

# **JBC**

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## **INSTRUCTION MANUAL**



## **GALE**

Guide Kits for ALE250

This manual corresponds to the following references:

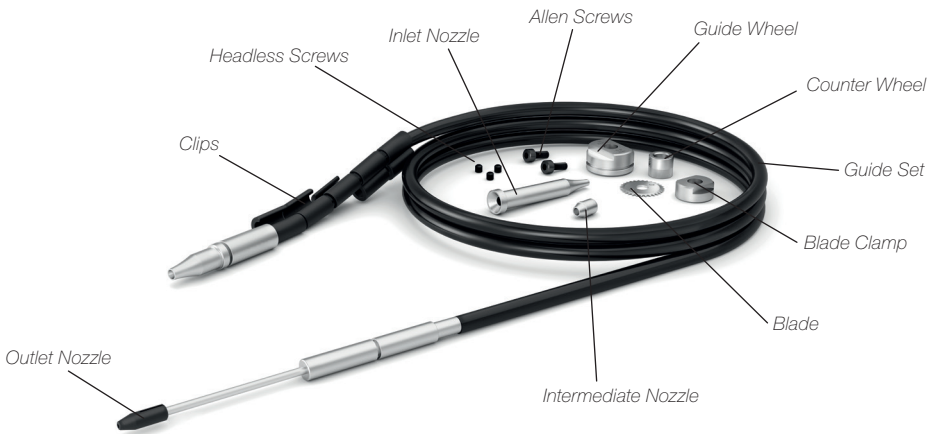
With Solder Wire Perforation:

- 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
- 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

## GALE Guide Kits for ALE250 with Solder Wire Perforation



### Packing List

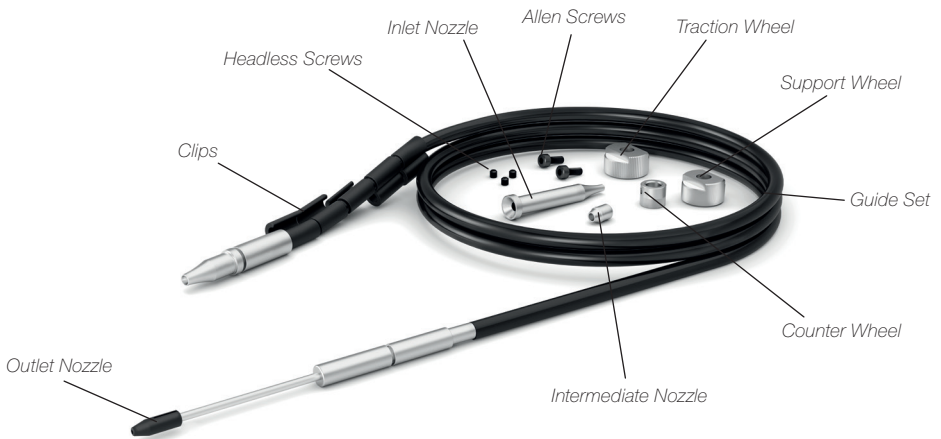
The following items are included:

<b>Guide Set</b> .....	1 unit	<b>Allen Screws</b> .....	2 units
<b>Inlet Nozzle</b> .....	1 unit	<b>Headless Screws</b> .....	3 units
<b>Guide Wheel</b> .....	1 unit		
<b>Counter Wheel</b> .....	1 unit		
<b>Blade Clamp</b> .....	1 unit		
<b>Blade</b> .....	1 unit		
<b>Intermediate Nozzle</b> .....	1 unit		
<b>Outlet Nozzle</b> .....	1 unit	<b>Manual</b> .....	1 unit



Ref. 0033472

## GALE Guide Kits for ALE250 without Solder Wire Perforation



### Packing List

The following items are included:

<b>Guide Set</b> .....	1 unit
<b>Inlet Nozzle</b> .....	1 unit
<b>Traction Wheel</b> .....	1 unit
<b>Support Wheel</b> .....	1 unit
<b>Counter Wheel</b> .....	1 unit
<b>Intermediate Nozzle</b> .....	1 unit
<b>Outlet Nozzle</b> .....	1 unit

<b>Allen Screws</b> .....	2 units
<b>Headless screws</b> .....	3 units



<b>Manual</b> .....	1 unit
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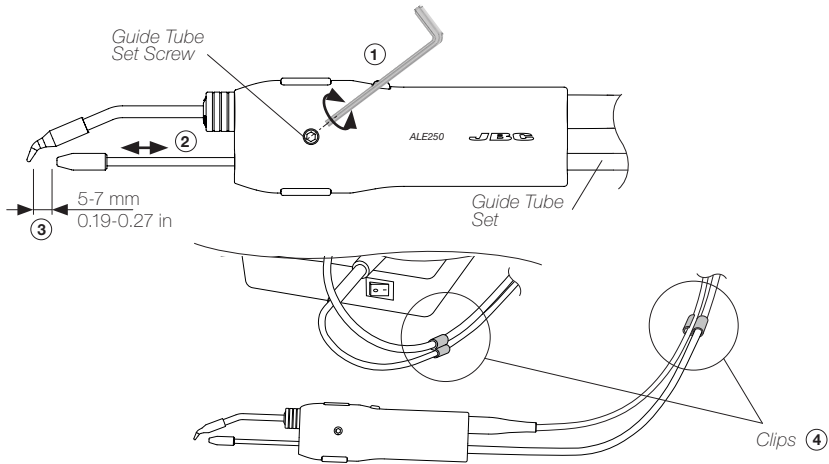
Ref. 0033472

## 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).

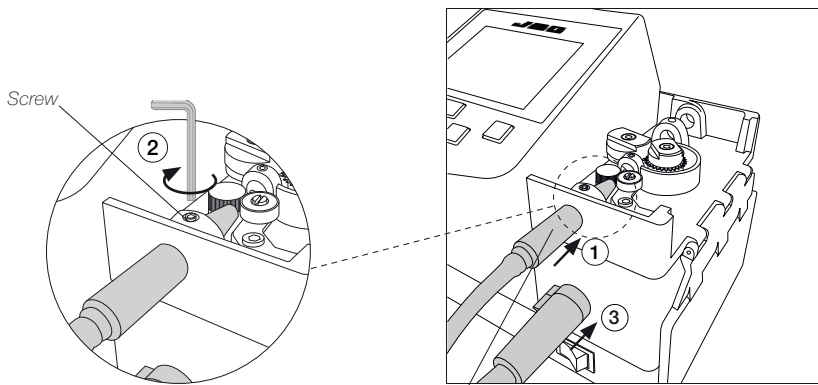
For a better handling use the clips (4) to attach the guide tube to the tool cable.



## 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).




*Insert all the way in until it stops*

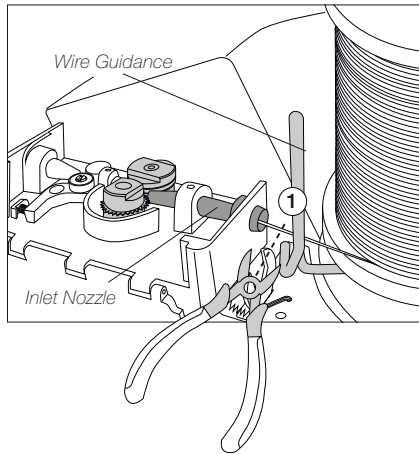
## Solder Wire Unloading

### 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.

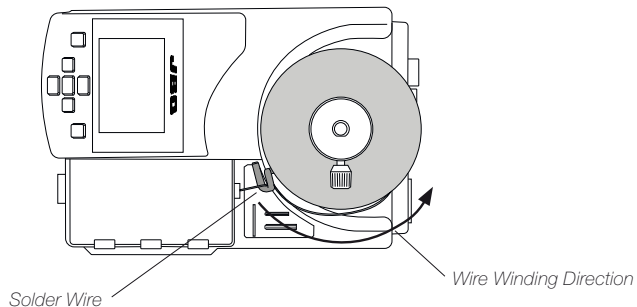
Grasp the wire coming out of the outlet nozzle with a pliers and pull from it until it is completely out.



### 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.



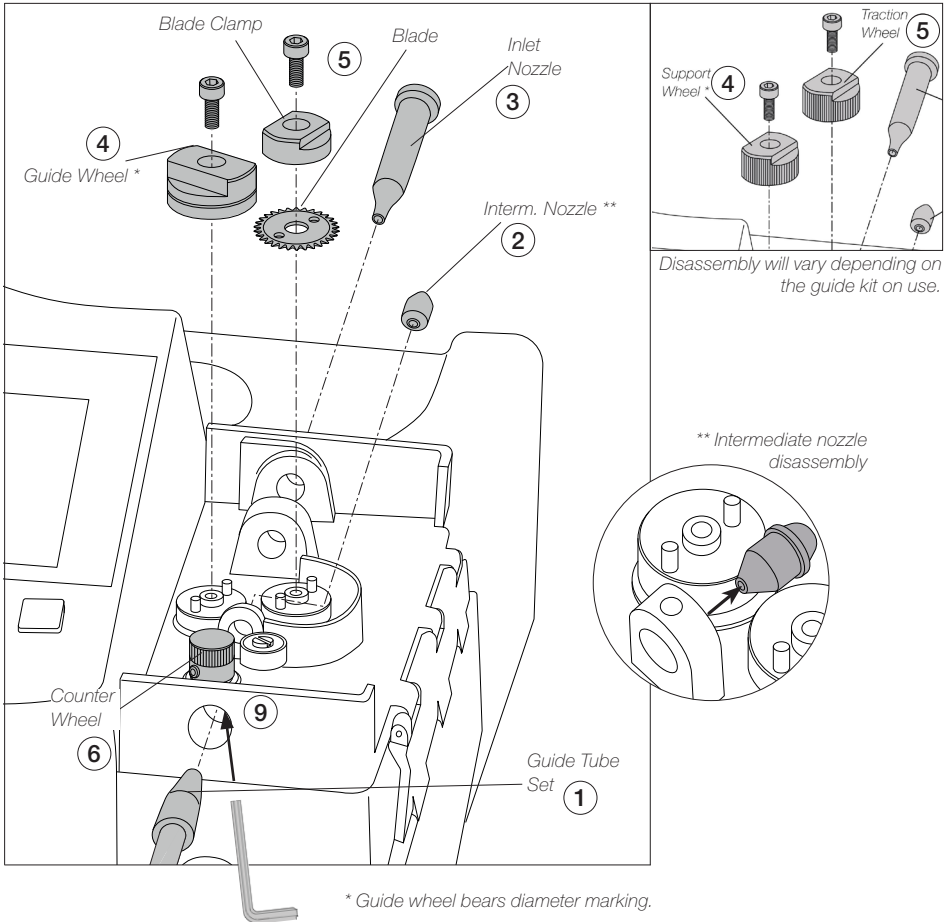
# Changing Guide Kits

## Disassembly

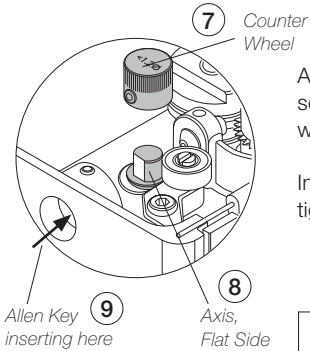
For this operation, disconnect the device from the mains. Unload any solder wire running inside the guide tube, disconnect the tool from the control unit and open its cover.

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).

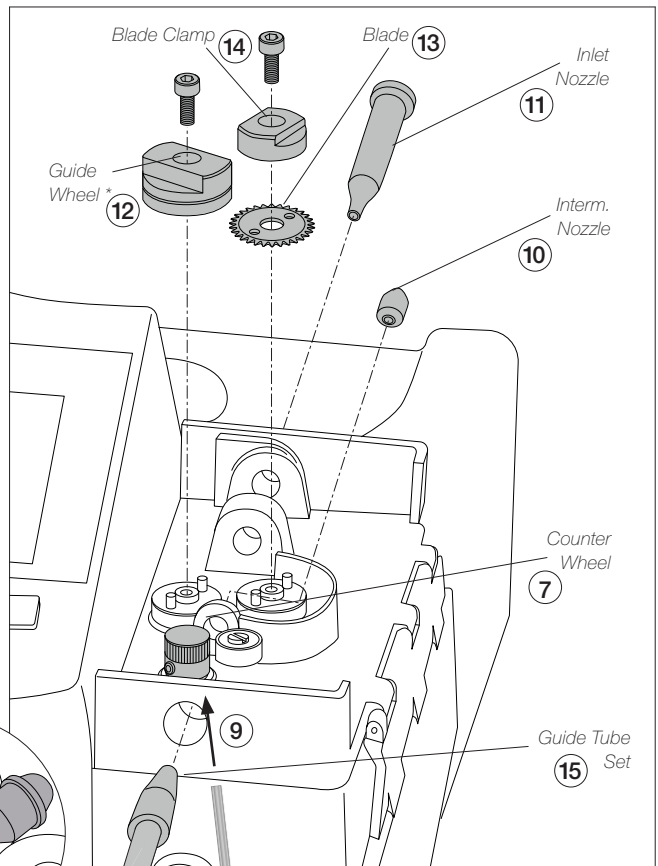
Insert the intermediate nozzle (10) until its collar rests against the housing and tighten its screw.

Assemble the inlet nozzle (11).

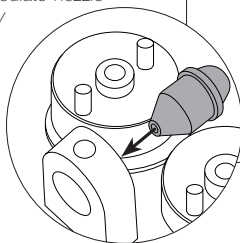
Assemble the guide wheel\* (12) and tighten the screw.

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

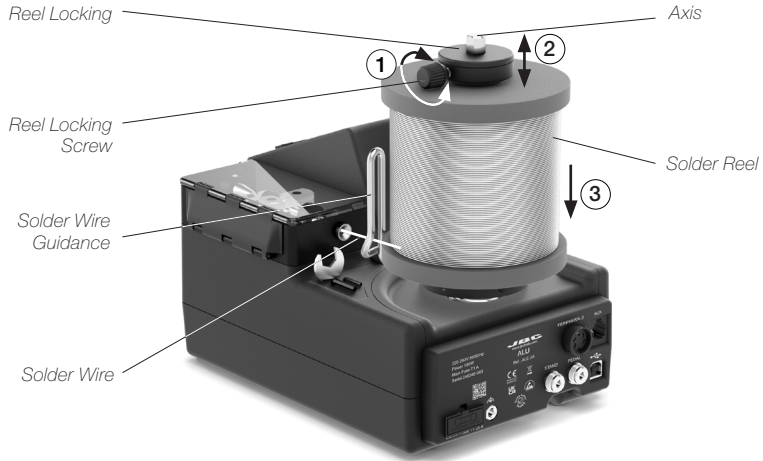


\* Guide wheel bears diameter marking.





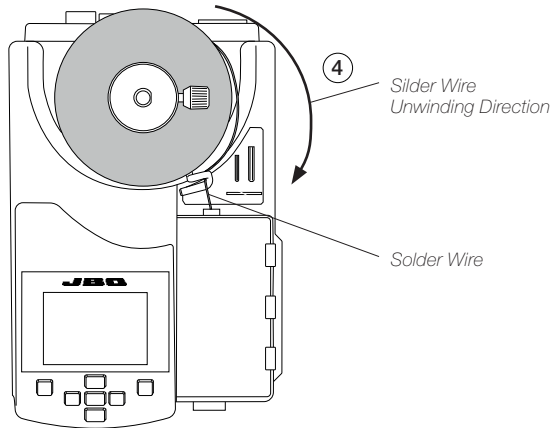
## Solder Reel Assembly



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

Assemble the solder reel onto the axis (3).

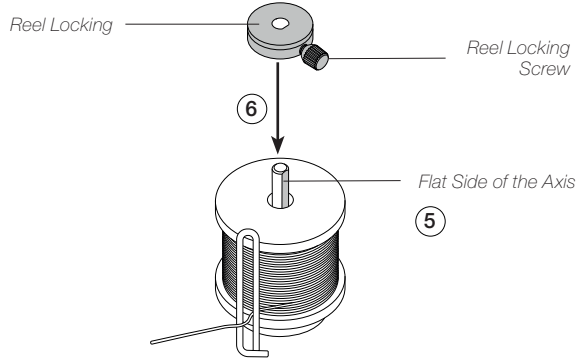
**⚠** Insert the solder reel in such a way - when viewed from above - that the solder wire unwinds on the dispensing mechanism side (4).




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

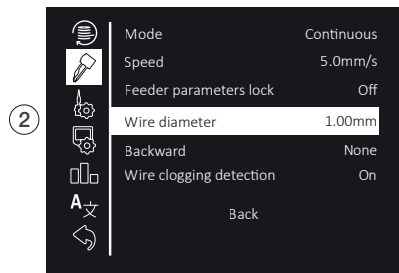
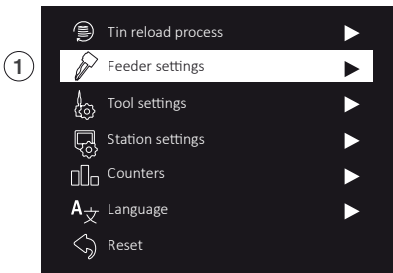
Align the flat side of the axis (5) with the inner flat side (the one with the screw) of the reel locking and reassemble it to the axis (6).

**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.



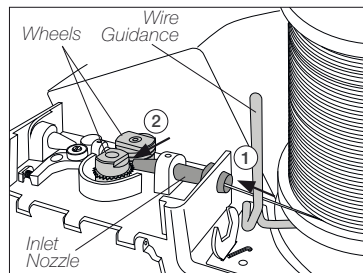
## Main Menu Screen


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

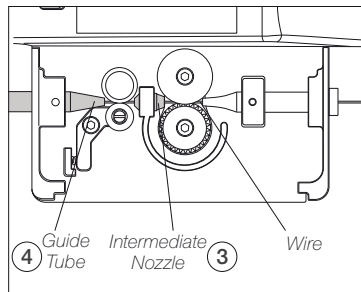
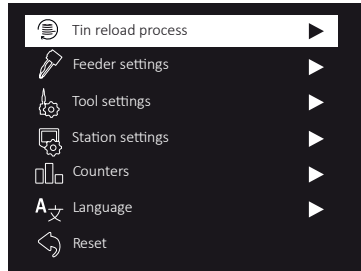
Pass the solder wire through the wire guidance and introduce the solder wire into the inlet nozzle (1) until it reaches the wheels (2).



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

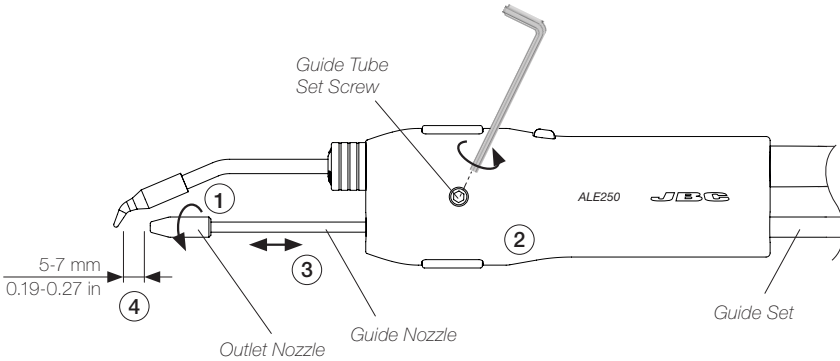
Once the tool is disconnected from the control unit and has cooled down, follow these instructions:

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.

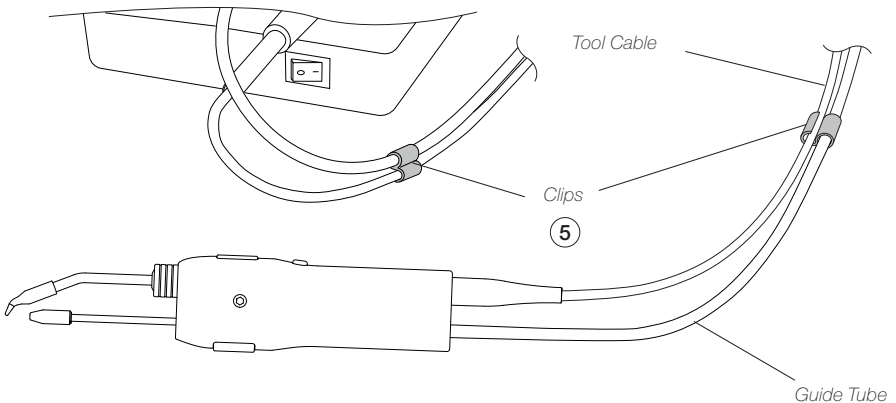
Loosen the guide tube set screw (2), take out the guide set (3) and insert the desired one.

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.



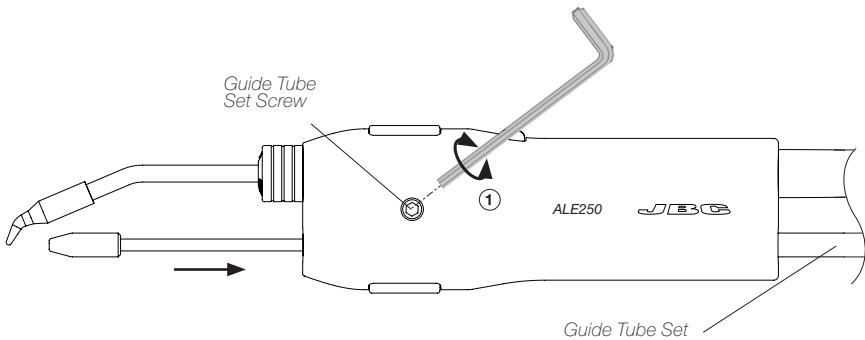
## Outlet Nozzle Replacement

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.

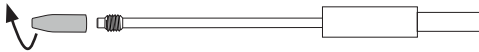
**Note:** There is a nozzle size for each soldering wire diameter. The use of the nozzle is necessary as its inner diameter is adjusted to the solder wire diameter and guides the wire with greater precision.

To replace the outlet nozzle, follow these steps:

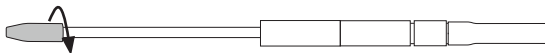
First, make sure that the tool has cooled down and unload any remaining solder wire that might still be inside the guide tube (see pages 11 and 12). Unplug the tool. Loosen the guide tube set screw (1) and detach the guide tube set from the tool for easier handling.



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.



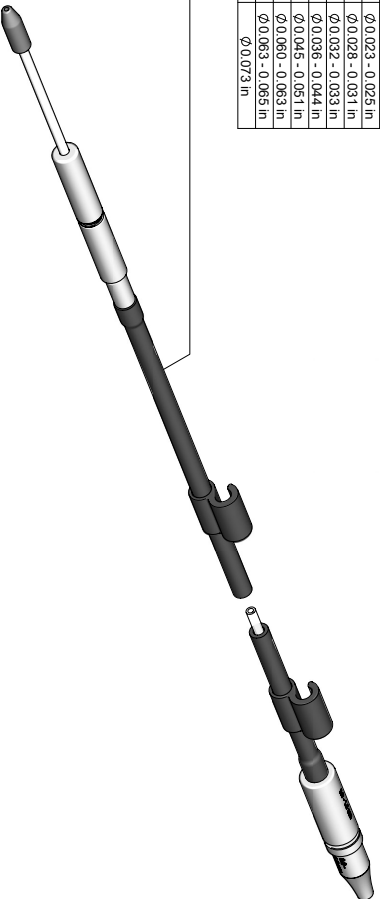
Replace the outlet nozzle and screw it back onto the guide nozzle.



# GALEXXD-B WITHOUT SOLDER WIRE PERFORMANCE

XX	Wire diameter	
	Range of use	
04	Ø 0.38 - 0.40 mm	Ø 0.015 - 0.016 in
05	Ø 0.46 - 0.56 mm	Ø 0.018 - 0.022 in
06	Ø 0.60 - 0.64 mm	Ø 0.023 - 0.025 in
07	Ø 0.70 - 0.78 mm	Ø 0.028 - 0.031 in
08	Ø 0.80 - 0.82 mm	Ø 0.032 - 0.033 in
10	Ø 0.90 - 1.10 mm	Ø 0.036 - 0.044 in
12	Ø 1.14 - 1.27 mm	Ø 0.045 - 0.051 in
15	Ø 1.50 - 1.57 mm	Ø 0.060 - 0.063 in
16	Ø 1.60 - 1.63 mm	Ø 0.063 - 0.065 in
18	Ø 1.80 mm	Ø 0.073 in

Guide tube	
GALE04D-B	0032405
GALE05D-B	0028358
GALE06D-B	0029491
GALE07D-B	0028492
GALE08D-B	0028359
GALE10D-B	0028360
GALE12D-B	0028361
GALE15D-B	0028362
GALE16D-B	0028363
GALE18D-B	0029493



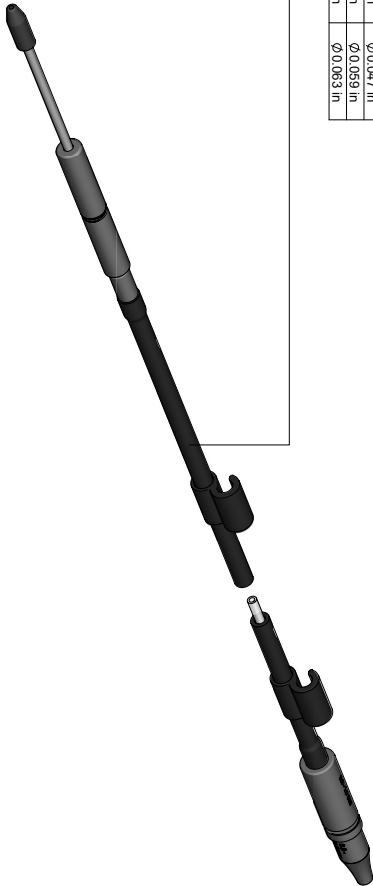
## SPARE PARTS

Wire Ø	Outlet nozzle	Nozzle	Traction wheel	Support wheel	Inlet nozzle	Intern. nozzle	Counter wheel	Screws	Threaded stud
GALE04D-B	00033982	0032608	0019479	0020345	0019520	0024954	0026694	0026695 (x2)	0026696 (x3)
GALE05D-B	00033983			0019519		0025293			
GALE06D-B	00033984			0019480		0025291			
GALE07D-B	00033985			0019832		0024955			
GALE08D-B	00033986			0019170		0024956			
GALE10D-B	00033987			0019481		0024957			
GALE12D-B	00033988			0019171		0024958			
GALE15D-B	00033989			0024233		0024959			
GALE16D-B	00033991			0024234		0024960			
GALE18D-B	00033992								

## GALEXV-B WITH SOLDER WIRE PERFORATION

Wire diameter	
XX	Diameter of use
08	Ø 0.8 mm Ø 0.032 in
10	Ø 1.0 mm Ø 0.040 in
12	Ø 1.2 mm Ø 0.047 in
15	Ø 1.5 mm Ø 0.059 in
16	Ø 1.6 mm Ø 0.063 in

GALE08V-B	Guide tube	0028359
GALE10V-B		0028360
GALE12V-B		0028361
GALE15V-B		0028362
GALE16V-B		0028363



### SPARE PARTS

Part Name	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number	Part Number
Outlet nozzle	0033986														
Nozzle	0033987	0032608													
Guide wheel	0021696		0021699												
Blade	0021689		0023728		0021555										
Blade damp	0023728				0018638										
Inlet nozzle	0018632														
Intern. nozzle	0019170														
Counter wheel	0024955														
Screws	0024956														
Threaded stud	0024957														
	0024958														
	0024959														
	0028693														
	0028694														
	0028695 (x2)														
	0028696 (x3)														









## Specifications

### GALE

#### Guide Kits for ALE250

##### With Perforation:

Ref.: **GALE08V-B** wire  $\varnothing$  0.8 mm /  $\varnothing$  0.032 in

Ref.: **GALE10V-B** wire  $\varnothing$  1.0 mm /  $\varnothing$  0.040 in

Ref.: **GALE12V-B** wire  $\varnothing$  1.2 mm /  $\varnothing$  0.047 in

Ref.: **GALE15V-B** wire  $\varnothing$  1.5 mm /  $\varnothing$  0.059 in

Ref.: **GALE16V-B** wire  $\varnothing$  1.6 mm /  $\varnothing$  0.063 in

##### Without Perforation:

**GALE04D-B** for wire  $\varnothing$  0.38 - 0.4 mm /  $\varnothing$  0.015 - 0.016 in

**GALE05D-B** for wire  $\varnothing$  0.46 - 0.56 mm /  $\varnothing$  0.018 - 0.022 in

**GALE06D-B** for wire  $\varnothing$  0.60 - 0.64 mm /  $\varnothing$  0.023 - 0.025 in

**GALE07D-B** for wire  $\varnothing$  0.70 - 0.78 mm /  $\varnothing$  0.028 - 0.031 in

**GALE08D-B** for wire  $\varnothing$  0.80 - 0.82 mm /  $\varnothing$  0.032 - 0.033 in

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**GALE15D-B** for wire  $\varnothing$  1.50 - 1.57 mm /  $\varnothing$  0.060 - 0.063 in

**GALE16D-B** for wire  $\varnothing$  1.60 - 1.63 mm /  $\varnothing$  0.063 - 0.065 in

**GALE18D-B** for wire  $\varnothing$  1.8 mm /  $\varnothing$  0.073 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

- 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

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## Warranty

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

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.

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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.



[www.jbctools.com](http://www.jbctools.com)

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