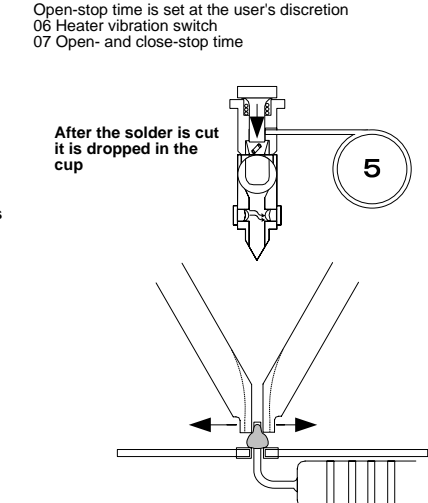
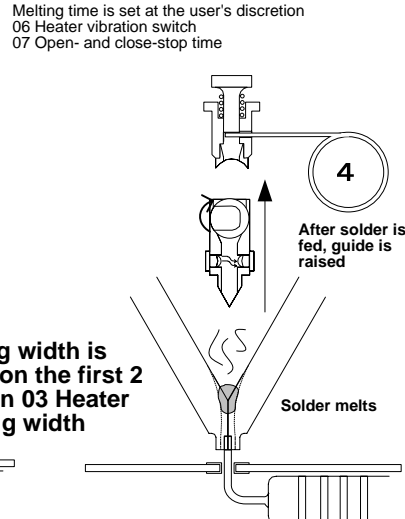
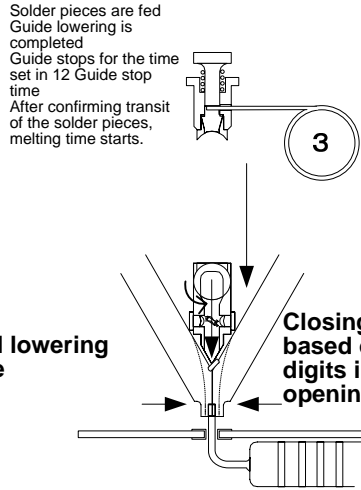
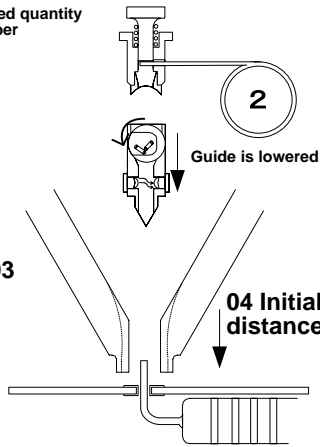
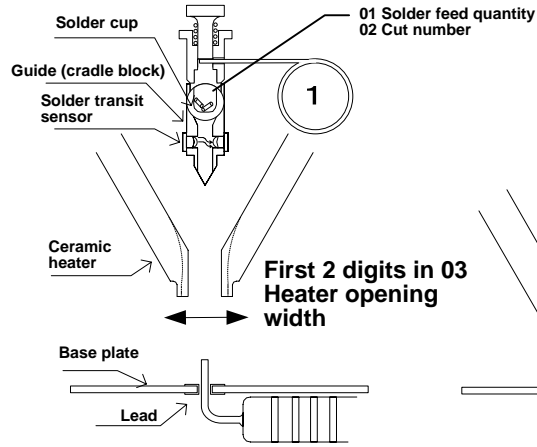


# Point Soldering Unit Operating Principles Reference Data

Work model: First 2 digits of 00 block & mode  
 Soldering: Set 07 in 00 block & mode (standard)  
 Not using data or end mark: Set 0000 in 00 block & mode



Preparing to solder. Heater opens.

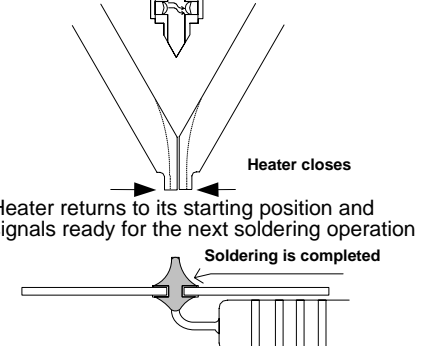
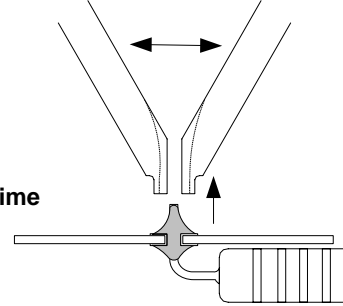
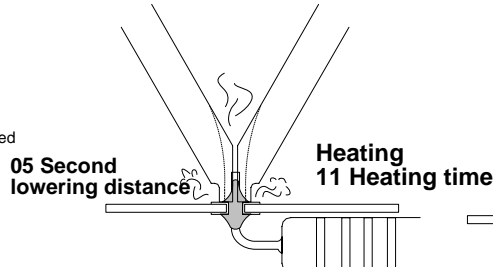
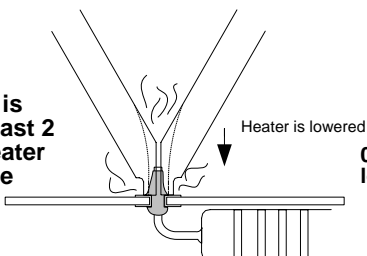
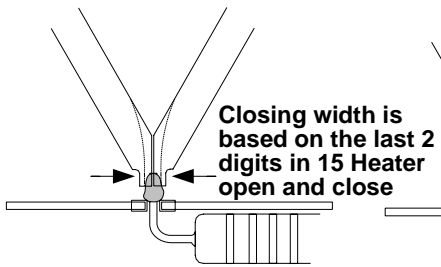
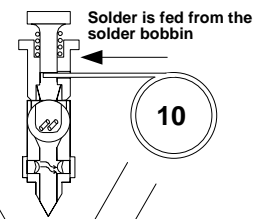
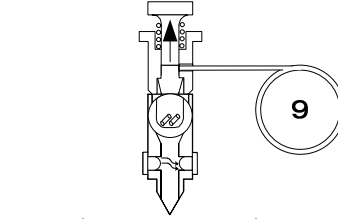
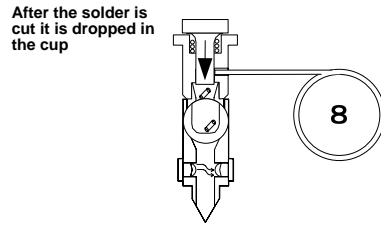
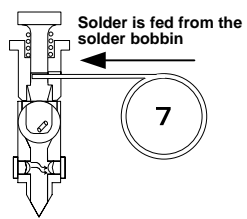
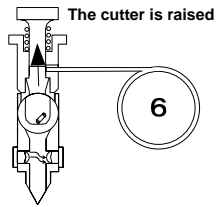
Initial lowering of heater and guide

Heater closes and solder is fed

Solder melts and guide is raised

The next piece of solder is cut. The heater opens and the solder drops.

First 2 digits in 15 Heater open and close  
 Opens for the time set in 10 Open-stop time



After solder drops the heater closes.

Second lowering of heater. Begins heating of the solder and pattern

Heating

After heating, heater opens and is raised

Soldering is completed. Waiting for the next point.