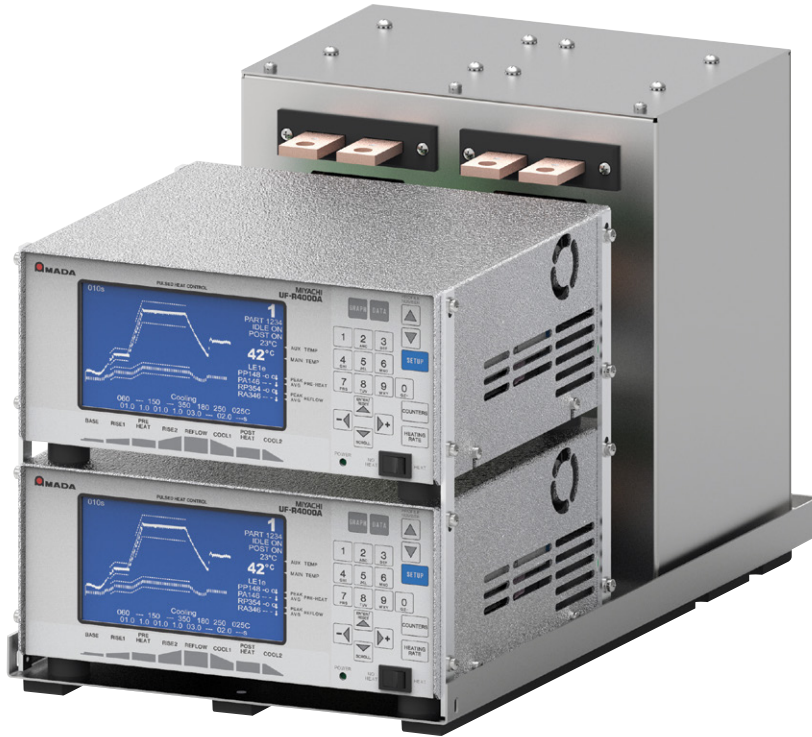


UF-R4000A-Dual

Dual Stack Hot Bar Soldering Control



UF-R4000A-Dual Stack provides targeted heating and precision temperature control for small hot bar soldering applications such as the connection of flexible circuits, ribbon cables, wires, heat staking and SMT components.

UF-R4000A-Dual Stack has a fully integrated dual 1kVA weld transformer and a dual stacked control unit. Space saving design making it ideal for multiple stage production lines and high throughput automation requirements using dual weld heads.

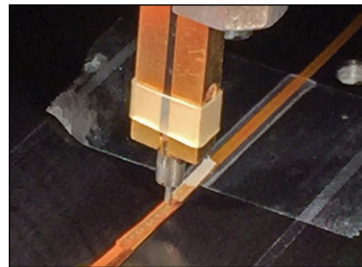
ADVANTAGES

- Reasonably priced
- Small foot print
- Ideal for high volume production lines and automation
- Can be used independently, simultaneously or sequentially

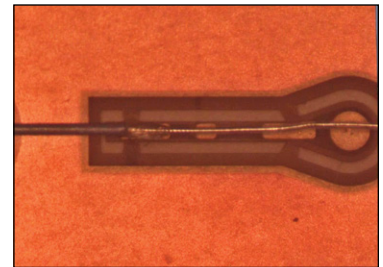
KEY FEATURES

- Closed-loop temperature and time control
- Stores 63 heating profiles (per Controller)
- Remote programming via RS-232/485
- Two thermocouples for process control and auxiliary monitoring (per Controller)
- Comprehensive and informative user interface:
 - Graphic and numeric process data
 - Status and alarm messages
 - Heat profile settings and envelope limits
 - Temperature error indicators
 - User scalable time axis
 - Real time temperature plot

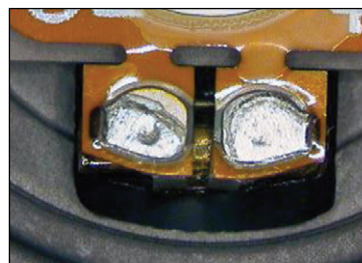
TYPICAL APPLICATIONS



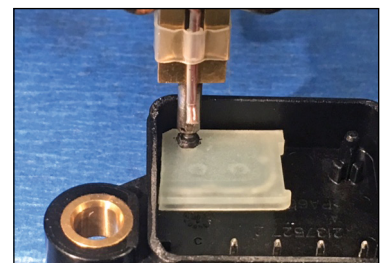
ACF flex to flex



Wire to flex



Flex to PCB



Heat staking

TECHNICAL SPECIFICATIONS

Temperature profile specifications (per Controller)		
Temperature range	Idle Base heat Preheat Heat Heat extended range Postheat	25 to 300° C 25 to 300° C 60 to 500° C 60 to 600° C 60 to 999° C 25 to 999° C
Time periods (in 0.1 sec. increments)	Base heat Rise to preheat time Preheat Rise to heat time Heat Postheat	0 to 99.9 seconds 0 to 9.9 seconds 0 to 99.9 seconds 0 to 9.9 seconds 0.1 to 99.9 seconds 0 to 99.9 seconds
Temperature Control	Accuracy Repeatability	±2% of reading or ±6° C, whichever is greater ±1% of reading
Thermocouple input		Type E, J or K
Heating rate control		Three integrated user-set parameters optimize temperature profile
Programmable heat profiles		Sixty three (63) non-volatile memory

Optional Equipment Ordering Guide		
Suggested basic system: power supply, reflow head, thermode, footswitch, auxiliary thermocouple		
Reflow heads	Force range lbf (Newtons)	Application guideline
LT-050B-F/LRF	0.08 - 2.2 (0.4 - 9.8)	Light force pinpoint soldering
LT-050B-F/RF	0.275 - 2.2 (1.22 - 9.8)	Light force pinpoint soldering
TL-087B-EZ	0.5 - 20 (2.2 - 89)	Small/medium soldering
TL-087B-F	0.25 - 20 (1.1 - 89)	Small/medium soldering
TL-087B-SA/REFLOW	2 - 20 (8.9 - 88.9)	Flex soldering/bonding
TL-084B-SA/REFLOW	5 - 40 (22.2 - 177.9)	Flex soldering/ACF/heat staking
TL-180B-SA	7 - 100 (31.1 - 444.0)	Flex soldering/ACF/heat staking
SH80	1.8 - 18 (8 - 80)	Flex soldering/ACF/heat staking
SH500	6.7 - 112.4 (30 - 500)	Flex soldering/ACF/heat staking
System solutions:		
Desktop bonders	1.8 - 112.4 (8 - 500)	Small to large soldering, flex soldering & ACF bonding; request/see datasheet #991-006
Auxiliary thermocouples		
AUXTC/E	Auxiliary thermocouple, type E, 5 ft. long	
AUXTC/K	Auxiliary thermocouple, type K, 5 ft. long	
AUXTC/J	Auxiliary thermocouple, type J, 5 ft. long	

Switched Input electrical specifications (per Controller)	
Operator initiation	1 or 2 level footswitch
Dedicated relays Air head Head cool Solder cool	24 VAC/24 VDC 0.3 A ON/OFF for head actuation ON/OFF for cooling thermode holder ON@COOL, OFF@PREHEAT
Programmable relays Contact rating	7 each, electromechanical (24 VAC or +24 DC) 24 VAC/24DC, 0.3 A
Communication ports	RS-232, RS-485
Programmable relay functions –	Reflow, preheat, baseheat, idle on, alarm, out of limits, clean thermode, replace thermode, end reflow, heat on, head valve active, system ready
Operating temperatures	59° F (15° C) – 104° F (40° C)
Relative humidity, max.	93% @ 104° F (40° C)

Power Supply Ordering Guide		
Power Supplies	Description	Electrical
UF-R4000A	UF-R4000A-Dual power supply, 120 VAC, two 1 KVA transformer built-in	15 A, single phase 50 or 60 Hz
UF-R4000A	UF-R4000A-Dual power supply, 240 VAC, two 1 KVA transformer built-in	15 A, single phase 50 or 60 Hz

Pulse Heated Thermodes	Description	Application/Size*: Inches (mm)
17P	Peg tip - (circular probe tip)	Thermocompression bonding-single point soldering / 0.020 - 0.093 (0.5 - 2.4)
17T	"T" tip - (rectangular probe tip)	Thermocompression bonding-single point soldering / 0.008 x 0.010 (0.2 x 0.25)
17BM	Blade	Multiple contacts / 0.030 - 1.0 (0.76 - 25.4)
17F	Nichrome fold-up	Multiple contacts / 0.250 - 1.0 (6.45 - 25.4)
17TD	Three dimensional	Multiple contacts / 1.0 - 3.0 (25.4 - 76.2)

*NOTE: Standard size ranges are listed, consult AMADA WELD TECH for custom requirements and application advice.

WEIGHT & DIMENSIONS

	UF-R4000A-Dual
Dimensions (W x D x H)	11.81 in x 20.87 in x 12.52 in (300 mm x 530 mm x 318 mm)
Weight	60 lb (27.2 kg)



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