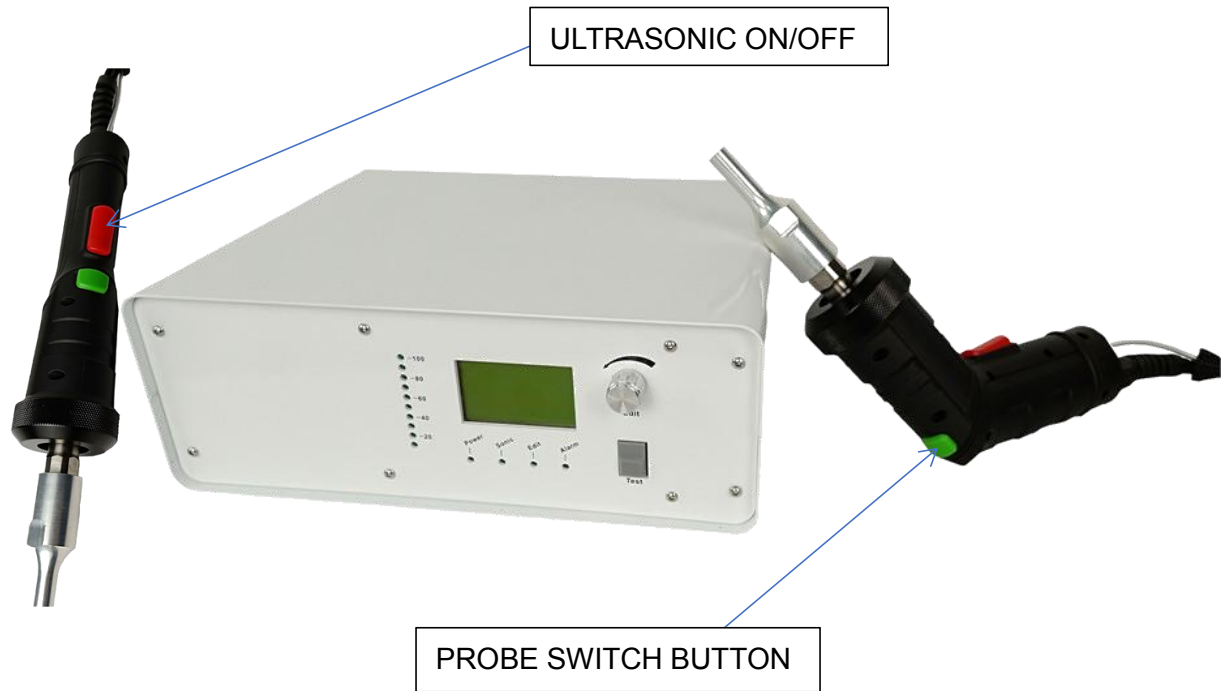


35khz Switchable Ultrasonic Spot Welding Equipment



- ❖ Easy to operate, cost-effective efficient
- ❖ safe, self-contained frequency-fault alarm program
- ❖ Automatic frequency search, English display
- ❖ Hand-held handle design ergonomic
- ❖ Hand-held handle can be switched between straight handle and pistol

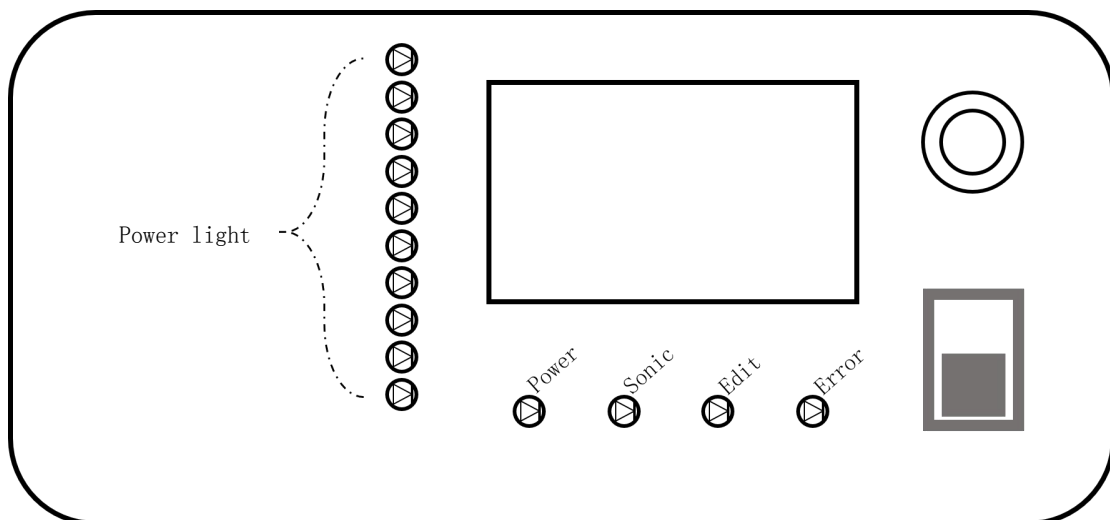
Power supply requirement

The power input : single phase AC220V 50HZ/60HZ.
 Input power supply voltage fluctuation range: <10%.
 Input power grid harmonic content: <20%.
 Input supply current: <20A.
 Input power cable diameter: >2.5 mm².

Port Interface



Operate Interface



Single light

- Power: Power light
- Sonic: Ultrasonic light
- Edit: edit light
- Error: Alarm light
- Power light 1~10: power output rate light

Button



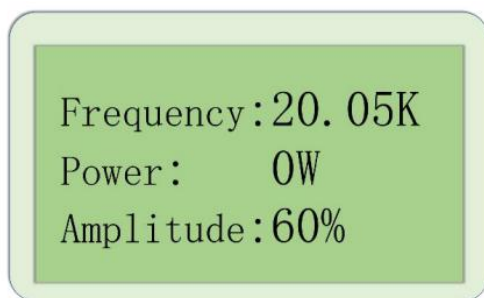
- Turn clockwise: the parameter item can be incremented.
- Turn counterclockwise : the parameter item can be decremented
- Short press : enter the parameter edit status and the parameter bit increment.
- Long press :save the parameters and exit the edit state.



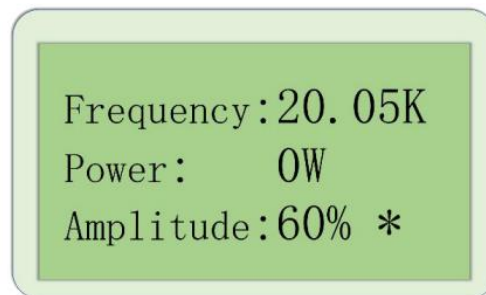
Test button: test ultrasonic

User parameter management menu

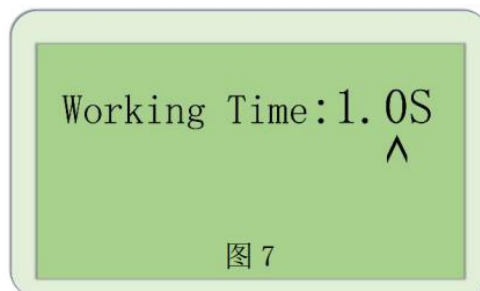
LCD display



P1 Boot interface



P2 Amplitude twinkle



P3 Welding time twinkle

When you open the equipment , it will show as P1.

Parameter : Frequency: the working frequency

Power:the working power

Amplitude:the working amplitude.

Working Time: welding time.

Adjust : End user can adjust the amplitude and working time.

Press Edit shortly,The amplitude parameter twinkle, and turn the edit right to increase,turn edit left to decline.And then keep edit w while to keep and exit.

Press Edit a while , the working time twinkle , Turn the edit right to increase.Turn the edit left to decline.And then keep edit w while to keep and exit.

Adjust Instruction

Amplitude: The parameter of amplitude in percentage. The adjustment range is 40~100. The bigger in percent, the stronger of output. (Note: This device has a constant electronic amplitude control system, the no-load amplitude is normal working amplitude. It is better to adjust the amplitude in small range each time.

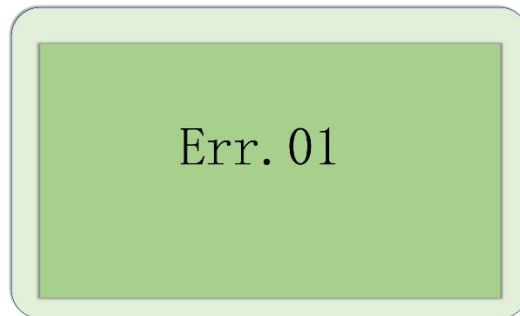
Working time: This parameter is set to the single working time of the equipment (0~99.9S). When the parameter is set to 0, the working time of the equipment is only controlled by the switch on probe, commonly the hand welder control the welding time by welding probe, no need set the welding time .

Technical parameter

Mechanical parameters	
Weight of generator	4KG
Weight of probe	1KG
Dimension	285 x 222 x 105 mm
Color of probe	Black
Material of probe	Nylon plus 30% glass fiber
Electrical parameters	
Frequency	35Khz (20、28、30、40kHz)
Power supply	210 - 250 VAC ,50 - 60 Hz
Current	20A in max
Power	800W in max
Environment temperature	-10~40°C

Fault protection display and solution

Power overload alarm



Cause of issue:

The power protection value is set too low;

The voltage fluctuation is abnormal;

The horn pressure too much.

Solution:

Increase the power protection value;

Add a voltage regulator equipment;

Check the horn.

Frequency alarm

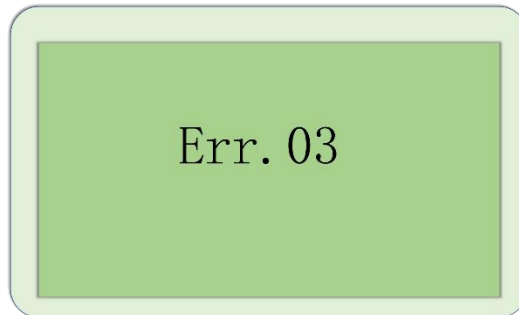


Cause of issue:

The horn temperature rises leads the frequency changed;
Loose or damaged horn cause frequency deviations.

Solution:

Cool the horn to the normal range;
Check that the horn connection and transducer. It is better to Equipped with impedance analyzer

Frequency too low**Cause of issue:**

Horn Loose or damaged.

Method of exclusion:

Check if the horn is loose;
Check the horn any cracks.

Operation fault protection

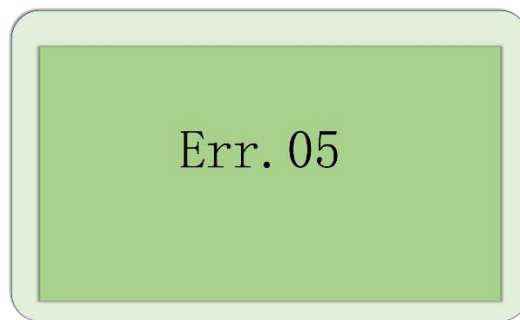
Cause of issue:

The transducer has cracks or incorrect selection.

Method of exclusion:

Check the horn for cracks;
Replace the transducer.

Parameter read fault



Cause of issue:

The parameter memory is abnormal.

Method of exclusion:

Turn off the equipment and wait for 30S before turning it on.