

⚠ 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. Please set the pressure adjuster to the right parameter to avoid poor welding effect.
3. Please keep the surface of welding needles clean 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.



SUNKKO 709AD+



SUNKKO 788H-USB



SUNKKO 797DH

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SUNKKO 737G⁺

Dual induction ① Induction fast welding ② Induction setting

high speed pulse welding Large size of 700X500mm battery pack could be welded fast by SUNKKO 737G⁺.

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.

Manual Instruction



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.

Features summarize

- ✦ 1. Induction mode is for fast setting pulse group and fast welding.
- ✦ 2. Induction welding automatically could be in high speed.
- ✦ 3. Fixed welding head and removable welding pen two modes for convenient to use
- ✦ 4. Fast welding large size battery pack.
- ✦ 5. There are 2/4/6/8 pulses welding selection function to get firm welding spot.
- ✦ 6. Welding position and sophisticated technology could be attained easier by external foot pedal control switch.
- ✦ 7. The SUNKKO 737G+ spot welder is with a unique welding pressure regulator for fixed welding head to get more reliable welding spot.

Range of application

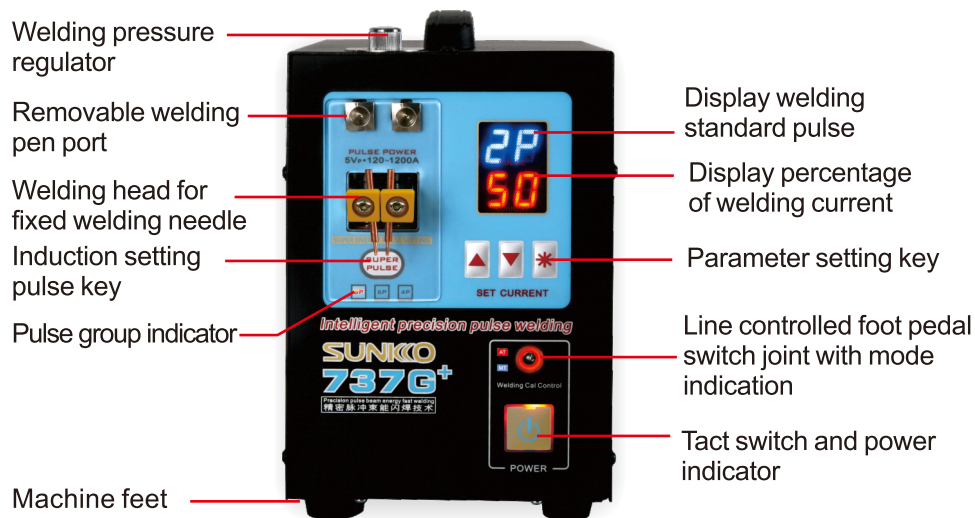
- Fast welding chargeable battery lead wire.
- Welding and assembling large battery pack and movable power.
- Welding metal components' lead wire and lead wires.

737G+ standard packing list

Machine *1 Manual instruction *1 Warranty card *1
 Removable welding pen *1 Line controlled foot pedal switch *1
 Welding needles for fixed welding *4 Welding needles for welding pen *2
 Hexagon wrench *1 Fuse tube *2

Product structure

1. Front



The way of connection and use

1. Please polish the welding pen needle with sand paper. We could use a little bit lubricating oil on needle for avoiding oxidation.
2. It is the same way to deal with welding needle clips.
3. Use M4 hexagon screw for connect welding pen to spot welder. Please screw tight M4 screw to ensure electricity conductivity.
4. In order to obtain good weld effect, please do not use the active socket, and should be used the wall socket to ensure stable power supply.
5. The length of welding pen's cable is 0.65Mx2, the resistance will decrease the current from spot welder. If the welding pen didn't connect with the SUNKKO spot welder, please increase spot welder's welding current.
6. After running out of the Φ1.5 aluminum alloy needle on welding pen. Please pull out the needles from the welding pen for replacement.
7. Please keep cleaning oxide on the welding needle for ensuring welding quality.

The maintenance of welding needle

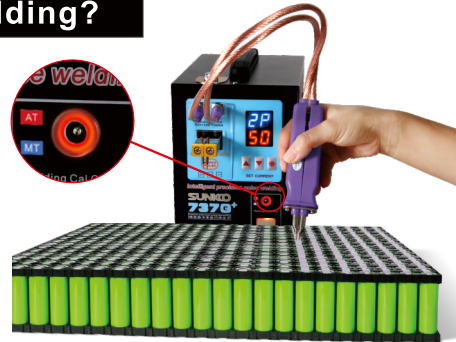
1. The welding needles on new spot welder must be clamped by M4 hexagon screws.
2. Please check oxidation on 2 needle clamps and grinding it with crocus cloth.
3. Please check oxidation on welding needles and grinding it with sand paper.
4. It can be smeared some lubrication oil on welding needle clamps and welding needle for avoiding oxidation.
5. Please use welding needles from SUNKKO.

Repairment for simple fault

Fault situation	Treatment
There is no electricity of spot welder	Please check power and the fuse tube on the back of spot welder.
Poor welding effect	<ol style="list-style-type: none"> 1. Check the power supply cable must reach to 5mm² or more. 2. Check the power supply's voltage reach to 220V and the socket is whether connected. 3. Check the power supply.
Poor welding	Check the welding needle oxidized situation and adjust welding pressure.
GFCI-protected	If you use the spot welder for the first time, replace another power supply or change 60A GFCI.

How do we use induction welding?

1. Turn on the power switch on the back side. And press "POWER" key on the front side to turn on welding mode. The spot welder is turned on.
2. The port of foot pedal switch is in red blinking means that is in the AT mode. The induction welding automatically mode is on when the spot welder is not with line controlled foot pedal switch.
3. The spot welder could not weld in induction welding automatically mode when the line controlled foot pedal switch connect with the spot welder.
4. The removable welding pen connect with the spot welder and setting welding pulse to weld.
5. The welding current will be released automatically when two pins of welding pen touch metal after 1 second. That means the welding will be finished when two pins of welding pen press tight the nickel strip and battery in 1 second.



6. When the line controlled foot pedal switch connected with the spot welder, the connected port was in blue circle that mean the MT function is on. The welding pen could not release current to weld automatically in MT mode.



Line controlled foot pedal switch welding mode

High power removable pulse welding pen

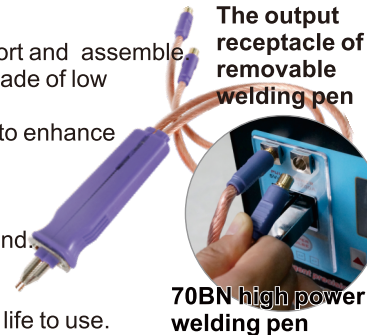
Lithium battery and rechargeable battery are used in electronic appliances more and more widely in recent day. Because of the shape limited, it would be difficult to weld leading wire and nickel strip when welding different shapes of battery packs. The fixed welding head of regular spot welder are lack of flexibility to weld. Therefore we need removable welding pen to weld different shape of battery packs. And SUNKKO welding pen are suitable for SUNKKO different model spot welder.

Range of use

1. Welding leading wire of lithium battery
2. Welding leading wire of circuit board
3. Welding metal components
4. Welding leading wire of electronic appliance's shell
5. Welding for hobby

Features

1. The welding pen is independent for convenient to transport and assemble
2. Welding releasing steadily because the welding pen is made of low resistance copper material.
3. The welding pen cooperate with the SUNKKO "7" series to enhance spot welder's function.
4. The replacement welding head is convenient to replace different sizes welding pins.
5. The anti-slip professional pen shape is easy to hold in hand.
6. The pressure balance elastic device inside is good for releasing current to weld.
7. The welding needles are made of alumina alloy and long life to use.



70BN high power removable welding pen

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Parameter of welding pen



The adjustable distance of welding needle	2 ~ 7mm
The total length of removable welding pen	≈580mm
The area of welding pen's cable	16mm²
The size of welding needle	∅1.5mm X 7mm

The parameter of spot welder

Spot welder

Power voltage	AC220V/110V+20V
Power	4.3kw
Welding current	120~1200A
2 pulse time	1~10ms
4 pulse time	2~20ms
8 pulse time	8~80ms



How do we use spot welder?

1. Turn off power. Loosen screws for holding welding needles and adjust the height of welding needles. Fasten screw and adjust welding pressure.
2. Turn on power switch on the back of spot welder. The spot welder is switched on. Press the red WELDING key to turn on welding function.
3. How do we set CURRENT and PULSE?
 - (1) Please turn the current setting knob in clockwise. The higher grade the higher current.
 - (2) There are 3 keys for selecting PULSE.
 - (3) For example we could set 4 pulse and 4-5 current for welding 0.2mm nickel strip when using fixed welding head. We could set 4 pulse and higher current for welding 0.2mm iron strip when using removable welding pen.
4. It is based on thickness of welding material to set current and pulse. Welded on the right spot by fixed welding head or removable welding pen.

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5. Please use external foot pedal switch for welding precisely. The welding control function would be transfer to foot pedal switch when connect with foot pedal switch.

6. It is convenient to expand welding area of spot welder, more flexible welding different places.

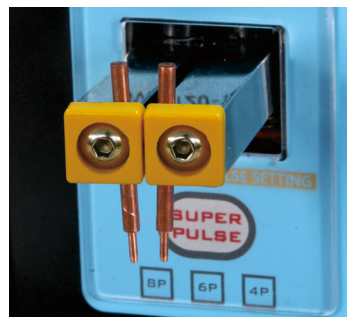
7. Installation way and adjustment of welding needle

- 1) Loosen welding needle clip with hexagon wrench. Put welding needle through the hole of welding needle clip and tighten hexagon screw.
- 2) Loosen hexagon screw slightly for fine tune the distance and angle for welding needle.
- 3) It is the same way for fine tune the height of welding needle.
- 4) Please pay attention to two welding needles and welding needle clips do not touched otherwise the spot welder could not weld.

Installation of welding needles



Before



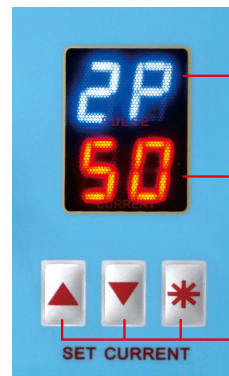
After

8. Welding pressure adjustment



welding pressure adjuster

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 firm and reliable and small diameter for meeting the welding quality requirement.



Standard pulse of P1-P2 selection display

Percentage of current display (0-99 adjustable) corresponding to 120-1200A pulse current

- ▲ UP
- ▼ DOWN
- * CONFIRM

Control board instruction

- The first and second digit show the volume of current. Press “*” key, the first digit will blink, that means the parameter could be adjusted through “UP” and “DOWN”. Press “*” confirm again.
- The second digit will blink, that means the parameter could be adjusted through “UP” and “DOWN”. Press “*” confirm again.
- P1 or P2 will blink for selecting. Please select P1 or P2 through “UP” and “DOWN” to select pulse. P1 means welding once in 1 time. P2 means welding once in 2 times.
- Press “*” confirm again. The spot welder can start to operation when the digits not blink.
- Please select higher current power to weld material which is thicker than 0.1mm. And adjust suitable welding pressure.
- Please refer the sheet to setting current and pulse.

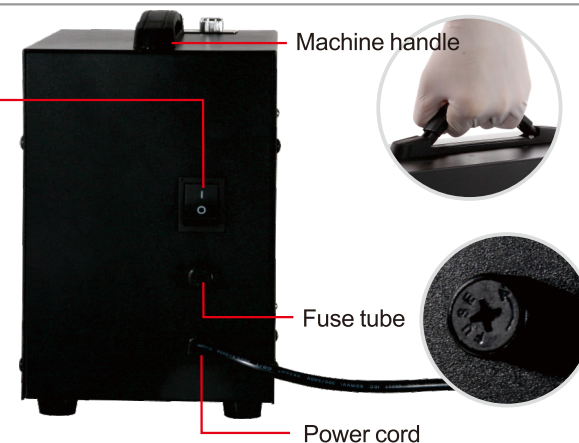


2. Back Side

Power switch

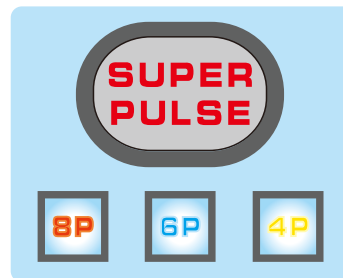
Product parameter

Net Weight: 4.3KG
 Size: 140(length)X230(weight)
 X200mm(height)
 Welding thickness: 0.05~0.3mm



Induction fast setting

It is easy to setting pulse when touch SUPER PULSE slightly by finger.



18P pulse setting

- ◆ It was 2P pulse when not touch SUPER PULSE.
- ◆ It showed 4P pulse when touch SUPER PULSE for the 1st time.
- ◆ It showed 6P pulse when touch SUPER PULSE for the 2nd time.
- ◆ It showed 8P pulse when touch SUPER PULSE for the 3rd time.
- ◆ It showed 4P and 6P pulse (10P pulse) when touch SUPER PULSE for the 4th time.
- ◆ It showed 6P and 8P pulse (14P pulse) when touch SUPER PULSE for the 5th time.
- ◆ It showed 4P, 6P and 8P pulse (18P pulse) when touch SUPER PULSE for the 6th time.
- ◆ The 4P, 6P and 8P pulse will not light up when touch SUPER PULSE for the 7th time. It means that the pulse is 2P.



14P pulse setting