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INSTRUCTION MANUAL

GALE

Guide Kits for ALE250

This manual corresponds to the following references:

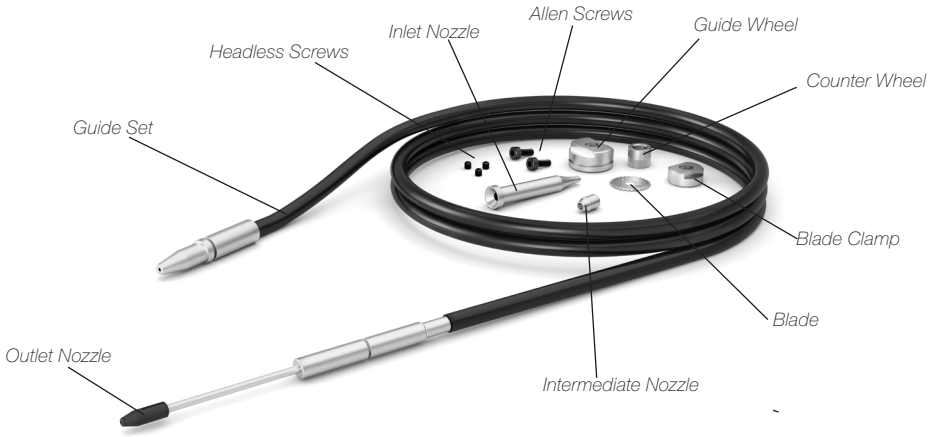
With Solder Wire Perforation:

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 0.4 mm / Ø 0.016 in*
GALE05D-A*for wire Ø 0.5 mm / Ø 0.020 in*
GALE06D-A *for wire Ø 0.6 mm / Ø 0.025 in*
GALE07D-A *for wire Ø 0.7 mm / Ø 0.028 in*
GALE08D-A *for wire Ø 0.8 mm / Ø 0.032 in*
GALE10D-A *for wire Ø 0.9 - 1.0 mm / Ø 0.035 - 0.040 in*
GALE12D-A *for wire Ø 1.1 - 1.2 mm / Ø 0.043 - 0.047 in*
GALE15D-A *for wire Ø 1.3 - 1.5 mm / Ø 0.051 - 0.059 in*
GALE16D-A *for wire Ø 1.6 mm / Ø 0.063*
GALE18D-A *for wire Ø 1.7 - 1.8 mm / Ø 0.067 - 0.071 in*

GALE Guide Kits for ALE250 with Solder Wire Perforation



Packing List

The following items are included:

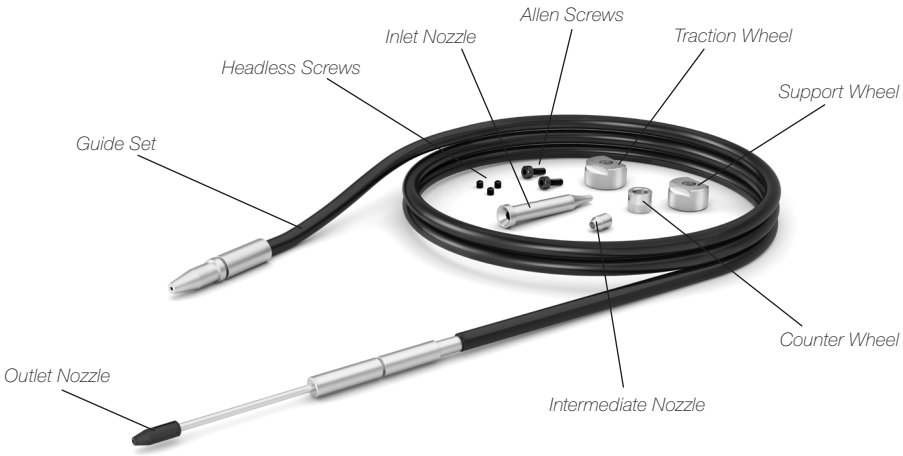
Guide Set* ..... 1 unit
Inlet Nozzle* ..... 1 unit
Guide Wheel* ..... 1 unit
Counter Wheel* ..... 1 unit
Blade Clamp* ..... 1 unit
Blade* ..... 1 unit
Intermediate Nozzle* ..... 1 unit
Outlet Nozzle* ..... 1 unit

see reference table on page 4

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

Manual ..... 1 unit
Ref. 0028365

GALE Guide Kits for ALE250 without Solder Wire Perforation



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

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

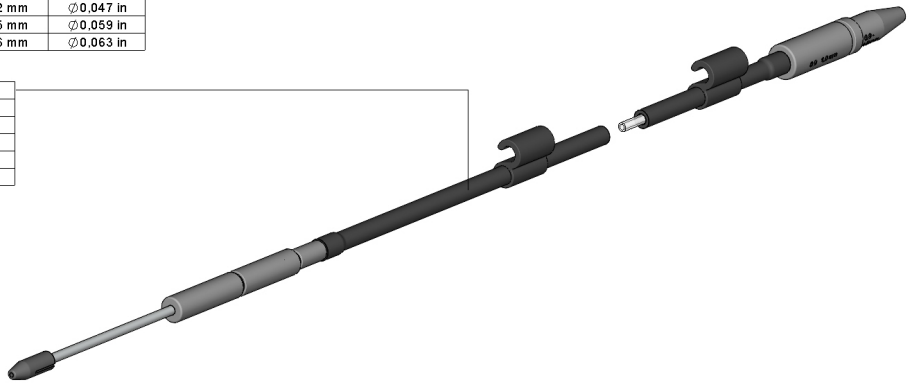
Manual ..... 1 unit
Ref. 0028365

*see reference table on page 5

GALEXXV-A WITH SOLDER WIRE PERFORATION

Wire diameter		
XX	Diameter of use	
08	∅0,8 mm	∅0,032 in
10	∅1,0 mm	∅0,040 in
12	∅1,2 mm	∅0,047 in
15	∅1,5 mm	∅0,059 in
16	∅1,6 mm	∅0,063 in

	Guide tube
GALE08V-A	0028358
GALE10V-A	0028359
GALE12V-A	0028360
GALE15V-A	0028361
GALE16V-A	0028363



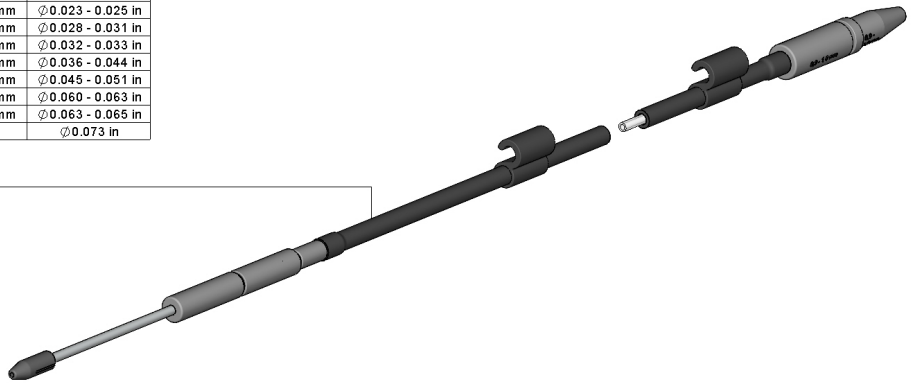
SPARE PARTS

	Outlet nozzle	*Nozzle*	Guide wheel	Blade	Blade clamp	Inlet nozzle	Interm. nozzle	*Counter wheel*	*Screws*	*Threaded stud*
Wire ∅										
GALE08V-A	0025270	*0021158*	0021696	0021555	0018638	0018632	0024955	*0026693 (Supplied with SF)*	*0026695 (x2)*	*0026696 (x3)*
GALE10V-A	0021560		0021699			0019170	0024956			
GALE12V-A	0025272		0023738			0019171	0024957	*0026694*		
GALE15V-A	0025274		0019696				0024958			
GALE16V-A	0025276		0025922			0024233	0024959			

GALEXXD-A WITHOUT SOLDER WIRE PERFORATION

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

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



SPARE PARTS

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

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Changing Guide Kits

Changing Wheels and Blade

For this operation, disconnect the device from the mains. Disconnect the tool from the control unit and open its cover.

First disassemble the guide tube (6), the nozzles (2)+(3), then the Wheels, Blade and Clamp (4)+(5). Disassemble the Counter Wheel (1). Use the allen key and the spanner, provided with the station.

Assembly with Solder Wire Perforation

Assemble the counter wheel (1).

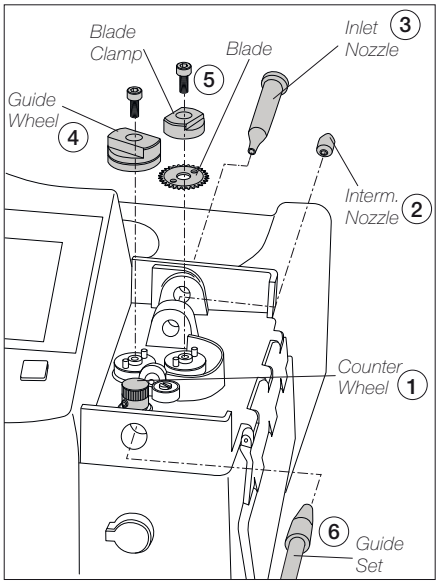
Insert the intermediate nozzle (2) until its collar rests against the housing and tighten the screw.

Assemble the inlet nozzle (3).

Assemble the guide wheel (4) and tighten the screw.

Assemble the blade first, then mount the blade clamp (5) onto the same axis and tighten the screw. **Caution:** handle the blade carefully to avoid injury.

Insert the guide set (6).



Assembly without Solder Wire Perforation

Assemble the counter wheel (1).

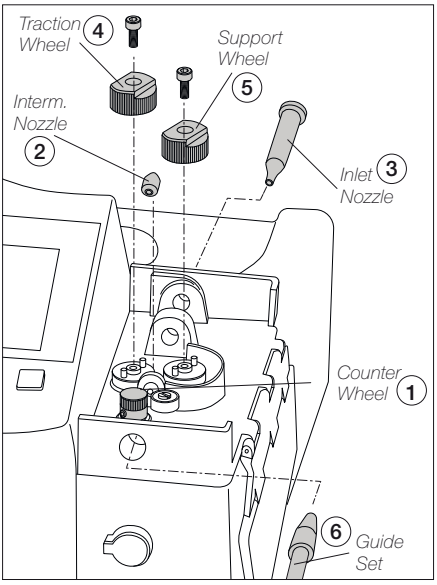
Insert the intermediate nozzle (2) until its collar rests against the housing and tighten the screw.

Assemble the inlet nozzle (3).

Assemble the traction wheel (4) onto the axis and tighten the screw.

Assemble the support wheel (5) and tighten the screw.

Insert the guide set (6).



Replacing Guide Sets

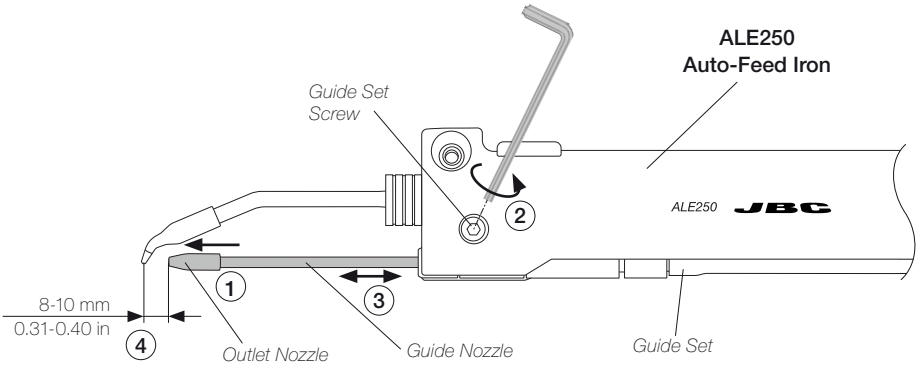
Once the tool is disconnected from the control unit and has cooled down, follow these instructions:

Disassemble the outlet nozzle (1) from the guide set.

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

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

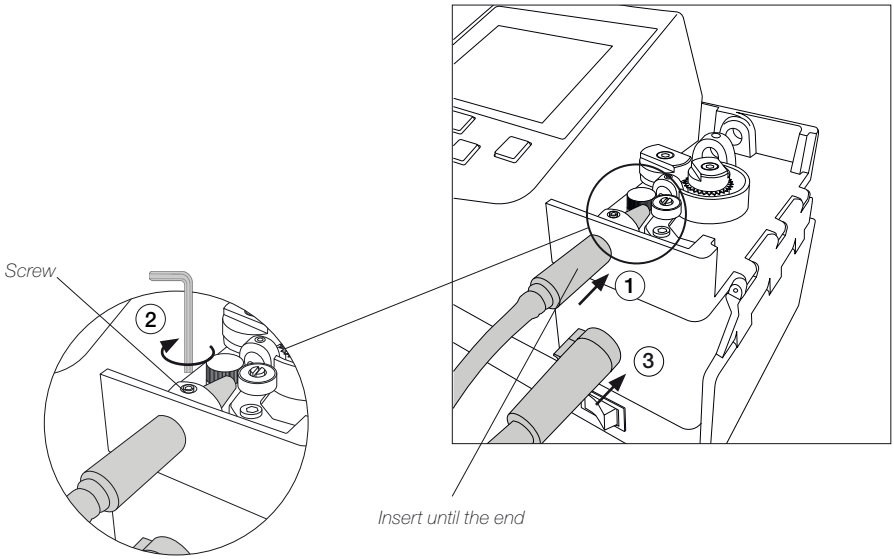
Once the guide nozzle length is adjusted tighten the guide set screw (2).



Tool Assembly

Connect the tool to the control unit following this steps:

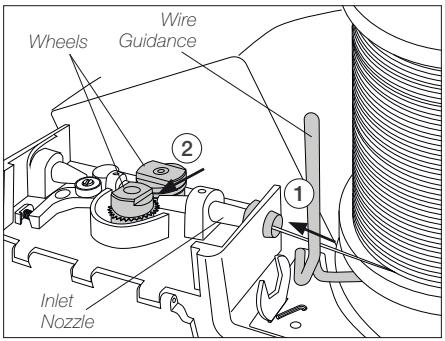
Insert and push the guide nozzle until the end (1) and tighten the screw (2). Then connect the tool connector (3).

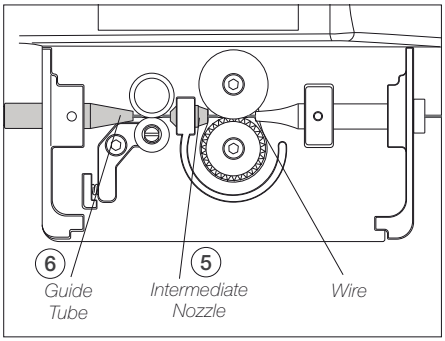


Solder Wire Loading

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

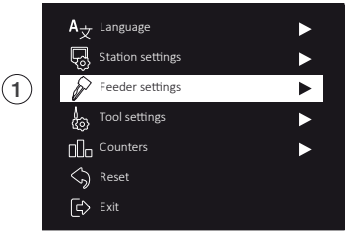
Make sure the wire passes through the Intermediate Nozzle (5) and enters into the Guide Tube (6).



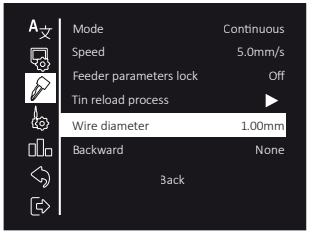


Main Menu Screen

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



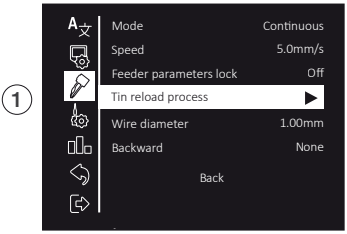
1



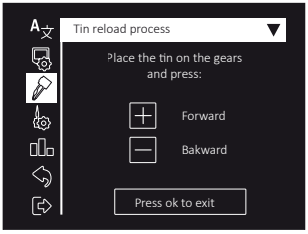
2

Tin Reloaded Process Screen

Select "*Tin Reloaded Process"* (1) and then use to feed the solder wire and advance until it comes out through the outlet nozzle. Keep pressed and after a while the wire will advance faster.

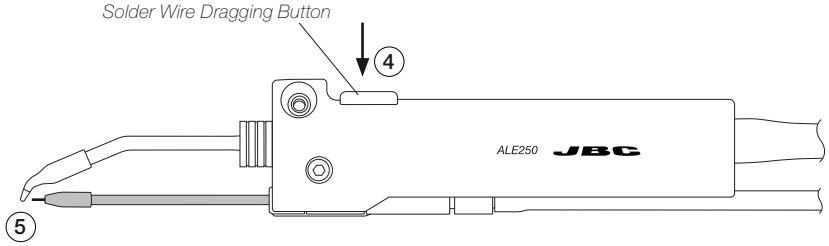


1



Solder Wire Feeding

Forward the solder wire by pushing the dragging button (4) until the wire comes out of the tip (5).



To feed the solder wire, alternatively the pedal P405 can be used. The pedal should be plugged in at the rear of the feeder control unit into the pedal connector.

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
Ref.: **GALE15V-A** *wire Ø 1.5 mm / Ø 0.059 in*	94 g / 0.21 lb	186 g / 0.41 lb
Ref.: **GALE16V-A** *wire Ø 1.6 mm / Ø 0.063 in*	94 g / 0.21 lb	186 g / 0.41 lb
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Ref.: **GALE16D-A** *wire Ø 1.6 mm / Ø 0.063 in*	90 g / 0.20 lb	182 g /0.40 lb
Ref.: **GALE18D-A** *wire Ø 1.7 - 1.8 mm / Ø 0.067 - 0.071 in*		

- 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

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.

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