

DAILY PRODUCTION SOP FOR SOLDERING MACHINE

1. Before Production:

- Turn on the machine and heating controller, and set the temperature to the required production level.
- Check for any clogs in the solder feeder.
- Select the production program and check for any misalignment in solder joints.
- Once confirmed, start the soldering process.

2. After Production:

- If the operation is temporarily stopped or completed, feed solder onto the soldering iron tip to prevent oxidation.

3. Replacing Consumables:

- **Soldering Iron Tip Replacement SOP** (details provided later).
- **Solder Wire Replacement SOP** (details provided later).

4. Turn On 3 power (SOLDERING Robot+Soldering Iron+CCD)



SOLDERING ROBOT IRON TIP REPLACEMENT



1. During Operation:

- If you need to replace the soldering iron tip (e.g., at 420 C), Press "SELECT "and wait for it to cool down.
- At 450 C, it takes approximately 20 minutes to cool to room temperature before the soldering iron tip can be replaced.



Once the soldering iron tip has cooled to room temperature, turn the nut at the red arrow (shown in the left image) clockwise to loosen it. No need to completely remove the nut; just loosen it until you can see the threads.



1. Using your thumb and index finger, grasp the two knobs on the solder feed bracket (as shown in the left image).
2. Rotate the knob on top of the solder feed bracket from vertical to horizontal (as shown in the right image) to lock it in place.



Finally, using your hand, apply force to pull the soldering iron tip downward to remove it.

SOLDERING MACHINE IRON TIP INSTALLATION



Insert the Iron Tip:

Insert the iron tip vertically upward until it is securely in place. Make sure the iron tip is fully inserted; the tip should not be able to rotate once properly installed. If it can rotate, it indicates that the installation is not complete.

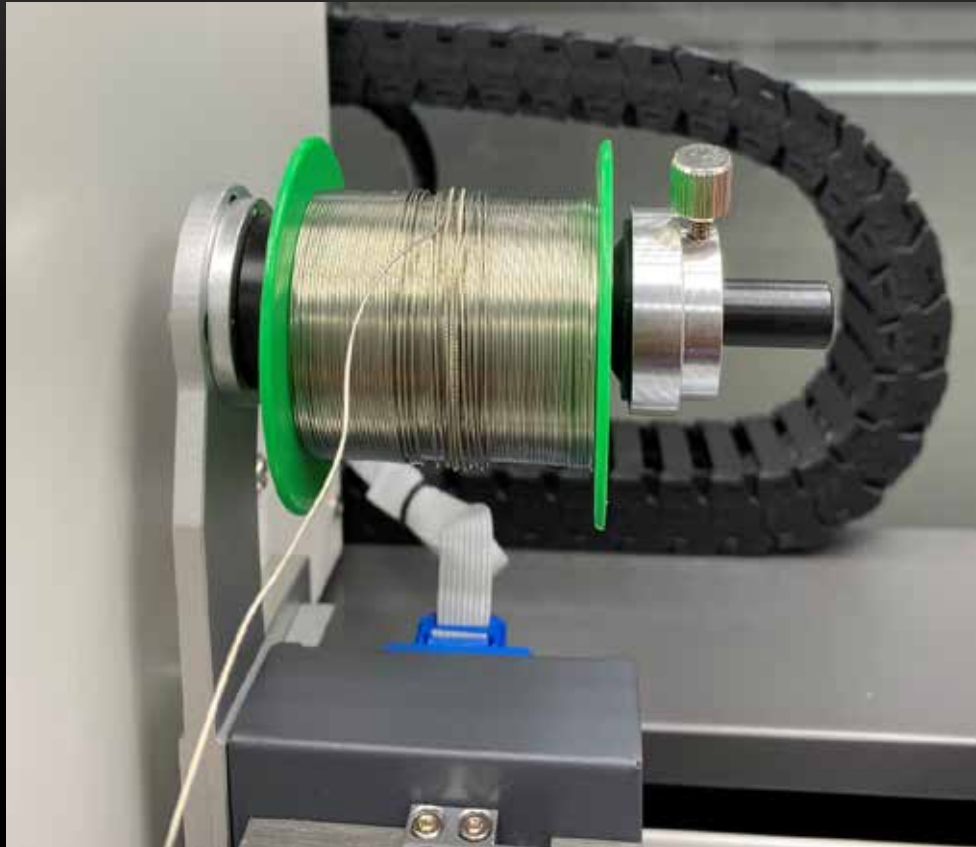
Confirm Installation:

The flat surface should be aligned as shown in the right image (red arrow), facing the left side.

Reverse Previous Steps:

Follow the previous steps in reverse order to complete the installation process.

SOLDER WIRE REPLACEMENT



Install the solder wire into the solder feeder. Align the bearing with the hole of the solder wire spool and ensure it is securely positioned.



1. Thread the Solder Wire:

Pass the solder wire through the two solder feed nozzles into the solder feed tube.

2. Check the Wire Diameter:

Confirm that the solder wire being used has a diameter of 0.8mm.

3. Adjust the Feeder Mechanism:

Adjust the feeder tension to ensure smooth and consistent feeding of the solder wire.



Turn on the soldering machine and perform a test (Press FEED) to ensure the new solder wire feeds correctly and solder joints are formed properly.



Continue feeding the solder wire until it is visible at the needle tip.