

SUNKKO 737DH

SUNKKO 737DH Battery Spot Welder Instruction Manual

Model: 737DH | Brand: SUNKKO

INTRODUCTION

This manual provides comprehensive instructions for the safe and efficient operation of your SUNKKO 737DH Battery Spot Welder. This portable and multifunctional equipment is designed for precision pulse welding, ideal for building 18650, 14500, and other lithium battery packs, as well as various metal welding applications.

KEY FEATURES

- First design with delayed welding function, offering 3-level power adjustment for precise welding.
- Induction automatic current release mode, specifically suited for battery pack welding.
- Adjustable pulse power knob to accommodate various welding part thicknesses.
- Real-time monitoring of current output via the display.
- Supports two welding modes: fixed welding head and movable welding pen.

PRODUCT OVERVIEW



Front view of the SUNKKO 737DH Spot Welder, showcasing the control panel and fixed welding head.



The SUNKKO 737DH Spot Welder connected to the mobile welding pen, offering flexibility for various welding tasks.

SUNKKO®

Precise Adjustment Battery Spot Welder

Welding effect of welding pen



Welding effect of welding head



Automatic Spot Welding

4.3KW

The spot welder setup, including the mobile welding pen and the foot pedal for hands-free operation.



AT

Press the AT/MT switch button, when 'AT' on the panel turns to green, automatic welding mode is ready



MT

Press the AT/MT switch button again, when 'MT' on the panel turns to red, spot welding with foot pedal switch is ready



Detailed view of the control panel, highlighting the AT (Automatic) and MT (Manual) welding modes.

'AT' Mode Time-lapse Spot Welding

Intelligent time delay function, 0.4s/0.5s/0.6s three settings are optional, superposition up to 1.5s.

0.4s

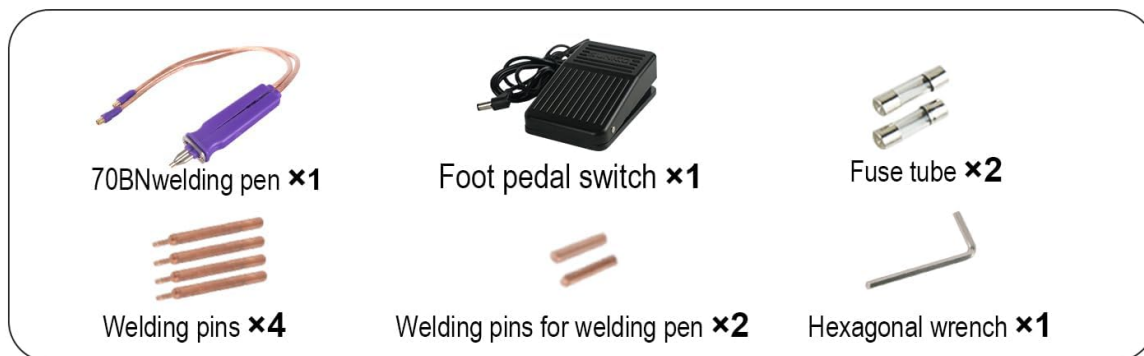
0.5s

0.6s



Illustration of the time-lapse spot welding feature, showing adjustable delay settings.

Packing List



Contents included in the product package, such as the welding pen, foot pedal, and nickel samples.

Official Product Tutorial Video

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This tutorial video from SUNKKO provides a detailed demonstration of the 737DH Battery Spot Welder's features and operation, including setup, mode selection, and various welding applications. (Duration: 4:29)

SETUP

- Power Connection:** Ensure the unit is placed on a stable, flat surface. Connect the power cord to the machine and a suitable power outlet.
- Main Power Switch:** Locate the main power switch on the backside of the machine and turn it to the 'ON' position. The LED light on the front panel will illuminate.
- Power Button:** Press the 'POWER' button on the front panel to initiate the spot welding function.
- Welding Head/Pen Installation:**
 - Fixed Welding Head:** For the fixed welding head, adjust the pressure controlling knob to secure the welding needles.

- **Mobile Welding Pen (S-70SN/S-70BN/S-71A/S-71B):** Plug the mobile welding pen securely into the designated port on the front panel. If using a foot pedal, connect it to the corresponding port on the backside of the machine.

OPERATING INSTRUCTIONS

Understanding the Display and Controls

- The top screen displays the actual output current during welding.
- The second screen displays the welding current range and the number of pulses.
- Press the '*' button to adjust the corresponding twinkling value on the display.
- Press the 'T' button to select multiple time-delay spot welding settings (e.g., 0.4s, 0.5s, 0.6s, up to 1.5s superposition).
- Press the 'P' button to set the pulse numbers (2-18 pulses).
- Use the 'AT/MT' button to switch between Manual (MT) and Automatic (AT) spot welding modes.
- The 'SUPER PULSE' knob adjusts the pulse current for higher output, allowing for welding of thicker nickel strips.

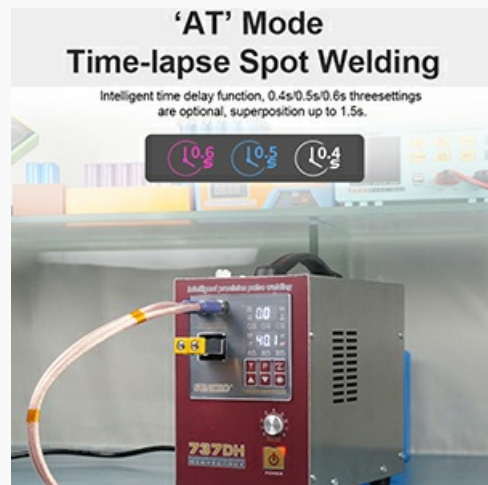
Welding Modes and Applications

1. Automatic (AT) Mode:

In AT mode, the output welding current is automatically triggered when the welding pen touches the welding part, eliminating the need for a switch. This mode is ideal for efficient, continuous welding of battery packs.



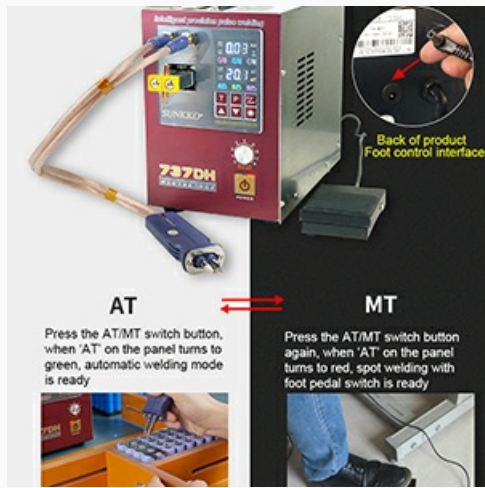
Welding a small-sized lithium-ion battery pack using the mobile welding pen in AT mode.



Welding a 10S lithium-ion battery pack, demonstrating the versatility for different battery configurations.

2. Manual (MT) Mode with Foot Pedal:

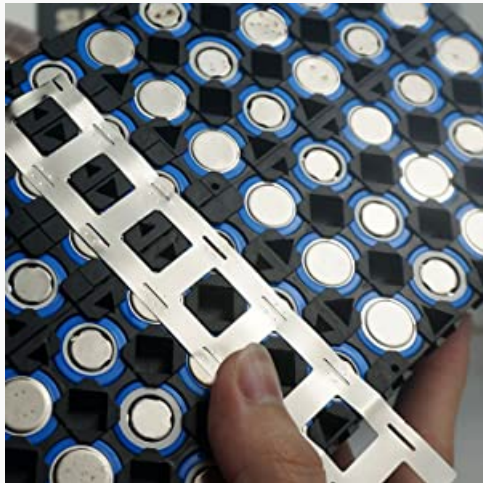
In MT mode, welding is activated by pressing the foot pedal switch. This provides precise control over the welding process, ideal for specific applications or when fine control is required.



Spot welding large single power batteries after nickel conversion, showcasing the machine's capability for series and parallel welding.

3. Welding Various Materials:

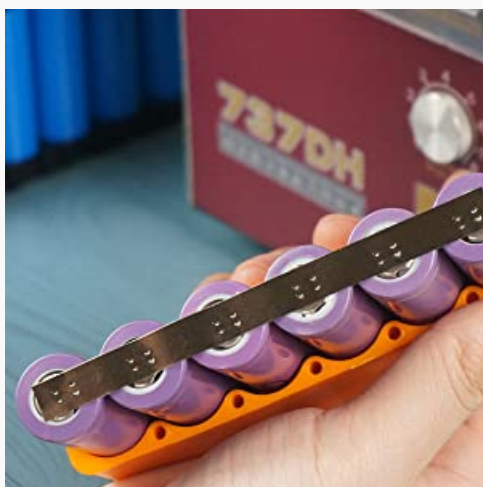
Beyond batteries, the 737DH can weld various materials like stainless steel, iron, and nickel. This includes mobile phone internal parts, stainless steel sheets, and iron sheets.



Demonstration of welding mobile phone internal parts, highlighting the machine's versatility.



Welding stainless steel mesh, filter, and other stainless steel parts.



Welding the positive electrode of a polymer lithium battery, demonstrating conversion to nickel.

4. Specialized Welding Pens:

- **S-71A Welding Pen:** Features a smaller welding needle, ideal for small welding surface products

and positive electrode caps of lithium batteries.

- **S-71B Welding Pen:** Designed for welding stainless steel mesh, filters, and other stainless steel parts.

MAINTENANCE

- Regularly inspect welding pins for wear and replace as needed to ensure optimal performance.
- Keep the welding area and machine clean from debris and metal particles.
- Store the unit in a dry, cool environment away from direct sunlight and excessive dust.
- Ensure proper ventilation during operation to prevent overheating.

TROUBLESHOOTING

- **No Power:** Check power cord connection, main power switch, and ensure the 'POWER' button is pressed.
- **Weak Welds:** Adjust the 'SUPER PULSE' knob for higher current. Ensure welding pins are clean and making good contact with the material. Verify correct pulse and time-delay settings for the material thickness.
- **Inconsistent Welds:** Check for stable power supply. Ensure welding pins are not worn or misaligned. Clean the welding surface of the material.
- **Foot Pedal Not Responding (MT Mode):** Ensure the foot pedal is securely connected to the machine.

SPECIFICATIONS

Attribute	Value
Manufacturer	SUNKKO
Part Number	737DH
Item Weight	14.63 pounds
Package Dimensions	15.75 x 14.53 x 8.98 inches
Power Source	AC
Batteries Included	No
Batteries Required	No
Date First Available	September 12, 2020



Packing List





- SUNKKO 737DH Spot Welder Unit x1
- 70BN Welding Pen x1
- Foot Pedal Switch x1
- Fuse Tube x2
- Welding Pins x4
- Welding Pins for Welding Pen x2
- Hexagonal Wrench x1
- Mini Grinder x1 (Gift)
- Six-cells Battery Clamp Fixture x1 (Gift)
- Nickel Samples x100 pcs (Gift)

Warranty and Support

For warranty information, technical support, or service inquiries, please refer to the official SUNKKO website or contact your authorized dealer. A detailed user manual in PDF format is also available for download: [User Manual \(PDF\)](#).

Related Documents - 737DH

	<p>SUNKKO 737DH Spot Welder: User Manual and Features</p> <p>Comprehensive guide to the SUNKKO 737DH spot welder, covering its features, usage, troubleshooting, and maintenance. Learn about its induction automatic welding, delayed welding, and pulse power adjustment capabilities.</p>
	<p>Sunkko 709AD Battery Spot Welder with Soldering Function - User Manual & Specifications</p> <p>Detailed information on the Sunkko 709AD battery spot welder, including specifications, welding capabilities, soldering features, operating instructions, packing list, safety notices, and support contact.</p>

	<p>SUNKKO D1524 Lithium Battery Pack Equalizer & Analyzer User Manual</p> <p>This user manual provides detailed instructions for the SUNKKO D1524 Lithium Battery Pack Equalizer & Analyzer. It covers features, product parameters, equilibrium principles, wiring diagrams, precautions, and operational steps for both discharge and charge equalization modes. The device is designed for detecting, analyzing, and equalizing lithium battery packs up to 24 strings.</p>
	<p>Инструкция по эксплуатации сварочного аппарата SUNKKO 737DH</p> <p>Подробное руководство пользователя сварочного аппарата SUNKKO 737DH, охватывающее его конструкцию, эксплуатацию, настройки, режимы сварки, подключение и обслуживание.</p>
	<p>Инструкция по эксплуатации анализатора аккумуляторов SUNKKO T688</p> <p>Руководство пользователя многофункционального интеллектуального анализатора аккумуляторов SUNKKO T688. Описывает общие сведения, особенности, области применения, функции кнопок, эксплуатацию, методики тестирования литиевых и Ni-MH аккумуляторов, измерение эффективности Power Bank, комплект поставки и важные указания по безопасности.</p>
	<p>SUNKKO 709-Plus Battery Spot Welder: Specifications and Notice</p> <p>Discover the SUNKKO 709-Plus, a portable and multifunctional battery spot welder for 18650 and 14500 lithium battery pack building. This overview includes key specifications and notices for the welding machine.</p>