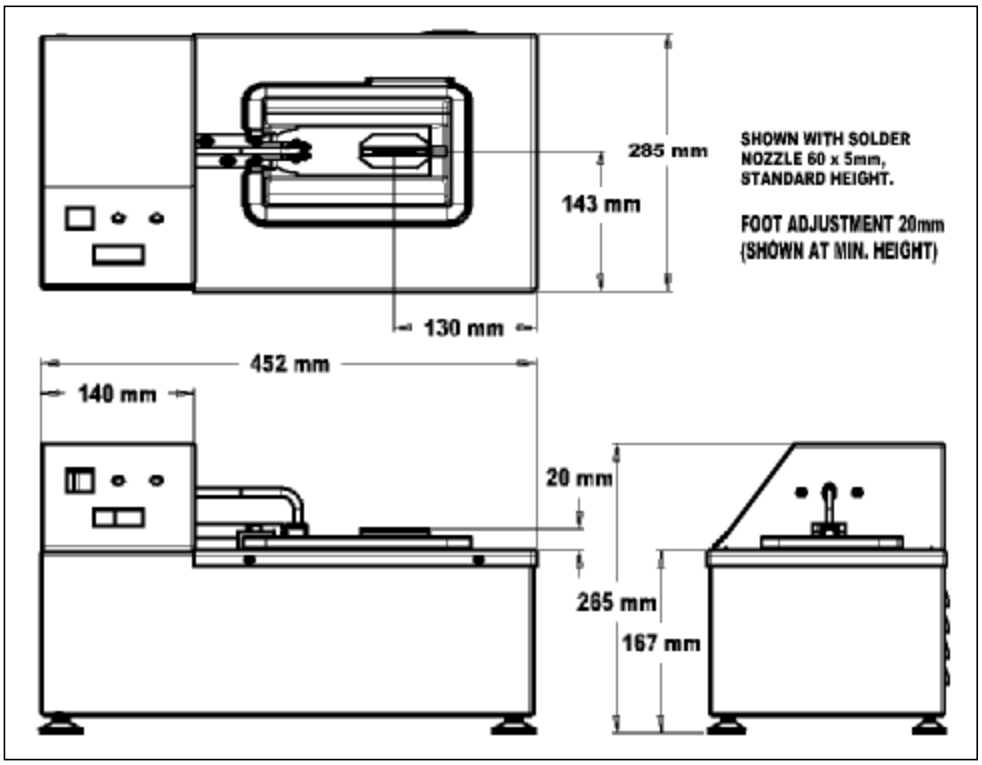
High temperature Wave Soldering Machine, model HT-M2+/LF

Eurotubes UK manufactures bench top pumped wave soldering machine for leaded and lead-free solders, suitable for operation up to 550°C/1020°F. 2000 watts heating and PID temperature control maintain operating temperature within 4°C/8°F of setpoint.
Titanium solder nozzles can be selected from a standard range or custom-made. Applications include bobbin and odd-form component soldering, lead and component preparation.



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VAT Reg No. 730 1445 74

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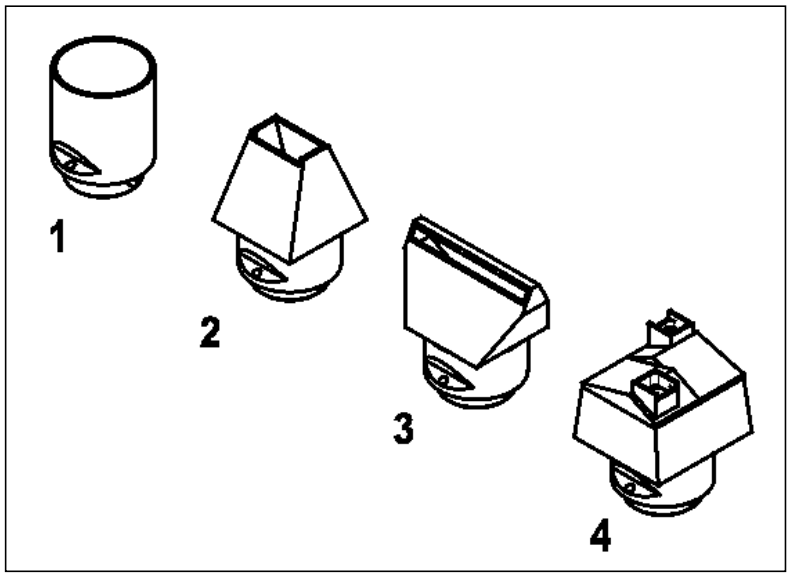
Specification

Maximum operating temperature	550°C/1020°F
Variation at set-point	± 4°C/ ± 8°F at steady state solder flow.
Temperature control	CAL Controls P.I.D. controller, type 3300
Solder types	Leaded and lead-free
Solder capacity	1.0 litre
Supply voltage	220 – 240 Vac 1ph, 50 – 60 Hz
Maximum consumption	Total 10A; heaters 8A
Overall size	452mm x 285mm x 265mm high. Height adjustment approx. 20mm.
Weight (without solder)	19 kg
Shipping weight	22 kg
Dimensions for shipping	570mm x 400mm x 490mm high
Heaters	2 x 1000W cartridge heaters
Time to reach operating temperature	35 minutes (typ, 450°C/840°F target temperature)
Construction	Casing: stainless steel Materials in contact with solder: cast iron, titanium
Pump drive	Permanent magnet motor 60W output power. Drive enabled on reaching operating temperature.
Controls	Footswitch, rotary speed control, temperature set-point.
Operating modes	**Mode#1**: Default mode, operation at speed set on rotary control when footswitch is pressed. **Mode#2**: Custom mode with selectable acceleration, deceleration and idle speed. **Remote operation mode (factory fit option)**: Remote selection of idle, run and maximum speeds.

Solder nozzles



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Solder nozzles are fabricated in grade 2 titanium. They are located by a bayonet fitting and locked in position with a screw. Precise and repeatable positioning is achieved by using fully machined locations for the solder nozzle and the solder pump and its location in the crucible.
The design and size of the nozzle will depend on each application. Stock nozzle sizes will accommodate a large number of general applications

Style	Standard sizes (mm)	Size range (mm)	Typical Applications
1. Circular	Ø25; Ø34; Ø36	Ø20 – Ø40	Lead and component hand solder dipping. Can be sloped to promote side flow.
2. Rectangular	40 x 3; 45 x 3 60 x 5; 70 x 5; 75 x 5 50 x 7; 70 x 7 75 x 8 10 x 10; 25 x 10; 60 x 10 20 x 20	100mm max length; 600mm^2 maximum cross section.	Bobbin terminal soldering.
3. Letter box	45 x 3 45 x 4; 60 x 4 30 x 5; 45 x 5; 60 x 5	Height 3 – 5mm; 300mm^2 maximum cross section.	'Curtain' soldering of terminals or components requiring single-sided soldering.
4. Custom design	Bobbin terminal soldering where precise solder flow is required. Odd-form component soldering on circuit boards.		

We can advise on nozzle selection from component samples or drawings.
Solder nozzles are normally made so that they project approximately 10mm above the rim of the solder crucible. Alternative heights can be specified. We do not normally recommend an increase of height of more than 15mm.

Other machine options.

- Supervisory software for logging actual solder temperature. This requires a factory-fitted modification to the temperature controller.
- Manual, air/manual and air-operated handling devices for component loading.

Soldering machines are supplied with a mains connection lead to suit the country of use and full operating and maintenance instructions. They are backed by an extensive spare parts stock.

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