

# Soldering machine manual

## Product introduction

1. This soldering machine is widely used in wire harness soldering field, Data cable USB.

Micro USB. Mini USB. Apple head. Type-C. HDMI plug docking. Motor wire, wire harness welding. PCB board. LED light/light strip/light panel. Electronic components, switches, adjustable resistance, electronic cigarette, rectifier bridge, waterproof joints and

other connector welding, welding field wide application ability is strong, easy to learn debugging and installation

2. This adopts 4.3-inch PLC touch-screen all-in-one machine, with timely and reliable response and anti-interference. Support system continuous update.

3. Soldering machine is divided into electric and pneumatic versions. The system can support free switching of two versions at the same time. The clean iron head mode can also

support free switching of different needs, which is flexible and changeable. More powerful function

4. After parameters are messed up due to improper operation, factory data recovery can be carried out by default parameters and pre-factory Settings can be restored

## Technical parameters

1. Power: Single phase AC 220V ,Rated voltage 210V-240V 50/60HZ (110V-24V Can be Customizable)

2. Air pressure: 0.2-0.6MPa (Use clean dry air)

3. Temperature: (-10) - (+60°C) No wind, no dust

4. Size: L410\*W350\*H500MM

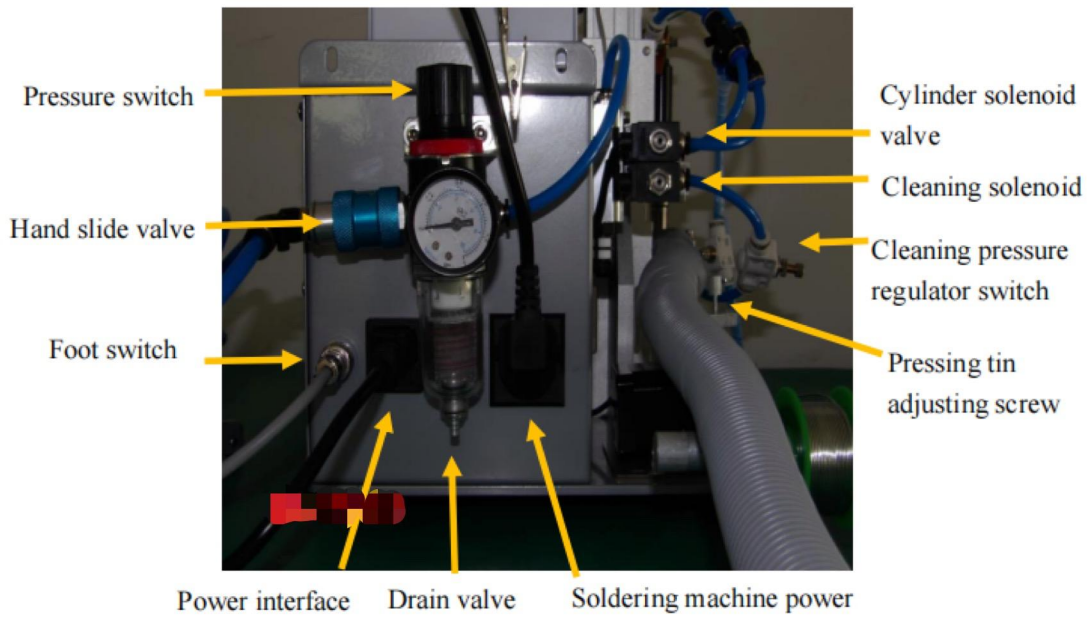
5. Weight: About 15KG



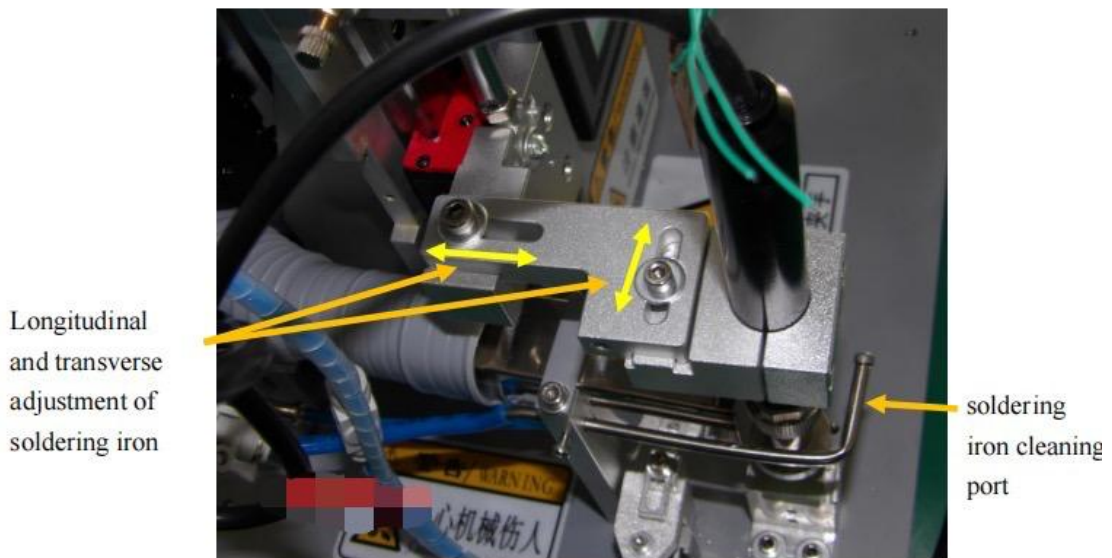
#### 4.21 Electric mode



### 3 Back Function Description of Solder Machine

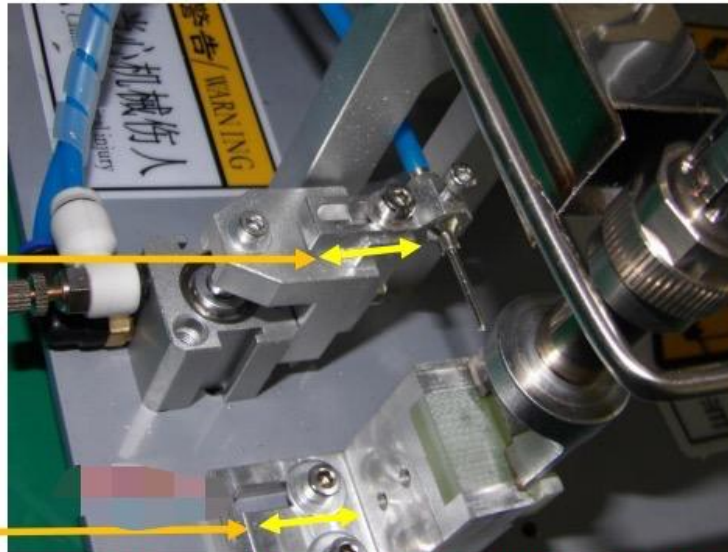


### 4.4 Adjustment structure description



Position  
adjustment for  
tin delivery

soldering position  
adjustment



4.4 Highlights: The solder joint of tin wire and product is adjusted to a straight line to make the best effect. The welding height is not crushed, the product structure is not destroyed, the welding temperature is the best effect, the solder joint effect is round, smooth and bright, the black spot is black, the temperature is too high, the tin is oxidized, the temperature is reduced, the fog surface is not round, the tin is not melted, the temperature is low, the welding temperature is adjusted

#### 4.5 Installation instructions for soldering Iron, soldering tip

Soldering tip

Fixed nut

**Must be installed in third lap  
or near third lap**

**\*\*Installation priorities:**

**Failure to install to a specified  
location can result in  
inaccurate temperatures,  
burning of heating cores and  
temperature sensors\*\***



# Introduction to Operation Interface

Chinese interface



English interface

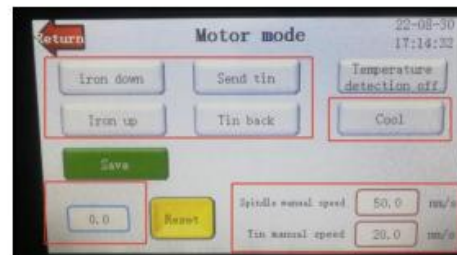
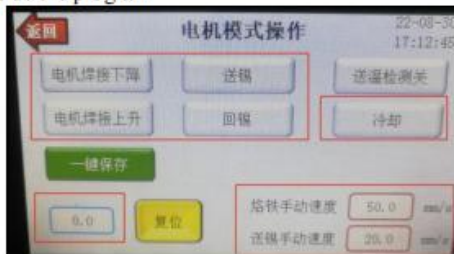


5.1. Click on the red box to switch between Chinese and English

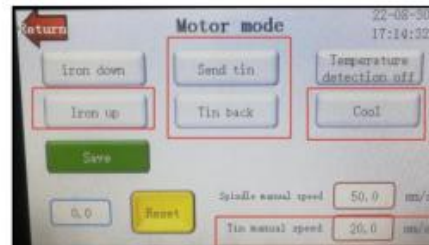


5.2. Red frame touch pedal mode/automatic mode toggle freely toggle cooling time control start interval cycle time

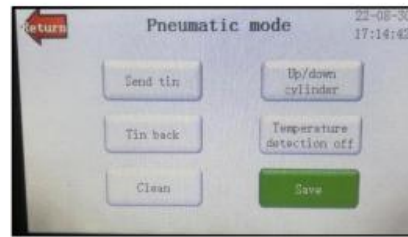
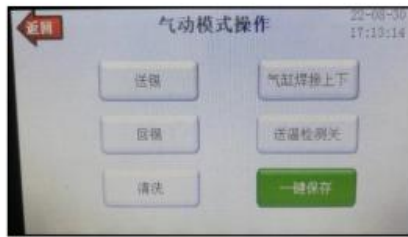
5.3. Click on the red frame to set the parameters of Forward Tin Feeding Mode/Switch Back Tin Feeding Mode. Refer to the picture of Back Tin Feeding on the parameters page of the next page  
Reset function: press for 3 seconds to find the original point automatically, and return to zero inside the program



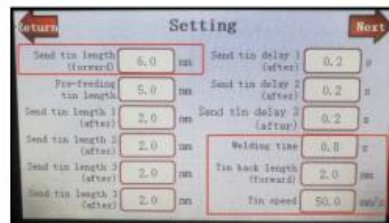
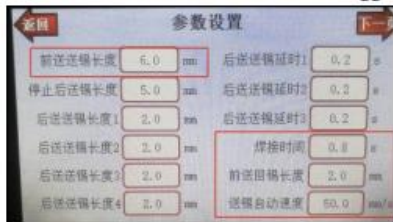
5.4 In the red frame is the motor mode manual debugging area



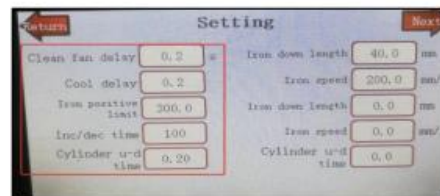
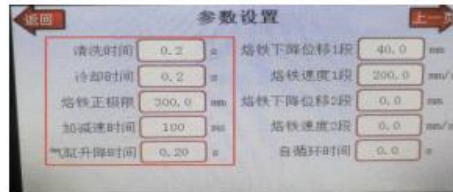
5.5 In the red frame is the motor mode manual debugging area



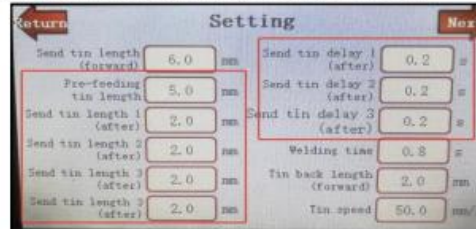
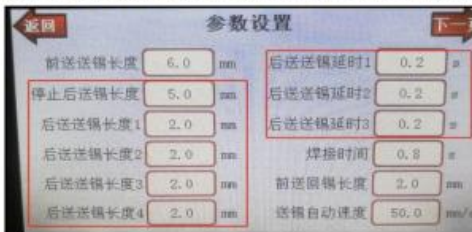
5.6 In the red frame is the manual debugging area of cylinder mode



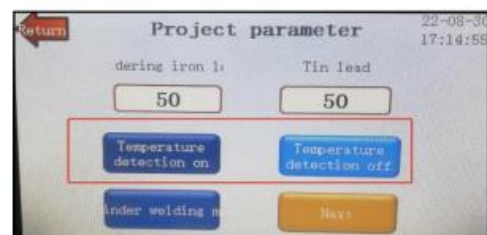
5.7 In the red frame is the debugging area for the parameters of the forward tin feeding



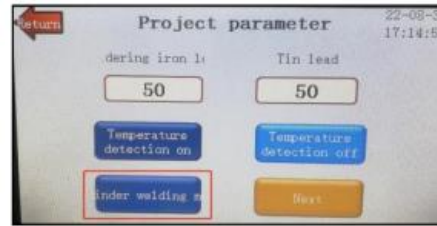
5.8 In the red frame are the parameters of the forward feeding tin mode and the back feeding tin mode. The cooling time of the common debugging area is automatic mode interval. The longer the cycle time, the longer the start



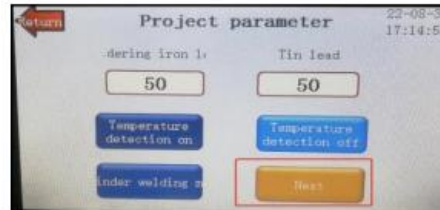
5.9 In the red frame is the debugging area for the parameters of the back feeding mode. The parameters can be adjusted according to the actual welding needs, such as the feeding length and interval time



5.10 In the red picture box, there is the switching button of forward feed tin mode/back feed tin mode cleaning mode



5.11 In the red frame is the switch button of cylinder welding mode/motor welding



5.12 In the red box is the factory setting parameter recovery button. Press the default parameter button first, then jump out of the dialog box as shown in the figure above, and then restore the factory parameters. Please use this function with caution, as this function is used in the case of abnormal operation of the equipment, otherwise all the original processing data will be lost and need to be set again

1. Objective: Explain the correct installation method, reduce installation errors, as soon as possible to make the equipment for your service

### Operational safety precautions:

1. During operation, do not place your hand or other hard objects in the moving area, so as not to hurt your hand or damage the equipment.
2. When the machine is debugging, it needs to be debugged again in the manual state of the machine.
3. Turn off power supply, gas source, soldering station when stop using.

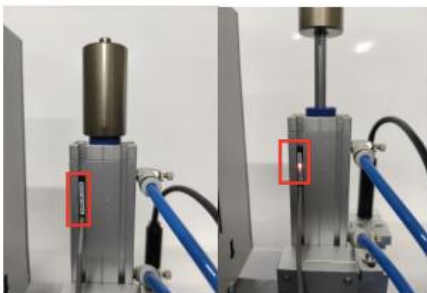
### Daily maintenance:

1. The waste produced by the machine in the course of work should be cleaned up in time to avoid obstruction and cause the machine to run badly.
2. After each shift, first clean the environment, so that the ground dust-free, clean. Clean the equipment again, including welding platform surface, moving shaft, welding head, etc. No debris, no dust, clean.
3. The sliding part of the machine is lubricated once a week to ensure smooth sliding.
4. Machine parts secured.
5. The fixture and fixture holder are cleaned every 4 hours.
6. The soldering tip is maintained every 2 hours. Observe the loss, service life about 20000-35000 points, timely notify the production line technician to replace the

soldering tip. (At present, all sold soldering tips may be oxidized or perforated due to tin wire damage is more common. Please replace the tin wire in time if you can not change the tin material and can not reach the above service life. Please understand above)

## Frequently Asked Questions

1. Equipment boot alarm-positive limit alarm, indicating that the equipment is back to the origin, after ventilation long press reset 3 seconds to return the equipment to the origin
2. After starting the foot switch, the equipment automatically reciprocating work, please switch the automatic mode to the foot mode can be normal, the automatic mode needs to be based on the combination of skilled cooperation time can be used normally.
3. Start no action-check if the origin sensor lamp is on, turn the gas on the sensor lamp to light, as shown below



### 4. Tin feeding anomaly



#### Pressing tin adjusting

8.4. Tin press flat press broken, press tin spring too tight,

Solutions: 1、 Relaxing the tin pressing adjusting screw reduces the pressure of the tin pressing spring so that the tin is not squashed

2、 Replace the weak force spring to relieve the pressure

Random standard pressure :0.8-2.0 mm diameter tin spring, if used below 0.8 mm need to be informed in advance,

#### 8.4.1. Tin skid

Solutions: 1、 Use the corresponding tin nozzle to make the tin nozzle smooth

2、 Tighten the tin spring



## Quality assurance policy

- 1、 Equipment warranty for one year, man-made damage is not guaranteed
- 2、 Consumables are not guaranteed (soldering tips, soldering Iron, sensor ,tin outlet)