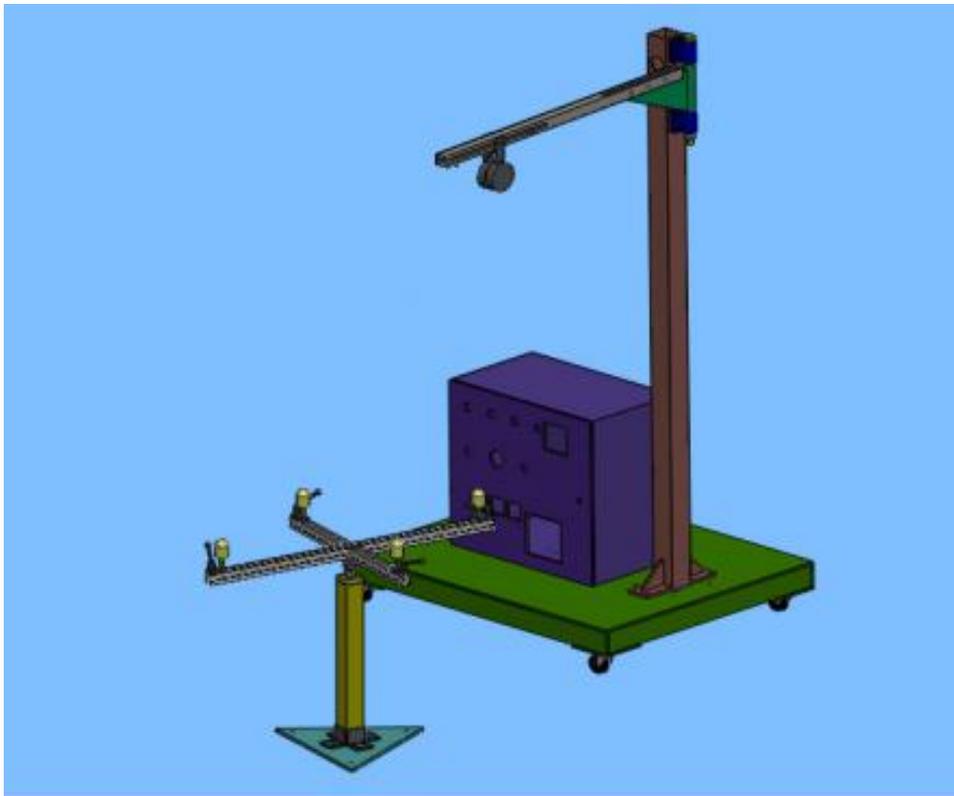


FZTSM-B

MANUAL SOLDERING MACHINE FOR BACKLITE

TECHNICAL SPECIFICATION



1. USE RANGE

This Terminal soldering machine is a semi-automatic welding machine. In order to connect the glass heating wire with the vehicle body control circuit, a terminal piece needs to be welded on the glass heating wire for connection. The most traditional welding method is to manually weld the connector to the glass heating line using an electric soldering iron. This method is not only inefficient, but also easily causes the connector to be welded on the glass heating line to be easily soldered and the solder is unevenly melted. The welding machine uses the working principle of low voltage and large current to quickly weld the connector to the glass heating line. Not only does the connector welded on the glass heating line not be easily soldered off, but the solder melts evenly and glossy, it also greatly improves labor efficiency.

2. TECHNICAL PARAMETERS

2.1 Technical Data

Maximum Glass Size	1850*1450 mm
Distance between the two welding needles	12-25 mm (Adjustable)
Tensile Strength	2-4 kg
Cycle Time for welding	≤ 10s
Supporting Frame Rotation	0-360°
Longer rod length for Supporting Frame	1000 mm
Shorter rod length for Supporting Frame	530 mm
Height for Supporting Frame	900 mm

2.2 INSTALLATION CONDITION

Temperature	18℃~35℃
Humidity	50% (Max≤75%)
Voltage/Frequency	380V/50Hz 3ph
PLC Voltage	220V
Control Voltage	24VDC
Voltage Variation	+/-10%
Compressed air	6bars dehumidified / free of oil
Glass request	Rear windshields, formed with heated wire

ADD.: NO. 121 QINGHONG ROAD, EHU TOWN, XISHAN DISTRICT, WUXI CITY, JIANGSU PROVINCE, CHINA.

MB/WECHAT/WHATSAPP: 0086-15924100880 FAX: 0086-510-88992553

 Email: june@glassmc.com
<http://www.fzmachine.com>

Authorized by Wuxi Fuzuan Machinery Technology Co.,Ltd

3. MECHANICAL STRUCTURE DESCRIPTION 机械结构说明

It's composed of 4 parts, mainly including welding table, tensile force balancer, welding head and control cabinet.

3.1 Welding table

It's a cross supporting frame with 2 rods, one is longer another is shorter, it can rotate 360° , The support frame have four freedom moveable roller rods and fixed on the cross.

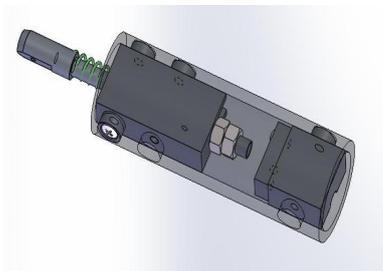
3.2 Tension balancer

Tension balancer is mainly used for welded point. It is fixed at one end to a swinging 1800 beam, and the other end is to hang the welding head. When the connector is needed, the welding head can be pulled to the glass of the connector piece by gently pulling the welding head.

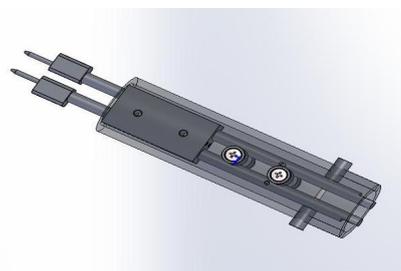
3.3 Welding head (device into two types, button type and connector type):

The welding head is composed of two tungsten electrode welding needle, vacuum cups, spring mechanism etc, when need to weld the connector, first place the connector in the right position where in need of welding, and the tungsten to the connector, foot switch once, the sucker vacuum once, the tungsten needle for electrical heating , the time is adjustable, and then cooling start (adjustable), to break the vacuum.

Schematic diagram of the welding heads



Button type welding head



connector type welding head

3.4 Control cabinet

It's mainly composed of a voltage regulator, a transformer, three timer, and a digital display meter etc, it's

used to control the heating time delay, welding time, cooling time, solder heating and welding current instructions etc.

4. WORKING PRINCIPLE

4.1 Process principle

In order to prevent the frost on the backlites, generally there are many automotive glass with heating wires on the surface, to keep the glass has a certain temperature. To contact the glass heating wires and the car body control circuit, it need to weld the connector on the glass heating wires for the connection.

4.2 Operating principle

Terminal welding machine adopts the principle of low voltage, high current, which will weld the connector on the heating wires and its working process is as follows,

Firstly pace the connector in the right position. tungsten aimed at the connector, foot switch once, sucker vacuum once, the tungsten needle for electrical heating , the time is adjustable, and then cooling start (adjustable), to break the vacuum, the welding head auto back and finish all the process.