XINGDA

SSJ SERIES
WIRE FEEDER

OPERATION MANUAL

CHINA COMPULSORY PRODUCT CERTIFICATION

NANJING TOPREACH ELECTRICIAN MACHINERY CO.,LTD

SSJ SERIES WIRE FEEDER
OPERATION MANUAL

The SSJ series products we provide are quality-leading in the line of welding machine and interchangeable with the same species aboard, which gained Certificate for ISO9001 Quality System Registration and China Compulsory Product Certification(ccc), thus basically reached international advanced level and shared high prestige for many years in customers in mainland and aboard。

1. Application and Characteristic

SSJ series are suitable for continues wire feeding for Carbon-dioxide, Argon, and mixed gas shield arc welder in different wire diameter and feeding speed。

Classified into two series (print motor and magneto motor) including several types as a whole. SSJ series are self-developed in both structure and process on the basis of international advanced technology and shares many advantages such as extra strong feeding power: mini-sized, structure-utilized, light-weighted, easy to install, interchangeable, feeding pressure adjustable, and so on.

Customers can enjoy both the superior performance of SSJ and our prompt service for its accessorles.

2. Structure and principle

Structure: SSJ is made up of driving motor, reduction gearbox,writrollers,roller compressor, pressute adjusting system, wire guide and bracket, (Diagram 1-Diagram17).

Principle: After being guide into compressed by the compressor, the writ can be automatically fed into the welding gun for continues welding.

3. Specifications (Attached Table No.1)

Table No.1

Type of feeding channel	Suitable diameter of wire roller(mm)
V type	0.6~0.8 0.8~1.0 1.0~1.2 1.2~1.6
U type	0.8~1.0 1.0~1.2 1.2~1.6 1.6-2.0 2.4-3.2
Knu rled channel	1.0~1.2 1.2~1.6 1.6~2.0 2.4~3.2

note: 1、2.4~3.2 for SSJ-11、SSJ-7H
2、V type for MIG wire
3、U type for ALUMINIUM wire
4、Knurled for FLUX CORED wire

4.Rated Feeding Speed (Attached Table No.2)

5.Operation and Maintenance

Installment and replacement for welding wire:

1) Welding wire installment

Firstly choose suitable welding wire, then pull lower the adjusting handle,

Table No.2 Specifications for all types of SSJ

	SSJ-4A	SSJ-4B	SSJ-4C	SSJ-5A	SSJ-5B	SSJ-5C	SSJ-6A	SSJ-6B	SSJ-7	SSJ-8	SSJ-9	SSJ-10
Motor	DC Magneto Motor									DC Print Motor		
Rated VoltageV	24	24	24/42	24	24	24/42	24	24	24	24/18.3	24/18.3	24/18.3
Rated CurrentA	5	5	5/3.5	5	5	5/3.5	5	5	5	5/5.5	5/5.5	5/5.5
Feeding Speed m/min	2.5~16/ 3.5~20	2.5~16/ 3.5~20	3~18/ 1.5~20	2.5~16/ 3.5~20	2.5~16/ 3.5~20	3~18/ 1.5~20	2.5~18/ 3.5~22	2.5~18/ 3.5~22	1.5~12/ 2.5~18	2~21/ 2~18	1.5~20/ 1.5~17	1.5~17/ 1.5~16
Diameter of Wire mm	0.6, 0.8, 1.0, 1.2, 1.6											
Diving Mode	single	single	single	double	double	double	single	single	double	single	single	double
Bottom to wire mm	62	62	58	93	93	85	75		95	80	75	90.5
Back to wire mm	89.5	89.5	88	89.5	89.5	91	90	90	90	115	113	126.5
Between install hole mm	50	50	50	60	60	70	50	50	100	130	130	130
Dimension (LXWXH) mm	170X120X200		156X120X197	205X200X215		190X195X210	180X120X215		230X200X225	210X140X210	270X145X215	250X150X220
Weight kg	2.5	2.5	2.5	3.0	3.0	3.0	2.8	2.8	3.5	3.0	3.2	3.5

follow

Table No.2 Specifications for all types of SSJ

	SSJ-11	SSJ-12	SSJ-13	SSJ-14	SSJ-15	SSJ-16	SSJ-17	SSJ-18		
Motor	DC Magneto Motor	Print Motor	DC Magneto Motor							
Rated VoltageV	24/42	24/18.3	24/42	24	24	24	42	24		
Rated CurrentA	5/3.5	5/5.5	5/3.5	5	5	0.9	5	2.5		
Feeding Speed m/min	3.5~20/ 1.2~19	1.5~20/ 1.5~17	3.5~20/ 1.2~19	3~17	3~18	1.5~12	3~21	2~13		
Diameter of Wire mm	0.6, 0.8, 1.0, 1.2, 1.6									
Diving Mode	double	single	double	double	double	single	double	single		
Bottom to wire mm	75	76	68.5	85	61	28	85	51		
Back to wire mm	103	110	103	91	94	77.5	285	85		
Between install hole mm	80	130	25~120	70	50	104X47.5	100	62		
Dimension (LXWXH) mm	230X160X215	240X130X215	230X160X210	190X122X210	170X112X210	150X95X82	260X305X210	200X110X170		
Weight kg	3.5	3.0	3.5	2.8	2.9	0.3	4	1.7		

after the compress roller automatically eject out,guide the wire successively into the channel of roller and the hose of the gun, then pull back the compress roller and the adjusting handle and adjust the feeding gressure to the best status to enable continues wire feeding

2)Change welding wire

Firstly close power supply,open pressure adjusting handle,take out welding wire, then choose another suitable welding wire and roller, guide the wire successively into the channel of roller and the hose of the gun,finally pull back the compress roller and the adjust handle.

Because of abrasion of roller channel for long time possibly causing the slide of wire on the roller,you can twist down the adjusting handle to fasten.

Match of roller and wire:

The roller should be correctlyselected to match the wire according to the wire diameter marked on the both side of roller.

Use and change of roller:

Clean up the protecting oil on the roller as using in order not to slide.

When feeding wire of differentdiameter, the rollershould be changed. Firstly twist down the holding knob of roller,change the roller or itsfeeding side.Then twist on the holding knobin case of thelocating of flat roller.

Daily Operation:

1)Regular checking the holdingknob, if it is not hardup, twist down to fastenit.

2)Don't touch theroller and gear by handwhen operating.

3)Regular clearance of oil fouling and dust in the roller channel is requ ired to ensure good feeding effect: Shield form sunshine and rain and prevent from dust into channel of roller.

4)All cable joint should be in solid connection and sound insulation. Any abnormal heating is forbidden.

6.Possible problem and solution (Attached table No.3)

Table No.3

Problem	Reason	Solution
Unable to feed the wire out	① The compress roller doesn't work; ② The motor hasn't been driven.	① Adjusting the compressor to the best pressure status; ② Check the input joint of motor; ③ If the motor is worn out,change the motor with a new one.
Instability of wire feeding	① Compress pressure for wire feeding is low; ② The diameter of channel on the roller and wire don't match with each other; ③ The hose of welding gun is bend too much; ④ Wire guide is jammed by oil or dust; ⑤ Contact tube of the gun is too rough.	① Adjusting the compressor to the best pressure status; ② Chang the whole roller or the feeding side of roller; ③ Straightening the hose of welding gun; ④ Clear or change the wire guide; ⑤ Change the contact tube of the gun.
Distortion of fed wire	① The wire guide and roller are coaxial; ② The hose of welding gun is bended; too much.	① Adjusting the coaxial of the wire guide and roller; ② Straighten the hose of welding gun.

7.Drawing of structure and measurement(Attached diagram No.1 ~17)

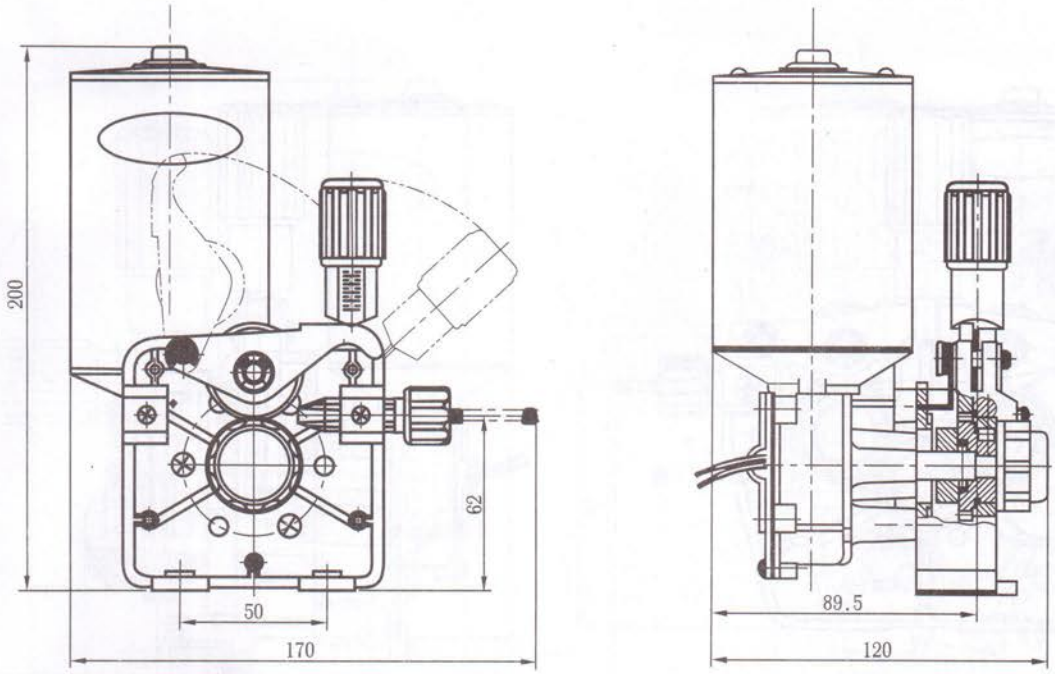


Diagram No. 1 SSJ-4A、SSJ-4B

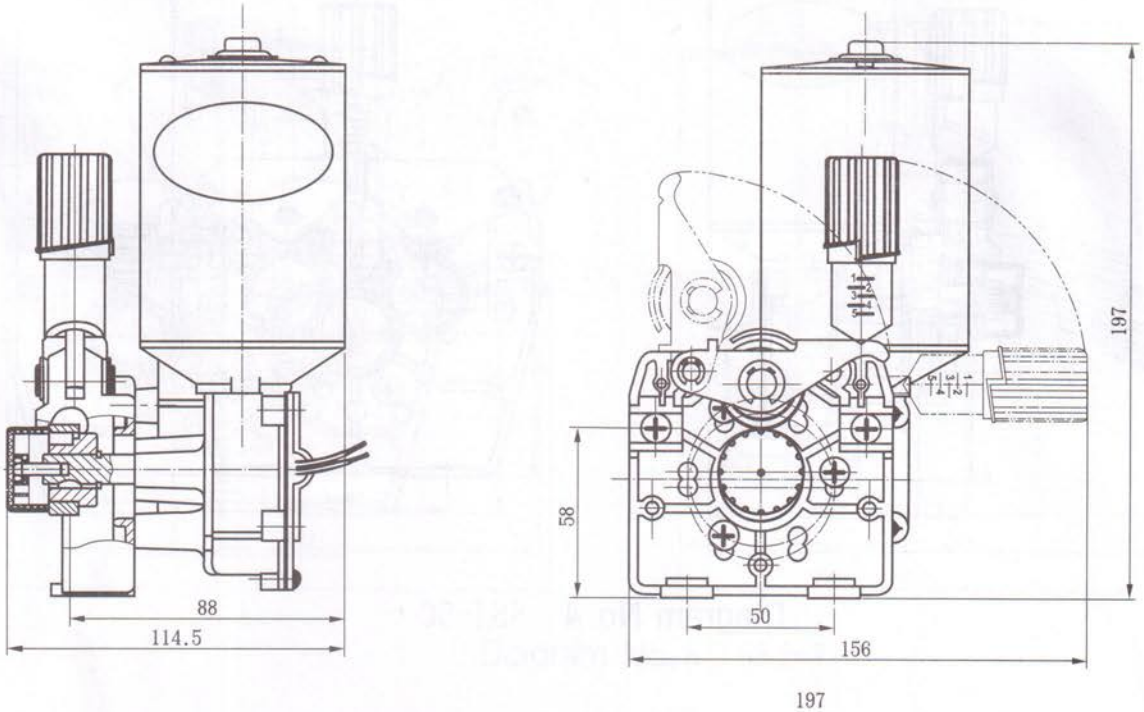


Diagram No. 2 SSJ-4C

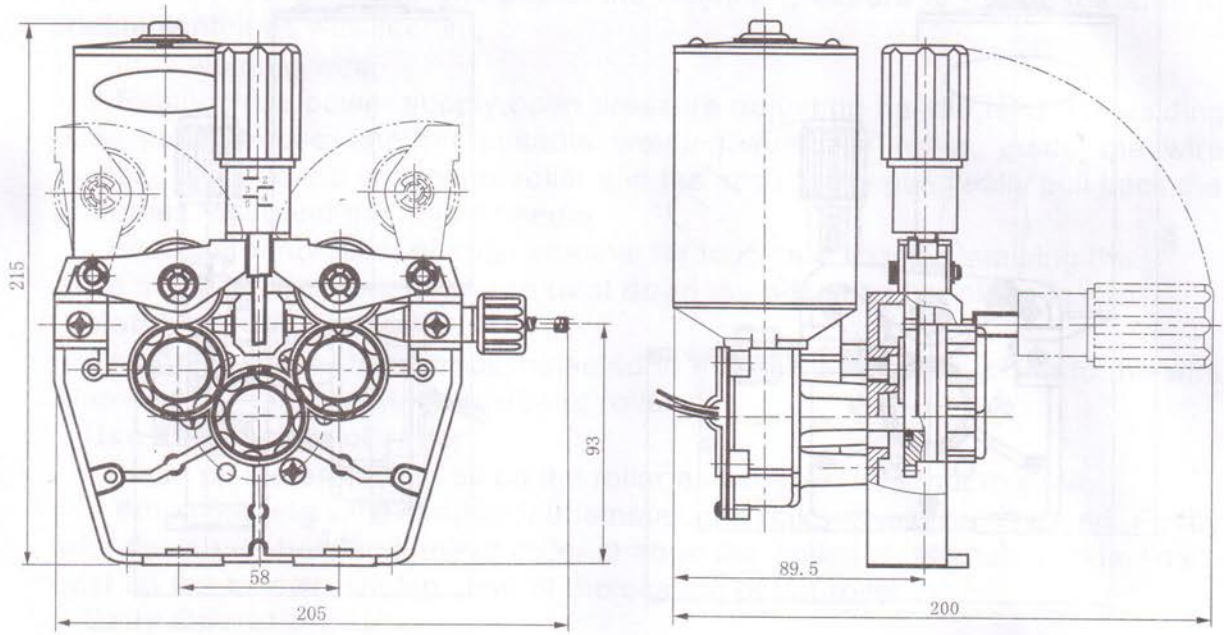


Diagram No. 3 SSJ-5A、SSJ-5B

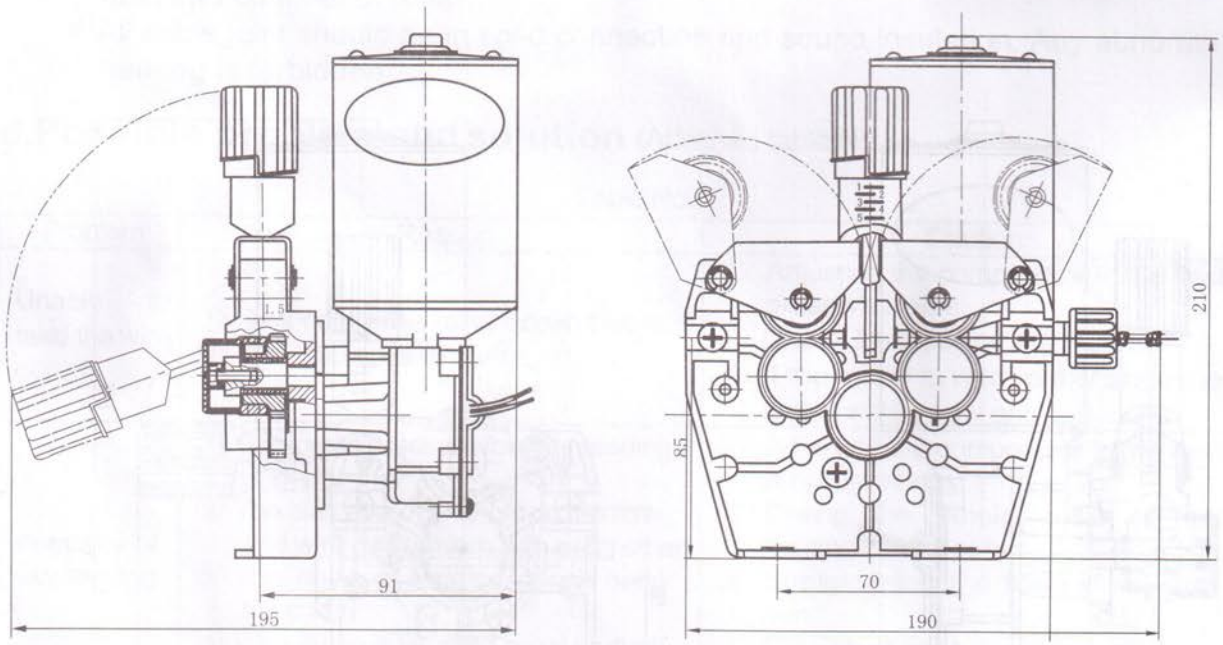


Diagram No. 4 SSJ-5C

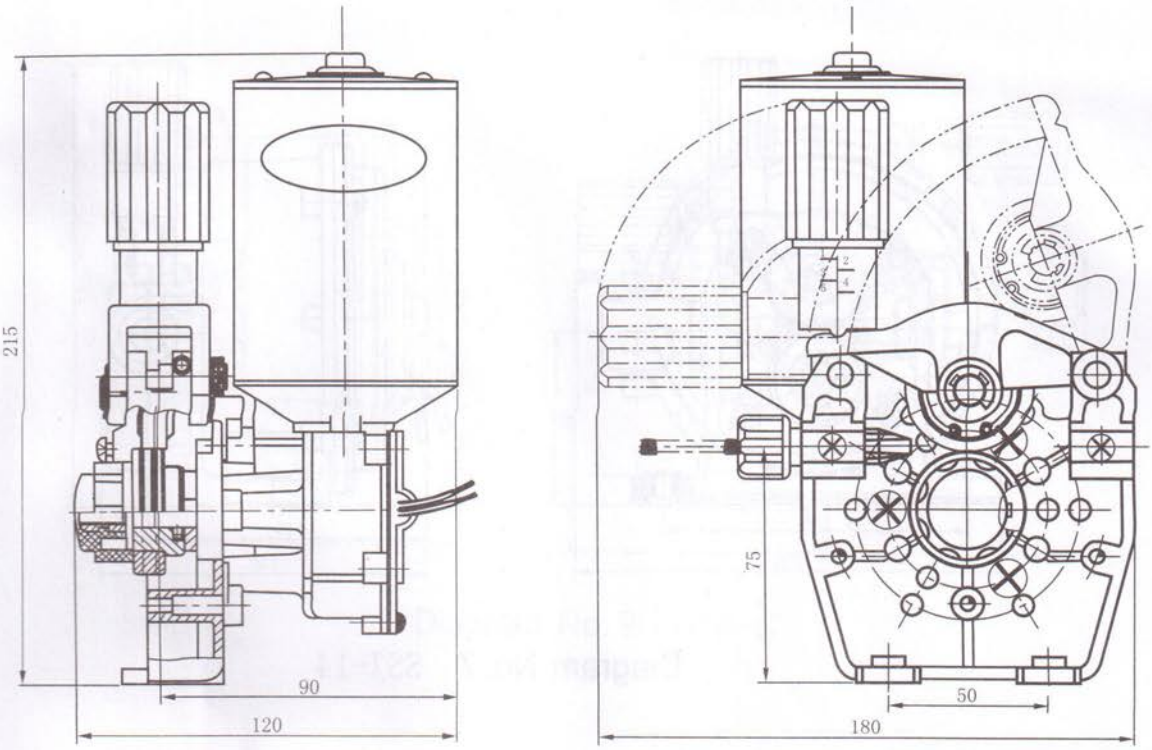


Diagram No. 5 SSJ-6、SSJ-6B

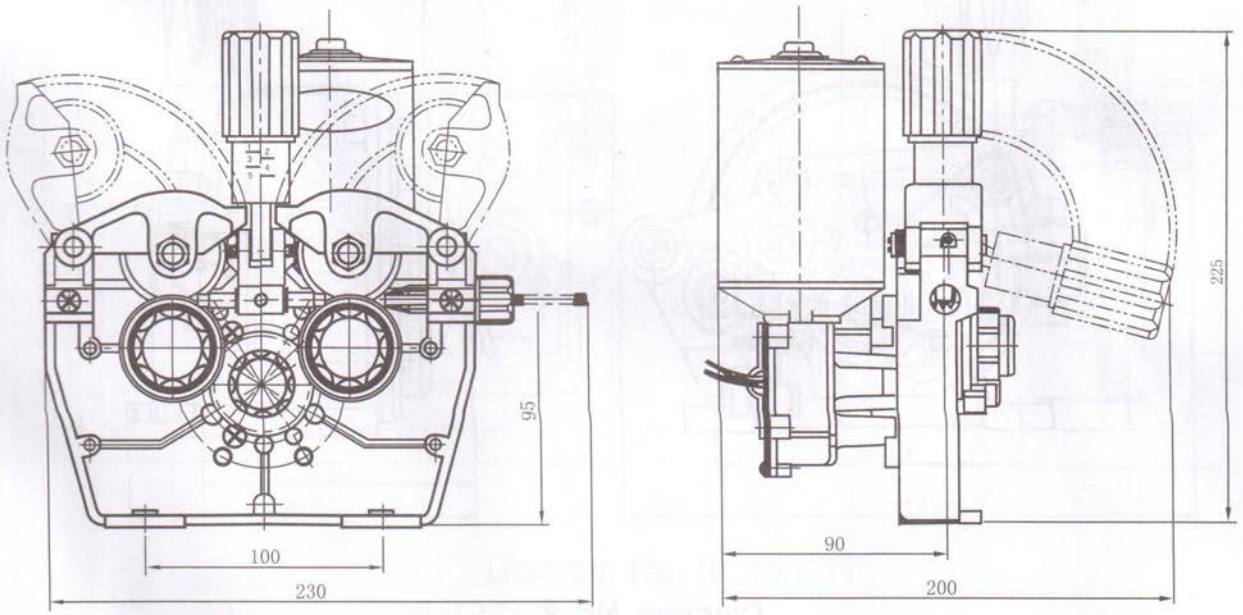


Diagram No. 6 SSJ-7

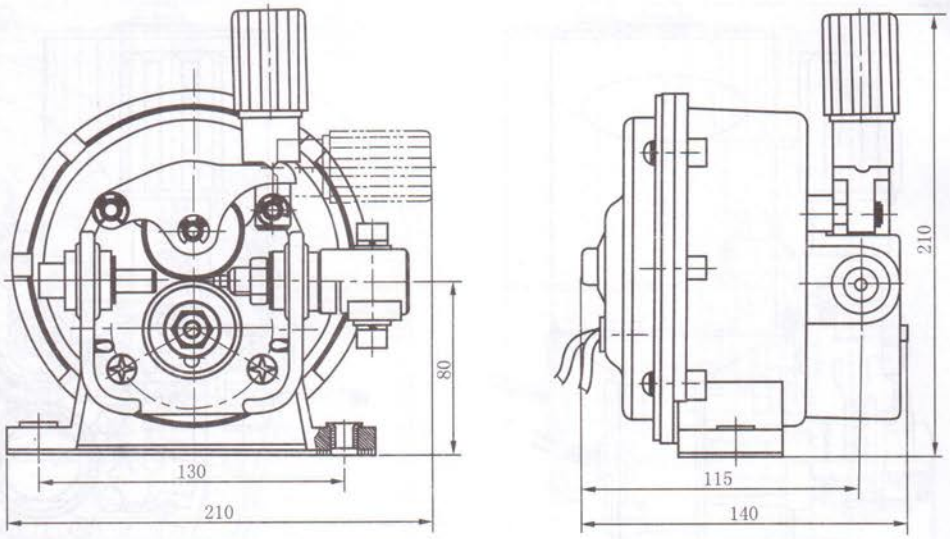


Diagram No. 7 SSJ-14

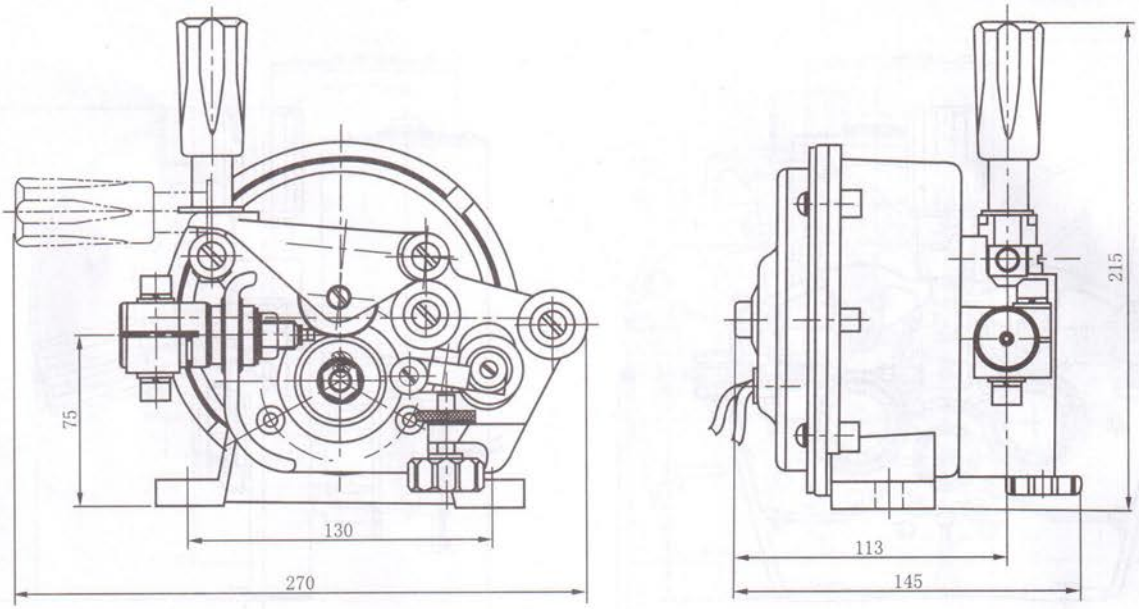


Diagram No. 8 SSJ-9

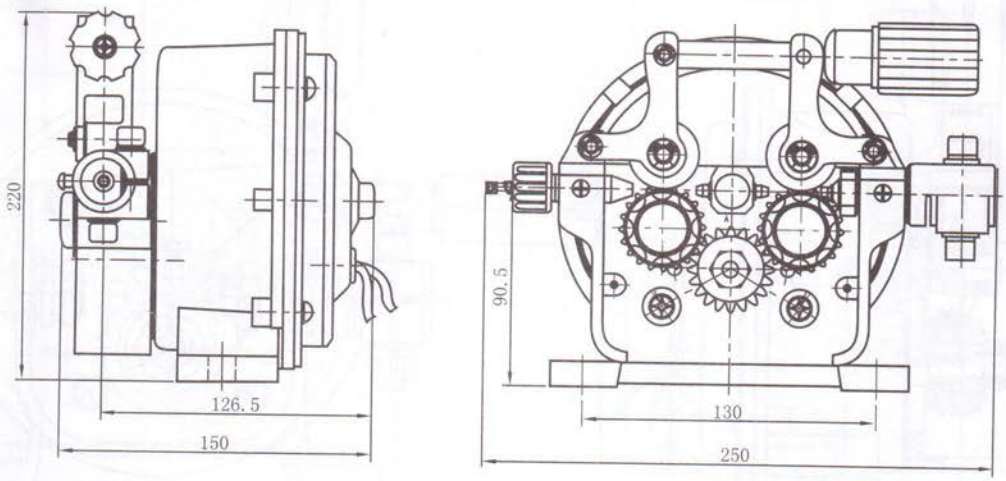


Diagram No. 9 SSJ-10

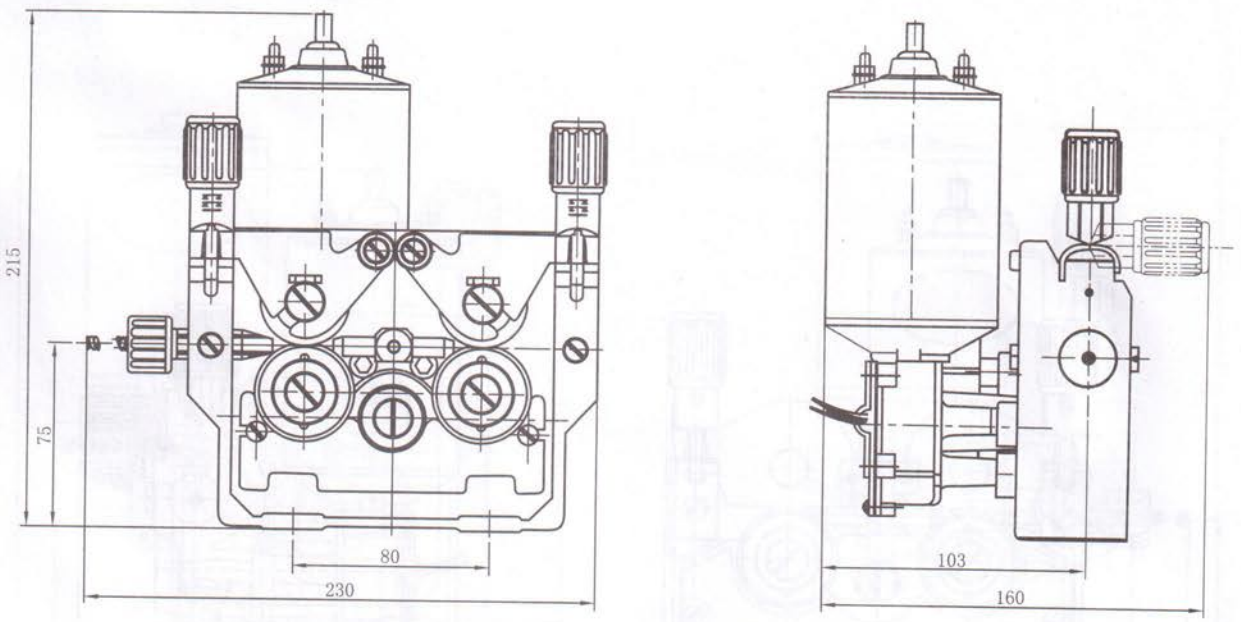


Diagram No. 10 SSJ-11

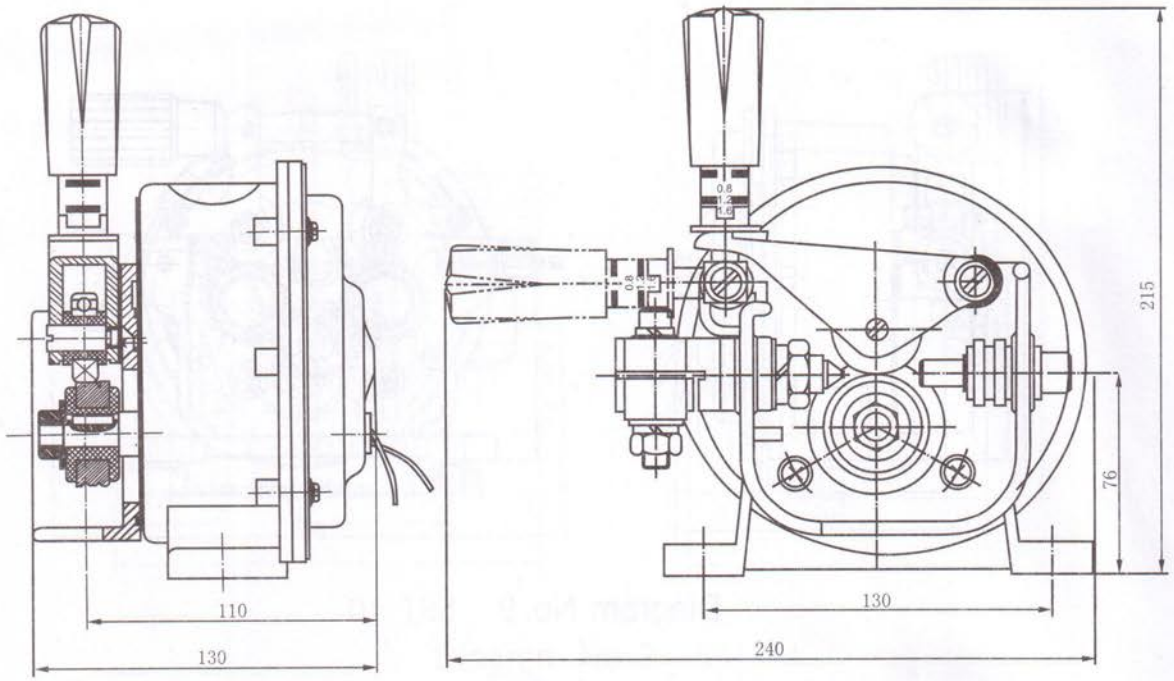


Diagram No. 11 SSJ-12

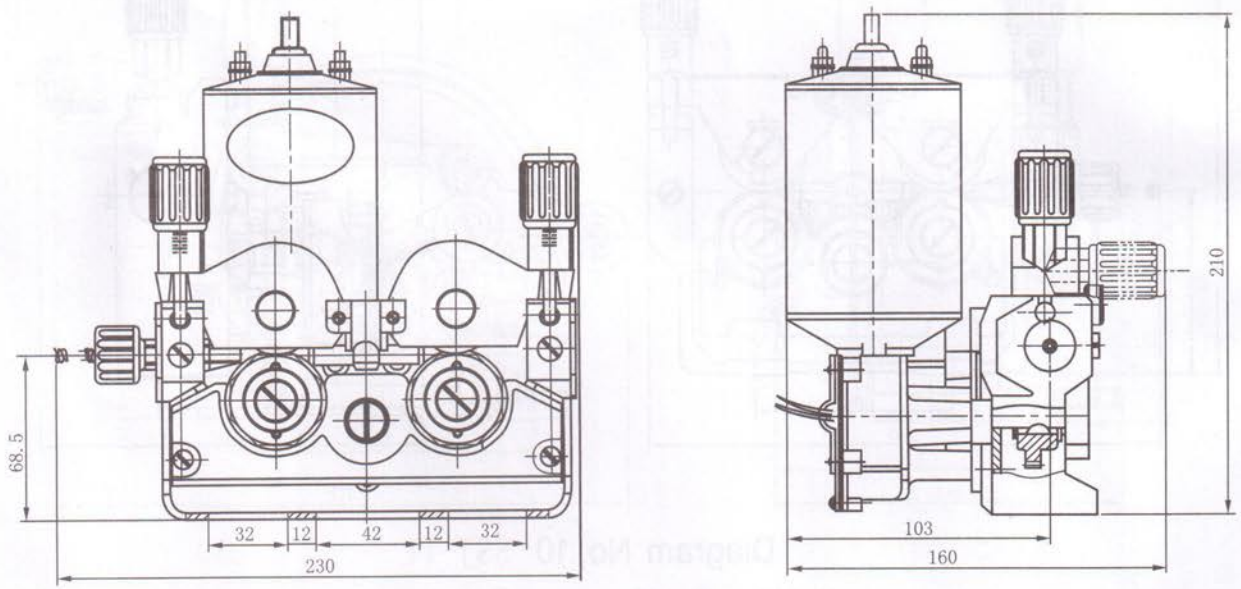


Diagram No. 12 SSJ-13

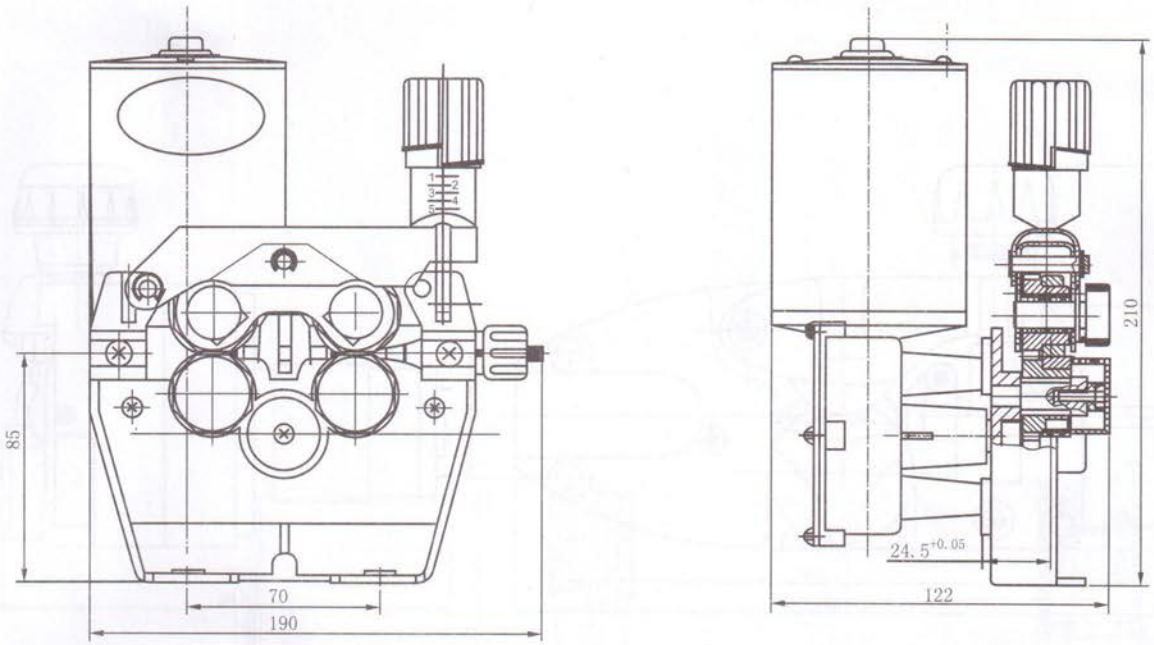


Diagram No. 13 SSJ-14

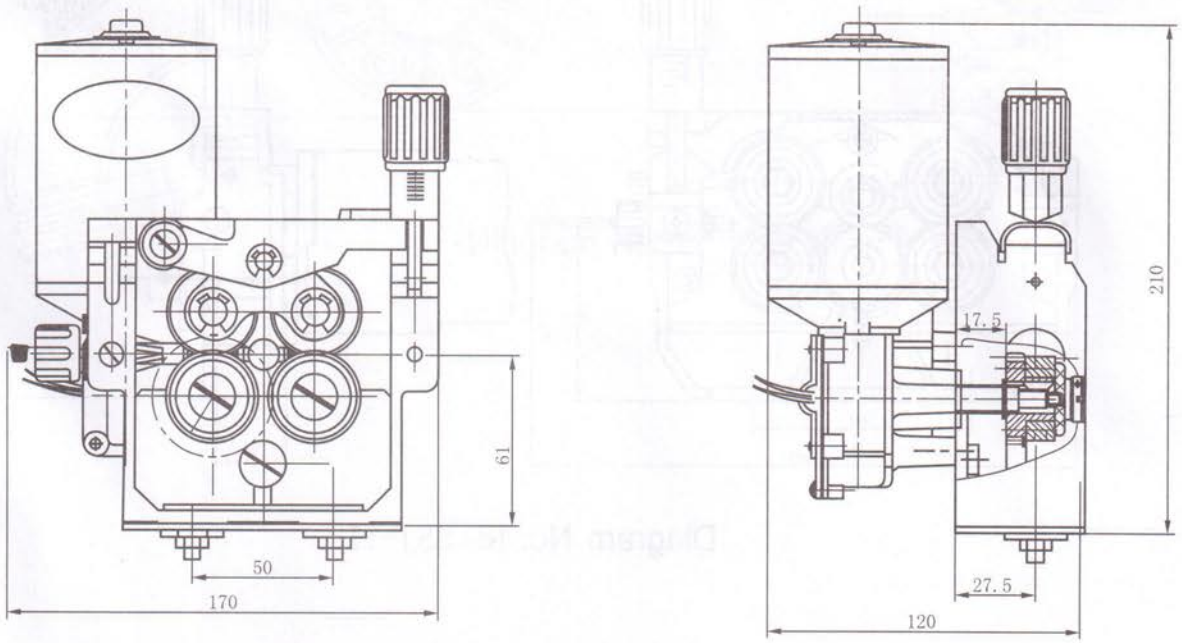


Diagram No. 14 SSJ-15

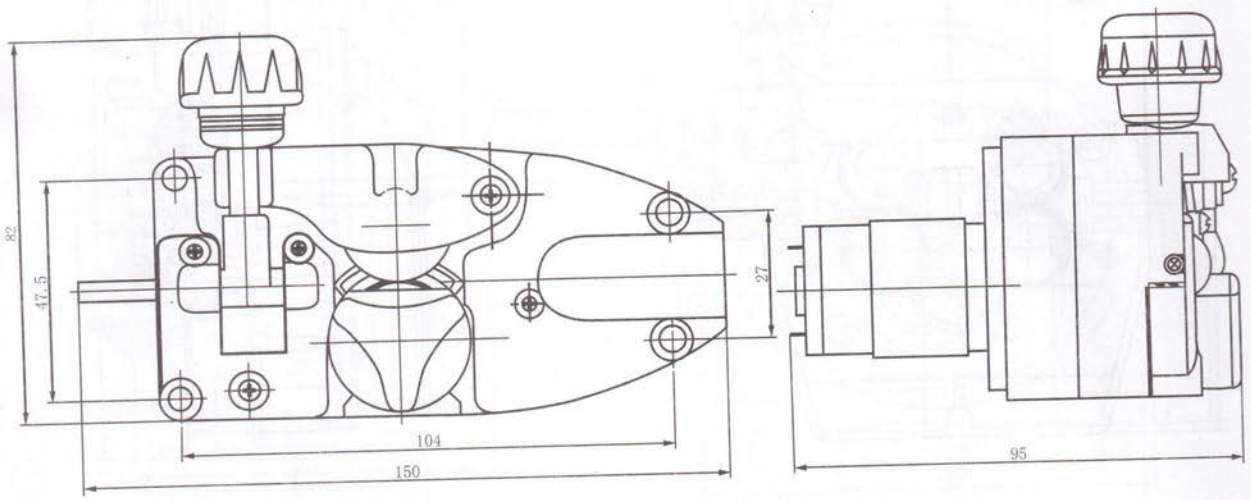


Diagram No. 15 SSJ-16

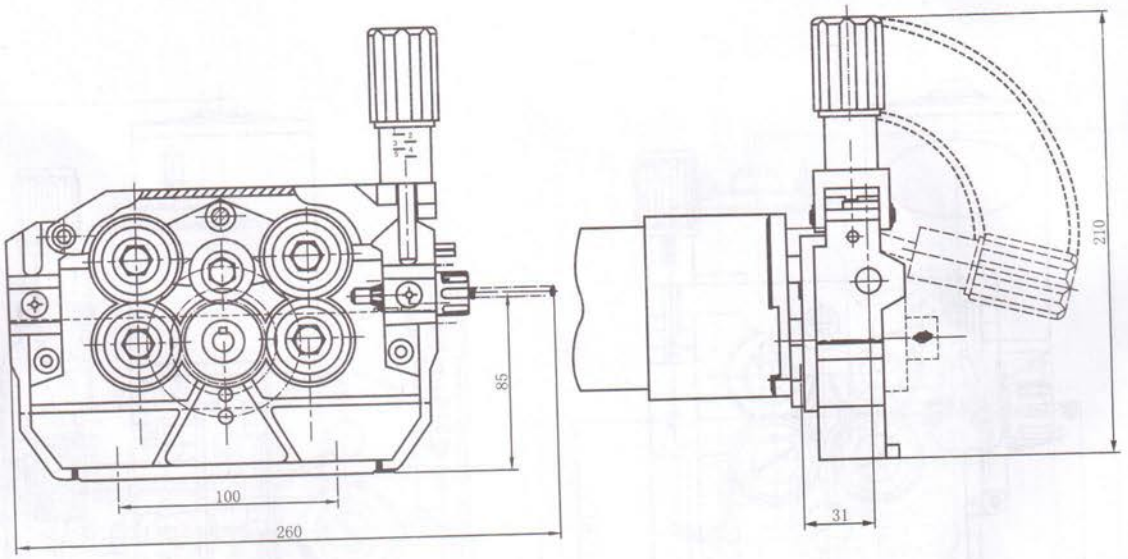


Diagram No. 16 SSJ-17

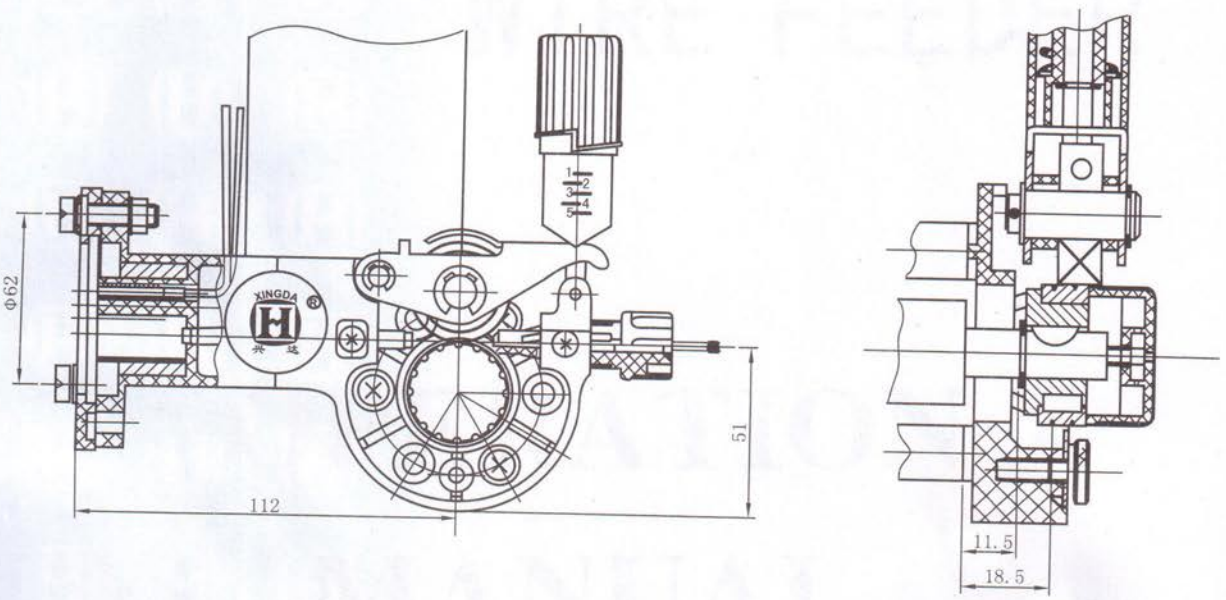
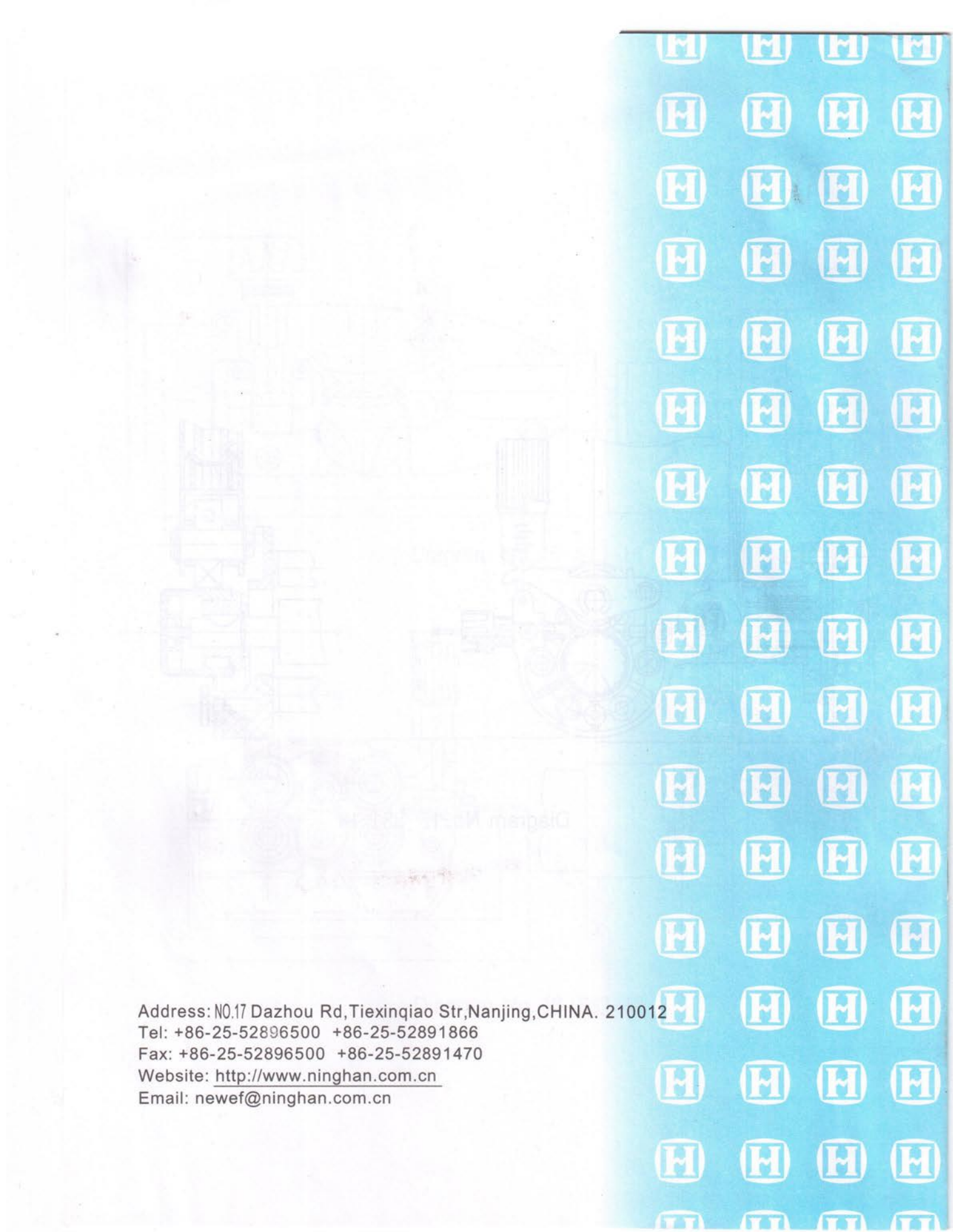


Diagram No. 17 SSJ-18



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