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> Qiterr Sunkko 709A Li Battery Spot Welder Instruction Manual

Qiterr 709A

Qiterr Sunkko 709A Li Battery Spot Welder Instruction Manual

Model: 709A | Brand: Qiterr

1. INTRODUCTION

The Qiterr Sunkko 709A is a versatile Li battery spot welder and circuit board soldering machine designed for various applications including welding rechargeable batteries, button batteries, and repairing/assembling Li battery packs and power banks. It is also suitable for welding stainless steel, iron, nickel, and other hardware accessories. This manual provides essential information for safe and effective operation.

2. SAFETY INFORMATION

- Always wear appropriate personal protective equipment (PPE), including safety glasses and gloves, when operating the spot welder or soldering iron.
- Ensure the work area is well-ventilated to avoid inhaling fumes from soldering.
- Keep the device away from flammable materials and liquids.
- Do not touch the welding needles or soldering iron tip when hot. Allow them to cool completely before handling.
- Disconnect the power supply before performing any maintenance or cleaning.
- Do not operate the device if any part is damaged or malfunctioning. Contact customer support for assistance.
- Keep out of reach of children.

3. PACKAGE CONTENTS

Verify that all items listed below are included in your package:

- 1 x Sunkko 709A Spot Welder Unit
- 1 x User Manual
- 1 x Spot Welding Pen (movable)
- 1 x Soldering Iron Pen
- 1 x Soldering Iron Stand

- 1 x Foot Switch
- 1 x 6S 18650 Battery Clamp
- 1 x Hex Wrench
- 2 x Fuse
- 4 x Welding Needle for Fixed Welding Head
- 2 x Welding Needle for Spot Welding Pen
- 50 x Nickel Plated Sheet (0.1*4*100mm)
- 50 x Nickel Plated Sheet (0.15*8*100mm)

4. PRODUCT OVERVIEW

Familiarize yourself with the main components and controls of the Sunkko 709A unit.

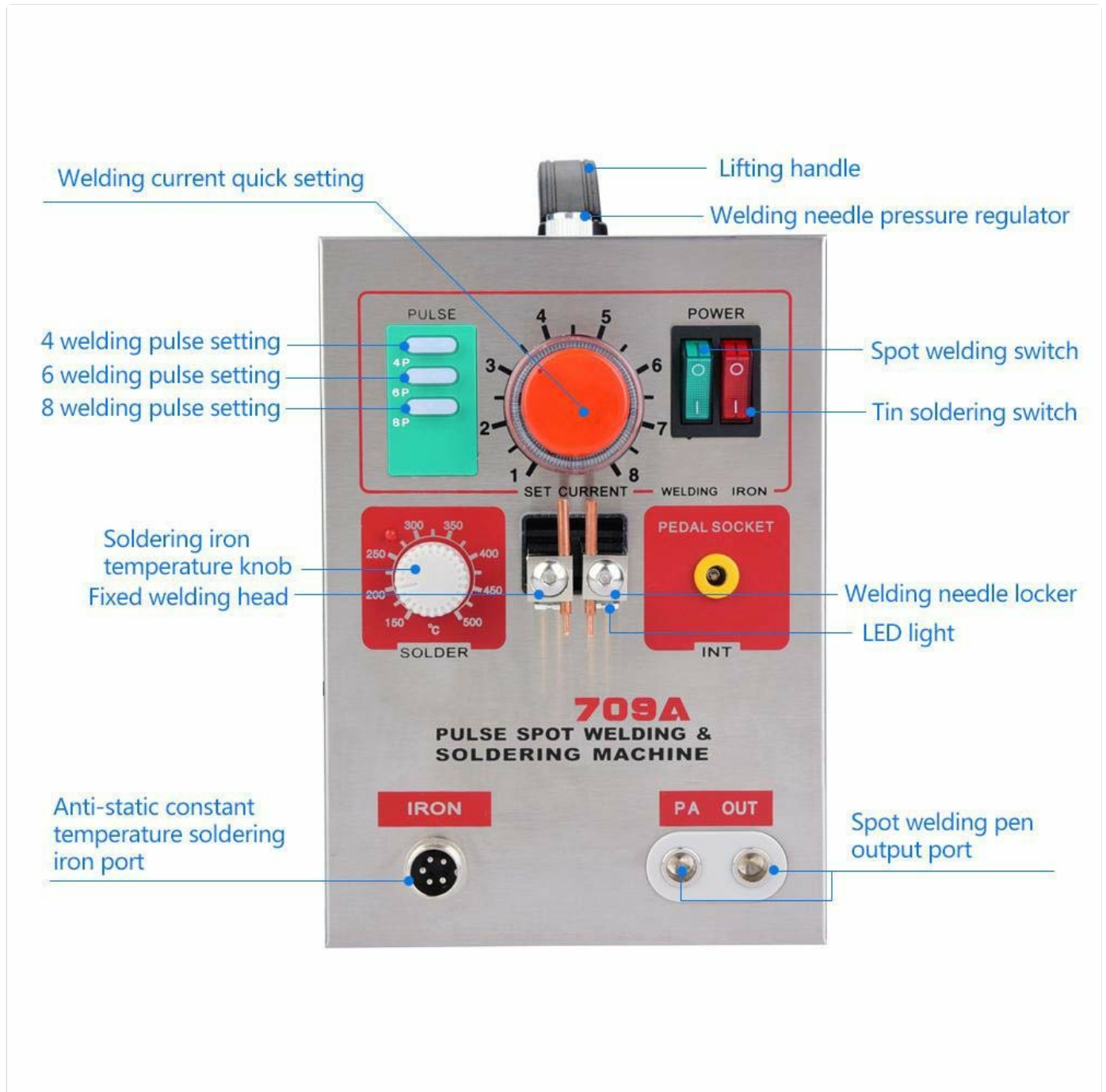


Figure 4.1: Front panel of the Sunkko 709A spot welder, showing the welding current quick setting knob, pulse setting buttons, spot welding switch, tin soldering switch, soldering iron temperature knob, fixed welding head, welding needle locker, LED light, anti-static constant temperature soldering iron port

constant temperature soldering iron port, and spot welding pen output port.



Figure 4.2: Side view of the Sunkko 709A spot welder, highlighting the lifting handle for portability and the foot pedal switch for accurate and reliable welding spots.



Figure 4.3: Front view of the Sunkko 709A spot welder with the LED light illuminated, demonstrating its function for accurate spot welding in low-light environments.



Figure 4.4: Dimensions of the Sunkko 709A spot welder, showing approximate measurements of 200mm (7.9in) height, 140mm (5.5in) width, and 245mm (9.6in) depth.

5. SETUP

1. **Unpacking:** Carefully remove all components from the packaging. Retain the packaging for future storage or transport.
2. **Placement:** Place the spot welder unit on a stable, flat, and non-flammable surface in a well-ventilated area.
3. **Power Connection:** Connect the power cord to the unit and then to a suitable power outlet (AC 110/220V).
4. **Fixed Welding Head Setup:**
 - Ensure the 4 welding needles for the fixed welding head are securely installed.
 - Adjust the welding needle pressure using the regulator for optimal contact with the workpiece.
5. **Spot Welding Pen Setup:**

- Connect the movable spot welding pen to the designated output port.
- Ensure the 2 welding needles for the spot welding pen are properly inserted.
- Connect the foot switch to the "PEDAL SOCKET" for hands-free operation.

6. Soldering Iron Setup:

- Connect the soldering iron pen to the "IRON" port.
- Place the soldering iron pen in its stand when not in use to prevent accidental burns.

6. OPERATING INSTRUCTIONS

6.1 Powering On/Off

Press the main power switch (labeled "POWER") to turn the unit ON or OFF. The LED indicators will illuminate upon power-on.

6.2 Spot Welding Operation

1. **Select Welding Mode:** Use the "WELDING" switch to activate the spot welding function.
2. **Adjust Welding Current:** Rotate the "SET CURRENT" knob to adjust the welding current from 50A to 800A. Start with lower settings and gradually increase as needed for your material thickness.
3. **Set Pulse Time:** Use the "PULSE" buttons (2, 4, 8 pulse) to select the desired pulse time.
 - 2 Pulse Time: 1-10ms (Adjustable)
 - 4 Pulse Time: 2-20ms (Adjustable)
 - 8 Pulse Time: 8-80ms (Adjustable)

Note: The pulse settings determine the duration and intensity of the weld. Experiment with scrap material to find the optimal setting for your application.

4. **Position Workpiece:** Place the nickel strip and battery (or other workpiece) securely under the fixed welding head or position them for the movable spot welding pen. Ensure good contact.
5. **Execute Weld:**
 - For the fixed welding head, press the foot switch to initiate the weld.
 - For the movable spot welding pen, apply pressure with the pen tips to the desired spot and then press the foot switch.

The LED lighting function assists in accurate spot welding in low-light environments.

6. **Inspect Weld:** After welding, inspect the joint for strength and consistency. Adjust settings if necessary.

6.3 Soldering Iron Operation

1. **Activate Soldering Mode:** Use the "IRON" switch to activate the soldering iron function.
2. **Set Temperature:** Rotate the "SOLDER" temperature knob to set the desired temperature (150-450°C). The soldering iron has an accuracy of $\pm 5^{\circ}\text{C}$ and heats up to 300°C in 6-8 seconds.
3. **Pre-tinning:** Apply a small amount of solder to the tip of the soldering iron to ensure good heat transfer.
4. **Solder Connection:** Apply the hot soldering iron tip to the joint to be soldered, then feed solder into the joint. Allow the solder to flow and create a strong connection.
5. **Cool Down:** Return the soldering iron to its stand after use and allow it to cool completely.

7. SPECIFICATIONS

Feature	Specification
Model	709A
Input Voltage	AC 110/220V
Power (Instantaneous)	3.2Kw
Spot Welding Current	50~800A
2 Pulse Time	1-10ms (Adjustable)
4 Pulse Time	2-20ms (Adjustable)
8 Pulse Time	8-80ms (Adjustable)
Fixed Head Spot Welding Range	0.05~0.35mm
Spot Welding Pen Welding Range	0.05~0.2mm
Soldering Iron Temperature	150-450°C
Soldering Iron Accuracy	±5°C
Soldering Iron Output Voltage	20VDC
Soldering Iron Temp. Rise Time (to 300°C)	6-8 seconds
Spot Welding Pen Welding Spot Pitch	2-7mm (Adjustable)
Welding Cable Sectional Area	16mm ²
Item Weight	6.21 kg
Product Dimensions	1 x 1 x 1 cm (Note: This dimension seems generic, refer to Figure 4.4 for more specific unit dimensions)

8. MAINTENANCE

- **Cleaning:** Regularly clean the welding needles and soldering iron tip to remove any residue. Use fine-grit sandpaper or a specialized tip cleaner for the soldering iron.
- **Storage:** Store the unit in a dry, cool place away from direct sunlight and moisture.
- **Inspection:** Periodically inspect all cables, connections, and the unit housing for any signs of damage. Replace worn or damaged parts immediately.
- **Needle Replacement:** Replace welding needles when they become worn or pitted to ensure consistent weld quality.

9. TROUBLESHOOTING

- **Poor Weld Quality:**
 - Check welding current and pulse time settings. Adjust as necessary.

- Ensure welding needles are clean and sharp. Replace if worn.
- Verify proper contact between the workpiece and welding needles.
- Clean the surface of the nickel strip and battery terminals.

- **Soldering Iron Not Heating:**

- Ensure the soldering iron is properly connected to the unit.
- Check the temperature setting.
- Verify the "IRON" switch is activated.

- **Unit Not Powering On:**

- Check the power cord connection and ensure it's plugged into a live outlet.
- Verify the main power switch is in the ON position.
- Check the fuses. Replace if blown.

10. WARRANTY AND SUPPORT

For warranty information, technical support, or service inquiries, please refer to the contact details provided by the manufacturer or your point of purchase. Keep your purchase receipt as proof of purchase.