

Deal with simple breakdown

Phenomenon	Solution
No power	Check the power supply and the fuse on the back of spot welder.
Bad welding quality	1 Check the power cable whether is over to 1.5mm ² . 2. Please check the power supply is whether lower than 200V. Check power connection. 3 Check the 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 40-63A leakage switch or other power supply line.

⚠ Spot welder 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 Set the pressure adjuster to the right parameter to avoid poor welding effect. The welding will be not fastened 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.
- 3 Keep clean surface of welding needles and wipe off oxide with sand paper.
- 4 Please keep the welding needles in sharp shape.
- 5 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.

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SUNKKO® 737DH

Induction welding / Fast welding

Pulse current / Precisely adjustment

Delayed welding / 3 level could be adjusted

Current showed / Controlled in time

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 this spot welder has been included. Please read before operation.

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

Manual Instruction



caveat:

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.

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

Features

- ◆ It is the first design for spot welder with delayed welding function with 3 level power adjusted in precisely welding.
- ◆ The mode of induction automatic releasing current is suitable for welding battery pack.
- ◆ The pulse power knob for adjustment is suitable to weld different thickness of welding part.
- ◆ It could be monitored the current output by current showed.
- ◆ There are 2 modes of fixed welding head and movable welding by welding pen.
- ◆ There are 2/4/6/8 pulse could be choose and welding spot is reliable
- ◆ It could be satisfied welding place and good quality of welding spot by external foot pedal control switch.

Use range

1. Welding lead wire of battery;
2. Welding lead wire of circuit board;
3. Welding metal parts;
4. Welding lead wire of metal shell;
5. For DIY.

Packing list of 737DH

1. Machine X1
2. Manual instructions X1
3. Warranty card X1
4. Removable welding pen X1
5. Foot pedal switch with wire controlled X1
6. Welding needles for fixed welding head X4
7. Hex wrench X1
8. Welding needles for welding pen X2
9. 20A fuse X2

Parameter information

1. Welding part

Voltage power	AC220V/110V+20V
Power	4.3kw(Instantaneous)
Welding current	120~1200A
2 Pulse time	1~10ms
4 Pulse time	2~20ms
8 Pulse time	8~80ms
The welding distance of fixed welding head	0.15~0.35mm
The welding distance of welding pen	0.1~0.2mm
Size	140X230X200mm
Net weight	5KG



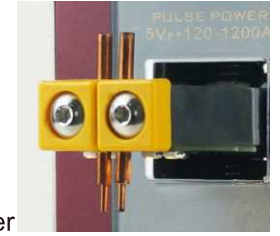
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Installation of welding needles

Before



After



welding pressure adjuster

8. Welding pressure adjustment

There is a welding pressure adjuster on the top of spot welder. It could be adjusted for depending on different thickness of welding material. Please turn the welding pressure in anti-clock-wise for welding thin material. And turn the welding pressure in clock-wise for welding thicker material. Please observe welding spots for adjusting welding pressure. The welding spots are firm and reliable and small diameter for meeting the welding quality requirement.

Connection

1. Polish tips of welding pen with sanding paper before connect to the spot welder. Put some lube oil on the tip for avoiding oxidize on surface.
2. It is the same way to deal with the fixed welding head.
3. Connect the welding pen to the spot welder. Please screw tight M4 bolt to keep electric conduction well.
4. Please connect the plug with socket on the wall to keep power supply steady. Don't use power strip for avoiding poor welding effect because power supply is instability.
5. The length of removable welding pen's cable is 0.62 Meters X2. These will consume the current from the spot welder. Please increase welding current if removable welding pen connect to non-original spot welder.
6. The welding needles are 1.5Φ aluminum alloy. The needle would be pulled out for exchange when the tips wore out. The new needles should be pushed to the deep bottom.
7. Please remove oxide on tip of welding needles to make sure welding quality.

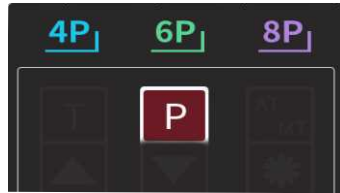
The maintenance of welding needles

1. The new SUNKKO spot welder must be installed welding needles tightly by M4 hex screw.
2. Use sanding paper to polish if the clips are covered by oxide.
3. Also use sanding paper to polish if the welding needles are covered by oxide.
4. Paint a little lube oil for avoiding welding clips and needles get oxide.
5. Please use original welding needles.

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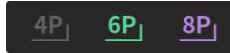
Fast setting pulse

It is easy to set pulse by press key of SUPER PULSE slightly to trigger induction.



18 Pulse setting

- It is 2 Pulse when the SUPER PULSE not be switched on.
- It shows 4P when press P 1 time and means 4 Pulse.
- It shows 6P when press P 2 times and means 6 Pulse.
- It shows 8P when press P 3 times and means 8 Pulse.
- It shows 4P and 6P when press P 4 times and means 10 Pulse.
- It shows 6P and 8P when press P 5 times and means 14 Pulse.
- It shows 4P, 6P and 8P when press P 6 times and means 18 Pulse.
- 4P, 6P and 8P not light on when press P 7 times. That means pulse group back to original setting of 2 Pulse.



14 Pulse setting

How to use DIS inductive automatic welding mode?



The light shows "AT" in green under automatic mode.



Press exchange key of AT/MT. The AT light on panel is on that means the machine is in the inductive automatic welding mode and no need to be controlled by foot pedal switch with wire.

The light shows "MT" in red under foot pedal switch wire controlled mode.



Press exchange key of AT/MT. The MT light on panel is on that means the wire controlled foot pedal switch should be connected to the spot welder. The welding operation is controlled by foot pedal switch.



The port for connection is on the back of spot welder.

The delayed function T

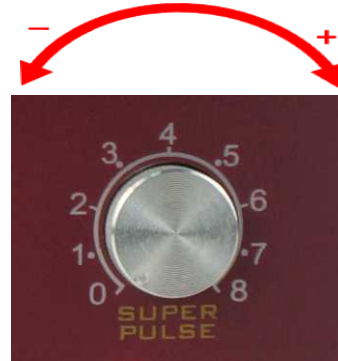
0.6s Press 0.6S delayed key, the corresponding light is on. It means the inductive welding is delayed 0.6 second.

0.5s Press 0.5S delayed key, the corresponding light is on. It means the inductive welding is delayed 0.5 second.

0.4s Press 0.4S delayed key, the corresponding light is on. It means the inductive welding is delayed 0.4 second.

0.4s 0.5s 0.6s The delayed time overlay welding to 1.5 second when 3 delayed lights are on.

How to use the pulse power adjustment knob?



Pulse power adjustment knob is for adjusting welding pulse power. Turning the knob from the anti-clockwise is for turning down power. Turning the knob from the clockwise is for turning up power. The knob could be adjusted to the middle side for welding parts. 0.05-0.35mm nickel strip could be welded by adjusting pulse power adjuster and pulse current and pulse.

High power removable welding pen

Lithium battery and chargeable battery are more and more use in modern electronic applicant. Welding different shapes of battery is limited by shapes and volume of battery pack. It hard to welding lead wire and nickel strip. The normal spot welder with fixed welding head is lack of adaptability welding. The high-power removable welding pen is suitable for work with SUNKKO spot welder to solve welding different shapes of battery pack by external releasing current electrode.

Features :

- A set of welding pen is convenience to transship and assemble to use.
- It is made of low resistance no-oxygen copper.
- It is suitable for use with SUNKKO spot welder to increase welding function.
- The removable welding head is suitable for welding different size welding spot.
- The anti-skid shell of welding pen is convenient to hold in hand.
- The internal pressure balance elastic device is good for releasing current.
- The welding needle is made of alumina alloy and could be used long time.



Parameter of welding pen

	The distance of welding needles	2 ~ 7mm
	The length of movable welding pen	≈580mm
	The cross area of welding pen's cable	16mm²
Solder pin size		∅1.5mm X 7mm

How to use spot welder?

1. Turn off power first. unfix bolt to adjust the same height of welding needles. And adjust welding pressure.
2. Put the plug to socket on the wall to connect power. Turn on the power switch (black) on the back of spot welder. The spot welder is powered on. Press “**⏻**” on the panel of spot welder. The spot welder is standby.
3. Press “*” key to select current. (Blinking digit showed.) Press “▲” to increase digit or “▼” to decrease digit. Press “*” to select PULSE. “▲” is for increase digit. “▼” is for decrease digit. Press P2 is dual pulse for 2 times fast welding. It is for welding spot more fasten on the working face. Press “*” to save parameter for exit digit setting after setting pulse. Please setting the current to the maximum digit and adjust adaption welding pressure when welding material thickness over 0.1mm.

(3) For example. Use fixed welding head to weld 0.2mm iron strip could be satisfied by setting 4 pulse and 40A-50A current. When under the same setting pulse to weld 0.2mm iron strip with removable welding pen. The higher current is needed.

4 The parameter setting is based on the thickness of welding material. Aiming at the right welding place under fixed welding head, and push up for welding.

5 The “MT” manual welding mode should be selected when use fixed welding head. Connect the foot pedal switch to the spot welder for control welding. It is easy to produce poor quality welding spot because the welding speed is fast and not catch up to press tight welding parts if use fixed welding head in “AT” mode.

6. It is more adaptability to weld different parts with removable welding pen to expend spot welder working area and welding method.

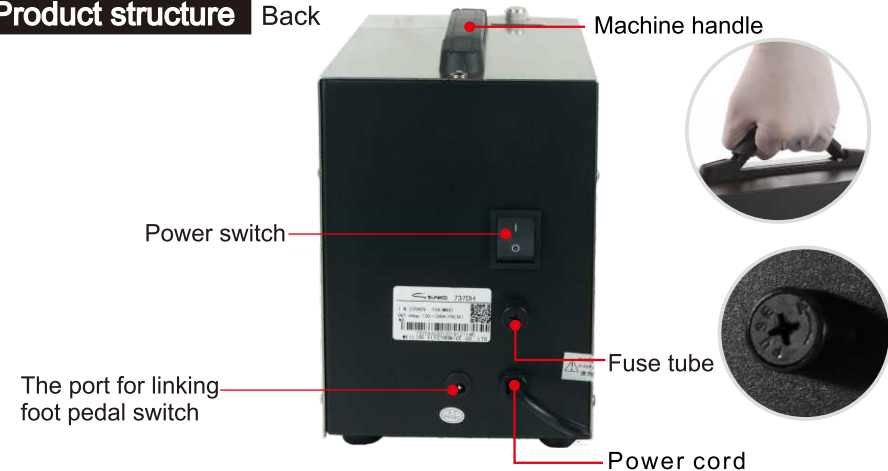
7. Installation and adjustment of welding needles

- ① Loosen the clip of nickel needle with hex wrench. Insert nickel needle into the gap and tight the hexagon screw.
- ② Loosen hex screw for the distance of welding needles' tips are adjusted slightly.
- ③ It is the same way to adjust the same level of 2 welding needles.
- ④ Please be careful that 2 welding needles and clips don't touch each other. Otherwise the welding operation could not work.

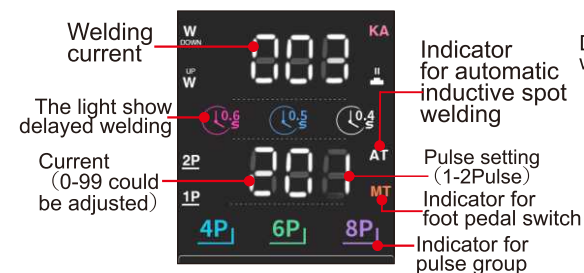
Product structure Front



Product structure Back



1. The panel showed



2. Function key

