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INSTRUCTION MANUAL



GALE

Guide Kits for ALE250

This manual corresponds to the following references:

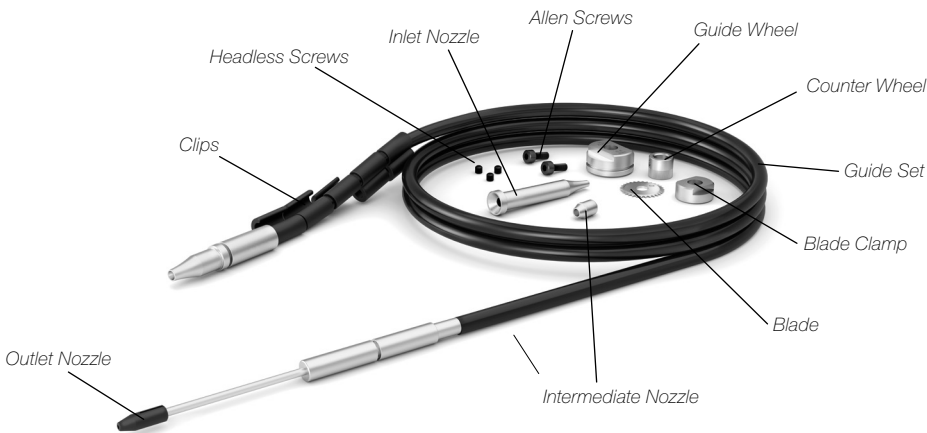
With Solder Wire Perforation:

GALE08V-B for wire Ø 0.8 mm / Ø 0.032 in
GALE10V-B for wire Ø 1.0 mm / Ø 0.040 in
GALE12V-B for wire Ø 1.2 mm / Ø 0.047 in
GALE15V-B for wire Ø 1.5 mm / Ø 0.059 in
GALE16V-B for wire Ø 1.6 mm / Ø 0.063 in

Without Solder Wire Perforation:

GALE04D-B for wire Ø 0.38 - 0.4 mm / Ø 0.015 - 0.016 in
GALE05D-B for wire Ø 0.46 - 0.56 mm / Ø 0.018 - 0.022 in
GALE06D-B for wire Ø 0.60 - 0.64 mm / Ø 0.023 - 0.025 in
GALE07D-B for wire Ø 0.70 - 0.78 mm / Ø 0.028 - 0.031 in
GALE08D-B for wire Ø 0.80 - 0.82 mm / Ø 0.032 - 0.033 in
GALE10D-B for wire Ø 0.90 - 1.10 mm / Ø 0.036 - 0.044 in
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GALE16D-B for wire Ø 1.60 - 1.63 mm / Ø 0.063 - 0.065 in
GALE18D-B for wire Ø 1.8 mm / Ø 0.073 in

GALE Guide Kits for ALE250 with Solder Wire Perforation



Packing List

The following items are included:

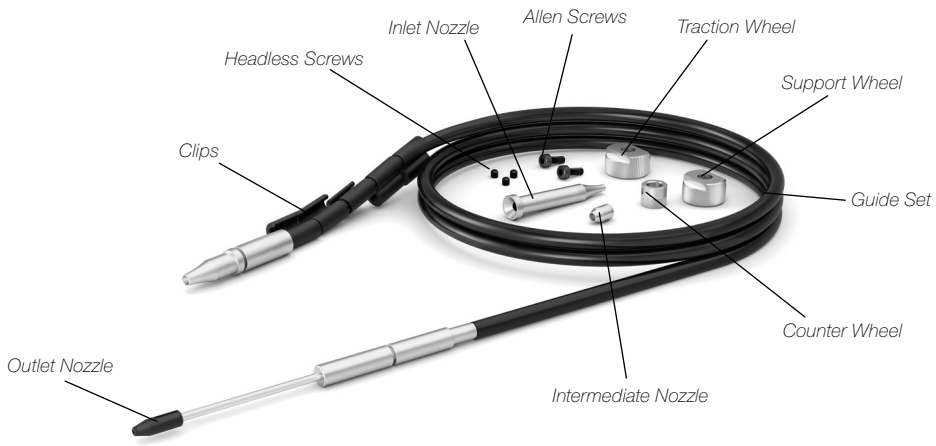
Guide Set	1 unit
Inlet Nozzle	1 unit
Guide Wheel	1 unit
Counter Wheel	1 unit
Blade Clamp	1 unit
Blade	1 unit
Intermediate Nozzle	1 unit
Outlet Nozzle	1 unit

Allen Screws	2 units
Headless Screws	3 units



Manual	1 unit
Ref. 0033472	

GALE Guide Kits for ALE250 without Solder Wire Perforation



Packing List

The following items are included:

Guide Set	1 unit
Inlet Nozzle	1 unit
Traction Wheel	1 unit
Support Wheel	1 unit
Counter Wheel	1 unit
Intermediate Nozzle	1 unit
Outlet Nozzle	1 unit

Allen Screws	2 units
Headless screws	3 units



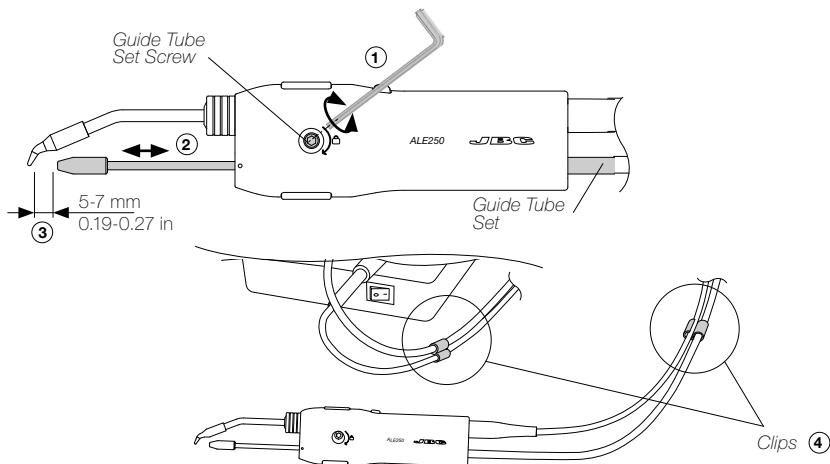
Manual	1 unit
Ref. 0033472	

Guide Tube Set Assembly

Open the guide tube set screw (1) and insert the guide tube set.

Adjust the guide tube length (2). Leave a gap of 8 to 10 mm (0.31 to 0.39 in) between the tip and the outlet nozzle (3). Once the position is adjusted tighten the guide tube set screw (1).

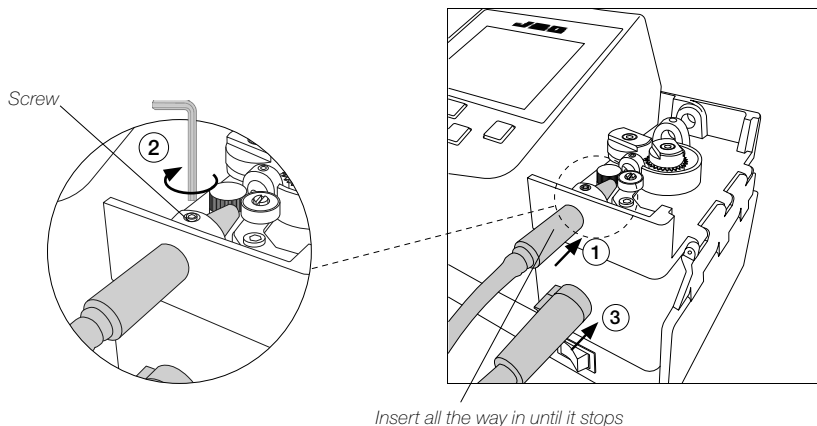
For a better handling use the clips (4) to attach the guide tube to the tool cable.



Tool Assembly

Connect the tool to the control unit following these steps:

Loosen the set screw, insert and push the guide nozzle until it stops (1) and tighten the set screw (2) again. Then plug in the tool connector (3).

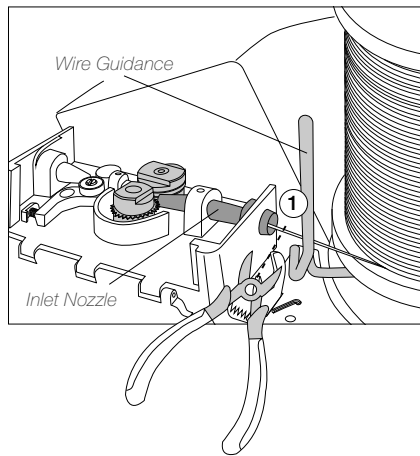


With Solder Wire Perforation

To unload solder wire with perforation that has already passed through the guide tube, cut the wire between the wire guidance and the inlet nozzle (1).

To extract the wire out of the tube, hold the tool on your hand and press  until the wire stops moving forward.

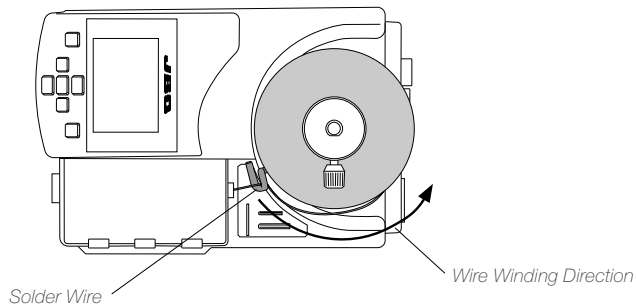
Grasp the wire coming out of the outlet nozzle with a pliers and pull from it until it is completely out.



Without Solder Wire Perforation

When using a kit without solder wire perforation, press  until the wire is completely wound to unload the solder wire. It is best to rotate the reel by hand as the wire is being pulled back in order to keep it neatly arranged on the reel.

Or, if preferred, proceed as described before for perforated solder wire unloading.



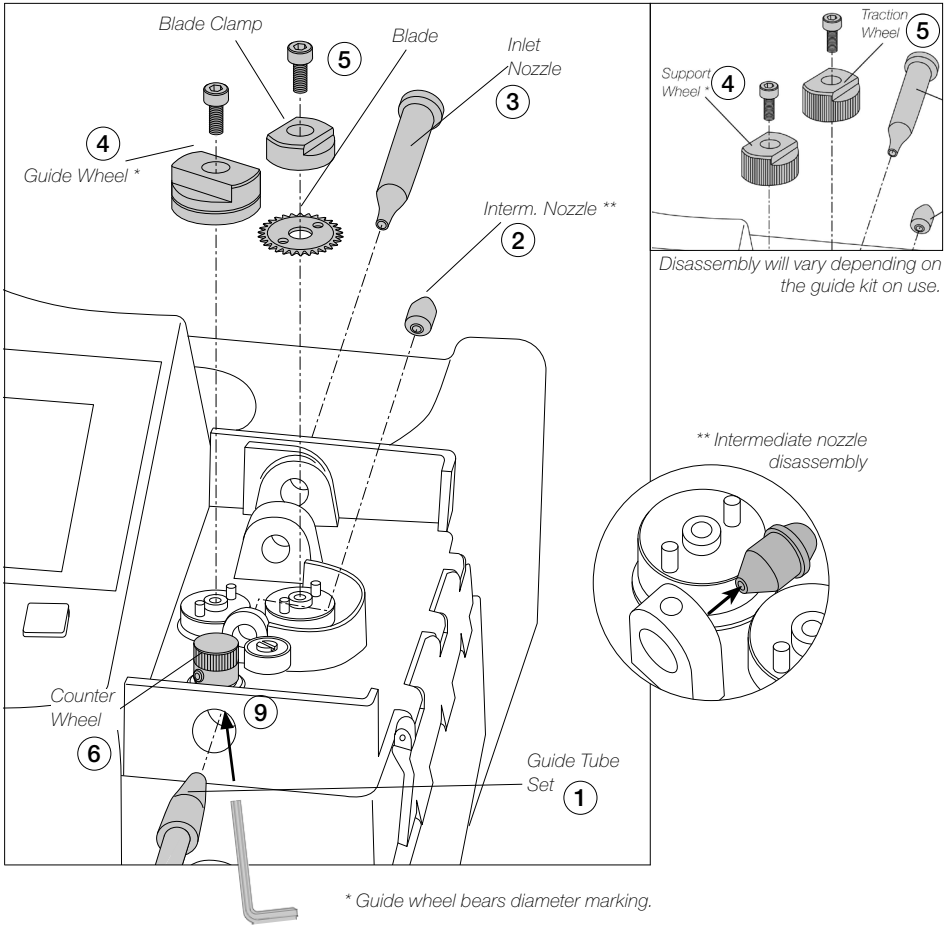
Changing Guide Kits

Disassembly

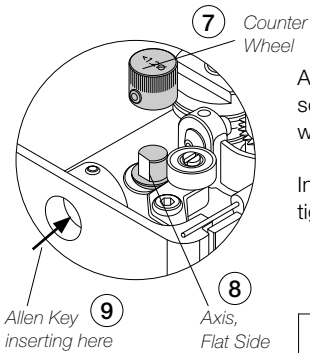
For this operation, disconnect the device from the mains. Unload any solder wire running inside the guide tube, disconnect the tool from the control unit and open its cover.

Before trying to remove any components from the device, be sure to loosen the corresponding set screws. To do this, use the Allen key and spanner provided with the station. First disassemble the guide tube set (1), the guide wheel, blade and blade clamp or the support and traction wheels (4) + (5), and then the nozzles (2) + (3). Lastly, disassemble the counter wheel (6). Introducing the Allen key through the frontal opening (9) will make it easier to loosen the screw of the counter wheel.

Note: The assembly steps are slightly different for devices with or without solder wire perforation.



Assembly with Solder Wire Perforation:



Assemble the counter wheel (7). Make sure that its thread entry for the set screw is aligned with the flat side of the axis (8). If not, the set screw will protrude, which may cause difficulties for the wire transportation.

Inserting the Allen key through the front opening will make it easier to tighten the screw (9).

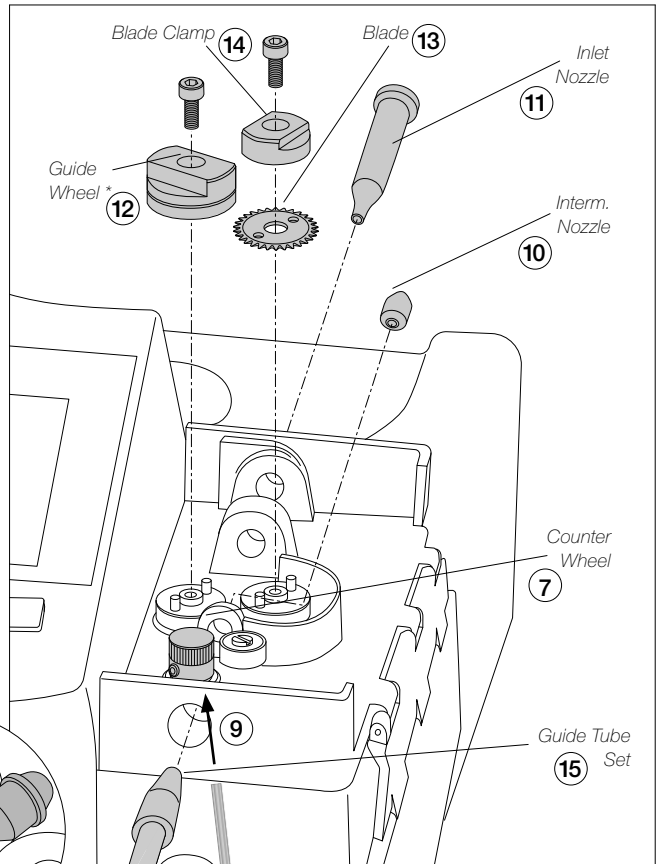
Insert the intermediate nozzle (10) until its collar rests against the housing and tighten its screw.

Assemble the inlet nozzle (11).

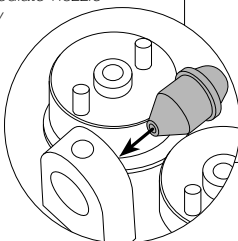
Assemble the guide wheel* (12) and tighten the screw.

Assemble the blade first (13), then mount the blade clamp (14) onto the same axis and tighten the screw. **Caution:** handle the blade carefully to avoid injury.

Finally insert the guide tube set (15).



** intermediate nozzle assembly



* Guide wheel bears diameter marking.

Assembly without Solder Wire Perforation:

Assemble the counter wheel in the same way as shown on the previous page (7), (8) and (9).

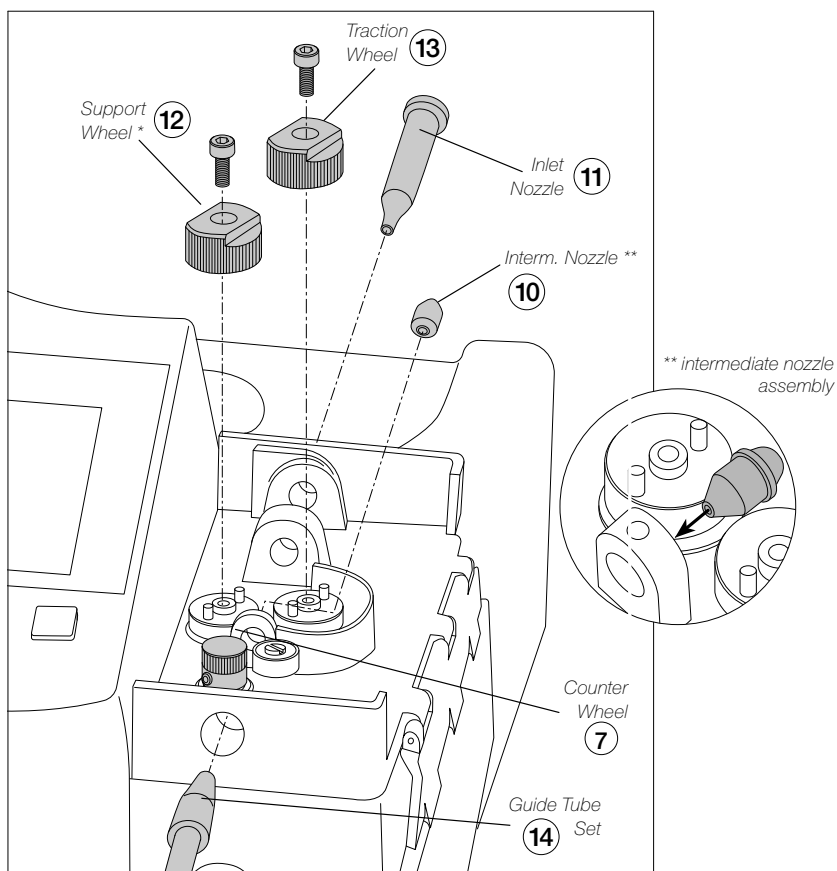
Insert the intermediate nozzle (10) until its collar rests against the housing and tighten its screw.

Assemble the inlet nozzle (11).

Assemble the support wheel* (12) onto the axis and tighten the screw.

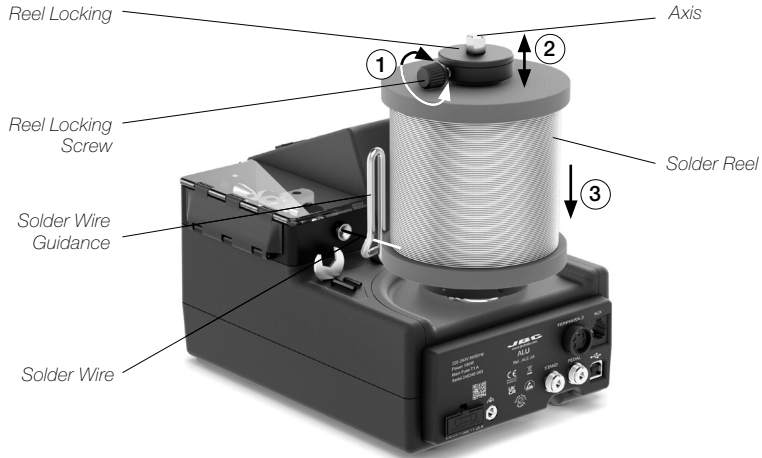
Assemble the traction wheel (13) onto the axis and tighten the screw.

Finally insert the guide tube set (14) and tighten the screw.



* Support wheel bears diameter marking.

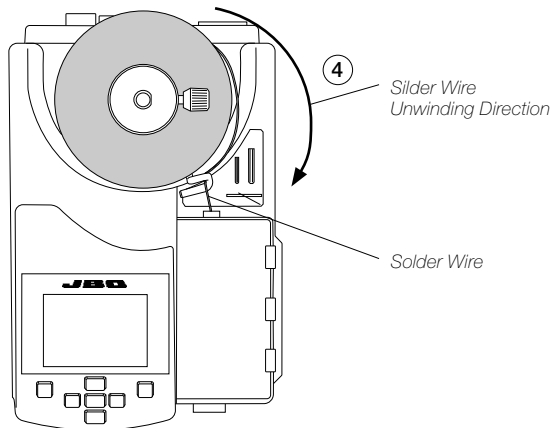
Solder Reel Assembly



Loosen the reel locking screw (1) and remove the reel locking (2) from the axis.

Assemble the solder reel onto the axis (3).

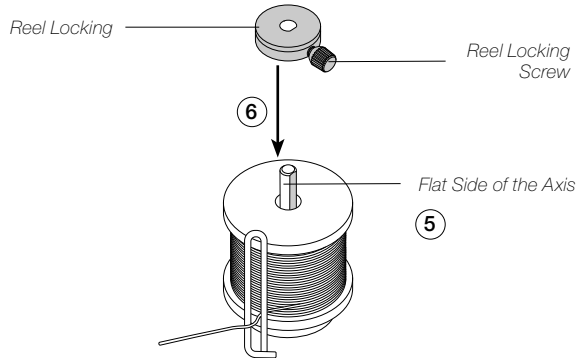
 Insert the solder reel in such a way - when viewed from above - that the solder wire unwinds on the dispensing mechanism side (4).



To assemble the reel locking, its conical side must be pointing downwards.

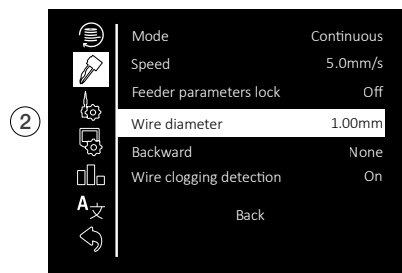
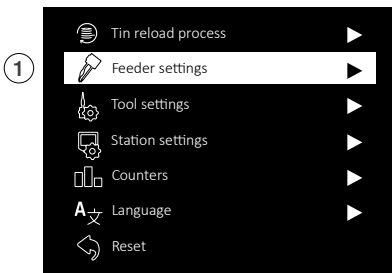
Align the flat side of the axis (5) with the inner flat side (the one with the screw) of the reel locking and reassemble it to the axis (6).

Note: To prevent the solder reel from spinning freely or binding, before tightening the reel locking screw gently press the reel locking down, but only enough to have the solder reel secured in place.



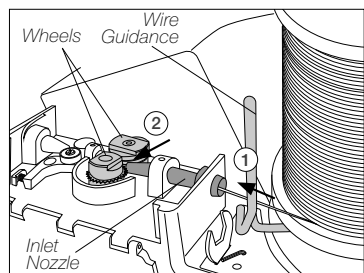
Main Menu Screen

Access to Main Menu by pressing  , select "Feeder settings" (1) and then "Wire diameter" (2) to adjust the value to the current solder wire diameter.



Solder Wire Loading

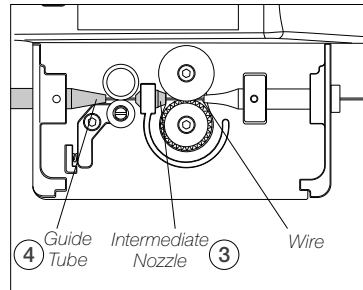
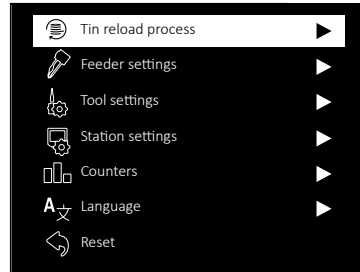
Pass the solder wire through the wire guidance and introduce the solder wire into the inlet nozzle (1) until it reaches the wheels (2).



Select “*Tin reload process*” and then use  to feed the solder wire and advance until it comes out of the outlet nozzle.

If needed, carefully push the wire until it gets locked in between the rotating wheels for the wire to start moving forward. Keep  pressed and after a while, the wire will advance faster.

Make sure the wire passes through the intermediate nozzle (3) and enters the guide tube (4).



Replacing Guide Sets

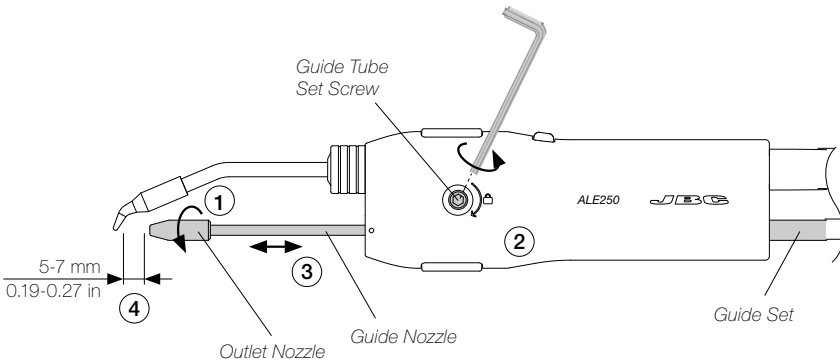
Once the tool is disconnected from the control unit and has cooled down, follow these instructions:

Unload the solder wire and disassemble the outlet nozzle by unscrewing it from the guide nozzle (1). If the outlet nozzle is stuck because of the flux, soak the outlet nozzle in alcohol to release it with ease.

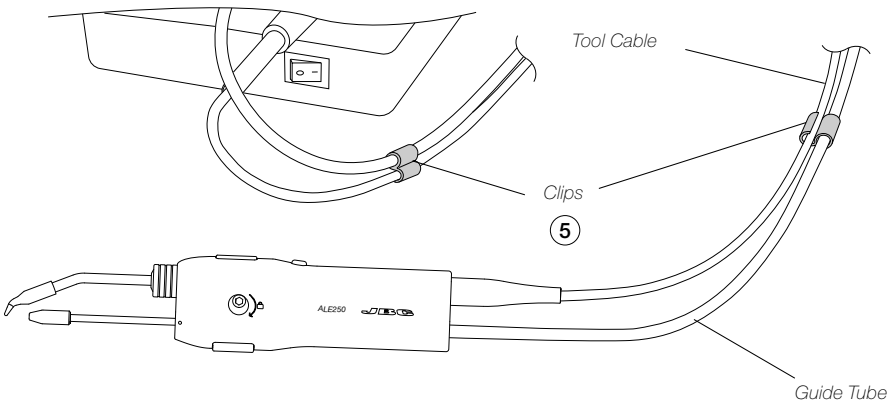
Loosen the guide tube set screw (2), take out the guide set (3) and insert the desired one.

Put the outlet nozzle back, by screwing it onto (1) the new guide nozzle. Leave a gap of 5 to 7 mm (0.19 to 0.27 in) between the cartridge tip and the outlet nozzle (4).

Once the guide nozzle length is adjusted tighten the guide set screw (2).



For a better handling use the clips (5) to attach the guide tube to the tool cable.



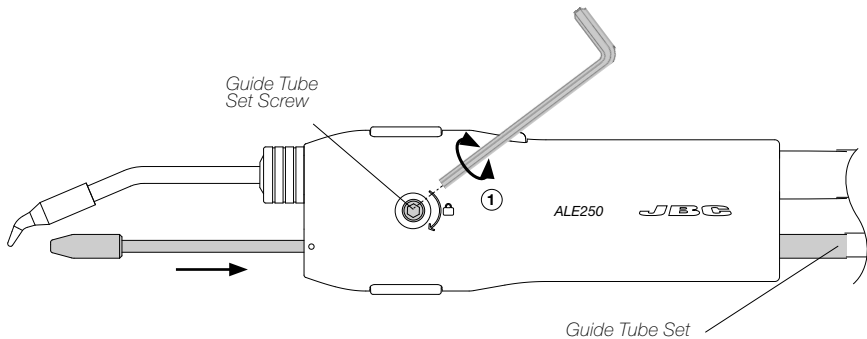
Outlet Nozzle Replacement

Flux can cause clogging at the outlet nozzle of the guide tube set and it can be necessary to replace the worn or clogged outlet nozzle.

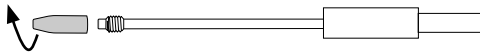
Note: There is a nozzle size for each soldering wire diameter. The use of the nozzle is necessary as its inner diameter is adjusted to the solder wire diameter and guides the wire with greater precision.

To replace the outlet nozzle, follow these steps:

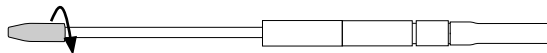
First, make sure that the tool has cooled down and unload any remaining solder wire that might still be inside the guide tube (see pages 11 and 12). Unplug the tool. Loosen the guide tube set screw (1) and detach the guide tube set from the tool for easier handling.



Unscrew the outlet nozzle. If the outlet nozzle is stuck onto the guide nozzle due to flux clogging, soak it in alcohol to release it.



Replace the outlet nozzle and screw it back onto the guide nozzle.



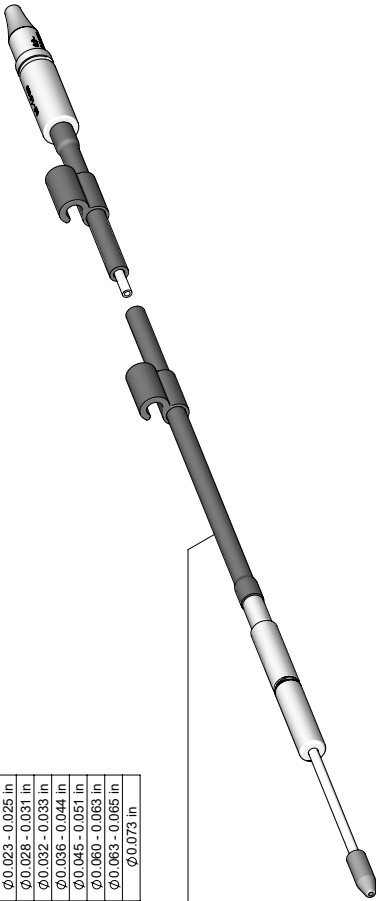
GALE Guide Kits for ALE250-B

without solder wire perforation

GALEXD-B WITHOUT SOLDER WIRE PERFORATION

Wire diameter Range of use	
XX	
04	Ø0.38 - 0.40 mm Ø0.015 - 0.016 in
05	Ø0.46 - 0.56 mm Ø0.018 - 0.022 in
06	Ø0.60 - 0.64 mm Ø0.023 - 0.025 in
07	Ø0.70 - 0.78 mm Ø0.028 - 0.031 in
08	Ø0.80 - 0.82 mm Ø0.032 - 0.033 in
10	Ø0.90 - 1.10 mm Ø0.036 - 0.044 in
12	Ø1.14 - 1.27 mm Ø0.045 - 0.051 in
15	Ø1.50 - 1.57 mm Ø0.060 - 0.063 in
16	Ø1.60 - 1.63 mm Ø0.063 - 0.065 in
18	Ø1.80 mm Ø0.073 in

Guide tube	
GALE04D-B	0034718
GALE05D-B	0034719
GALE06D-B	0034720
GALE07D-B	0034721
GALE08D-B	0034722
GALE10D-B	0034723
GALE12D-B	0034724
GALE15D-B	0034725
GALE16D-B	0034726
GALE18D-B	0034727



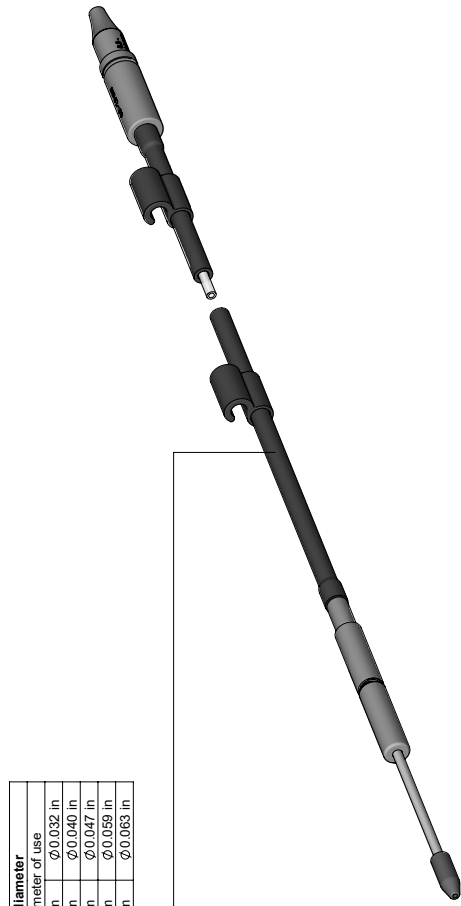
SPARE PARTS

	Wire Ø	Outlet nozzle	Nozzle	Traction wheel	Support wheel	Inlet nozzle	Intern. nozzle	Counter wheel	Screws	Threaded stud
										
GALE04D-B		0033982	0032612	0019479	0020345	0019520	0024954	0026693	0026695 (x2)	0026696 (x3)
GALE05D-B		0033983			0019519		0025293			
GALE06D-B		0033984			0019480	0019632	0025291			
GALE07D-B		0033985				0019170	0024955			
GALE08D-B		0033986				0019171	0024956	0024957		
GALE10D-B		0033987			0019481		0024958			
GALE12D-B		0033988		0028367	0024233	0024959	0026694			
GALE15D-B		0033989			0024234	0024960				
GALE16D-B		0033991								
GALE18D-B		0033992								

GALE Guide Kits for ALE250-B

with solder wire perforation

GALEXV-B WITH SOLDER WIRE PERFORATION



Wire diameter	
XX	Diameter of use
08	Ø0.8 mm Ø0.032 in
10	Ø1.0 mm Ø0.040 in
12	Ø1.2 mm Ø0.047 in
15	Ø1.5 mm Ø0.059 in
16	Ø1.6 mm Ø0.063 in

Guide tube	
GALE08V-B	0034722
GALE10V-B	0034723
GALE12V-B	0034724
GALE15V-B	0034725
GALE16V-B	0034726

SPARE PARTS

Wire Ø	Outlet nozzle	Nozzle	Guide wheel	Blade	Blade clamp	Inlet nozzle	Interm. nozzle	Counter wheel	Screws	Threaded stud
GALE08V-B	0033986	0032612	0021696	0021555	0018638	0018632 0019170 0019171 0024233	0024955 0024956 0024957 0024958 0024959	0026693 0026694	0026695 (x2) 0026696 (x3)	0026696 (x3)
GALE10V-B	0033987		0021699							
GALE12V-B	0033988		0023738							
GALE15V-B	0033989		0019696							
GALE16V-B	0033991		0025922							

Notes

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

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Specifications

GALE

Guide Kits for ALE250

With Perforation:

Ref.: **GALE08V-B** wire Ø 0.8 mm / Ø 0.032 in
 Ref.: **GALE10V-B** wire Ø 1.0 mm / Ø 0.040 in
 Ref.: **GALE12V-B** wire Ø 1.2 mm / Ø 0.047 in
 Ref.: **GALE15V-B** wire Ø 1.5 mm / Ø 0.059 in
 Ref.: **GALE16V-B** wire Ø 1.6 mm / Ø 0.063 in

Total Net Weight:

108 g / 0.24 lb
 108 g / 0.24 lb
 94 g / 0.21 lb
 94 g / 0.21 lb
 94 g / 0.21 lb

Package Weight:

200 g / 0.44 lb
 200 g / 0.44 lb
 186 g / 0.41 lb
 186 g / 0.41 lb
 186 g / 0.41 lb

Without Perforation:

GALE04D-B for wire Ø 0.38 - 0.4 mm / Ø 0.015 - 0.016 in
GALE05D-B for wire Ø 0.46 - 0.56 mm / Ø 0.018 - 0.022 in
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GALE10D-B for wire Ø 0.90 - 1.10 mm / Ø 0.036 - 0.044 in
GALE12D-B for wire Ø 1.14 - 1.27 mm / Ø 0.045 - 0.051 in
GALE15D-B for wire Ø 1.50 - 1.57 mm / Ø 0.060 - 0.063 in
GALE16D-B for wire Ø 1.60 - 1.63 mm / Ø 0.063 - 0.065 in
GALE18D-B for wire Ø 1.8 mm / Ø 0.073 in

104 g / 0.23 lb
 104 g / 0.23 lb
 104 g / 0.23 lb
 104 g / 0.23 lb
 104 g / 0.23 lb
 104 g / 0.23 lb
 90 g / 0.20 lb
 90 g / 0.20 lb
 90 g / 0.20 lb
 90 g / 0.20 lb

196 g / 0.43 lb
 196 g / 0.43 lb
 196 g / 0.43 lb
 196 g / 0.43 lb
 196 g / 0.43 lb
 196 g / 0.43 lb
 182 g / 0.40 lb
 182 g / 0.40 lb
 182 g / 0.40 lb
 182 g / 0.40 lb

- Guide Tube Length: 126 cm / 49.6 in

- Package Dimensions: 245 x 185 x 45 mm

(L x W x H) 9.65 x 7.28 x 1.77 in

Complies with CE standards.

ESD safe.

JBC

Warranty

JBC's 2 year warranty covers this equipment against all manufacturing defects, including the replacement of defective parts and labor.

Warranty does not cover product wear or misuse.

In order for the warranty to be valid, equipment must be returned, postage paid, to the dealer where it was purchased.



This product should not be thrown in the garbage.

In accordance with the European directive 2012/19/EU, electronic equipment at the end of its life must be collected and returned to an authorized recycling facility.



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