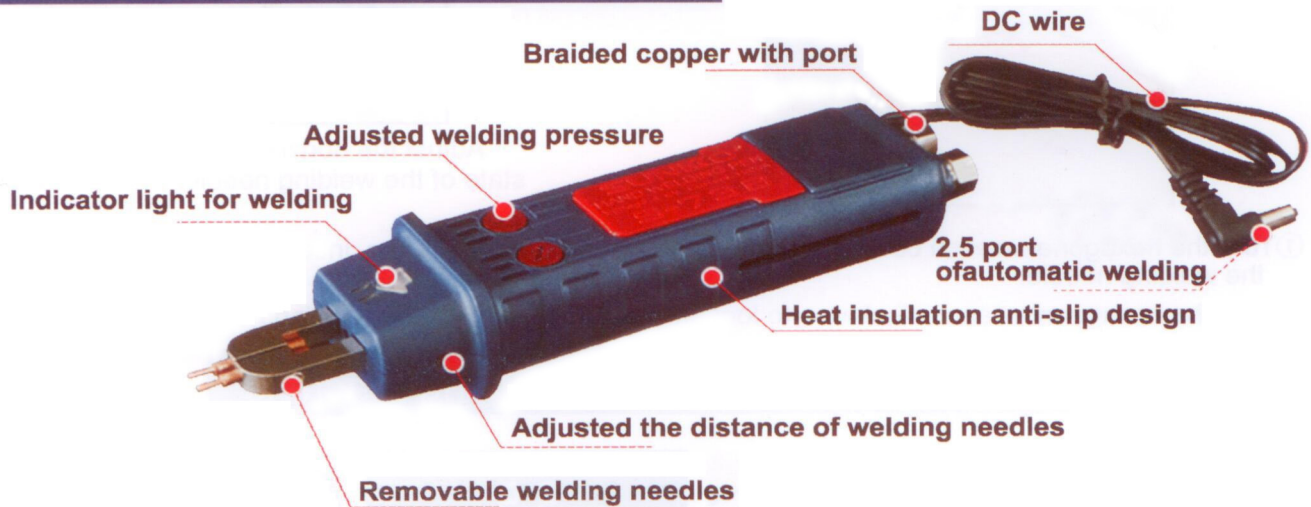


73B Mobile Spot Welding Pen Operation Instructions

Introducing the Spot Welding Pen



Adjustment operation guide

The knob for adjusting the pressure of the welding needle.



Max. pressure is about 1200g. Min. pressure is about 600g.



Suitable for welding 0.3mm nickel sheets.

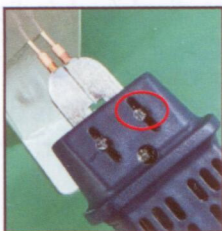


Suitable for welding 0.1mm nickel sheets.

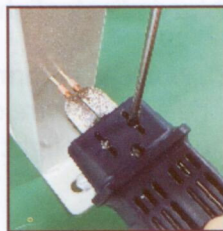
The welding needle pressure needs to be consistent, so as to avoid affecting the spot welding effect with one heavy and one light weight.

Note: The adjustment range of the pressure knob is within 270°. If it exceeds the range, it will be limited and can't be adjusted. If it exceeds the range and is adjusted forcefully, it will cause damage to the pressure system. Please adjust it carefully.

Adjusting the welding needle pitch



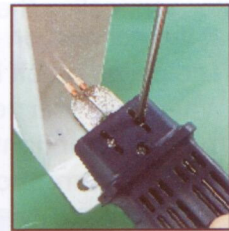
① Press the welding needle head to the hole position fixed by the screw.



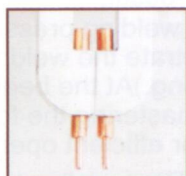
② Loosen the two screws of the welding needle clamp seat.



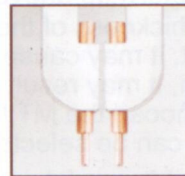
③ Adjusting the screws of needle pitch on the left and right sides of the welding needle.



④ Adjust to the appropriate needle pitch and tighten the large screw.

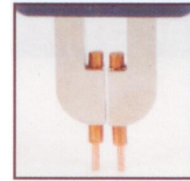
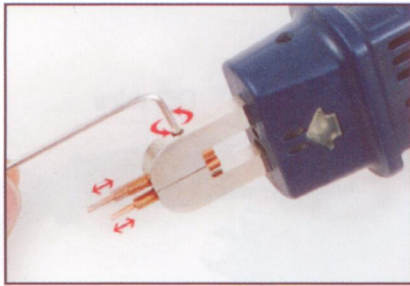


The shortest needle pitch is 3mm



the longest needle pitch is 7mm.

Detachable welding needle/adjustable welding needle balance



Adjust the horizontal state of the welding needle

- ① Turn the hexagonal wrench counterclockwise to loosen the screw. Then, insert or unscrew the welding needle.
- ② Turn the hexagonal wrench clockwise to loosen the screw and lock the welding needle for fixation.

Connect the spot welding pen to the spot welding machine



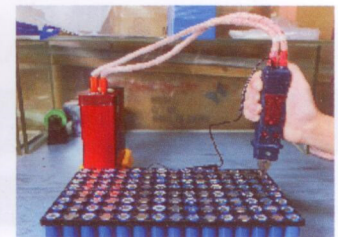
1. Connect the copper strip of the spot welding pen to spot welding machine.



2. Connect the DC cables of the spot welding pen to spot welding machine.

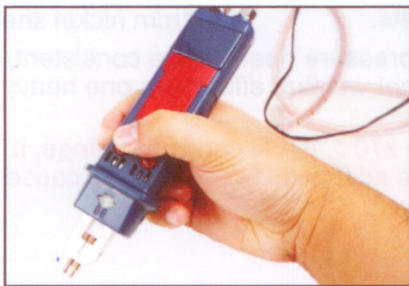


3. Set the spot welding mode to the MT manual mode.



4. Operation of pressing down to trigger spot welding

Dual color real-time spot welding work indicator light



Blue indicator light



Red work indicator light

After connecting the spot welding machine, a red/blue indicator light will be displayed, indicating that the connection is normal:

- ① The power on/off indicator lights will both light up, which is a normal occurrence.
- ② When the total negative electrode position of the copper wire connection device is different, the indicator light will turn on red/blue, and the indicator light will turn off when there is welding current output.

Precautions for spot welding operation

1. The welding needle of the spot welding pen should be pressed tightly on the welding work piece at the same time, otherwise uneven welding points may occur.
2. Depending on the thickness of the weldments, different welding pressures can be applied. (If the pressure is too light, it may cause false welding to penetrate the weldments. Conversely, if the pressure is too high, it may result in unstable spot welding.) At the beginning of welding, it is recommended to choose the MT foot mode first. After mastering the force, the AT automatic induction spot welding mode can be selected, which is suitable for efficient operation.
3. When spot welding, be careful not to touch the two welding needles together. Otherwise, a short circuit may occur and the machine may be damaged