373 Complete–Automatic Outing Tin System

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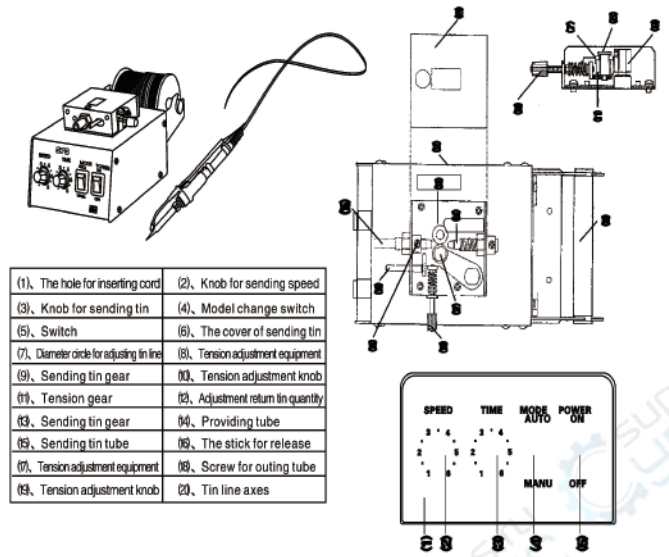
1.Part Name



(1)、The hole for inserting cord	(2)、Knob for sending speed
(3)、Knob for sending tin	(4)、Model change switch
(5)、Switch	(6)、The cover of sending tin
(7)、Diameter circle for adjusting tin line	(8)、Tension adjustment equipment
(9)、Sending tin gear	(10)、Tension adjustment knob
(11)、Tension gear	(12)、Adjustment return tin quantity
(13)、Sending tin gear	(14)、Providing tube
(15)、Sending tin tube	(16)、The stick for release
(17)、Tension adjustment equipment	(18)、Screw for outing tube
(19)、Tension adjustment knob	(20)、Tin line axes

2.Specifications

373 Complete–Automatic Outing Tin System

Power Consumption	5W
Motor Speed	DC24V 3.2W

Application Tin Cord (Max Volume 1Kg Axes)

Tin Cord Diameter(mm)	0.6、0.65、0.8、1.0、1.2、1.6

Domination Station

Sending Tin Time:0s–7s	Sending Tin Speed:4.5–26mm
Dimensions:107(W)x110(H)x215(D)mm	Sending Tin quantity:0–182mm/s
Weight:About 1,500g	Return Tin quantity:0–5mm(Stability Speed)

Notice:
- Setting anti–static disposal.
- Without notice ,when the specification & showing change in anytime.

3.Operation in safety condition

⚠ WARING

In this instruction manual ,"waring " & "caution " are defind as follows :
Waring :Misuse may potentially cause death ,or serious injury to the user .

Notice :Misuse may potentially cause death , serious injury to the user,or the damage to the equipment .
Remark :The key point for operation
For example : Instructions for special process ,dealing with .

●For you own safty,be sure to comply with the following precations.

CAUTION

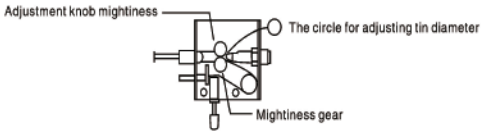
- Setting the soldering tip after it is cool
- Turn on the power comes from the voltage by switch .
- Do not bend the transmission tube ,prevent from damage .
- Turn on the transmission tube in order to clean weldering tin draff .
- When the tube is bend or upright ,do not use or damage to the tube .
- Do not adjust screws or return quantity ,it is damage to equipment .
- Sending tin gear & tension is pasted together ,cleaning by brush .

4.Assembly

Make sure the parts is suitable for soldering iron & soldering diameter .

A . Adjusting setting of the tin diameter .

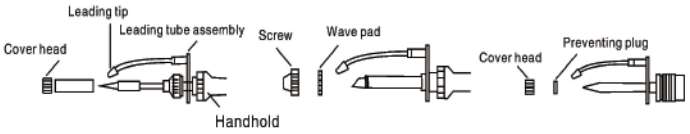
●Pull–out the cover of the soldering station & tension knob by forceps in opposition direction.
●Put the ring is adjusting tin line on the tension gear ,adjusting position as formerly.



B .Leading tube assembly setting .

●The tube is between Leading tube assembly and screws .After fixed,it is using wave pad when is needed .

⚠Caution: ■Setting the soldering tip after it is cool .
■ not bend the transmission tube ,prevent from damage .
■When the tube is bend or upright ,do not use or damage to the tube .



C .Outting tin setting

●When you set the tube is in–double–floor ,inside inserts tie–in diameter is covered by a black out tube part .
Do not bend the soft tube.

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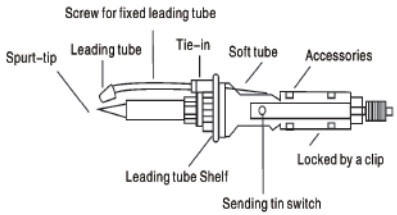
● Put the accessories in the handhold .



D .Setting the tin line

●Getting out the double tin-line ,changing a new one .

1.Basing on you are welding element diameter ,setting the tin line rolls .Then put line axes into tin line axes . following :

2.Put the tin line into the leading tip .

3.The 1cm tin line is released by tension gear .When the power is on ,model is by hand .

4.Turn on the switch by hand ,and send tin .

E .Change the diameter of the tin line

●The diameter adjustment equipment can change the diameter when you are working all the time . The leading tube is changed by different diameter .Assembly for making sure following :

- The ring for adjustment tin line diameter
- Leading tube assembly
- Leading tip
- Outing tin assemble

1.The left tin line can be returned , you open release setting when power is on .

2.Change the diameter ring bases on different tin line by tension adjustment eqiment .Loosing the tension gear axes by forceps.

3.If it is necessary,please change leading tube assembly .

5.Operation Method

A .Operation way

●Automatic :You turn on the power switch .When you set the time & speed at a fixed time , it is done by itself as you set .

●By-hand :You turn on the power switch .Sending the tin bases on setting speed .

B .Adjustment sending tin position

●When the tin line into the tube ,please get it out ,and adjust it .

1.Loose the screw cap of the leading tube ,ajust the leading tube & tip position .Later fixed the screw .

⚠Caution :

- Do not fixed screw in the tube tightly ,or damage to the tube .
- Prevent scald ,adjustment after cool later .

C .Setting the time & speed

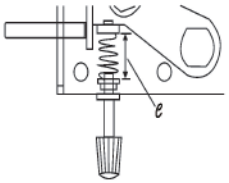
●Setting the speed early than time .Speed model AUTO&MANUAL .Time model AUTO efficiency.

D .Setting the return tin quantity

●After sending tin line ,set a fixed distance (0-5mm) for return tin by robot .Please the min quantity , if it is beyond the min ,and return it . when the tin line gets to tube ,The tin solvent is easy to be cohered. In order to prevent this happened ,the tin must be returned back by "—"screwdriver.the right is more , and left is less.

E.Adjustment the tension

●When you adjust the tension ,do not the gear loosen ,or do not send the tin line when the tin jam happened .Please set the loosen gear tension ,use thin tin line (diameter 0.6mm ,0.8mm ,1.6mm)for you referance .following :



Tin line diameter	ℓ
ϕ0.6	Max
ϕ1.0	About14mm
ϕ1.6	About10mm

6.Avoiding Trouble Manual

If there some wrong with the sending tin ,you can check following :

Trouble Reason	Avoiding
Please choose the proper part bases on tinline diameter or not ?	Check tin line diameter part
Insert the min receptacle or not ?	Check the receptacle tin is inserted exactly or not?
Adjust tension accurately or not ?	Check adjust tension accurately or not ?
Fuse is bad or not ?	Check the fuse is bad or not?
The soft tube is bend or not ?	Check soft tube is bend or not?
The power is on or not ?	Check power is on or not ?
The tin line is pasted on sending gear or tension stick or not?	Check the tin line is pasted on sending gear or tension stick or not?
Is it right for sending time or speed ?	Check it is right for sending time or speed
Is it normal for the temperature ?	Check the tip is normal for the temperature