

# **JBC**

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## **INSTRUCTION MANUAL**



### **CSR245/CSR470**

General/Heavy Duty  
Cartridge Exchanger for Robot

This manual corresponds to the following references:

- **CS2R245-B** for R245 cartridges
- **CS2R470-B** for R470 cartridges

## Packing List

Either Ref. CS2R245-B or Ref. CS2R470-B is included:



**General/Heavy Duty Cartridge Exchanger for Robot** ..... 1 unit  
*according purchased reference*



**Lower Centering Jig** ..... 1 unit  
Ref. 0029067 for CS2R245-B  
Ref. 0029055 for CS2R470-B



**Upper Centering Jig** ..... 1 unit  
Ref. 0023652 for CS2R245-B  
Ref. 0023648 for CS2R470-B



**Manual** ..... 1 unit  
Ref. 0027877

## Features

CSR245 and CSR470 are designed to be used in automatic soldering processes. Two pairs of grippers can be used to hold the cartridges while they are not in use.

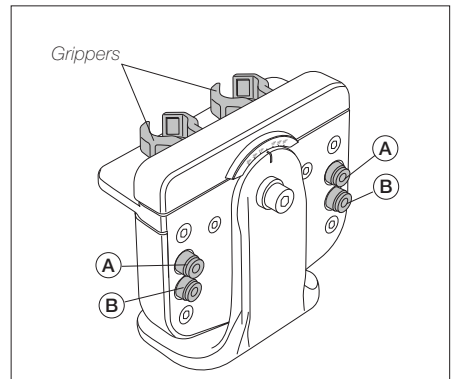
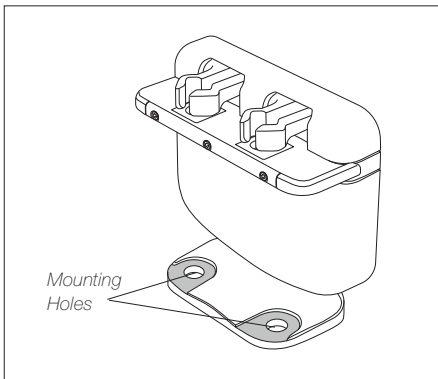
They can work in combination with JBC Automatic Soldering Tools (**TRA245/TRA470**) and the cartridges for automated processes (**R245** and **R470**).



## Assembly

CSR245 and CSR470 need to be fixed to the robot work place area. Use a **DIN912 M6** screw and the mounting hole as shown bellow.

The grippers must be connected to an air-circuit, by using the tube connections **A** and **B**, to be actuated.

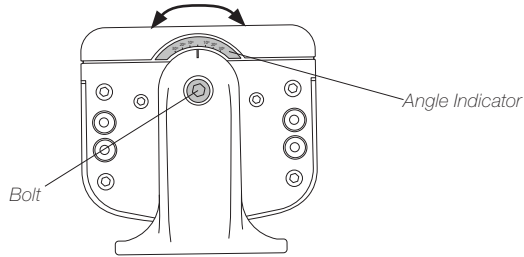


Gripper Activation	
Fluid	Air
Applicable tubing	Ø 4mm
Operating pressure	1,5 to 7 bar

- (A) Tube connection to fix Cartridge.
- (B) Tube connection to release Cartridge.

# Work Position Adjustment

CSR245 and CSR470 bodies can be pivoted 35° to both sides to suit the inclination of your soldering head in every job necessities. Use a 5mm allen key to loosen the bolt and pivot the cartridge exchanger body manually.



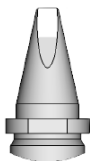
**Note:** The angle indicator around the bolt area helps to adjust the desired angle position. Tighten the bolt for holding the body in the desired position. The soldering head must be set to the same angle.

# Compatibility

Cartridge Exchanger	Cartridge Range		Control Unit		Soldering Tools	
	R245	R470	UCR245	UCR470	TRA245	TRA470
CSR245	●		●		●	
CSR470		●		●		●

# Compatible Cartridges

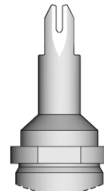
Find the Cartridge models that best suit your soldering needs on [www.jbctools.com](http://www.jbctools.com)



Chisel



Pin / Connector

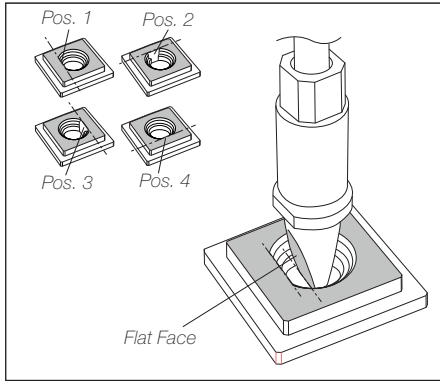


Drag

## Tool Position Adjustment

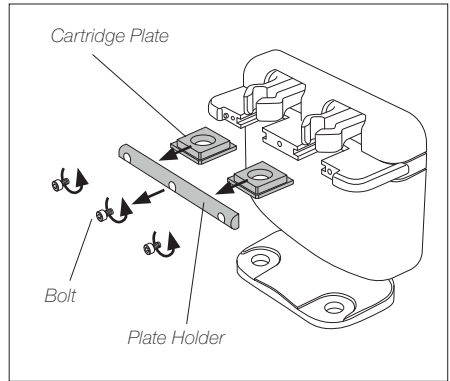
The cartridge plate can be set to four different positions.

The flat faces of the plate and the cartridge must match.



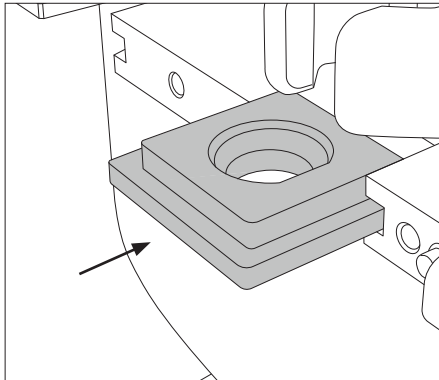
Use an 1,5 mm allen key to loosen the three indicated screws.

Evenly pull the plate holder and remove the cartridge plates.

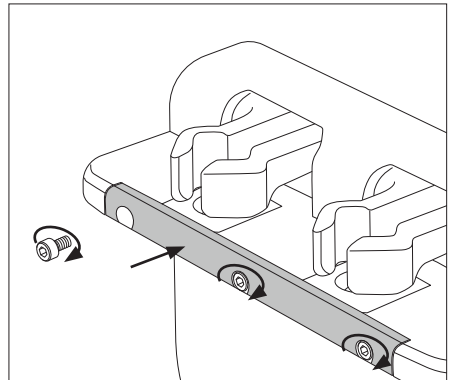


Insert the cartridge plates to any of the four positions you need.

The smaller squared shape must face upwards.



Assemble the plate holder to its initial position and tighten the three screws evenly.

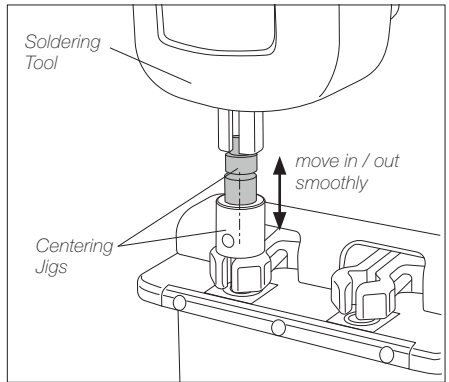
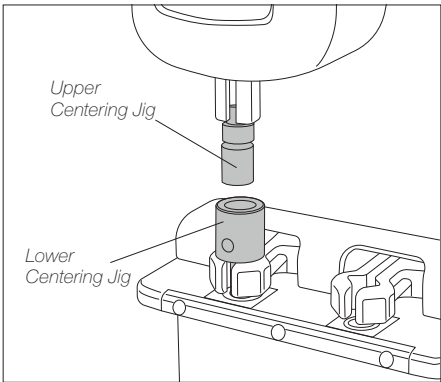


# Centering Jig

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

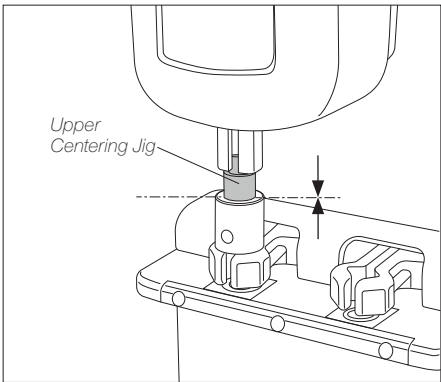
Instal, as shown, the lower centering jig into the gripper of CSR and the upper centering jig into the soldering tool of HA Automatic Soldering Set.

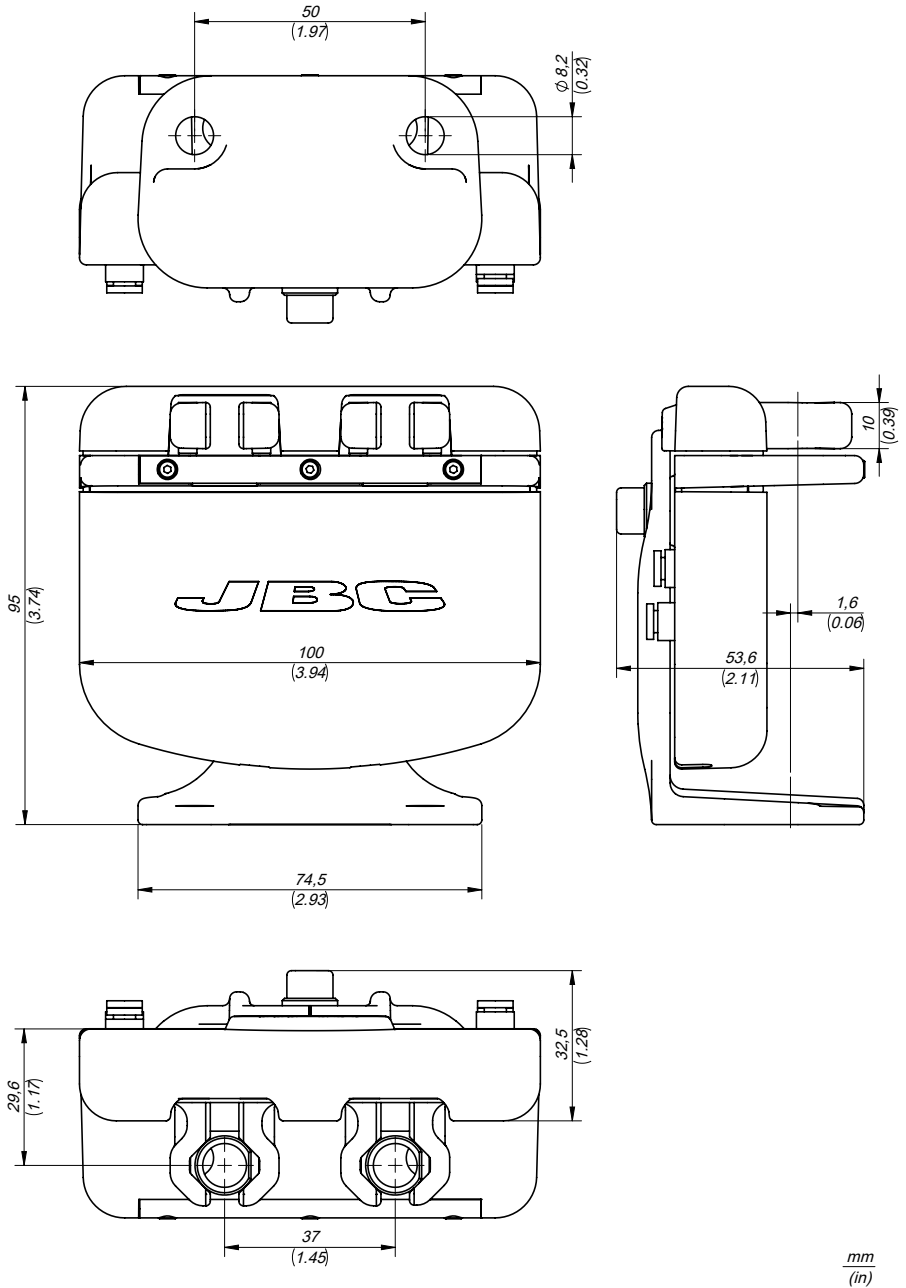
Adjust the soldering tool position until the centering jigs are aligned. It must be possible to move in and out smoothly.



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.



**Dimensions**

# Workplace Example

## HA Automatic Soldering Set for Robot





## Maintenance

- Before carrying out maintenance, always unplug the equipment.
- Use a damp cloth to clean the equipment. Alcohol can only be used to clean the metal parts.
- Periodically check that the metal parts of the equipment are clean.
- Periodically check all cables and tube connections.
- Replace any defective or damaged part. 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 equipment for any other purpose.
- Do not leave the appliance unattended when it is on.
- Be sure that the power supply is disconnected before changing any spare part.
- The temperature of accessible surfaces may remain high after the unit is turned off. Handle with care.
- 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.



# Specifications

## CSR245

### General Cartridge Exchanger for Robot

Ref.: **CS2R245-B**

- Operating pressure	1,5 - 7 bar / 20 - 100 psi
- Total Net Weight:	789 g / 1.74 lb
- Package Dimensions/Weight: (L x W x H)	221 x 136 x 126 mm / 1004 g 8.70 x 5.35 x 4.96 in / 2.21 lb

## CSR470

### Heavy Duty Cartridge Exchanger for Robot

Ref.: **CS2R470-B**

- Operating pressure	1,5 - 7 bar / 20 - 100 psi
- Total Net Weight:	807 g / 1.78 lb
- Package Dimensions/Weight: (L x W x H)	221 x 136 x 126 mm / 1045 g 8.70 x 5.35 x 4.96 in / 2.30 lb

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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