

## Adjust the welding needle

The installation way of welding needle

- (1) Use hex wrench to loose tight of welding needle clamp and insert welding needle into the clamp slot to tighten the hexagon screw.
- (2) Adjust the distance between the pin of welding needle. To loosen the hexagon screw slightly.
- (3) It is the same way to adjust the height of welding needle.
- (4) If 2 welding needle touching together will be in short circuit and can not weld.

## Deal with simple breakdown

Phenomenon	Solve method
No power	Check the power supply and the fuse on the back of spot welder.
Bad welding quality	Please check the power supply is whether lower than 200V. Check the connection of socket and the capacity of electric power supply line for obtaining good power supply.
Welding not well	Check the installation of welding needle and the tip of welding needle whether in oxidation. And adjust the welding pressure to reach to the welding requirement.
Leakage switch tripped	The leakage switch tripped when the spot welder is in first used. Please change 60A leakage switch or other power supply line.
Charging not normal	Check the charging voltage output and battery pack whether are corresponding or not. And the constant current setting whether is reasonable.
Close charging protection	Reduce constant current charging and charge in ventilation place.

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# SUNKKO 738AL

## Spot Welder With Magnetic & Telescopic Welding Head

Thank you for choosing **SUNKKO** series product. 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 tester, an instruction manual has been included. Please read before operation.

Please store this manual in a safe location for both current and future reference.

**Attention:** Rated current of tripping device of the leakage protection switch should be up to 60A.

In order to obtain good weld effect, please do not use active socket, and should be used the wall socket to ensure stable power supply.



## Manual Instruction

The performance of this product is improving. And we will reserve the right to change the parameters without prior notice.

## Features summarize

- \*Capable for welding 0.2mm pure nickel and 0.3mm nickel plated.
- \*2/4/6/8/10/12/14/18 multiple pulses numbers are optional according to welding requirements.
- \*Pulses numbers can be set up quickly and easily via touch sensing
- \*The magnetic and moveable welding head is easy to install.
- \*Flexible welding distance with moveable welding head.
- \*Quickly build Large-size power battery pack.
- \*Ergonomic product design.
- \*Spot welding with foot pedal switch is optional.
- \*Series welding pens are optional, expanding welding range and meeting specific welding needs

## Use range

- 1.Power tool battery pack,large lithium battery pack;
- 2.Welding wire of electric circuit board;
- 3.Welding metal components' lead wire and lead wires.

## ⚠ Notice

- 1.In order to obtain good welding effect, please don't use the active socket, and should be used the wall socket to ensure stable power supply.
  - 2.The spot welder should be placed to the ventilation place to make sure the spot welder will release heat well.
  - 3.Set the pressure adjuster to the right parameter to avoid poor welding effect. The welding will be not fasten or reliable when the pressure is not enough to welding. The welding quality is not good for the welding needle wear and tear too much when the pressure is too big.
  - 4.Welding frequently will cause the temperature of spot welder in serious heating in big current welding. The spot welder will stop to work for protection until the internal temperature decrease to the normal when the internal temperature over than temperature protection.
  - 5.We suggest welding intermittence when welding the thickness of welding part over than 0.2M for avoiding the spot welder in temperature protection.
  - 6 Keep clean the surface of welding needles and wipe off oxide with sand paper.
  - 7.Please keep the welding needles in sharp shape.
  - 8.Please do not worry about the lighting in flash. The spot welder is a high power machine and discharging high current instantaneously. It is normal for the time is within 20ms.

## 738AL Extended function(Optional)


### HB-70BN Mobile welding pen (Optional)





- (1) Plug in the 70BN welding pen, make sure that the welding pen's connector and panel's port are connected firmly, in case of spark and poor welding effect.
- (2) When coming across of the problem of loose plug, just use hexagonal wrench rotate the connector two laps clockwise.

### Parameter:

Welding current	50~600A
The total length of removable welding pen	≈580mm
The area of welding pen's cable	16mm²
The size of welding needle	Φ1.5mm X 7mm

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S-70BN use for 18650,26650,32650 battery and Stainless Steel Wire Mesh/Sheet.
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S-71A use for small battery,nickel,PCB,button battery Hardware parts and more.
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S-71B polymer lithium battery aluminum and 0.5mm Stainless Steel Wire Sheet.

## Welding Arm Fixing Diagram

Fixing the welding arm can avoid it being moved by thrust forced on it.



1. Loose the screw on the top of machine with screwdriver
2. Position the welding arm in an appropriate place, and then the metal sheet
3. Lastly tighten the screw

## 0.2mm pure nickel welding demonstration



Reliable welding effect of 0.2mm pure nickel strip.

## Welding current and pulse choosing reference chart

Type of nickel strip	Thickness of nickel strip					
		0.1mm	0.12mm	0.15mm	0.2mm	0.3mm
Nickel plated steel	Current	15	25	45	65	65
	Pulse	1P	1P	2P	2P	2P+4P+6P
Pure nickel strip	Current	25	35	65	95	—
	Pulse	1P	1P	2P	2P	—

## Parameter

Voltage power	AC 110V/220 $\pm$ 20V	4 pulse times	2~20ms
Power	3.6KW	8 pulse times	8~80ms
Welding current	120A~1100A	Magnetic arms distance	95~160mm
2 pulse times	1~10MS	Welding thickness	0.05~0.3mm

## Diagrammatic sketch



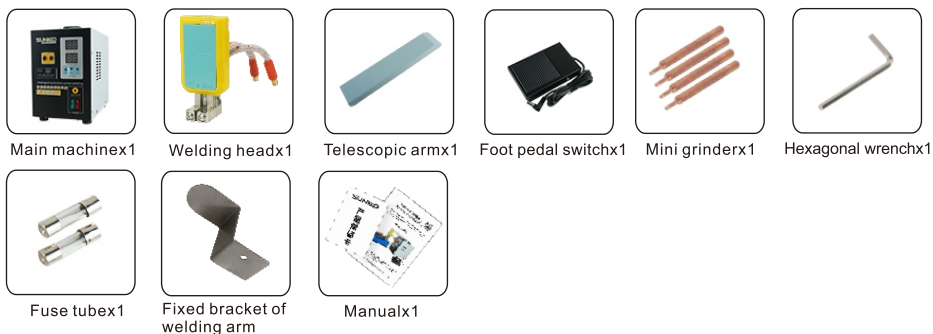
## Reverse side



Weight:5.6KG  
Size:140x245x200MM



## Standard Package List



## Operation

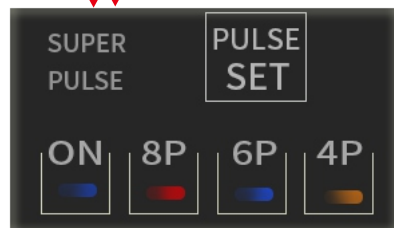
**Press down the red switch, turn on the pulse group choice**

Without press any button means 2 pulses

Press 4P means 4 pulses  
Press 6P means 6 pulses  
Press 8P means 8 pulses  
Press 4P and 6P means 10 pulses  
Press 6P and 8P means 14 pulses  
Press 4P, 6P and 8P means 18 pulses

Pulse adjusting display

Current adjusting display



**Press the green switch and turn on the power**

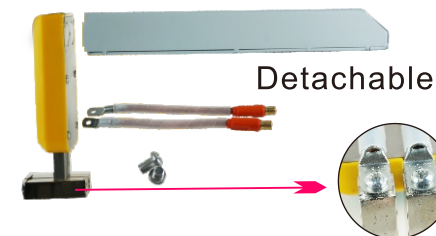
1. Please disconnect the power. Release the screw to adjust the height and distance of welding needles and adjust the welding pressure.
2. Press the green power switch to turn on the welding part. Press the red power switch to turn on the pulse group choice.

3. Press setting key to change CURRENT and PULSE.

- (1) Press 'UP' or 'DOWN' key to adjust. 'UP' is for increase digit. 'DOWN' is for decrease. Press '\*' to confirm
- (2) We could increase pulse to weld when the welded material thickness is thicker than 0.2mm. There are 2/4/6/8P pulse could be selected. The pulse could be superposed. The maximum pulse is 18 pulse when press 4/6/8P together.
4. Setting the welding current and pulse are based on the thickness of welding material. Pushing up the welding material on the welding electrode and the welding is finishing.
5. We could use foot pedal controlled switch to weld if the welding is precision to locate to welding. Connect the foot pedal controlled switch to the panel. The control welding function is transfer to the foot pedal controlled switch.

## Telescopic Welding Head

1. Welding head
2. Telescopic arm
3. Red copper wire
4. Fixing screw



## Assembly magnetic and telescopic welding head



1. Fix the magnetic arms on the machine



2. Copper wire plug in the welding head



3. Assembly the welding head and magnetic arms

