

## **overview**

JX - 0858 microcomputer series precision spot welding is currently popular spot welding, communication pulse is according to the current world production of high-grade nimh batteries (nickel cadmium, and lithium battery) needed to special design. Microcomputer single-chip microcomputer control, the power supply voltage of automatic tracking compensation, can realize monopulse, double pulse and impulse welding, more stable performance and reliable. Mainly has the following a few major characteristics:

Beautiful shape legerity, welding firmly, low fault rate and easy operation.

Solder beautiful, spark small, no dark, and steady welding current, solder joint size uniform.

3, control circuit adopts imported from Japan bidirectional thyristor discharge pulse circuits and digital procedure control circuit. Various parameters, consequently digitizing set parameters adjustment intuitionistic and accurate. USES the straight insert maintenance circuit board and long service life.

Aiming at the battery welding, not because spot-welded appeared after sag, flowing liquid phenomenon, overcome completely lithium battery spot-welded appears after the low-pressure and outlet phenomenon, is your manufacturing assembly battery ideal equipments.

JingMiXing (points pedal-powered and air-powered), they all have, suitable for accurate alignment of welding, the rate of core cap advanced characteristic.

Welding needle pressure and two needle distance can be independent adjustment, and convenient adjustment, ensure welding stress is stable and reliable.

Welding switch is domestic only using photoelectric switch. The welding current code switch the dial can be set.

### **working principle**

This machine adopts double double point over-current welding principle, work two electrodes pressurized workpiece make two layers of metal in polar under the pressure of formed certain contact resistance, from one electrode welding current flows through another electrode in two contact resistance is formed on instant of hot catch, not hurt and the welding workpieces interior structure.

### **main technical parameters**

1. The power input: AC 220V + 10% 50HZ + 2HZ
- 2 the welding power: AC pulse (AC)
3. Output power: 10KVA
- 4:00-99 welding current
5. The driving type: feet/pneumatic
6. The output signal, a photoelectric switch
7. Electrode diameter:  $\varnothing 3$
8. Electrode traveling: 20mm
9. The weight: 45KG
10. Shape dimension: 800L x 580W x 1100H (unit: mm)
11. Application: suitable for battery connection pieces welding, various hardware pieces welding. (some materials welding thickness can reach 1mm thicker even)

### **Instructions**

- 1, the power switch: when switch up when the power is connected, throw

down when the power cut off the trigger.

2, work instructions: turn on the power switch, constantly flickering lights as normal.

3, welding current: according to the size of the current welding requirements set.

### **procedures**

1, foot pole Angle and height adjustment: first use spanner pedal feibao loosen lock screw, and adjust the Angle and height (90 ° Angle for static) to proper position, finally lock this screw.

2, welding needle height adjustment: first unscrewing the welding needle height adjustment screw, then adjust or replace welding show the length of the needle electrode below (usually 20 millimeter, too long welded needle easy deformation), then tighten the screws.

3 and electrode welding needle width adjustment: first use wrench unscrew welding needle width adjustment screw, and then according to the welding workpieces width, adjust the two electrodes to make the two welding needle to suitable distance, then tighten the screws.

4, stowage platform height adjustment: first the wrench will stowage Taiwan screw loosen, then to spot welding workpiece adjustment and welding needle suitable distance (is commonly 4 millimeter), then tighten the screws.

5, welding pressure adjustment: by hand twist welding stress knob, clockwise pressure will be increased, conversely decreases, and according to the welding workpieces demand adjust the proper pressure.

6, inspection: check whether carbon welding needle, if have, use file or sand paper, then clean it with his right foot down on foot pedals, the nose drops, visual welding needle and welding required whether the location alignment, or resize, only to welding needle position of welding required

alignment so far.

7, switch on the power: will plug into 220V power, then open spot welding power switch, flashing lights shine and work, according to the welding material and thickness adjustment parameters.

8, welding: with the foot pedal, the nose drops, when welding needle pressure to continue hard after welding, at the same time two step forward into closed state, welding switch and discharge welding. This machine is welding current digital adjustment, according to the size of the spark, soldering welding firmly degree, welding surface without heat damage, welding current and transferred to the optimal value.

9, in order to insure good welding quality, to diligently trim welding needle, needle with small file will be welding smooth tips file.

Note:

If discover the machine at electrify, but without welding, under the situation of bright lights, or light without flash, explain existence fault, must through access to use them.

### **general troubleshooting**

Fault may cause the solving methods

HanKou (point) rickety welding tsui pressure is too great

Welding current is not enough

Welding area is too big check pressure regulation

Increase current

Apply brazing ZhenZhen mouth processing to appropriate

HanKou blasting fire welding tsui pressure is not enough

Welding current is too high

Fluctuationon for dirt raise pressure

Appropriate to reduce the flow of electric current

Cleaning the workpiece dirt

Not harmonious welding voltage instability

The workpiece and HanKou inappropriate position

The surface of workpiece have dirt check whether normal distribution network

Adjust jig and positioning device

Remove dirt workpiece

Boot LCD display fault insurance tubes with same specification burn out the insurance replacement pipe

Welding twice but only discharge once 24V relays bad replacement with same specification of relays

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**Ann is really keep**

Should use this machine before please read the code

Do not put the machine damp and do strong mechanical motion.

Please confirm the local power supply voltage is 220V + 10V.

Please pay attention to machine warning information.

The power cord is the main power supply connection, the power line not left any item not to make the power cord in users easy maloperation of place, or fire high temperature environment.

The power plug for single-phase three-wire grounding end plug, and the third. If you cannot be plugged into the plug sockets, please contact electrician and replacing power sockets and don't let mono phase three pin plug security function failure.

Don't let power socket overload or enlarge long power supply cord, lest cause fire or shock.

As additional protection effect, when not in use, please turn off the switch, Power failure or a long time without use machine, should plug plucked power plug, in order to prevent the power supply cord to machine caused by the transient shock.

Chassis on the grooves and opening is for ventilation and set, also used to guarantee the reliability of the machine to work to prevent the overheating. Do not put other goods jams cooling hole.

To use this machine is necessary before undertake to operating personnel training, and designate special persons to take charge.

10 and in the machine has the following situations, please first from the socket plucked power plug, and please professional maintenance personnel for comprehensive maintenance:

A) the power cord or power plug damaged or worn-out,

B) there is liquid diffused in the machine,

C) machine by rain water and poured it out,

D) machine can't be used normally.

11 and replacement parts should ensure maintenance personnel use manufacturer prescribed with parts performance of the same replacement components. Not recognized replacement components may cause fire, electrocution or other dangerous.

12, please strictly according to use the instructions, prohibited to machine without modification, desoldering and we're which results in any consequence does not undertake any responsibility.