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INSTRUCTION MANUAL



TRA245/TRA470

Automatic General/Heavy Duty
Soldering Tool for Robot

This manual corresponds to the following references:

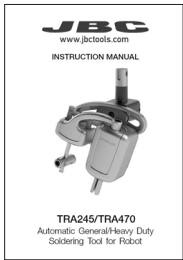
- **TRA245-B** works with R245 cartridges
- **TRA470-B** works with R470 cartridges

Packing List

Either Ref. TRA245-B or Ref. TRA470-B is included.



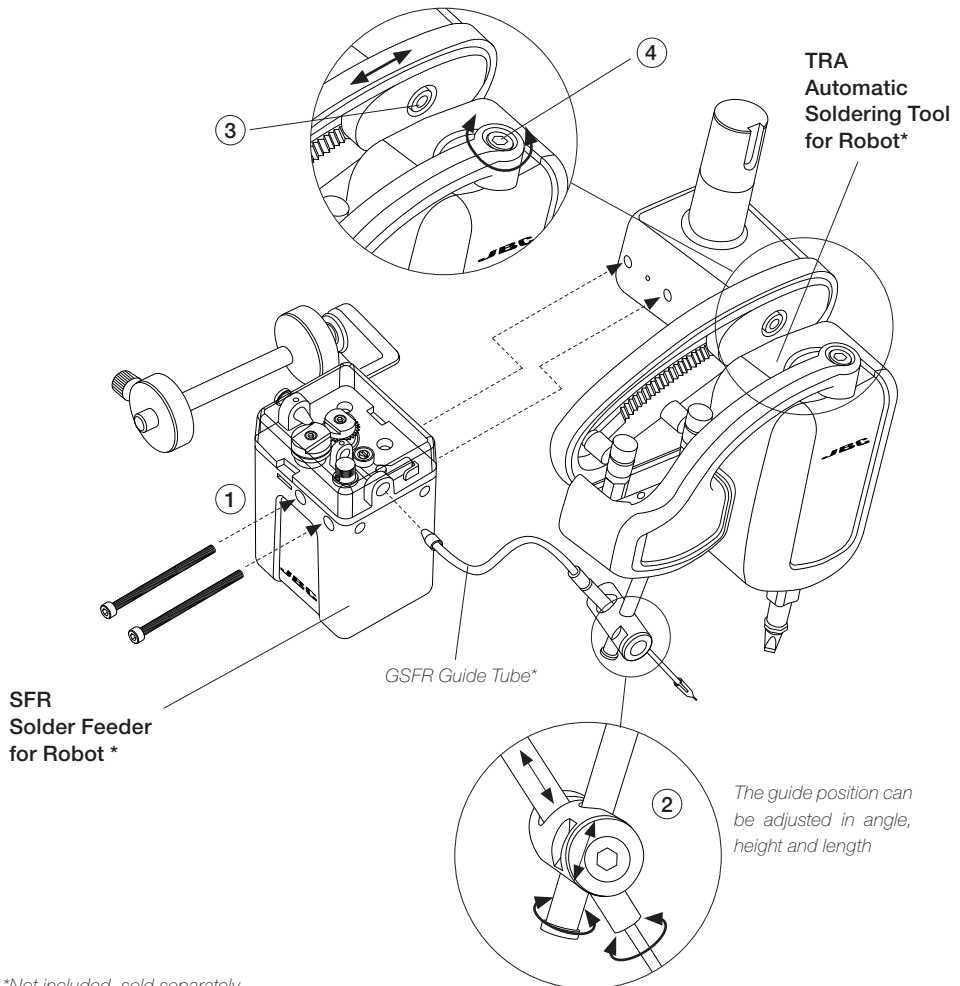
Automatic Soldering Tool for Robot 1 unit



Manual 1 unit
Ref. 0027874

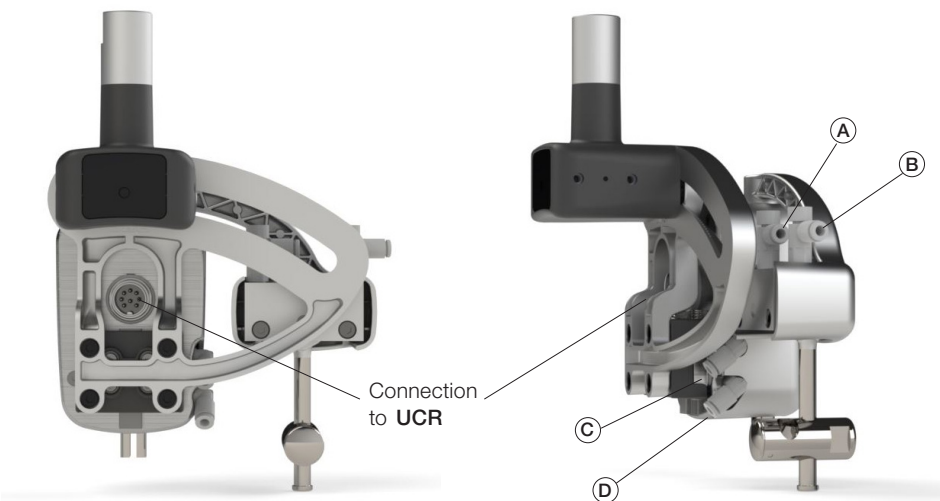
Assembly: GSFR Tube to SFR* and TRA*

1. Assemble SFR and the appropriate GSFR Guide Tube to TRA as described in the SFR instructions manual.
2. Adjust the TRA guide position in angle, height and length, then tighten the bolt to lock your settings.
3. Adjust the TRA angle to its desired position by using the indicated bolt.
4. Adjust the TRA guide arm position for your application by using the indicated bolt.



**Not included, sold separately*

Connections



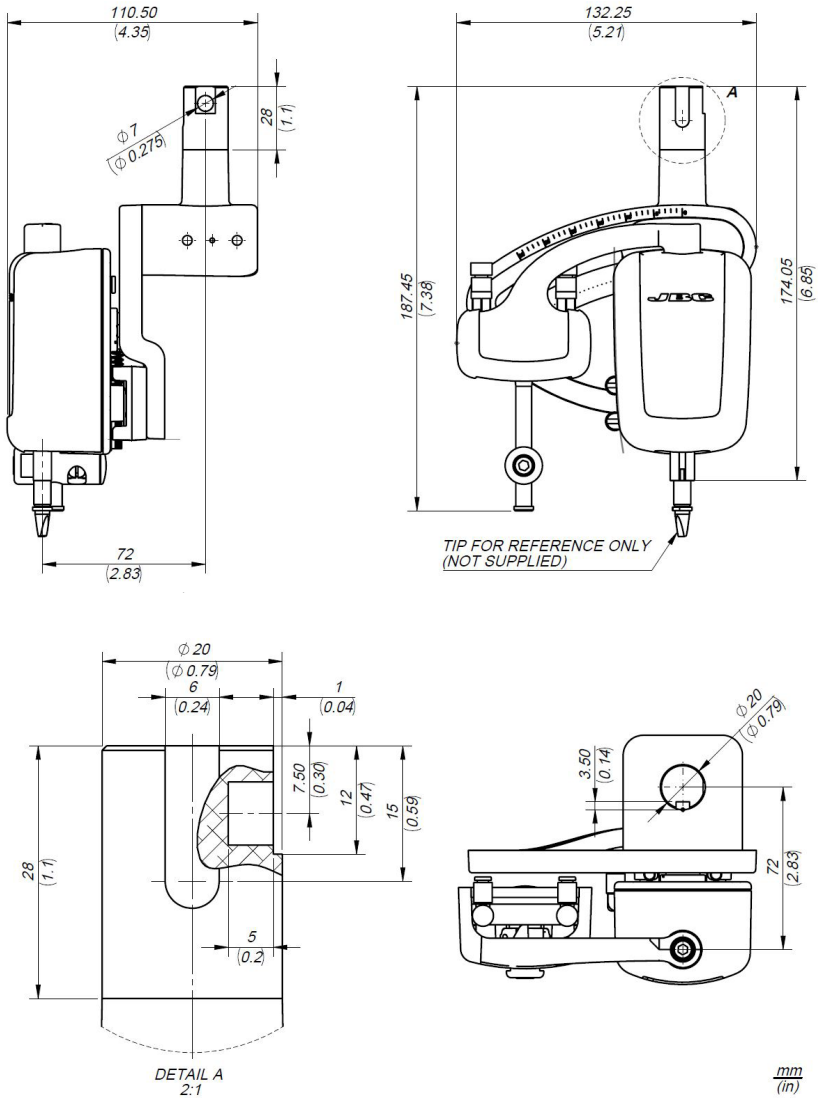
Gripper Actuator	
Fluid	Air
Applicable tubing	Ø4mm
Operating pressure	1,5 to 7 bar 20 to 100 psi

- (A) Air tube connection: Close arm to soldering position.
- (B) Air tube connection: Open arm to service position.
- (C) Air tube connection: Close grippers.
- (D) Air tube connection: Open grippers.

Note: JBC recommends bi-stable valves for the grippers to prevent the cartridge from falling out in case of an emergency stop or power cut.

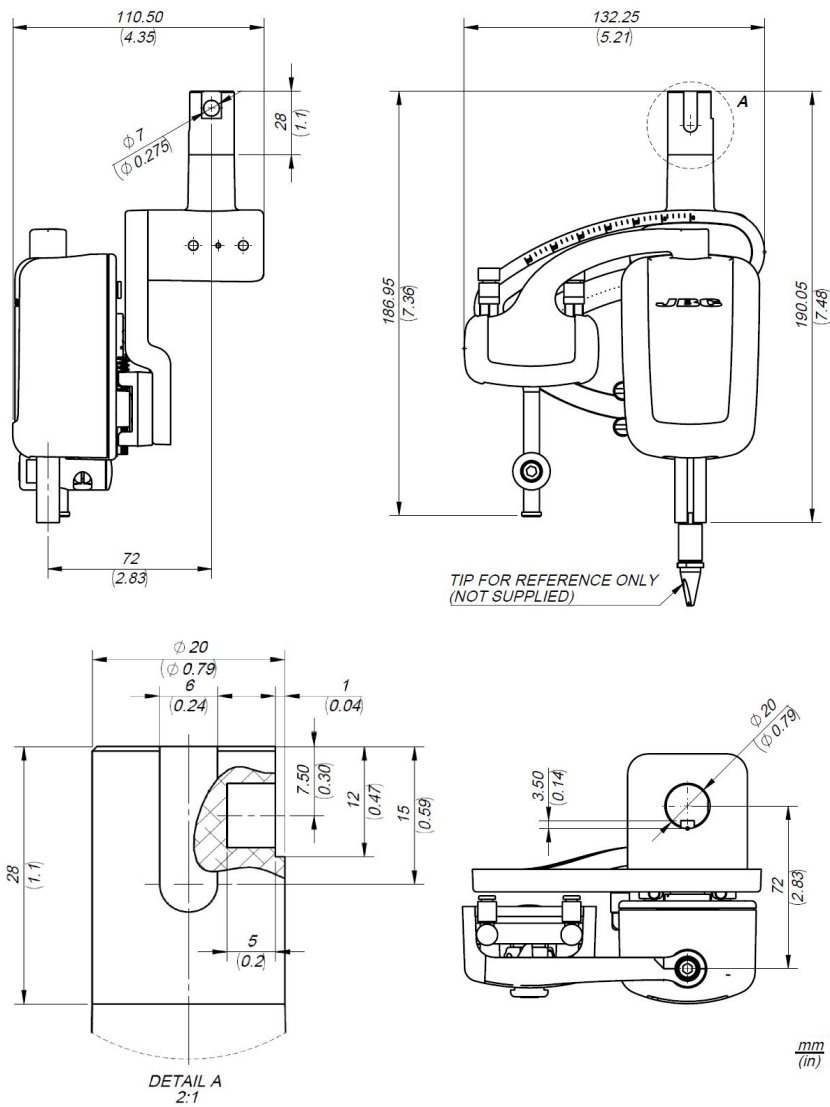
Dimensions

TRA245



Dimensions

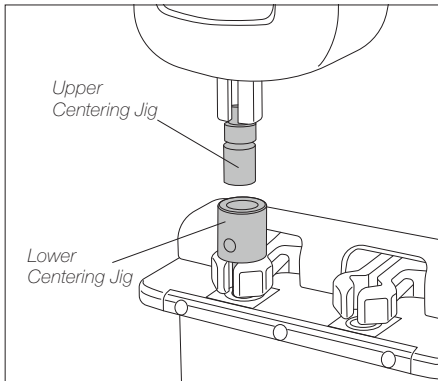
TRA470



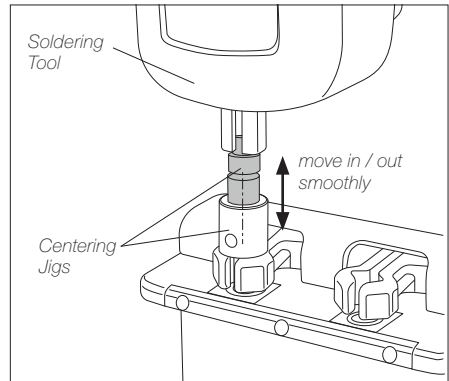
Centering Jig

In order to align CSR245 and CSR470 to the soldering tool and set the cartridge pick-up points use JBC's centering jigs.

Install, as shown, the lower centering jig into the gripper of CSR and the upper centering jig into the soldering tool of HA Automatic Soldering Set.

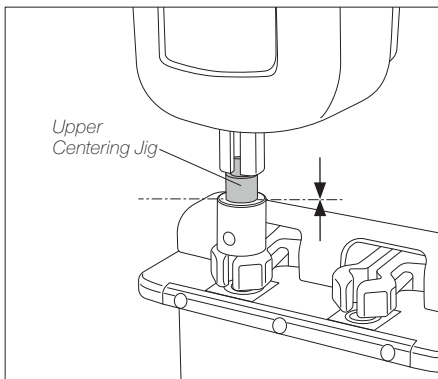


Adjust the soldering tool position until the centering jigs are aligned. It must be possible to move it in and out smoothly.



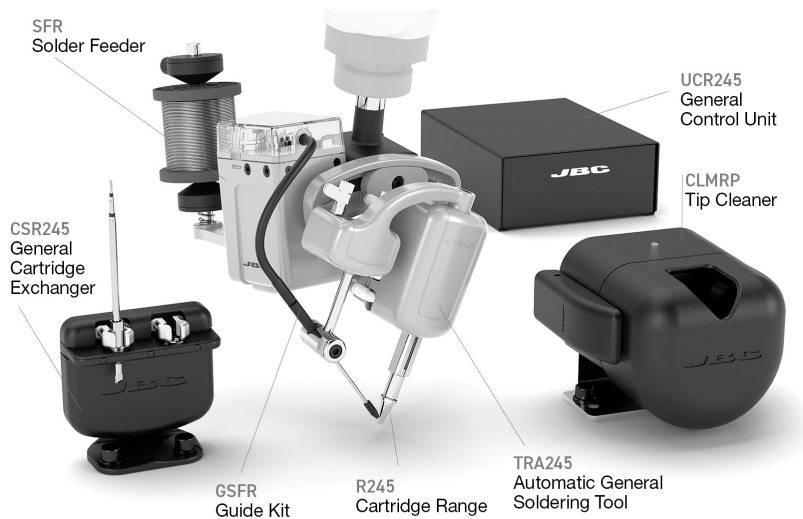
Insert the upper centering jig completely into the lower centering jig.

Set this point as the pick-up point position. From this point on, the soldering tool should do a linear movement when inserting or removing cartridges.



Workplace Example

HA Automatic Soldering Set for Robot



Compatibility

Automatic Soldering Tool	Cartridge Range		Control Unit		Cartridge Exchanger	
	R245	R470	UCR245	UCR470	CS2R245	CS2R470
TRA245	●		●		●	
TRA470		●		●		●

SFR, GSFR and CLMR are compatible with both R245 and R470 cartridges.

Maintenance

- Before carrying out maintenance, always unplug the tool.
- Use a damp cloth to clean the tool. Alcohol can only be used to clean the metal parts.
- Periodically check that the metal parts of the tool are clean so the control unit can detect the tool's status.
- Periodically check all cable and tube connections.
- Maintain the tip surface clean and tinned before storage to avoid tip oxidation. Rusty and dirty surfaces reduce heat transfer to the solder joint.
- Replace any defective or damaged parts. Use original JBC spare parts only.
- Repairs should be performed only by a JBC authorized technical service.
- Under normal operating conditions, the air gripper lifespan is 10 million cycles. It is recommended to replace it at the end of its lifespan.

Safety



It is imperative to follow safety guidelines to prevent electric shock, injury, fire or explosion.

- Do not use the soldering iron for any purpose other than soldering or rework. Incorrect use may cause fire.
- Do not leave the appliance unattended when it is on.
- Be sure that the power supply is disconnected before changing any spare parts.
- The temperature of accessible surfaces may remain high after the unit is turned off. Handle with care.
- Allow the cartridges to cool down before changing them.
- Heat can cause inflammable products to ignite even when not visible.
- Avoid flux coming into contact with skin or eyes to prevent irritation.
- Be careful with the fumes produced when soldering.
- Keep your workplace clean and tidy. Wear appropriate protection glasses and gloves when working to avoid personal harm.
- Utmost care must be taken with liquid tin waste which can cause burns.

Notes

This image shows a single sheet of white paper with horizontal blue or grey 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.

Specifications

TRA245

Automatic General Soldering Tool for Robot

Ref.: **TRA245-B**

- | | |
|---|---|
| - Total Net Weight: | 700 g / 1.54 lb |
| - Package Dimensions/Weight:
(L x W x H) | 221 x 136 x 126 mm / 909 g
8.70 x 5.35 x 4.96 in / 2.00 lb |
| - Operating Pressure | 1.5 to 7 bar / 20 to 100 psi |

TRA470

Automatic Heavy Duty Soldering Tool for Robot

Ref.: **TRA470-B**

- | | |
|---|--|
| - Total Net Weight: | 716 g / 1,58 lb |
| - Package Dimensions/Weight:
(L x W x H) | 220 x 213 x 160 mm / 1000 g
8.66 x 8.39 x 6.30 in / 2.20 lb |
| - Operating Pressure | 1.5 to 7 bar / 20 to 100 psi |

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 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.



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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