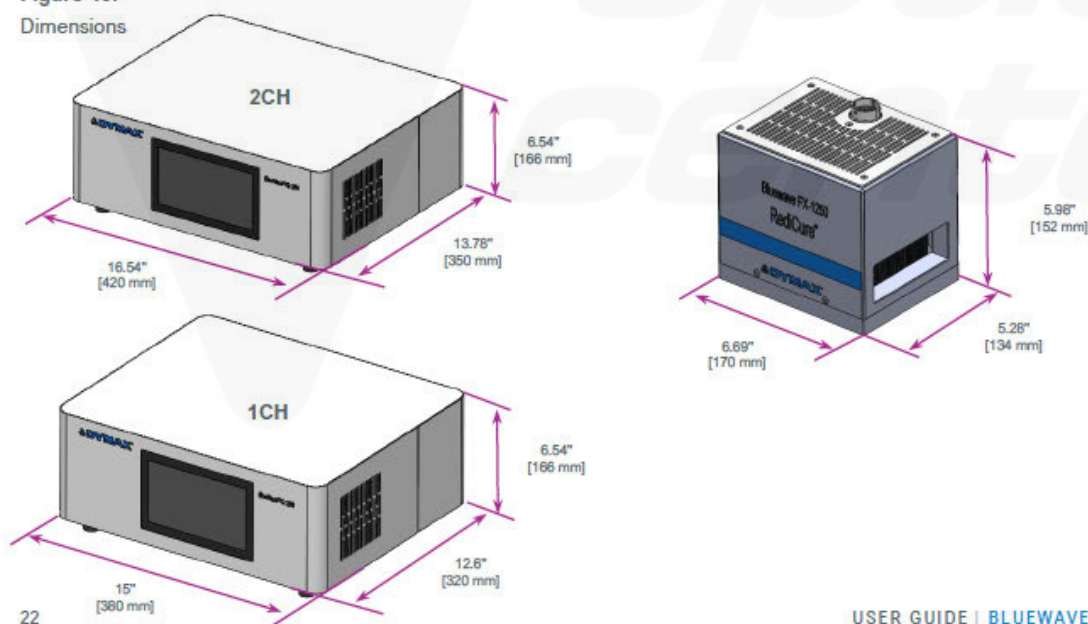
Specifications



Property	Specification		
Emitter	RediCure	PrimeCure	VisiCure
Output Wavelength	365 nm	385 nm	405 nm
Irradiance Output at 25-mm Working Distance*	1.7 W/cm ²	2.1 W/cm ²	2.0 W/cm ²
Curing Area	5" x 5" [127 mm x 127 mm]		
Power Requirements	100-240 V~, 50/60 Hz 1CH Controller: 850 W 2CH Controller: 1700 W		
Cooling	Air cooled		
Dimensions (W x D x H)	1CH Controller: 15" x 12.6" x 6.5" [380 mm x 320 mm x 166 mm] 2CH Controller: 16.5" x 13.8" x 6.5" [420 mm x 350 mm x 166 mm] Emitter: 6.7" x 5.3" x 6" [170 mm x 134 mm x 152 mm]		
Weight	1CH Controller: 28.2 lb. [12.8 kg] 2CH Controller: 43.7 lb. [19.8 kg] Emitter: 8.8 lb. [4 kg]		
Unit Warranty	1 year from purchase date		
Operating Environment	10°C to 40°C (50°F to 104°F) 0 - 80% relative humidity, non-condensing (recommended: 30% RH) 2,000-meter max. altitude		
Shipping and Storage Conditions	Temperature: -20°C to +50°C Humidity: 10 - 80% RH, non-condensing Ship via standard ground, ocean, or air freight		
Certifications	RoHS, CE Marked, UKCA, EMC and Low Voltage		

* Measured using a Dymax ACCU-CAL™ 50-LED radiometer in flood mode at 25-mm working distance.

Figure 40.
Dimensions



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Figure 41.
Mounting Hole Locations and Size

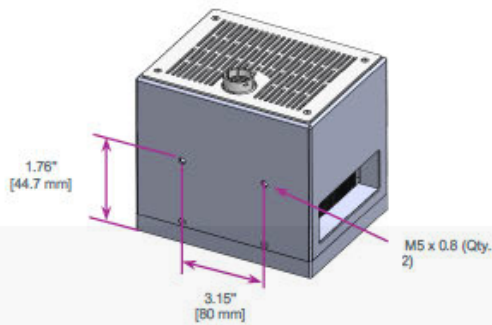
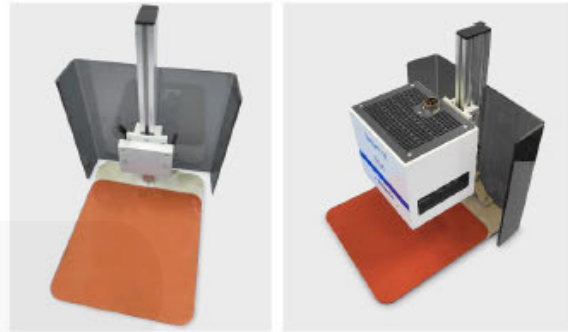


Figure 42.
Mounting Stand (PN 88844)



Mounting stands are sold separately. Emitters can be mounted on mounting stand with two M5 screws included with the mounting stand.

Table 6.
Operation Timing

Input Event	Out Event	Test Condition	Maximum Time Delay
LED ON/OFF Change to Low	UV LED ON	PLC Mode	20 ms
	LED STATE Output Change to LOW		25 ms
LED ON/OFF Change to High	UV LED OFF		30 ms
	LED STATE Output Change to High		40 ms
LED ON/OFF (Closed)	UV LED ON	Manual Mode	150 ms
	LED STATE Output Change to LOW		180 ms
LED ON/OFF (Open)	UV LED OFF		25 ms
	LED STATE Output Change to High		50 ms
LED ON/OFF Asserted (Change form Open to Closed)	UV LED ON	Timer Mode UV LED is OFF	140 ms
	LED STATE Output Change to Low	Before Timer Expired UV LED is ON	150 ms
	UV LED OFF		140 ms
	LED STATE Output Change to High		160 ms

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Validation

Tests should be conducted prior to production to determine the time and light intensity required to fully cure your resin. The following approaches may be used to validate the curing process.

Set Exposure Time, Determine Intensity

Users can specify a cure time and, through empirical testing, determine the intensity required to achieve a full cure. As with any manufacturing process, it is advisable to incorporate a safety factor.

Set Intensity, Determine Exposure Time

Users can specify light intensity and, through empirical testing, determine the exposure time required to achieve a full cure. As with any manufacturing process, it is advisable to incorporate a safety factor.

NOTE: Dymax recommends intensities low at first to preserve LED life.

Control

Process validation confirms a minimum acceptable intensity. Users can then choose to operate at full intensity (using the excess intensity as an additional safety factor) or adjust the output to a specific intensity level. To ensure consistent and repeatable process results, intensity levels should be monitored with a radiometer. This enables users to identify light intensity changes and take corrective action (either adjusting the light intensity or performing maintenance).

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Declaration of Conformity

Figure 43.

Declaration of Conformity - CE



DYMAX®

EU Declaration of Conformity

Manufacture:
Hanarey Chemicals (Shanghai) Co., Ltd.
No.111 Muhua Road, Fengdan District,
Shanghai, China 201507

Product description:
Model name(s):

UV Flood Curing Device
BlueWave FX-1250 Controller 1CH/2CH
BlueWave FX-1250 Emitters RediCure/ PrimeCure/ VisiCure
BlueWave FX-1250 Interconnect cable I&L/ L&L

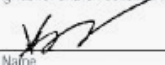
This product complies with the following relevant Union Harmonization Legislation:

Electromagnetic Compatibility Directive (2014/30/EU):
EN 55011:2016+A1:2017+A11:2020
EN 61000-3-2:2014 Class A
EN 61000-3-3:2013
EN 61326-1:2013

Low Voltage Directive (2014/35/EU):
EN 61010-1:2010+A1:2019
EN 62471:2008

RoHS Directive 2011/65 EU (Incl. (EU) 2015/863)
EN IEC 63000:2018

Declaration:
*This declaration of conformity is issued under the sole responsibility of the manufacturer.
Signed for and on behalf of Hanarey Chemicals (Shanghai) Co., Ltd*

 2021.11.3 Shanghai
Name Date Location

Authorized Signatory:
Kyle Zhu
Senior Manager, Equipment Development
Hanarey Chemicals (Shanghai) Co., Ltd.

CE

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Figure 44.
Declaration of Conformity – UK CA

DYMAX®

UK Declaration of Conformity

Manufacture:
Hanarey Chemicals (Shanghai) Co., Ltd.
No.111 Muhua Road, Fengxian District,
Shanghai, China 201507

Product description:
Model name(s):
UV Flood Curing Device
BlueWave FX-1250 Controller 1CH/2CH
BlueWave FX-1250 Emitter RediCure/ PrimeCure/ VisiCure
BlueWave FX-1250 Interconnect cable I&L/ L&L

This product complies with the following relevant UK Legislation:

Electromagnetic Compatibility Regulation 2016:
EN 55011:2016+A1:2017+A11:2020
EN 61000-3-2:2014 Class A
EN 61000-3-3:2013
EN 61326-1:2013

Electrical Equipment (Safety) Regulations 2016:
EN 61010-1:2010+A1:2019
EN 62471 :2008

The Restriction of the Use of Certain Hazardous Substances
in Electrical and Electronic Equipment Regulation 2012
EN IEC 63000:2018

Declaration:
This declaration of conformity is issued under the sole responsibility of the manufacturer.
Signed for and on behalf of Hanarey Chemicals (Shanghai) Co., Ltd

[Signature] *2021.11.3* *[Signature]*
Name Date Location

**UK
CA**

Authorized Signatory:
Kyle Zhu
Senior Manager, Equipment Development
Hanarey Chemicals (Shanghai) Co., Ltd.

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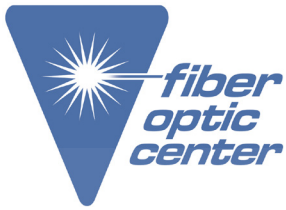
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**Manufacturer:**

Dymax

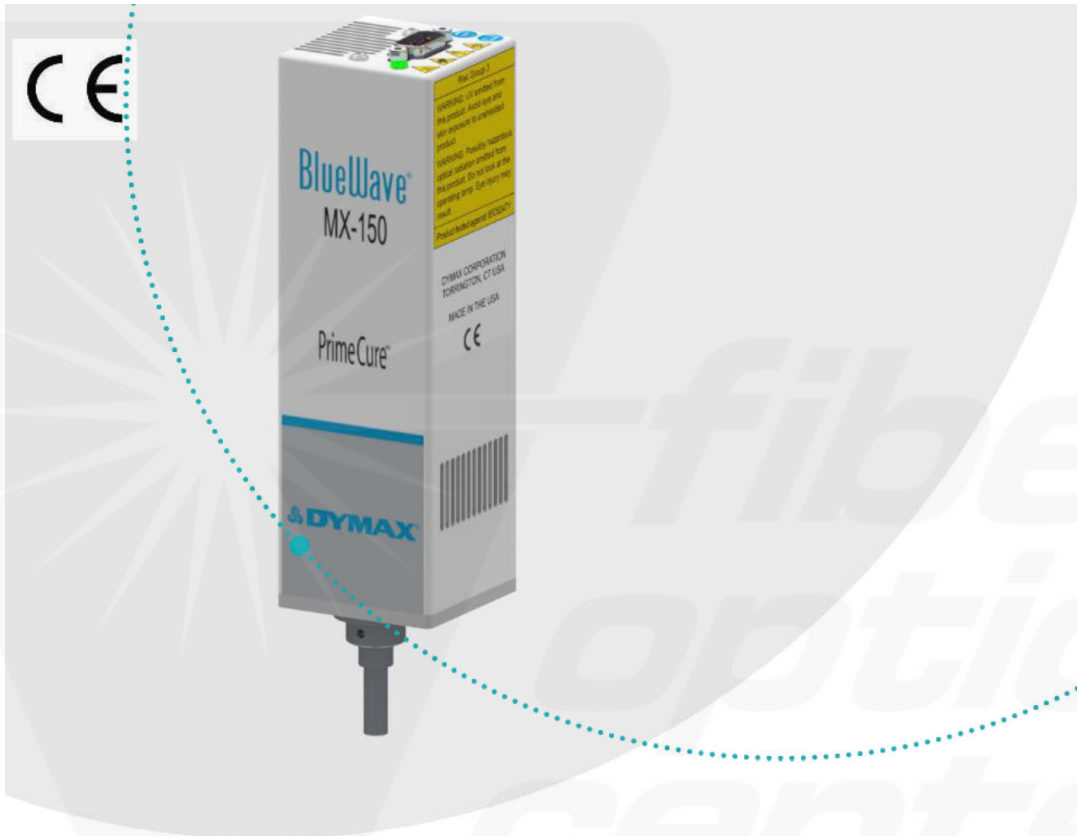
Product Name:

Dymax UV Protective Safety Goggles - Dark Lens

Manufacturer Part Number:

35286

▶ [Click here for more details on the Dymax UV Protective Safety Goggles - Dark Lens](#)



BlueWave® MX-150 LED Spot-Curing Emitters

User Guide

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Introduction

This guide describes how to set up, use, and maintain BlueWave® MX-150 emitters safely and efficiently.

Intended Audience

This user guide is meant for experienced process engineers, technicians, and manufacturing personnel.

Safety



WARNING! Under NO circumstances should the interconnect cable from the controller to the LED emitter be connected or disconnected while power to the unit is on. This procedure is usually called “hot swapping” and should not be performed as it could cause damage to the controller or the emitter. Always power down the equipment before disconnecting or connecting any of these devices.



WARNING! If you use this UV LED light source without first reading and understanding the information in the UV Light Safety Guide, SAF001, injury can result from exposure to high-intensity light. To reduce the risk of injury, please read and ensure you understand the information in that guide before assembling and operating the Dymax UV LED light source.



Specific Safety statements for this device:

This device falls under IEC 62471 Risk Group 3 for UVA and Blue Light Emissions:

WARNING. UV emitted from this product. Avoid eye and skin exposure to unshielded products.

WARNING. Possibly hazardous optical radiation emitted from this product. Do not look at operating lamp. Eye injury may result.

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Product Overview

Description of BlueWave MX-150 Emitters

- When paired with a MX-series controller, BlueWave MX-150 emitters function as a high-intensity spot-curing system. The system can be set up in many configurations and can be used with a lightguide if needed.
- The BlueWave MX-150 emitter is air cooled using an axial fan.
- The BlueWave MX-150 emitter can be mounted using one of two hole-patterns in the housing body.

Figure 1.
BlueWave MX-150 Emitter



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Unpacking

Upon arrival, inspect all boxes for damage and notify the shipper of box damage immediately. Open each box and check for equipment damage. If parts are damaged, notify the shipper and submit a claim for the damaged parts.



WARNING! *Until the BlueWave® MX-150 emitter is attached to a controller via the interconnect cable it is susceptible to ESD damage, handle according to ESD standards using a ground strap and do not touch exposed connector pins.*

The parts below are included in every package/order.

Parts Included

LED Emitter

- BlueWave MX-150 LED Emitter Assembly
- 5-mm Lightguide Simulator
- User Guide

Installation

The BlueWave MX-150 emitter is part of a MX-series curing system and requires connection to a controller via an interconnect cable for proper operation.

Important Information

- Do not connect any components while power is applied.
- Mount the BlueWave MX-150 emitter to a rigid support, such as the emitter stand PN 42390, prior to connecting the interconnect cable to prevent handling damage.
- Always keep the LED area covered by a lightguide, rod lens, or lightguide simulator. Assure that FOD cannot flow into the LED area.

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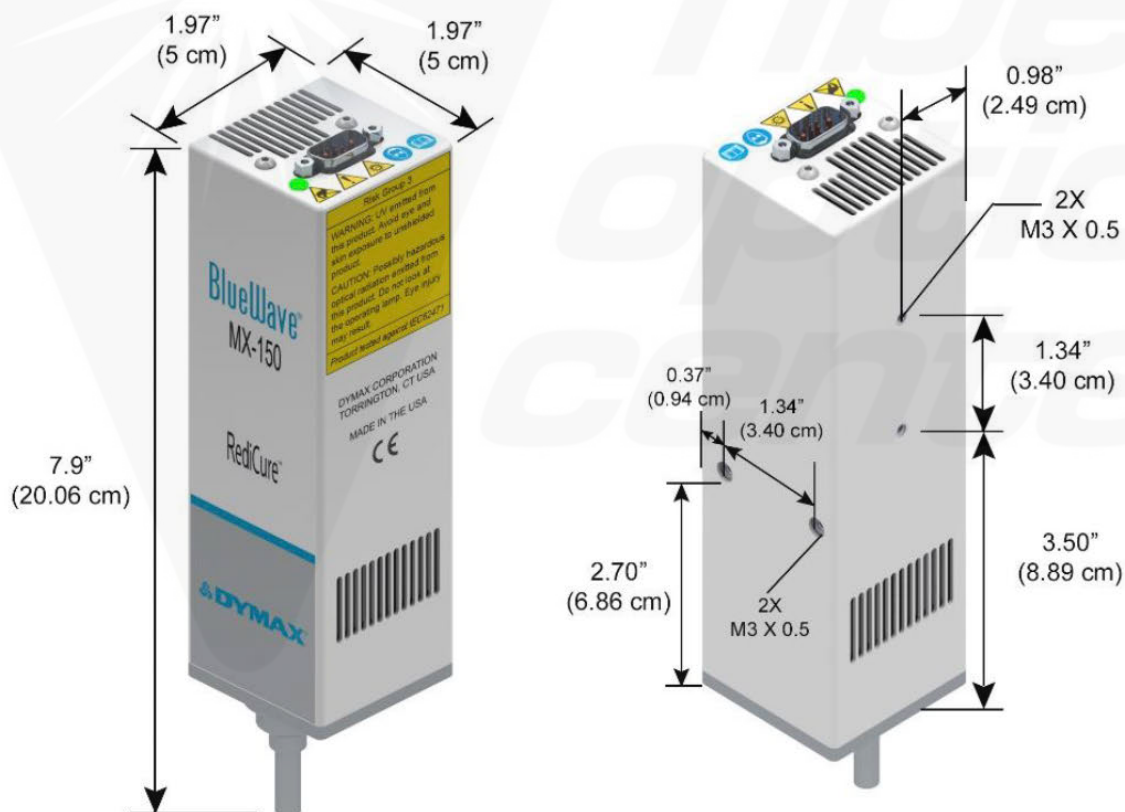
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Mounting/Connections

- Each emitter has two sets of M3 x 0.5 mm holes (Figure 1) that align with Dymax stands and holders.
- When connecting the emitter to the controller, ensure proper strain relief to prevent pinching or kinking of the interconnect cable.
- The cooling air intake on top of unit must be free flowing, do not cover.
- Exhausting air on sides must be given at least 1 mm (0.04") of clear space to obstructions for safe use.

Figure 2.
Bluewave MX-150 Emitter Dimensions



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Troubleshooting & Maintenance

Problem	Possible Cause	Corrective Action
BlueWave MX-150 LED does not produce light	LED intensity adjustment set to 0% or too low	Increase LED intensity setting.
	LED cycle time is set to 0 seconds	0 Seconds sets manual mode and requires a trigger.
	Interlock is open	Verify interlock jumpers are in place. Verify PLC command structure for PLC mode.
	Interface cable connections loose or damaged	Check connections and condition of interface cable.
	Trigger setting not matched to input	Trigger setting on admin screen should match the desired input trigger channel.
	LED head is not connected to the correct port/channel	Verify that the head is connected to the desired port/channel.
BlueWave MX-150 LED suddenly stops producing light	Lightguide not inserted	Ensure the lightguide simulator or any lightguides installed with the unit are fully seated into the Wolf connector.
	Over-temperature shutdown was triggered	Verify alarms.
	Footswitch defective	Activate unit using the front control panel. Replace the footswitch if the unit operates from the front control panel.
	Interlock is open	Verify interlock jumpers are in place. Verify PLC command structure for PLC mode.
BlueWave MX-150 LED provides only low-intensity light	LED intensity adjustment set to minimum	Increase LED intensity setting on admin settings or I/O input for PLC mode.
	Contaminated/dirty lens optics	Clean the surface of the lens.

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Product Cleaning and Care

- Product cleaning is limited to wiping the outside of the product with a damp cloth. Do not soak. Isopropanol Alcohol or household cleaners may be used for cleaning the product.
- Keep the LED array free from dust and debris (FOD). Contamination can lead to loss of performance or failure. Protect the LED array by always keeping a light guide, rod lens, or light guide simulator installed.
- Do not insert tools or cleaning devices into the LED opening, and do not attempt to clean the LED array. Disruption from touching, and exposure to cleaning materials can damage the array.
- Do not use compressed air to remove particle debris inside the emitter as it may damage the LED array or the high-speed cooling fan.

Spare Parts

Item	Part Number
5-mm Lightguide Simulator	36987

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Compatible Devices

Item	Part Number
Controllers	
BlueWave® MX Series 2-Channel Controller/Power Supply - US	43185
BlueWave® MX Series 4-Channel Controller/Power Supply - US	43182
Emitters	
BlueWave MX-150, VisiCure® (405 nm)	42338
BlueWave MX-150, PrimeCure® (385 nm)	42337
BlueWave MX-150, RediCure® (365 nm)	42336
BlueWave MX Series System Components	
Interconnect Cable Assembly - 12 Inches	43453
Interconnect Cable Assembly - 2 meter	42287
Interconnect Cable Assembly - 5 meter	42889
Extended Interconnect Cable - 10 meter*	43010
Extended Interconnect Cable - 20 meter*	43011
5-mm Lightguide Simulator	36987
5-mm x 1,000-mm Liquid Lightguide	35102
3-mm x 1,000-mm Bifurcated Guide (5-mm Rod)	37043
Adjustable Focusing Lens	41148
Radiometer	
ACCU-CAL™ 50-LED Radiometer	40505
Stands	
Array Stand	43070
Single Emitter Mounting Stand	42390
Dual Emitter Mounting Bracket for MX Controller	60868
Personal Protection Equipment	
Three-Sided Acrylic Shield	41395
Protective Goggles — Green**	35286
Protective Goggles — Gray (standard model included with unit)**	35285
Face Shield**	35186

* Intended for machine installations only.

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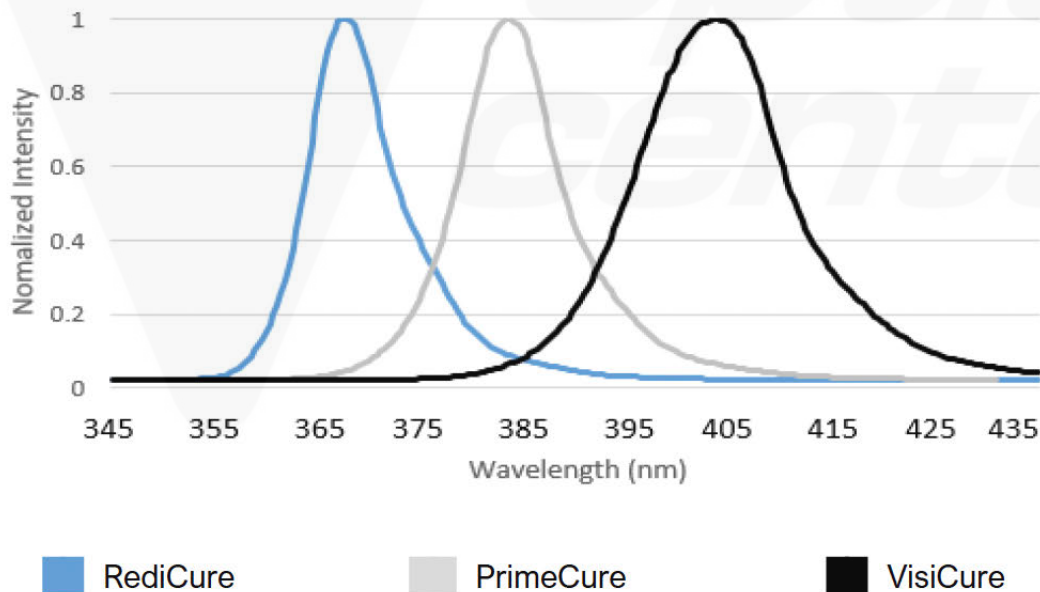
Specifications



Property	Specification		
Emitter	RediCure	PrimeCure	VisiCure
Output Frequency	365 nm	385 nm	405 nm
Typical Intensity Output*	24 W/cm ²	38 W/cm ²	36 W/cm ²
Emitter Dimensions (W x D x H)	1.97" x 1.97" x 7.9" [5 cm x 5 cm x 20.06 cm]		
Weight	1.4 lbs. [0.64 kg]		
Unit Warranty	1 year from purchase date		
Operating Environment	10 to 40°C (50°F to 104°F), 0-80% relative humidity, non-condensing		

* Measured using an ACCU-CAL™ 50-LED radiometer with a 5-mm lightguide at a distance of 0 mm.

Figure 3.
BlueWave MX Series Spectral Output



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Declaration of Conformity

Figure 4.

Declaration of Conformity - CE

DYMAX

EU Declaration of Conformity

Manufacturer:
Dymax Corporation
318 Industrial Lane
Torrington CT 06790, USA

Product description:
Model name(s):

BlueWave ® MX-150 LED Spot-Curing System
BlueWave ® MX-150 LED Emitter

This product complies with the following relevant Union Harmonization Legislation:

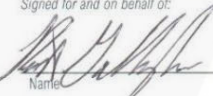
Applicable EU Directives:
Electromagnetic Compatibility Directive(2014/30/EU)

Low Voltage Directive(2014/35/EU)

RoHS Directive 2011/65/EU (2015/863)

Applicable Harmonized Standards:
EN55011:2016/A1:2017/A11:2020
EN 61000-3-2:2014 Class A
EN 61000-3-3:2013
EN 61326-1:2013
EN 61010-1:2010 AMD1:2019
EN IEC 63000:2018

Declaration:
This declaration of conformity is issued under the sole responsibility of the manufacturer.
Signed for and on behalf of:

 3/26/2025 Torrington, CT

Name Date Location

Authorized Signatory:
Robert Gallagher
Engineering Manager, Equipment
Dymax Corporation
Torrington CT., USA

CE

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Figure 5.
Declaration of Conformity - UKCA



UK Declaration of Conformity

Manufacturer:
Dymax Corporation
318 Industrial Lane
Torrington CT 06790, USA

Product description:
Model name(s):

BlueWave® MX-150^{PA} LED Spot-Curing System
BlueWave® MX-150 LED Emitter

This product complies with the following relevant UK Legislation:

Applicable UK Legislation:
Electromagnetic Compatibility Regulations 2016

Applicable Harmonized Standards:
EN55011:2016/A1:2017/A11:2020
EN 61000-3-2:2014 Class A
EN 61000-3-3:2013
EN 61326-1:2013
EN 61010-1:2010, AMD1:2019
EN IEC 63000:2013

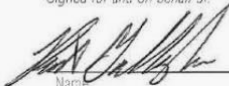
Electrical Equipment Safety Regulations 2016

The Restriction of the Use of Certain Hazardous Substances in Electrical
And Electronic Equipment Regulations 2012

Other Regulatory Compliance

Photo-biological Safety
IEC 62471 (2006)

Declaration:
This declaration of conformity is issued under the sole responsibility of the manufacturer.
Signed for and on behalf of:

 6/26/2025 Torrington, CT USA

Name Date Location

Authorized Signatory:
Robert Gallagher
Engineering Manager, Equipment
Dymax Corporation
Torrington CT, USA

**UK
CA**

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