Microcomputer high frequency precision welding machine

operating manual; run book;working instruction

Directory

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One 、 summarize

Microcomputer precise spot welding is according to the current production upscale batteries in the world

（Nickel cadmium, nickel metal hydride, the lithium battery） Needed to specific design。

Single chip microcomputer control， A more stable performance and reliable。 My latest product improvement

， Mainly has the following a few big characteristics:

● Beautiful shape, and lighter。

● Solder joints and beautiful, the spark small, no black，And steady welding current，

Even the size of the solder joints。

● Completely overcome lithium battery spot welding low voltage and water appears after the phenomenon， Is your battery manufacturing assembly of ideal equipment。

● Each of the parameters for the digital Settings， So adjust intuitive accurate。

● The pressure of two welded needle independent regulation， And easy to adjust，

Ensure welding stress is stable and reliable。

● Single chip microcomputer control, double pulse welding.

● Welding current integral-differential calculation， urrent control is very accurate。

● Using digital pipe display, keyboard, welding parameters using FLASH storage technology, than previously used code switch out better, don't worry about the code switch with long pull out a code after contact caused by poor welding parameters are not

allowed to read。

Two 、 technical parameters

● power: AC $110v \pm 10\%/220V \pm 10\%$ 50Hz/60HZ

● Output the maximum power: 3KVA

● Welding current: $00-99\%$

● Net weight: 4.5KG ; **Gross weight: 5KG**

● Shape dimension: $250L \times 180W \times 200H$; After packing size: 330L*240W*300H

（unit: mm）

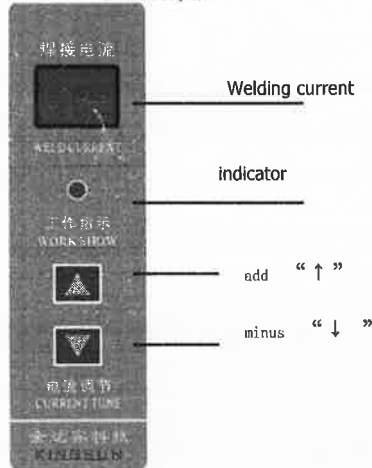● Applicable scope: Apply to 0.03 mm to 0.1 mm of various welding pieces。

● **Three、 welding current end weld interval**

Welding current by users set, welding time by a program for welding time out of calculus, the general welding current are in under 50, welding time in 1-3 ms or so。

Current and time relationship as follows:

Welding time (%)	10	20	30	40	50	60	70	80	90	100
Welding time (ms)	1.4	2.0	2.5	2.9	3.3	3.6	4.0	4.3	4.6	5.0

Four、 The microcomputer controller

焊接电流 — Welding current

WELD CURRENT — indicator

工作指示 WORK SHOW — add " ↑ "

— minus " ↓ "

电流调节 CURRENT TIME

金速索科技 KINGSUN

Five、 Welding current Settings

1. Welding current Settings:

Enter into the normal after welding mode， Direct press " ↑ " or "press" button to set the need of welding current, shut down after procedures automatically save value。

2. Indicator that:

Welding long bright lights, not welding flashing lights。

Six、 how to use help:

1、 The power switch: when switch up when the power is connected throw, throw down when cut off power supply 。

2、 Work instructions: turn on the power switch, if the lights flashing constantly as normal。

3、 Welding current: used to set the size of the current, its configuration range is 00-99; General welding current set in the 25 or so often。 Pay attention to the adjustment of the current size, the factory is a factory current, 3 cases of electrical debugging and use 220 v electric conversion of 110 v electric debugging of the machine, so the current can change different to different countries is normal, the customer can increase the current when needed, until can welding cell. Customer 1: electricity at home environment; Customer 2: 11 0 v electricity environment

4、 Fuse blocks: 25 A fuse in the electrical box。

5、 Welding switch: within the head, when welding needle pressure to welding, closing switches, spot welding to discharge welding, this switch for vulnerable parts。

Seven、 operating steps:

1、 Welding needle height adjustment:

Use first wrench to loosen the welding needle height adjustment screw, and then adjust (or replace) welding show the length of the needle electrode (usually about 15 mm, too long tweldingdeformation needle), to lock the screw 。

2、 Electrode (welding needle) width adjustment .

Use first wrench to loosen the welding needle width adjustment screw, then according to need the width of the welding, adjust the two electrodes make two welding needle to the suitable distance, to lock the screw .

3、 inspection:

Check welding needle for carbon, if there is need file or sand paper to clear it; Then with his right foot pedal and on a ruler to, the nose down, visual welding needle and whether the location for welding on, otherwise, they can be the first step in front of repeat

operation, welding and welding required until the position of the needle to it so far。

4、 In order to insure good welding quality, must diligently finishing welding needle, with

small file will be welding needle tip file level off is smooth (front the four steps, new basic need not do, the main sign of the long-term work of the cases need maintenance operation)

5、 Switch on the power:

First the plug to 220 v/110v power supply socket, then turn on the power switch, the work light constantly flicker is normal, if work light not bright or light and not flash, need to power off restart a. The next step is the result we want: began to practical work, will need to spot welding parts of the place welding needle below and strength to service, the process will see tiny spark (please don't worry, this is normal phenomenon) and leave welding needle. Operation so simple!

Eight、 General troubleshooting

1、 Can't make needle or welding electrode contact together, this will make short

circuit current, and can't welding。

2、 Adjust current cannot too big, with can live for welding principle, general welding

0.1 mm of welding in 20-30 that can live between welding。

3、 There were high pressure case, can't open it。

Nine、 General troubleshooting

Serial number	Fault phenomena	causes	Elimination method
1	Boot is no power instructions	1. Insurance tube burned。 2. Input power failure。	1. Replace the same specification insurance tube。 2. Overhaul the power lines。
2	There are power instructions, no welding sparks	1. The welding current parameters is too small. 2. Welding switch off the attachment. 3. Start switch damage. 4. Work in bright lights or do not twinkle, mainly is the power to interference。	1. Increase the welding current value. 2. Replacement photoelectric switch. 3. Turn off the power switch, turn back on。
3	When not firm when welding prison	1. Check whether to tighten the welding needle 2. Welding joint parts if there's any loose access phenomenon 3. Welding joint parts if there's any loose access control panel and the phenomenon SCR plug is close	1. All to tighten the。
4	Welding easily when the strike, even burning battery shell	1. Welding needle end viscosity under a foreign body, 2. Welding materials not.	1. Increase the welding stress. 2. With small file will end file level off is smooth weld needle. 3. Choose proper welding materials.

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welding machine

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