

F-NIRSI 菲尼瑞斯

SWM-10

便携式智能彩屏点焊机

PORTABLE INTELLIGENT COLOR SCREEN SPOT WELDING MACHINE



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NOTICE TO USERS

- This manual introduces the usage method, precautions and related matters of the product in detail. Before using the product, please read the manual carefully so as to give full play to the best performance of the product.
- Do not use the device in a flammable or explosive environment.
- The used battery for replacement of the device and the scrapped device cannot be disposed of together with domestic waste, please dispose according to relevant national or local laws and regulations.
- When there is any quality problem with the device or you have questions about the use of the it, you can contact FNIRSI online customer service or manufacturer, we will solve it for you in the first time.

1.PRECAUTIONS

- Be sure to read this manual and related safety information before using the product. Users should fully understand and operate in accordance with the relevant instructions.
 - Do not use this product in a flammable or explosive environment, which may cause sparks, ignite dust or smoke.
 - There may be sparks from the tip of the pen during spot welding, please pay attention to protection.
- ※ **Special statement: The company does not assume legal responsibility for any derivative results of using this product.**

2.PRECAUTIONS

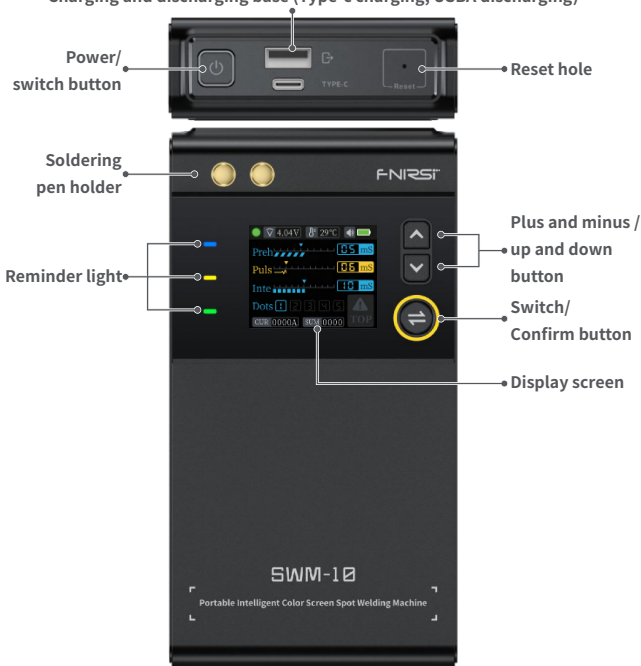
- Do not press the nickel strip hard for welding, otherwise it will cause false welding and the solder joints will not be firm. The correct way is to lightly press the nickel strip to ensure the best fit to the surface of the battery.
- If the battery voltage is too low, it may lead to poor welding or even welding failure. Please fully charge the battery before welding.
- Soldering while charging is not recommended, as it is easy to damage the charging chip.

- The soldering pen is easy to produce black oxide after using for many times, please use it after polishing with sandpaper.

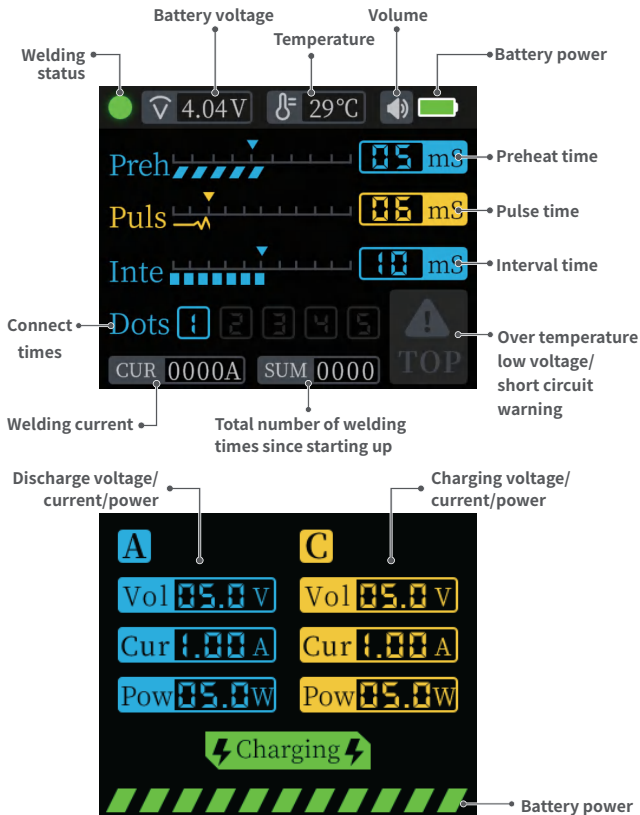
3.PRODUCT INTRODUCTION

The portable handheld spot welding machine is an efficient, convenient and easy-to-carry spot welding tool. Double pulse spot welding technology is adopted to make the welding more stable and firm, and it also has the function of power bank.

Charging and discharging base (Type-c charging, USB-A discharging)



4.INTERFACE INTRODUCTION



5. OPERATION INSTRUCTIONS




Preheat Pulse: Briefly heats the electrode to a predetermined temperature before spot welding. (2ms is the best by default.)

Main pulse: During the spot welding process, the equipment will output a short high-energy pulse to generate enough welding heat, and at the same time avoid overheating of the electrode and excessive current to cause the material to burn through or melt. (According to the actual situation, adjust the main pulse size, if it is too large, it will be directly welded through, and if it is too small, it will not weld firmly).

Interval time: In order to avoid too long thermal process, overheating of the electrode and premature withdrawal of the joint, it is necessary to set the time interval between spot welding pulses to ensure the welding success rate and welding quality. (On the uneven surface, after the preheating pulse softens the material, there may be insufficient interval time, resulting in the nickel strip not sticking to the battery surface)

Number of connection points: To strengthen the solder joints. After the soldering pen touches, it will weld N times continuously. The default is 1. When welding thick nickel sheets, the number of connection points can be changed appropriately to achieve around the reinforcement of solder joints, but it cannot break through the maximum welding thickness.

6. KEYS DESCRIPTION

Button	Short press	Long press
	Welding/charging treasure function switching	On and off
	Addition/subtraction/ up/down selection	Null
	Welding interface parameters option switching, setting interface confirmation/exit.	Enter/exit settings page

7. INDICATOR LIGHT DESCRIPTION

LED light 1:

The charging treasure discharges, it is always on when the battery is full, and flashes when the battery is low.

LED light 2:

When the two soldering pens are placed on the welding object, it will be on, and it will be off when they are away.

LED light 3:

When the power bank is charging, it flashes, and it is always on when it is fully charged.



8. PARAMETERS

Capacity	5000mAh
Charge	5V/2.1A
Discharge	5V/2.1A
Welding materials	Nickel sheet, iron sheet, stainless steel sheet
Welding thickness	0.1-0.25mm
Maximum welding current	1200A
Gear	4 combination gear adjustment

9.MAINTENANCE INSTRUCTIONS

- Do not disassemble the device parts or modify the device without authorization. Unprofessional disassembly will damage the device.If the device is damaged, please contact your local dealer.
- Do not dispose of this product together with domestic waste, and dispose of discarded devices or components in strict accordance with local regulations.

10.CONTACT US

Any FNIRSI' users with any questions who comes to contact us will have our promise to get a satisfactory solution + an Extra 6-Month warranty to thanks for your support!

By the way, We have created an interesting community, welcome to contact FNIRSI staff to join our community.

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