

# **JBC**

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## **INSTRUCTION MANUAL**



### **GALE**

Guide Kits for ALE250

This manual corresponds to the following references:

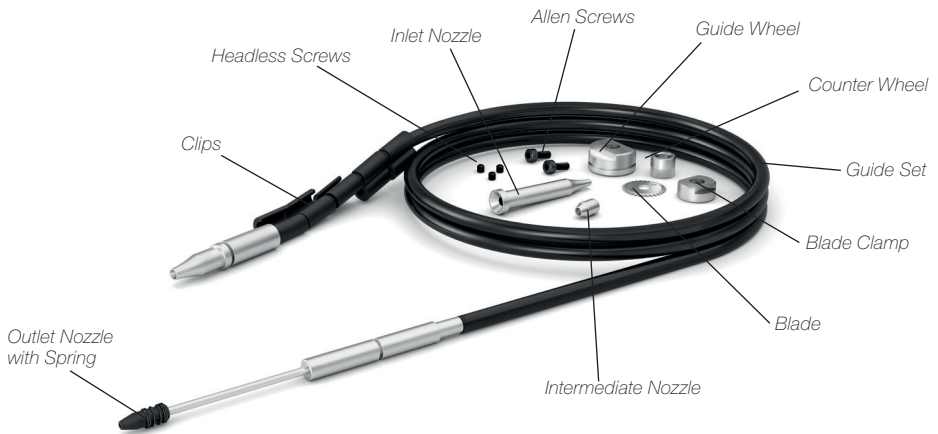
With Solder Wire Perforation:

- 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 with Solder Wire Perforation



### Packing List

The following items are included:

<b>Guide Set*</b> .....	1 unit
<b>Inlet Nozzle*</b> .....	1 unit
<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 with Spring*</b> .....	1 unit

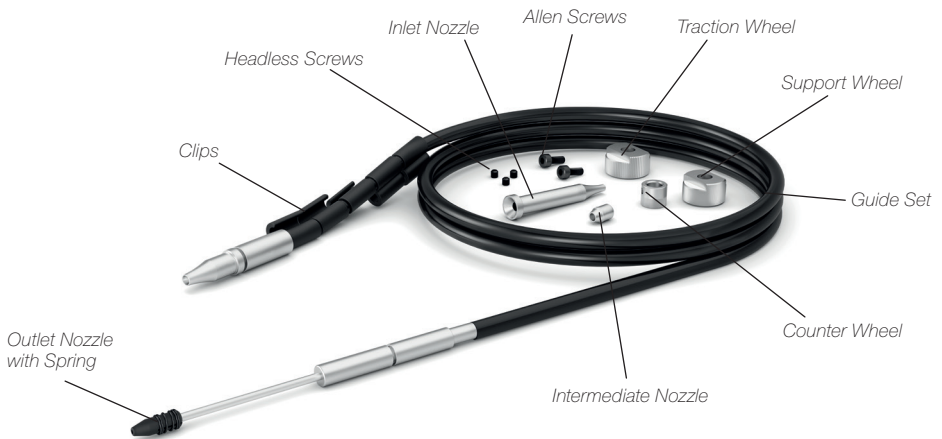
<b>Allen Screws*</b> .....	2 units
<b>Headless Screws*</b> .....	3 units



<b>Manual</b> .....	1 unit
Ref. 0028365	

\*see reference table on page 4

## 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 with Spring*</b> .....	1 unit

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



<b>Manual</b> .....	1 unit
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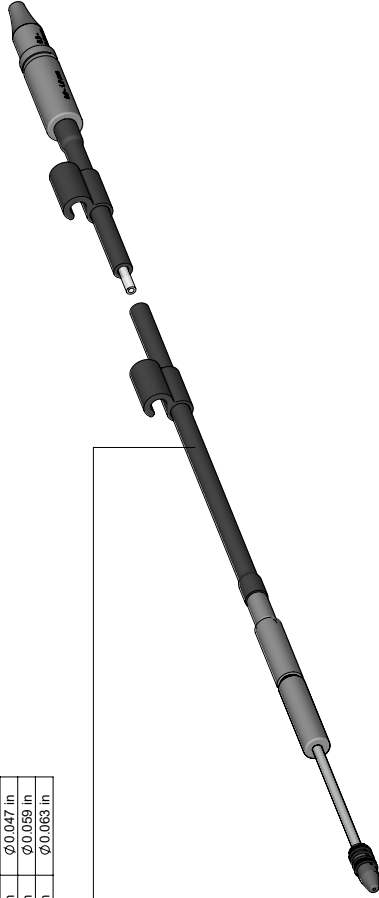
Ref. 0028365

\*see reference table on page 5

**GALEXV-A WITH SOLDER WIRE PERFORMANCE**

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    0028359
GALE10V-A    0028360
GALE12V-A    0028361
GALE15V-A    0028362
GALE16V-A    0028363



**SPARE PARTS**

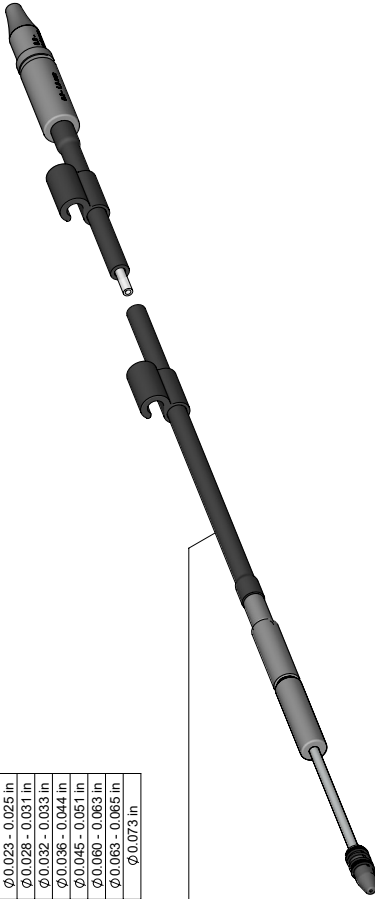
Wire Ø	Outlet nozzle	Nozzle	Guide wheel	Blade	Blade clamp	Inlet nozzle	Interm. nozzle	Counter wheel	Screws	Threaded stud
GALE08V-A	0025270	0000913	0021696	0021555	0018638	0018632	0024955	0026683	0026695 (x2)	0026696 (x2)
GALE10V-A	0021560		0021699			0019170	0024956			
GALE12V-A	0025272		0023738			0019171	0024957			
GALE15V-A	0025274		0019696			0024233	0024958			
GALE16V-A	0025276		0025922			0024959	0024959			

## GALE Guide Kits for ALE250

### GALEXD-A WITHOUT SOLDER WIRE PERFORMANCE

Wire diameter		Range of use
XX		
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 - 1.65 mm	Ø 0.063 - 0.065 in
18	Ø 1.80 mm	Ø 0.073 in

Guide tube	
GALE04D-A	0032405
GALE05D-A	0028358
GALE06D-A	0028491
GALE07D-A	0028492
GALE08D-A	0028359
GALE10D-A	0028360
GALE12D-A	0028361
GALE15D-A	0028362
GALE16D-A	0028363
GALE18D-A	0028493



#### SPARE PARTS

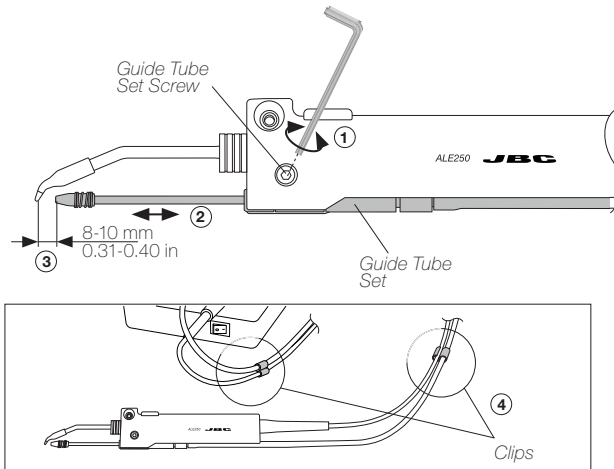
Wire Ø	Outlet nozzle	Nozzle	Traction wheel	Support wheel	Inlet nozzle	Interm. nozzle	Counter wheel	Screws	Threaded stud	
GALE04D-A										
GALE05D-A	0032512			0020345						
GALE06D-A	0025268	0030913	0019479	0019519	0019520	0024954	0026693	0026695 (x2)	0026696 (x3)	
GALE07D-A	0022994			0019480	0019481	0024955				0024956
GALE08D-A	0025269			0019170	0024233	0024957				0024958
GALE10D-A	0025270			0019171	0024234	0024959				0024960
GALE12D-A	0021560									
GALE15D-A	0025272									
GALE15D-A	0025274									
GALE16D-A	0025276									
GALE18D-A	0021559									

## 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).

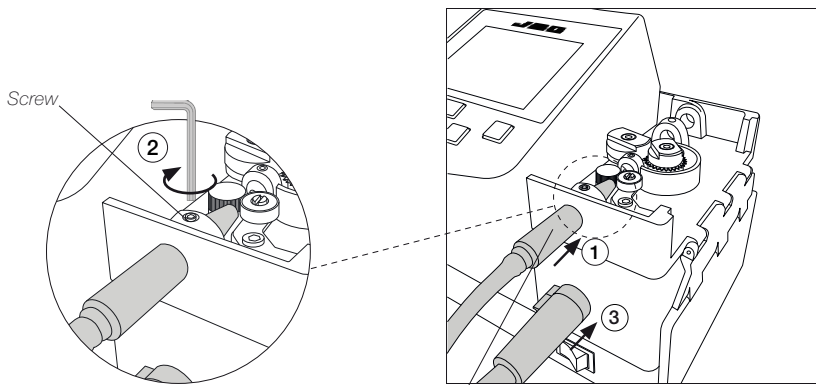
For a better handling use the clips (4) to attach the guide tube to the tool cable.



## 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*

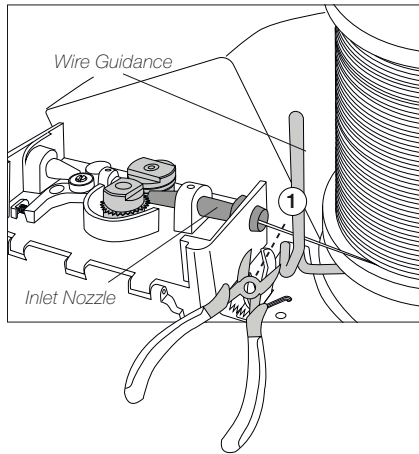
## Solder Wire Unloading

### 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.

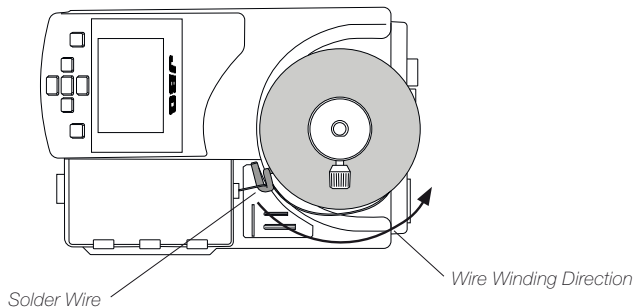
Grasp the wire coming out of the outlet nozzle with a pliers and pull from it until it is completely out.



### 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.



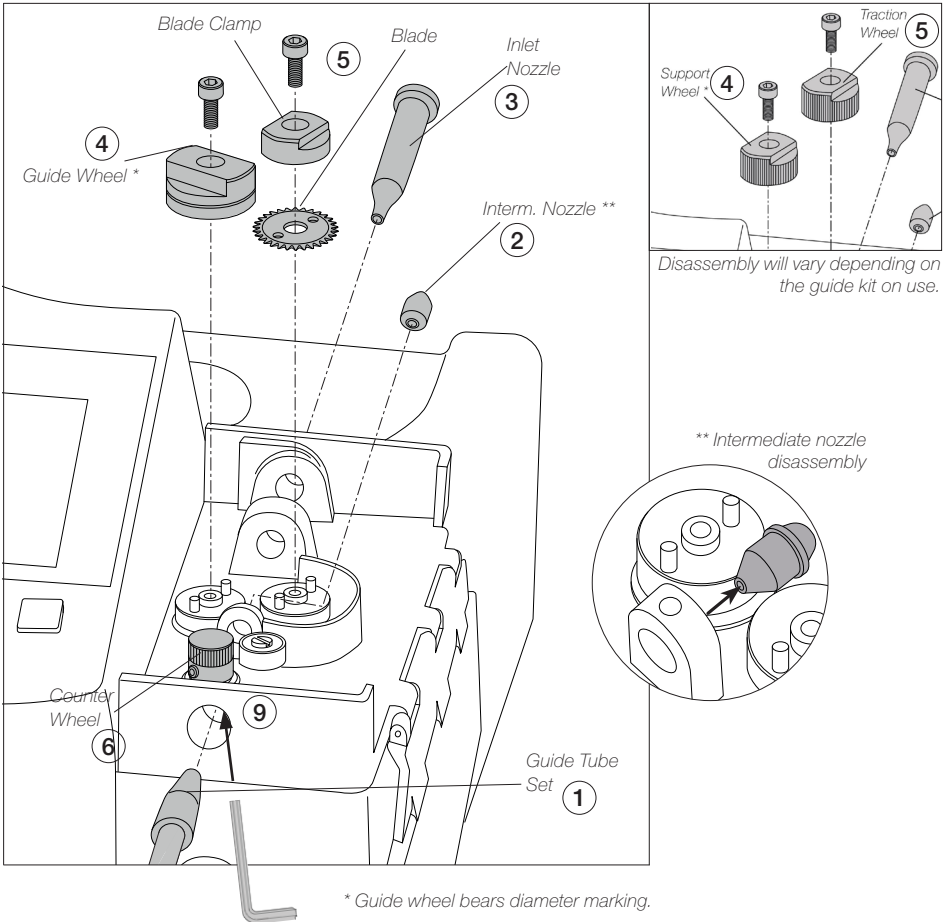
# Changing Guide Kits

## 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.

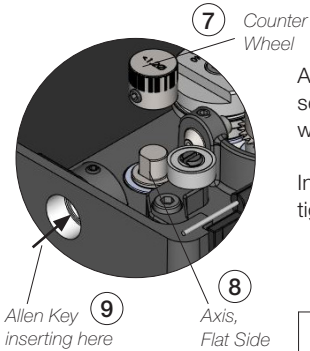
Before trying to remove any components from the device, be sure to loosen the corresponding set screws. To do this, use the Allen key and spanner provided with the station. First disassemble the guide tube set (1), the guide wheel, blade and blade clamp or the support and traction wheels (4) + (5), and 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).

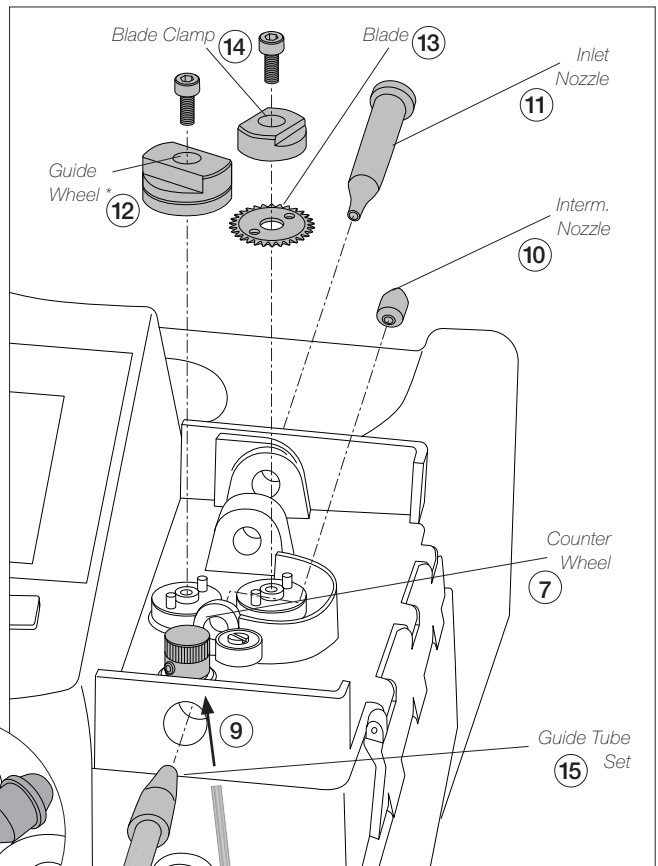
Insert the intermediate nozzle (10) until its collar rests against the housing and tighten its screw.

Assemble the inlet nozzle (11).

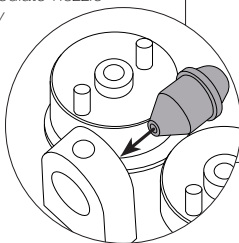
Assemble the guide wheel\* (12) and tighten the screw.

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.

**Assembly without Solder Wire Perforation:**

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

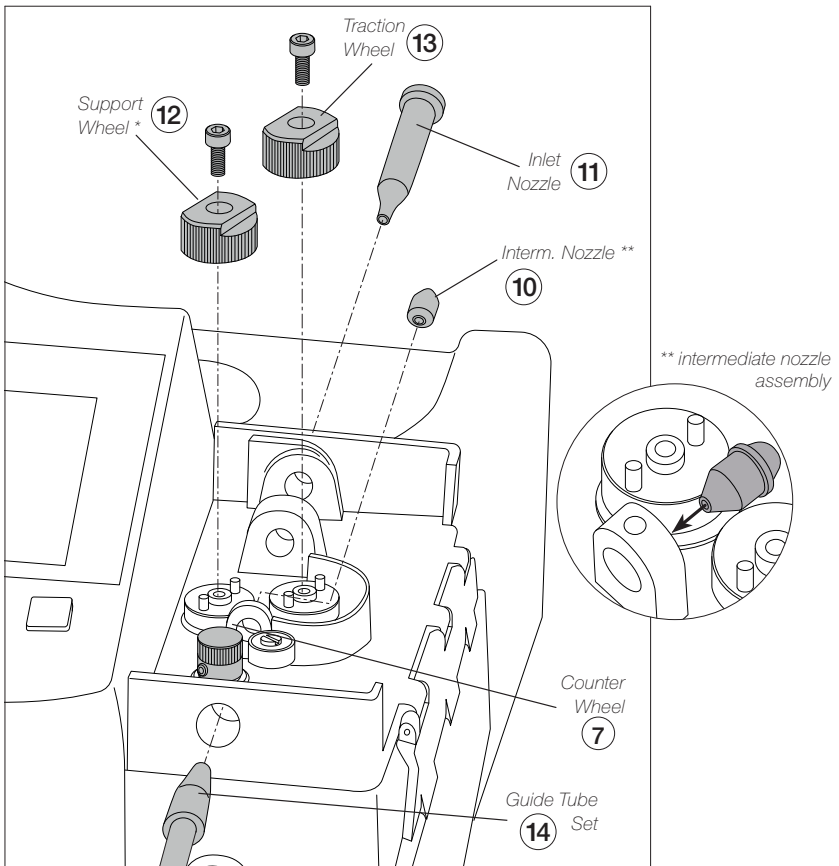
Insert the intermediate nozzle (10) until its collar rests against the housing and tighten its screw.

Assemble the inlet nozzle (11).

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

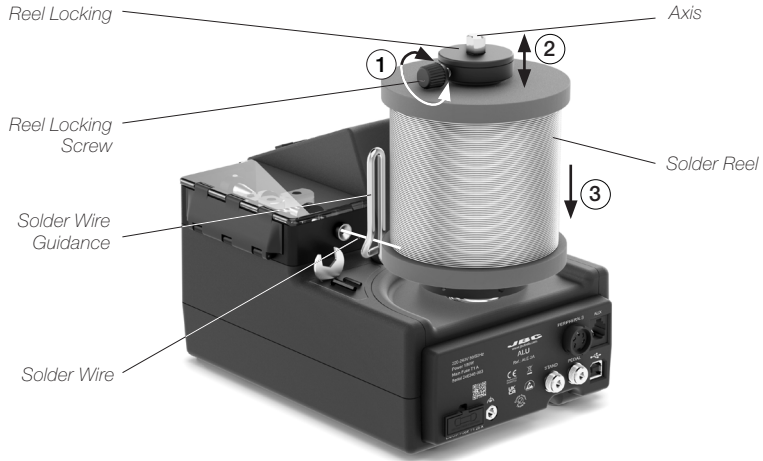
Assemble the traction wheel (13) onto the axis and tighten the screw.

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



\* Support wheel bears diameter marking.

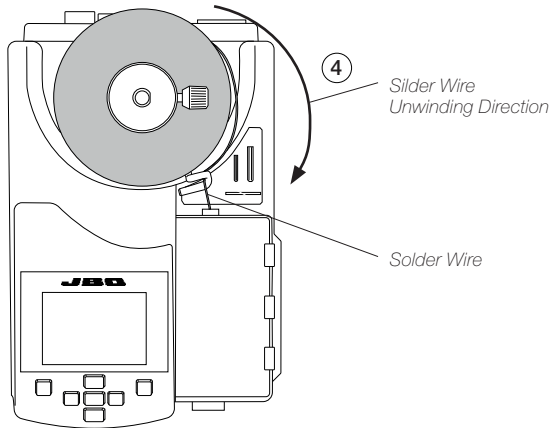
## Solder Reel Assembly



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

Assemble the solder reel onto the axis (3).

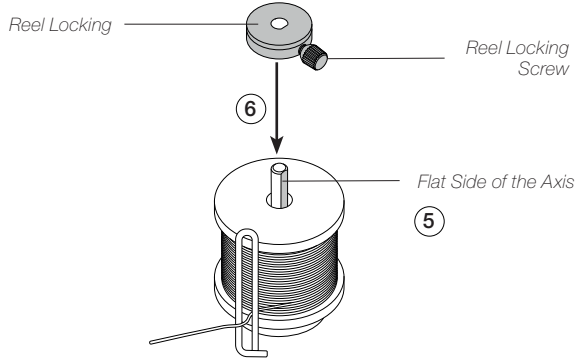
**⚠** Insert the solder reel in such a way - when viewed from above - that the solder wire unwinds on the dispensing mechanism side (4).




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

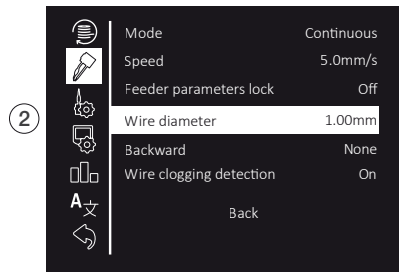
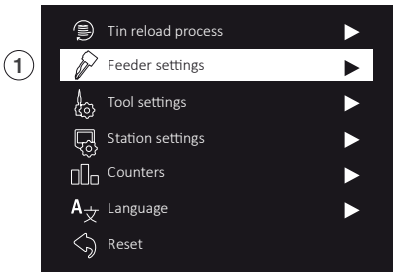
Align the flat side of the axis (5) with the inner flat side (the one with the screw) of the reel locking and reassemble it to the axis (6).

**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.



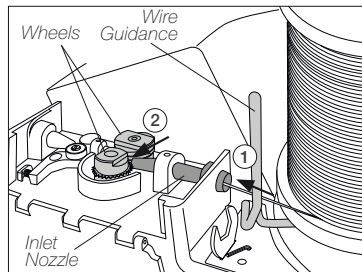
## Main Menu Screen


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.




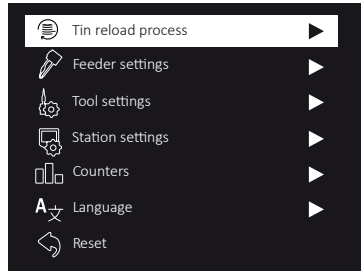
## Solder Wire Loading

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

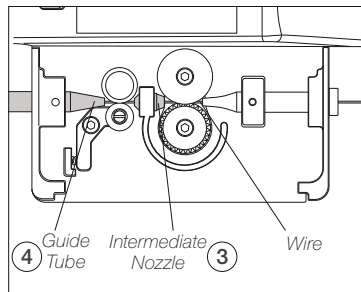


Select “*Tin reload process*” and then use  to feed the solder wire and advance until it comes out of the outlet nozzle.

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

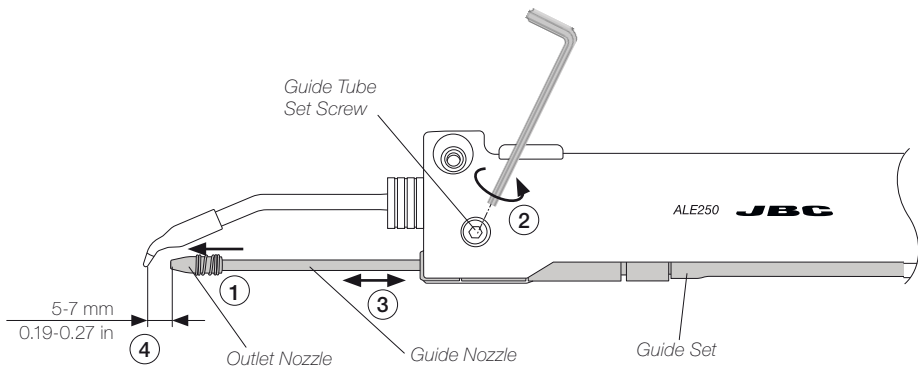
Once the tool is disconnected from the control unit and has cooled down, follow these instructions:

Unload the solder wire and disassemble the outlet nozzle (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 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).



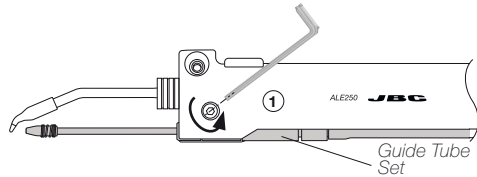
# Outlet Nozzle Replacement

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.

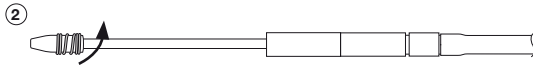
**Note:** There is a nozzle size for each soldering wire diameter. The use of the nozzle is necessary as its inner diameter is adjusted to the solder wire diameter and guides the wire with greater precision.

To replace the outlet nozzle, follow these steps:

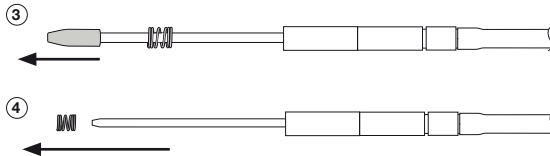
First, make sure that the tool has cooled down and unload any remaining solder wire that might still be inside the guide tube (see page 7). Unplug the tool. Loosen the guide tube set screw (1) and detach the guide tube set from the tool for easier handling.



Unscrew the spring inwards (2), following the downward direction of the spring.



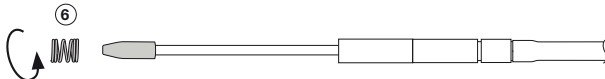
Once the outlet nozzle is released from the spring, pull the outlet nozzle out (3) and then remove the spring (4).



Place the new outlet nozzle onto the guide tube set (5).



Once the outlet nozzle is set in place, screw the spring onto it to fix the outlet nozzle onto the guide tube (6).



## Specifications

### GALE

#### Guide Kits for ALE250

##### With Perforation:

Ref.: **GALE08V-A** wire  $\varnothing$  0.8 mm /  $\varnothing$  0.032 in  
 Ref.: **GALE10V-A** wire  $\varnothing$  1.0 mm /  $\varnothing$  0.040 in  
 Ref.: **GALE12V-A** wire  $\varnothing$  1.2 mm /  $\varnothing$  0.047 in  
 Ref.: **GALE15V-A** wire  $\varnothing$  1.5 mm /  $\varnothing$  0.059 in  
 Ref.: **GALE16V-A** wire  $\varnothing$  1.6 mm /  $\varnothing$  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-A** for wire  $\varnothing$  0.38 - 0.4 mm /  $\varnothing$  0.015 - 0.016 in  
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**GALE12D-A** for wire  $\varnothing$  1.14 - 1.27 mm /  $\varnothing$  0.045 - 0.051 in  
**GALE15D-A** for wire  $\varnothing$  1.50 - 1.57 mm /  $\varnothing$  0.060 - 0.063 in  
**GALE16D-A** for wire  $\varnothing$  1.60 - 1.63 mm /  $\varnothing$  0.063 - 0.065 in  
**GALE18D-A** for wire  $\varnothing$  1.8 mm /  $\varnothing$  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  
 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  
 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

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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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