

# S-WS350 wave soldering machine



# Transportation system

- 1, Direct-connected into the board device, using special stainless steel chain, smooth into the board.
- 2, Special high-strength aluminum alloy transport rail, hardly deformed.
- 3, Auxiliary guide rail :40mm×80mm thick aluminum profile.
- 4, Central support system prevents the rail from deforming.
- 5, Newly type of titanium alloy claw, its deformation resistance can reach 20kg/cm.
- 6, Convey speed is 0-1.8m/min.
- 7, Drive system by Delta inverter control motor.
- 8, Manual angle adjustment, angle adjustment range 3 °C-7 °C.
- 9, Sensor for board loading, containing production quantity record function.



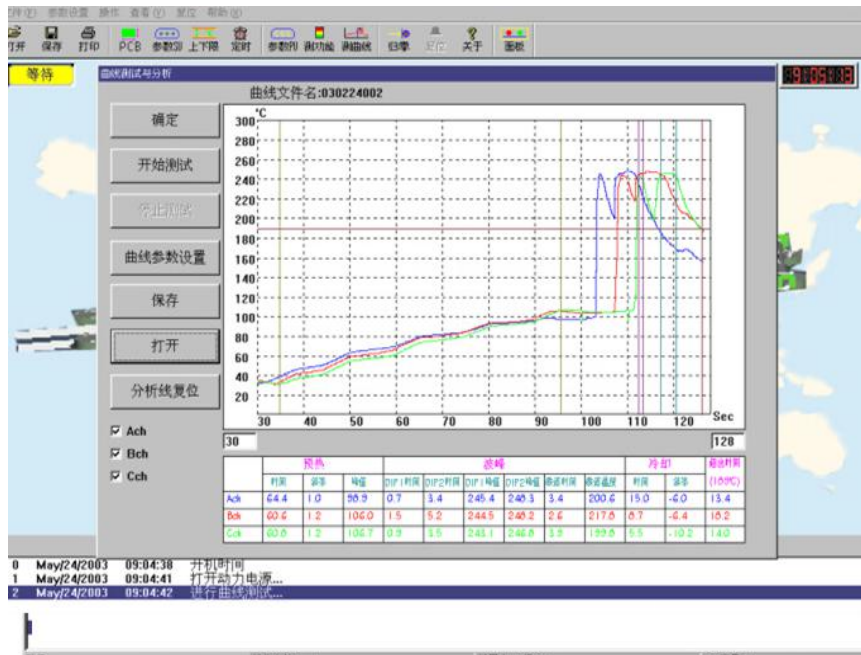
# The preheating system

- 1,The inner preheating tank is made of special materials and has high thermal insulation performance.
- 2,Using four-stage hot air preheating zone,about 2000mm.
- 3,Frame is made of stainless steel plate(high temperature resistance), contain transparent full-size tempered glass monitoring the running condition of the PCB board.
- 4,Hot air conveying method and special motor, which has long service life and low noise.
- 5,The special heating wire is a star-shaped heating element wound in a special way, which has fast heating, long life and low thermal inertia.
- 6,Circulating temperature feedback system precise temperature control, control accuracy  $\pm 2^{\circ}\text{C}$ .
- 7,Preheating and close design of tin gallbladder, the maximum temperature drop coefficient before soldering is  $-1.5^{\circ}\text{C}$ .



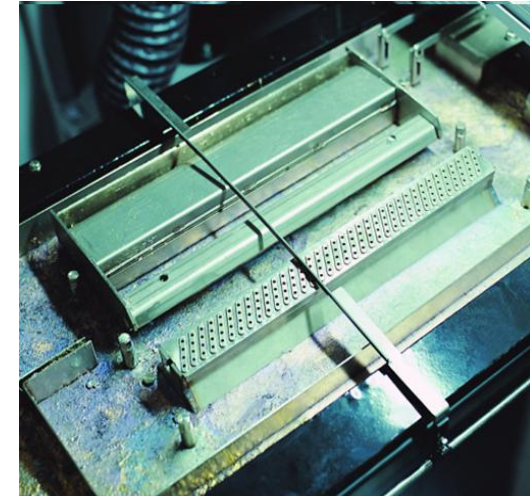
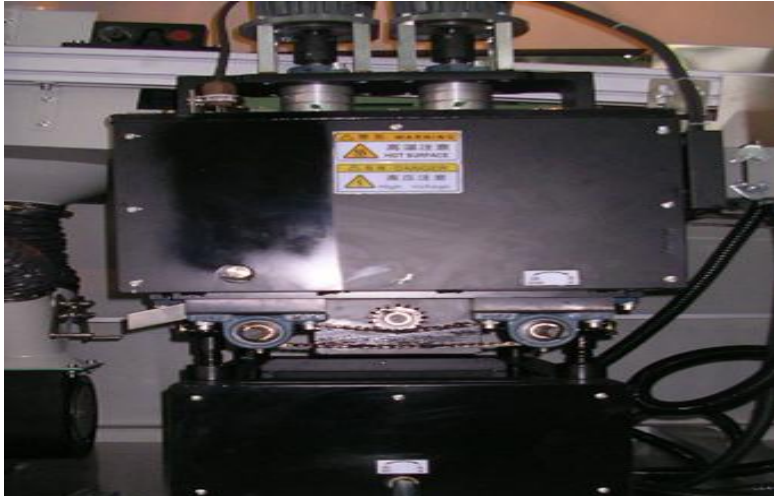
# The control system

- 1,Control by Lenovo computer + Siemens PLC.
- 2,Using thermocouple detection system, automatic cold junction compensation, temp control stability.
- 3,Siemens temper control module with imported SSR drive system
- 4, Using PID temper control mode.
- 5, Emergency engine. Ultra-high and low temper alarm funtion
- 6,Time setting automatiction to switch machine in computer.
- 7,Convey speed&wave height directly set by computer.
- 8,Windows XP operation system.
- 9,Each zone temper raising sate showed by columnar.
- 10,Various PCB spec settings can be stored, suitable for different size PCB.



# The solder tank system

- 1, The inner tank is made of 316 stainless steel, 380kg capacity.
- 2, Tin bath material is made of 316 stainless steel.
- 3, Extrapolation modular method of heating .
- 4, Power: 18KW, room temperature: 260 °C ( 1.5 hours), the highest temperature can reach 300 °C.
- 5, Automatic protection function: if tank temperature didn't reach the setting level, it's pump will not start.
- 6, The frequency converter controls the motor speed
- 7, Flat wave peak: 12-13mm.



1. Automatic fault alarm function; a thermocouple abnormal alarm function, high and low temperature alarm. When preheating or tin furnace fault stop heating.
2. Can control temperature of preheating zone respectively, tin stove temperature, transport speed, spray action, forced cooling, etc.
3. A week time setting (can be set, seven days a week and automatic switch machine three times a day ).
4. Equipped with two special emergency system in the machine ahead and the tail , please press the button when emergency situation.



# S-WS350 wavesoldering machine

<b>Control Method</b>	<b>PC (Lenovo) + PLC (Siemens)</b>
<b>Conveyor Motor and speed</b>	<b>4P AC220V,90W,0.5~1.8m / Min</b>
Direction	L-R
<b>PCB width</b>	<b>50-350 mm(Adjustable)</b>
<b>Preheating length</b>	<b>1800mm 3 PID control (via four-stage hot air)</b>
Preheating power&temperature	9KW; Room temp~220°C(adjustable)
Heating method	by hot air
Cooling method	Forced cooling
Solder type	Lead free solder/common solder
Tin stove power&temperature	18 kw,Room temp~350°C
Tin amount	Approx.380 KG
tin furnace material	316 stainless steel
tin furnace heating	cast iron heating plate
timing device	timer Control the automatic
Capacity and pressure of flux	Max5L 0.4~0.6Mpa
Wave Qty	2
Wave height	High wave 30mm, flat wave 5-12mm
Soldering angle	3-7 degree
Claw cleaning pump	AC 220V 10W
<b>Power</b>	<b>3 phase 5 lines 380V/50Hz , 19Kw</b>
<b>Dimension size(L*W*H)</b>	<b>L4200xW1350xH1650mm</b>
Weight	Approx.1200kg

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