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INSTRUCTION MANUAL

GALE
Guide Kits for ALE250

This manual corresponds to the following references:

With Solder Wire Perforation:
GALE08V-A *for wire Ø 0.8 mm / Ø 0.032 in*
GALE10V-A *for wire Ø 1.0 mm / Ø 0.040 in*
GALE12V-A *for wire Ø 1.2 mm / Ø 0.047 in*
GALE15V-A *for wire Ø 1.5 mm / Ø 0.059 in*
GALE16V-A *for wire Ø 1.6 mm / Ø 0.063 in*

Without Solder Wire Perforation:
GALE04D-A *for wire Ø 0.38 - 0.4 mm / Ø 0.015 - 0.016 in*
GALE05D-A *for wire Ø 0.46 - 0.56 mm / Ø 0.018 - 0.022 in*
GALE06D-A *for wire Ø 0.60 - 0.64 mm / Ø 0.023 - 0.025 in*
GALE07D-A *for wire Ø 0.70 - 0.78 mm / Ø 0.028 - 0.031 in*
GALE08D-A *for wire Ø 0.80 - 0.82 mm / Ø 0.032 - 0.033 in*
GALE10D-A *for wire Ø 0.90 - 1.10 mm / Ø 0.036 - 0.044 in*
GALE12D-A *for wire Ø 1.14 - 1.27 mm / Ø 0.045 - 0.051 in*
GALE15D-A *for wire Ø 1.50 - 1.57 mm / Ø 0.060 - 0.063 in*
GALE16D-A *for wire Ø 1.60 - 1.63 mm / Ø 0.063 - 0.065 in*
GALE18D-A *for wire Ø 1.8 mm / Ø 0.073 in*

GALE Guide Kits for ALE250 <u>with</u> Solder Wire Perforation
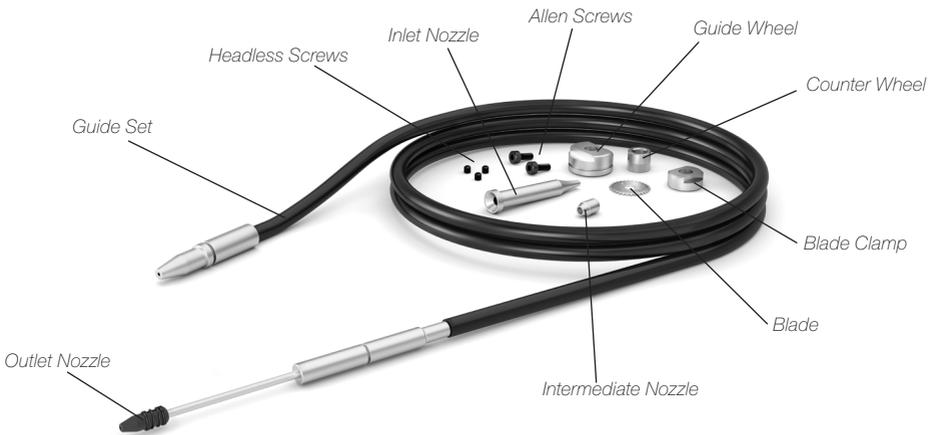
Packing List

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
*see reference table on page 4

Allen Screws* .... 2 units
Headless Screws* .... 3 units

Manual .... 1 unit
Ref. 0028365

GALE Guide Kits for ALE250 <u>without</u> Solder Wire Perforation

Headless Screws
Inlet Nozzle
Allen Screws
Traction Wheel
Support Wheel
Guide Set
Counter Wheel
Outlet Nozzle
Intermediate Nozzle
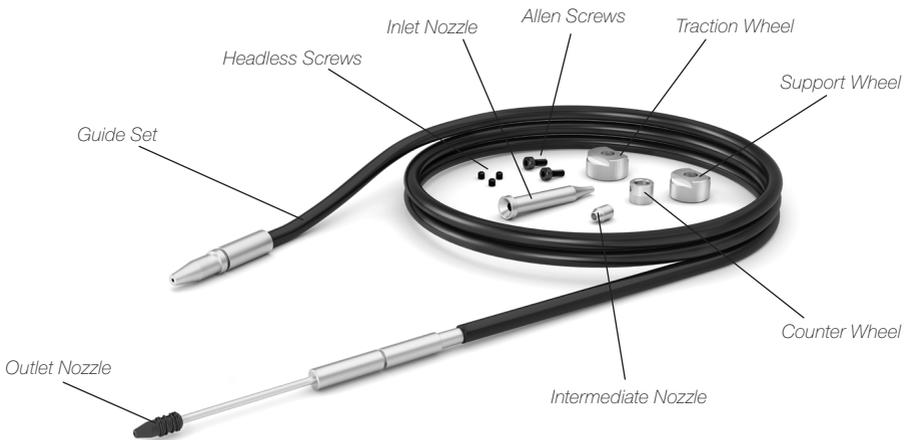
Packing List

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

*see reference table on page 5

Allen Screws .... 2 units
Headless screws .... 3 units

Manual .... 1 unit
Ref. 0028365

GALEXXV-A 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-A	0028358
GALE10V-A	0028359
GALE12V-A	0028360
GALE15V-A	0028361
GALE16V-A	0028363
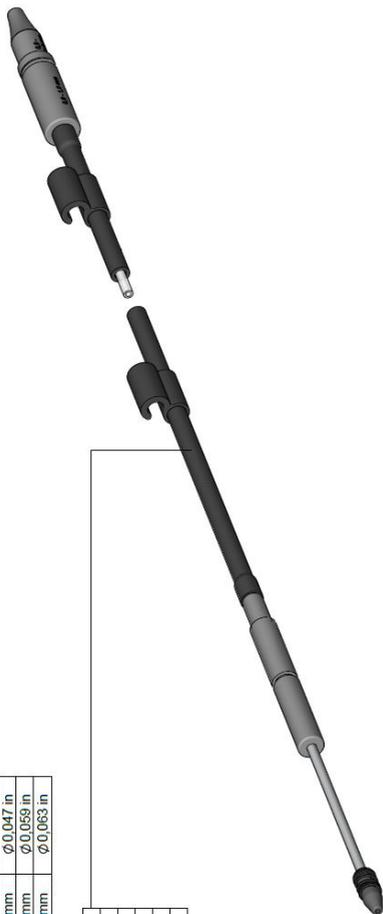
SPARE PARTS

Wire Ø	Outlet nozzle	Nozzle	Guide wheel	Blade	Blade clamp	Inlet nozzle	Interm. nozzle	Counter wheel	Screws	Threaded stud	Nozzle grip spring
GALE08V-A	0025270	0021158	0021696	0021555	0018638	0018632	0024955	0026693 (Supplied with ALE)	0026695 (x2)	0026696 (x3)	0030549
GALE10V-A	0021560		0021699			0019170	0024956				
GALE12V-A	0025272		0023738			0019171	0024957	0026694			
GALE15V-A	0025274		0019696				0024958				
GALE16V-A	0025276		0025922			0024233	0024969				

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GALEXXD-A WITHOUT SOLDER WIRE PERFORATION

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-A	0028358
GALE05D-A	
GALE06D-A	0028359
GALE07D-A	
GALE08D-A	0028360
GALE10D-A	0028361
GALE12D-A	0028362
GALE15D-A	
GALE16D-A	0028363
GALE18D-A	0028493
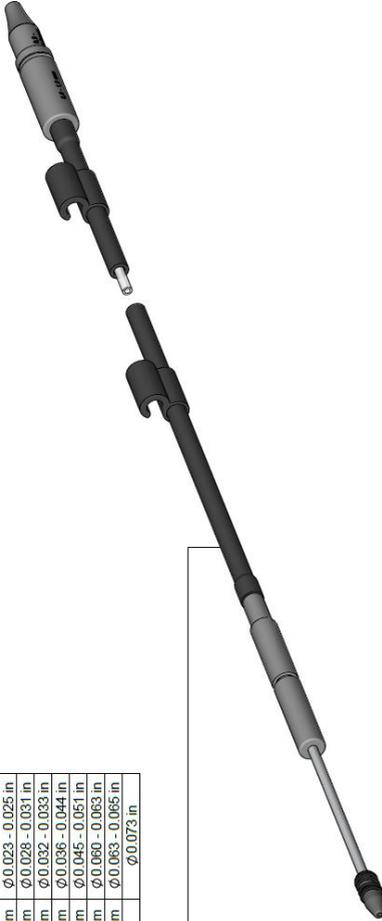
SPARE PARTS

Wire Ø	Outlet nozzle	Nozzle	Traction wheel	Support wheel	Inlet nozzle	Interm. nozzle	Counter wheel	Screws	Threaded stud	Nozzle grip spring
GALE04D-A	0025268	0021158	0019479	0020345	0019520	0024954	0026693	0026695 (x2)	0026696 (x3)	0030549
GALE05D-A				0019519		0025293				
GALE06D-A	0022994					0025291				
GALE07D-A	0025289			0019480	0018632	0024955				
GALE08D-A	0025270					0024956				
GALE10D-A	0021560				0019170	0024957				
GALE12D-A	0025272			0019481	0019171	0024958	0026694			
GALE15D-A	0025274					0024959				
GALE16D-A	0025276			0028367	0024233	0024960				
GALE18D-A	0021559				0024234					

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.

Guide Tube Set Screw

1

ALE250 *JBC*

2

8-10 mm
0.31-0.40 in

3

Guide Tube Set

4

Clips
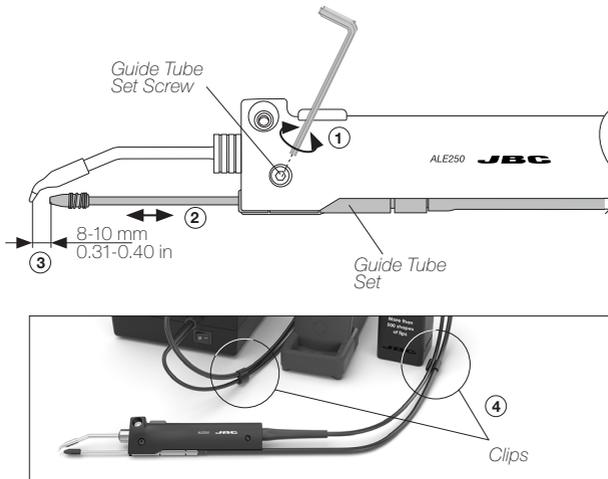
Tool Assembly

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).

Screw

2

1

3
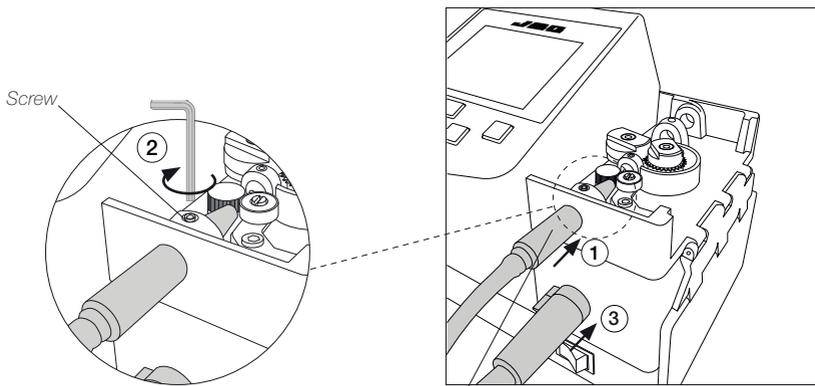
Insert all the way in until it stops

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.

Wire Guidance

Inlet Nozzle
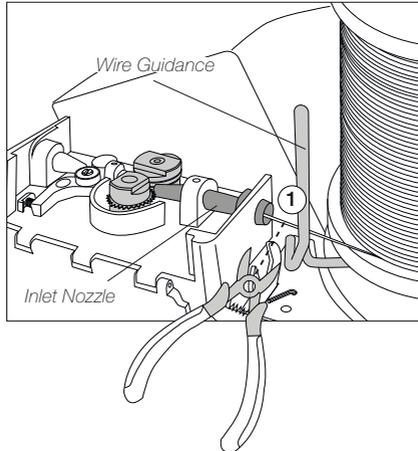
Without Solder Wire Perforation

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.

Wire Winding Direction
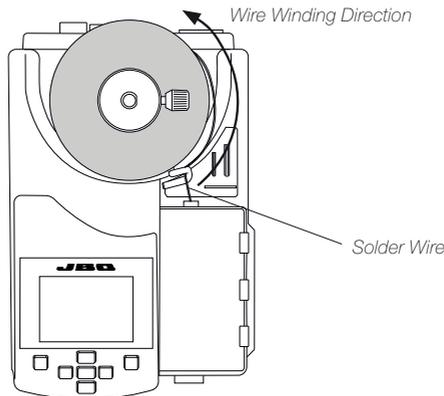
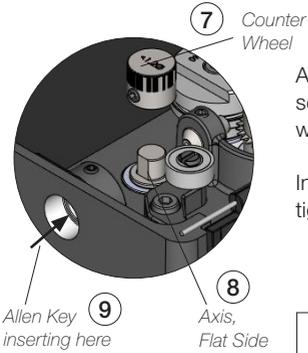*Solder Wire*

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.

Disassembly will vary depending on the guide kit on use.

** Intermediate nozzle disassembly

* Guide wheel bears diameter marking.
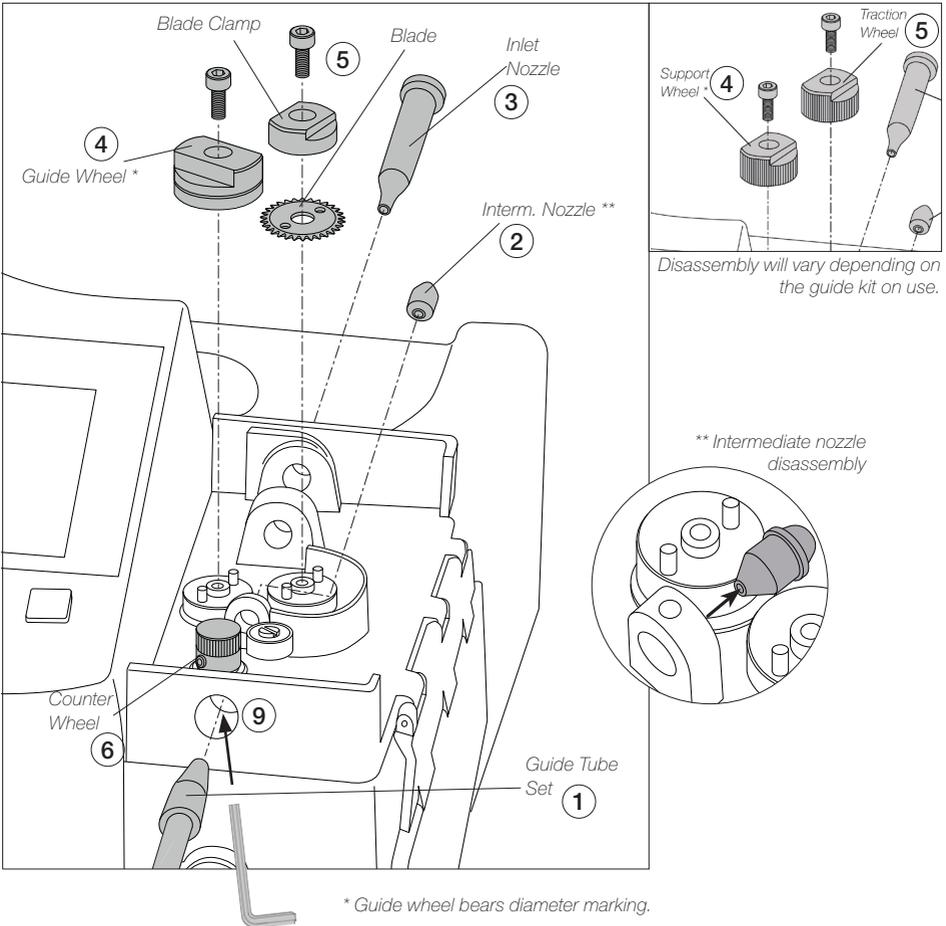
Assembly with Solder Wire Perforation:

7 *Counter Wheel*

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).
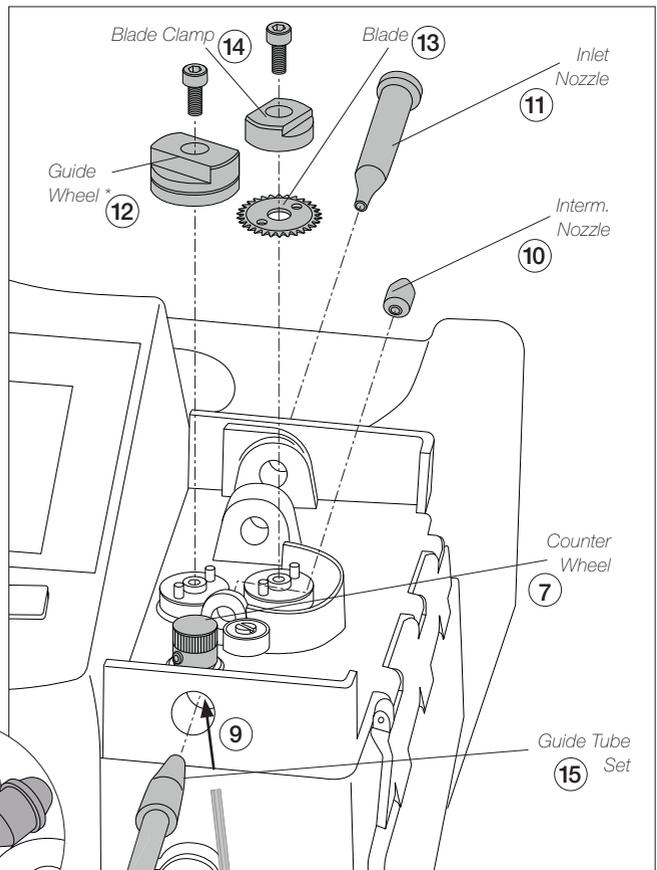
Allen Key 9 *inserting here*

8 *Axis, Flat Side*

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).

Blade Clamp 14   *Blade* 13   *Inlet Nozzle* 11

Guide Wheel * 12   *Interm. Nozzle* 10

Counter Wheel 7

*** intermediate nozzle assembly*

9

Guide Tube Set 15
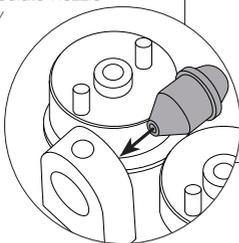
* Guide wheel bears diameter marking.

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).

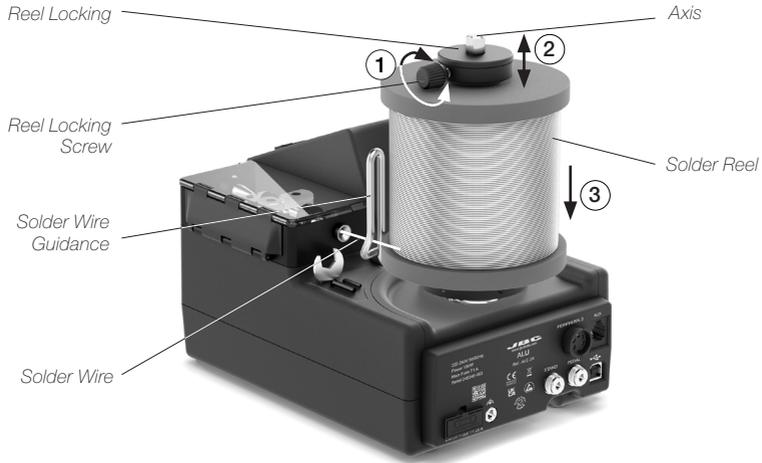Assemble the support wheel* (12) onto the axis and tighten the screw.

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

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

Traction Wheel (13)

Support Wheel * (12)

Inlet Nozzle (11)

Interm. Nozzle ** (10)

*** intermediate nozzle assembly*

Counter Wheel (7)

Guide Tube Set (14)
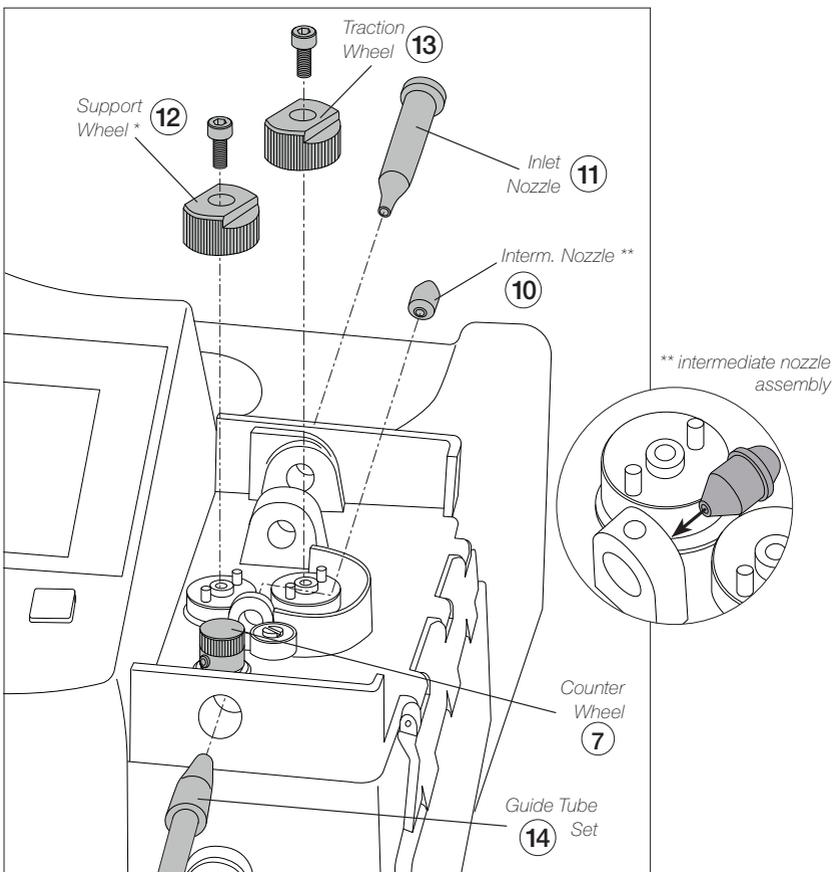
* Support wheel bears diameter marking.

Solder Reel Assembly

Reel Locking
Axis
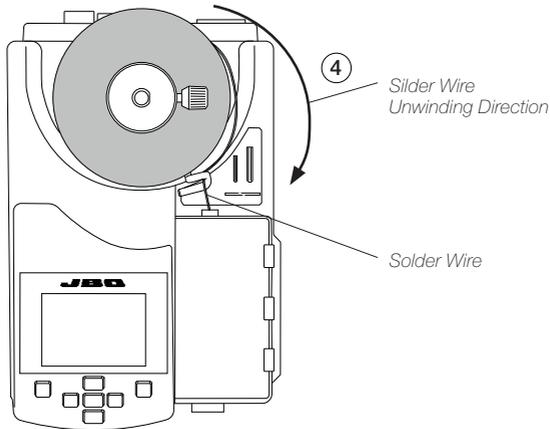*Reel Locking Screw*
Solder Reel
Solder Wire Guidance
Solder Wire

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).

Silder Wire Unwinding Direction

Solder Wire

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.
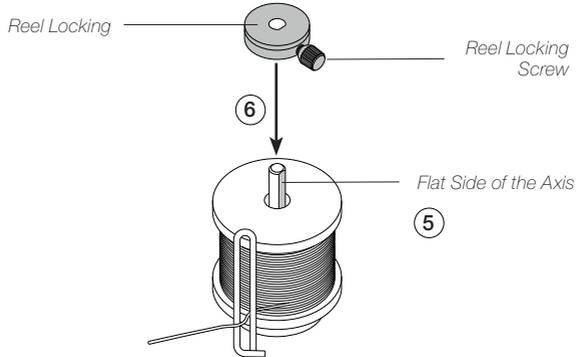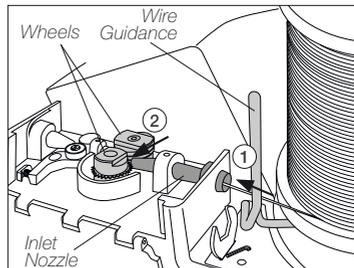

Main Menu Screen

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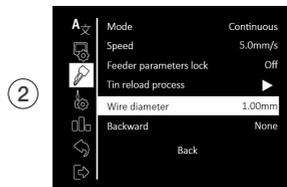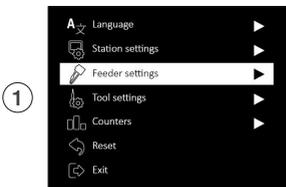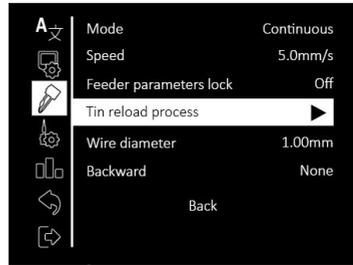

Solder Wire Loading

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.

Mode	Continuous
Speed	5.0mm/s
Feeder parameters lock	Off
Tin reload process	▶
Wire diameter	1.00mm
Backward	None
Back	

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

④ Guide Tube   Intermediate Nozzle ③   Wire
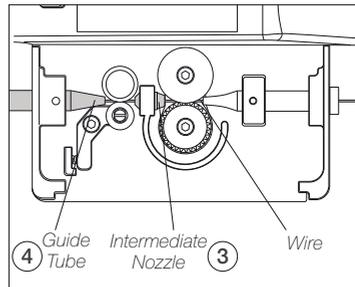
Replacing Guide Sets

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 (1) from the guide set.

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

Put the outlet nozzle (1) back on the new cartridge. Leave a gap of 8 to 10 mm (0.31 to 0.39 in) between the cartridge tip and the outlet nozzle (4).

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

Guide Tube Set Screw

②

ALE250 JBC

8-10 mm
0.31-0.40 in

①

③

④   Outlet Nozzle   Guide Nozzle   Guide Set

Notes
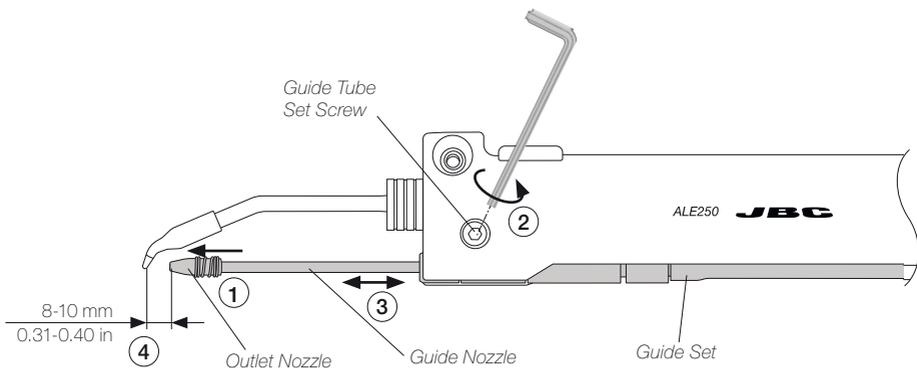
Specifications

GALE
Guide Kits for ALE250

	Total Net Weight:	Package Weight:
With Perforation:		
Ref.: **GALE08V-A** *wire Ø 0.8 mm / Ø 0.032 in*	108 g / 0.24 lb	200 g / 0.44 lb
Ref.: **GALE10V-A** *wire Ø 1.0 mm / Ø 0.040 in*	108 g / 0.24 lb	200 g / 0.44 lb
Ref.: **GALE12V-A** *wire Ø 1.2 mm / Ø 0.047 in*	94 g / 0.21 lb	186 g / 0.41 lb
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GALE15D-A *for wire Ø 1.50 - 1.57 mm / Ø 0.060 - 0.063 in*	90 g / 0.20 lb	182 g /0.40 lb
GALE16D-A *for wire Ø 1.60 - 1.63 mm / Ø 0.063 - 0.065 in*	90 g / 0.20 lb	182 g /0.40 lb
GALE18D-A *for wire Ø 1.8 mm / Ø 0.073 in*	90 g / 0.20 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.

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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.

Get 1 extra year JBC warranty by registering here: https://www.jbctools.com/productregistration/ within 30 days of purchase.

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.

CE ℮ EAC

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