SUNKKO 737G

Dual digital display intelligent precision pulse spot welder

Thank you for choosing SUNKKO series of products. These products are designed to make your work more convenient, safe and efficient. Such that you might become familiar with all the operations of the welder, an instruction manůal has been included.

INSTRUCTION MANUAL

Attention: Please make sure the GFCI (Ground Fault Circuit Interrupter) is up to 60A or more before turn on the spot welder.
In order to obtain good weld effect, please don't use the active socket, and should be used the wall socket to ensure stable power supply.
Please store this manual in a safe location for both current and future reference.

Catalogue

A. Showing

Front

Welding pressure adjuster

Fixed welding head

LED light

Machine leg

Back

Handle

Parameter ta

QC

B. Introduction

The SUNKKO 737G is a precision spot welding machine which is designed to enhance the welding of thin metals without excessive heat buildup.

Parameter

A. Welding part
1. Input voltage: AC 110V/220V
Please check your machine's suitable voltage to use.
2. Primary current: 2A-15A
Welding current: 50A-800A
The width of 1 pulse time: 0.5-5ms(Variable)
The width of 2 pulse time: 1-10ms(Variable)
B. Net weight: 4.3KG
C. Size: 140x245x200mm
D. Welding thickness: 0.05-0.2mm
(1 pulse: 0.05-0.12mm; 2 pulse: 0.12-0.2mm)
E. Work cycle: less than 20 times in 1 minute for intermittent welding.

Summary

1. Use micro chip for controlling precision current to weld in precision.
2. There are wide range of selecting current (1 / 2 pulse) can be selected to make your work more convenient, safe and efficient.
3. Controlled by micro computer.
4. Welding power can be set and displayed on Led panel.
5. It is suitable for welding charging battery pack, button cell leads, hardware to process, etc.

Range Of Application

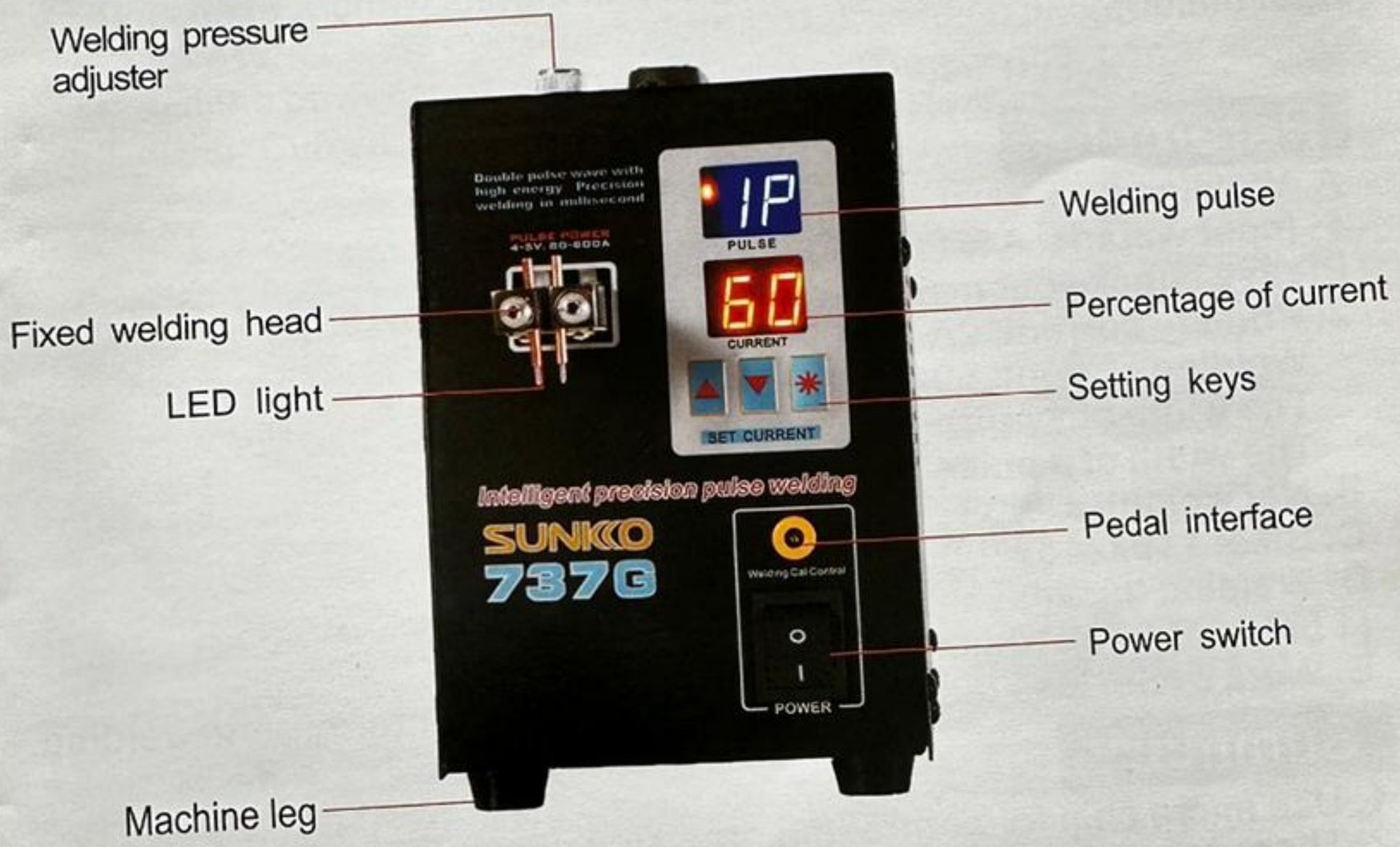
1. Welding different kinds of rechargeable battery wire lead.
2. Assembling and welding lithium battery and mobile power.
3. Repairing battery packs.
4. Welding lead sheets and wire of hardware parts.

Packing list

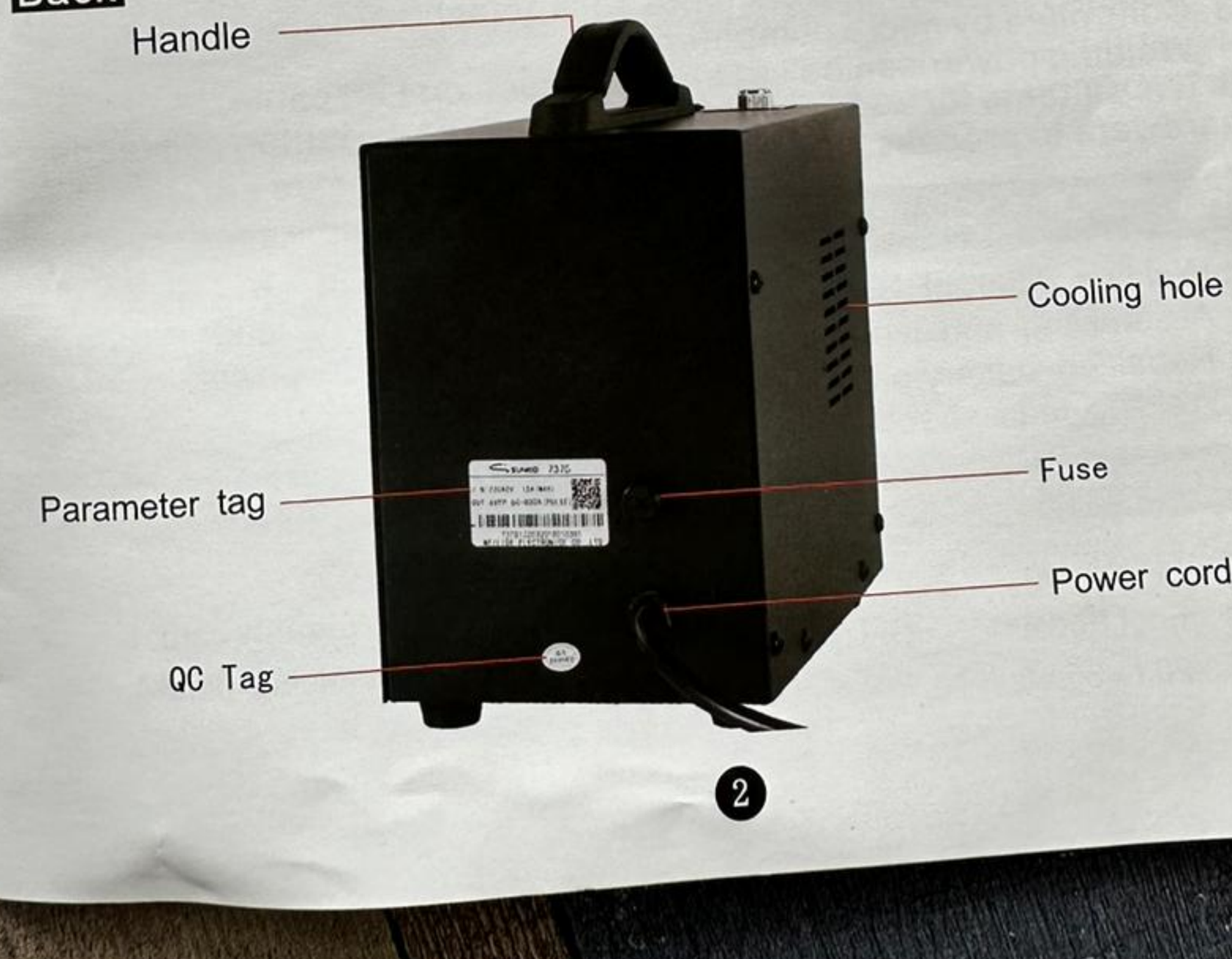
1、Machine*1
2、Instruction manual*1
3、Warranty card*1
4、Foot Pedal*1
5、Hex wrench*1
6、Welding pins*4
7、20 or 30A fuse*2

A. Showing

Front



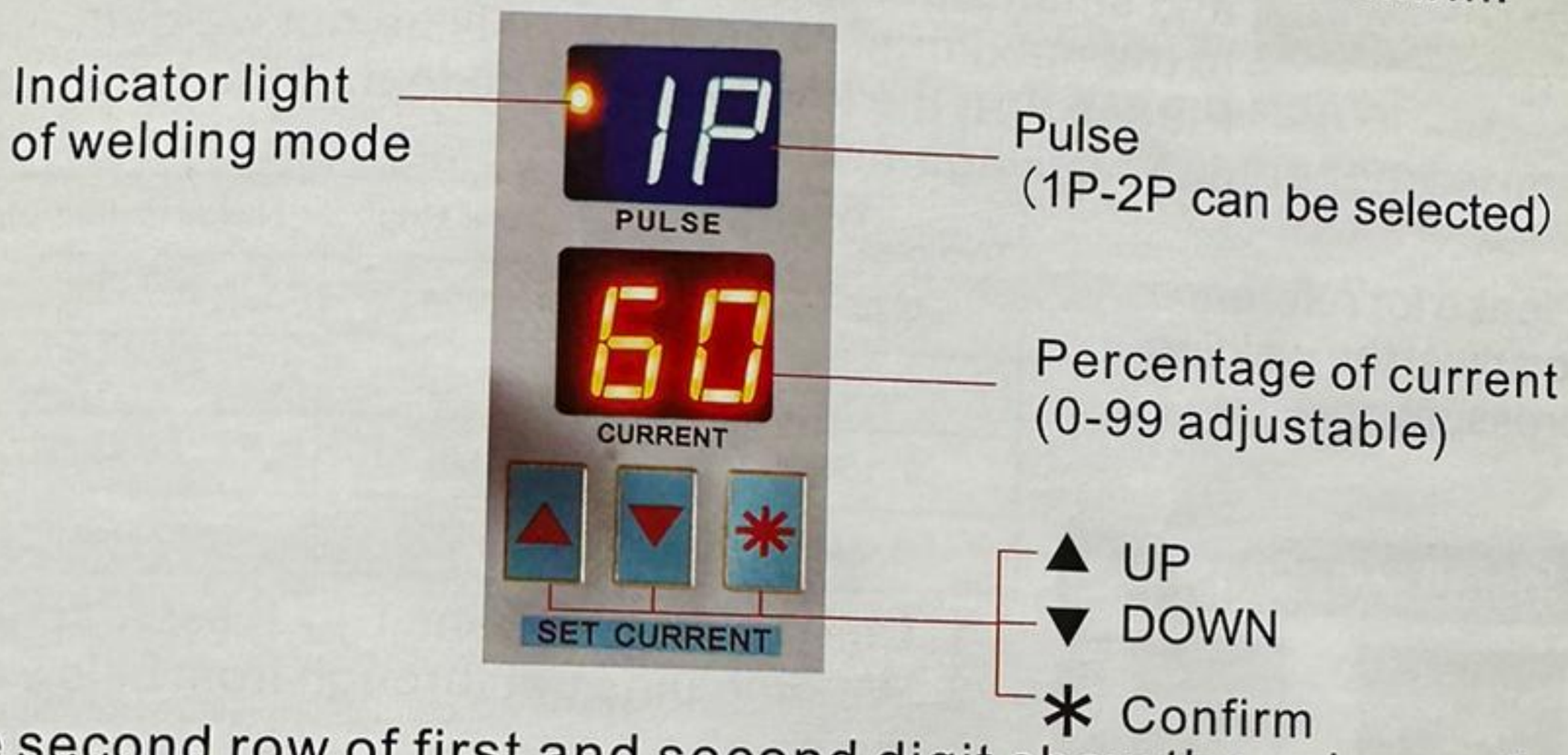
Back



C. Panel introduction

Operation

1.Please turn off the machine before install welding pins on.
2.Insert the power cord on the wall socket. Turn on the power switch.
3.Setting "Current" "Pulse". Pressing "＊" to select and confirm.



(1) The second row of first and second digit show the volume of current.
Press " ＊ ", the fist digit will blink, that means the parameter can be adjusted via "UP" and "DOWN". Press " ＊ " again to confirm.
(2) The second digit will blink, that means the parameter can be adjusted via "UP" and "DOWN". Press " ＊ " again to confirm.
(3) P2 or P1 will blink. Please select P2 or P1 via "UP" and "DOWN" to set the pulse. P2 means welding once in 2 times.
P1 means welding once in 1 time.
(4) Press " ＊ " again to confirm.
The spot welder can weld when the digit not blink.
(5) Please set bigger current power to weld thicker than 0.1mm.
(6) The table of current and time of pulse for number setting and knob setting.

Input voltage	AC 110V/220V
Power	2.8KW(Instaneous max)
Time of 1 pulse	0.5-5ms (Variable)
Time of 2 pulse	1-10ms (Variable)

D. Welding introduction

1.Welding pressure adjuster

Please turn up the pressure adjuster in clockwise to weld thicker thickness. Please turn down the adjuster in anticlockwise to weld thinner thickness. Please observe the welding spot wether fastness and small size. (Notice: When the pressure adjuster to the maximum or minimum will be not welded. Please turn the knob to other side and the machine can work again.)

Please for reference to adjust the welding pressure adjuster

Types of / Thickness	Pure nickel strip	Nickel plated strip
0. 05mm	200~220g	250~280g
0. 1mm	250~300g	320~350g
0. 15mm	320~350g	350~400g
0. 2mm	350~420g	400~480g

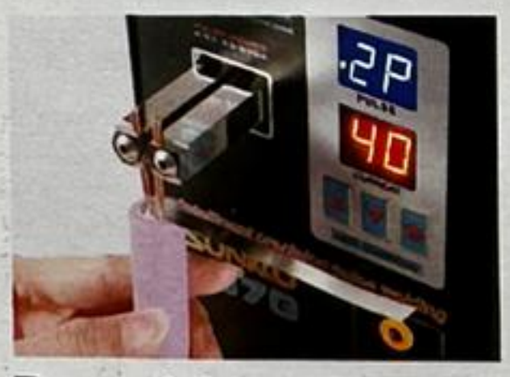
2. Install welding pins

Before

After

1. Use hexagon wrench to lossen screw.
2. Welding pins get through from below of the hole.
3. Adjust the length. Use hexagon wrench to tight up the screws.
4. It can be installed as you wish. But please do not let 2 welding pins get in touch.

3. Welding operation



Press tight and push up

Finished

1.Depending on the thickness of welding material to set current and pulse.
2. The welding pins press tight on the welding surface and push up the welding arm.

4. Pedal switch

Please plug on the pedal switch into the panel. The original welding controlling function transfer to the pedal switch to control.

When aiming to the welding spot and push up the welding arm. then step the pedal switch to weld.

E. Attention to use

Using notice

1. In order to obtain good weld effect, please don't use the active socket, and should be used the wall socket to ensure stable power supply.
2. Please place the spot welder in the ventilated areas to keep the machine for heat dissipation.
3. Please adjust the suitable welding pressure for welding.
4. Please notice when reaching to setting temperature inside of the spot welder, it would be protected and stop to work until the temperature cooling down.
5. Please let the machine take a break when welding over 0.2mm thickness to avoid overheat.
6. Please keep clean of welding pins surface for obtaining good welding spot.

The maintenance of welding pins

1. The welding pins on the new machine must be clamped by M4 hexagon screws.
2. Please check oxidation on 2 pin clamps and grinding it with crocus cloth.
3. Please check oxidation on welding pin and grinding it with sand paper.
4. It can be smeared some lubrication oil on welding pin clamps and welding pins for avoiding oxidation.

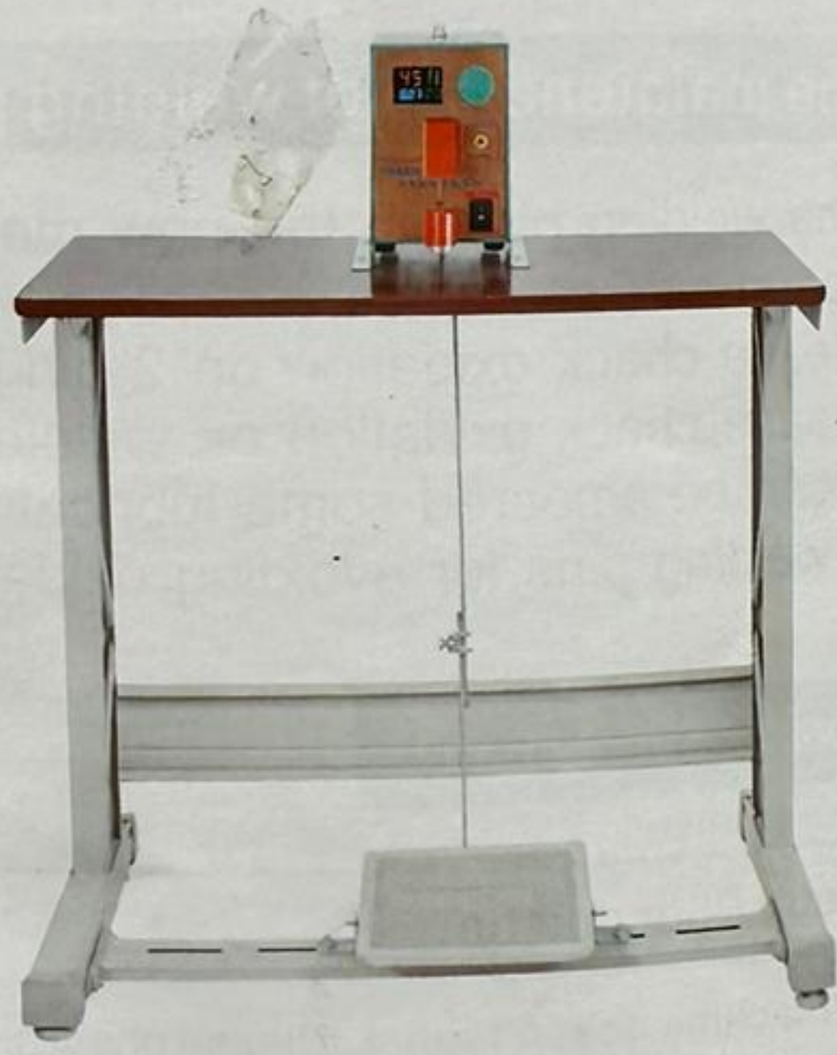
Repair of Simple Fault

Fault Phenomena	Treatment
The machine doesn't run	**Please check power and the insurance behind the machine.**
Bad welding effect	**Check the power supply if less than 200V and the socket is whether connected.**
Poor Welding	**Check the position of welding needle ,and observe the welding needle if it is oxidized. Adjust the welding needle.**
GFCI-protected	**If you use the machine for the first time,replace another power supply circuit or change 60A GFCI.**
Irregular chargering	**Check the output voltage whether compliance with the battery pack;the constant current whether set reasonable.**
The charging protected closed	**Reduction of the charging current,or use in a well ventilated environment.**

⚠ Notice

1. In order to obtain good weld effect, please don't use the active socket, and should be used the wall socket to ensure stable power supply.
2. Please set the pressure adjuster to the right parameter to avoid welding effect in not good.
3. Please keep the surface welding pins clean and wipe off oxide with sand paper.
4. Please keep the welding pin in sharp shape.
5. Please do not worry about the lighting in flash. SUNKKO 737G is a high power machine and discharging high current instantaneously. Because this moment is in 20ms and it is normal.

SUNKKO 709AD+



SUNKKO 796SD

SUNKKO 788H

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