

SOLDERING STATION
ESD SAFE / ADJUSTABLE TEMPERATURE / THERMOSTATIC

OPERATION INSTRUCTION

English

Thank you for purchasing this product. Please read the manual carefully before operating and keep this manual for future reference.

Made in China

Statement: The company reserves the right to improve & upgrade products, product specifications and design are subject to change without notice.

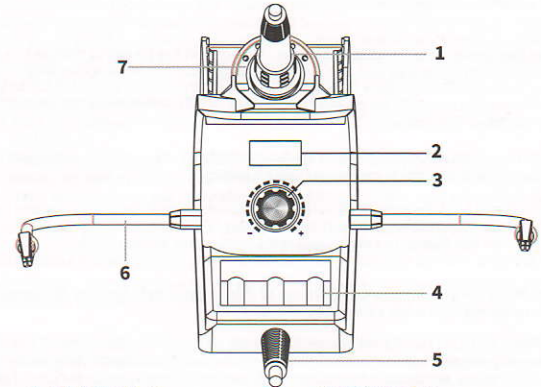
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Temperature range	90°C~480°C / 194°F~896°F
Display	LED
Tip to ground resistance	<2 ohms
Operating ambient temp.	0~40°C / 32~104°F
Storage temp.	-20~80°C / 4~176°F
Storage humidity	35~45%

I. PURPOSES

Suitable for soldering and desoldering operations on SMT, through-hole components such as SOP, DIP, SOIC, and other types of components.

II. PART REFERENCE



- | | |
|---|--|
| 1. Soldering Iron | 4. Residue Tray |
| 2. Temperature Display | 5. Cord Assembly (Soldering Iron) |
| 3. Menu Button / Temperature Adjustment Dial | 6. Soldering Helping Hand |
| | 7. Holder (Soldering Iron) |

III. INSTRUCTIONS

- Place the soldering iron in the holder correctly.
(If the station comes with a solder roll holder, install the solder roll holder. Installation: Put the solder roll holder on the left side of the station, and align the holes on the bracket with the installation holes on the station. Hold the solder roll holder securely together and level the both before tightening the screws.)

2. Connect the power cord and turn ON the power switch; the heating element will begin heating. The heating indicator light will light up and stay ON constantly when the station heating. The heating indicator light will stay lit when station heating up; The heating in-

350.

Indicator (PID Temperature Control Tracking & Compensating)

icator light will blink when the temperature stabilizes; The heating indicator light will turn off when station cooling. Start your work when the temperature stabilizes.

CAUTION: Upon the first use of the soldering iron tip, set the temperature to 250°C/482°F. When the iron tip is just hot enough to melt solder, coat the tip with a layer of solder, then move the temperature up to the required value.

3. When the operation is complete, clean the residuals off the tip with a damped cleaning sponge or a metallic wool ball. Tin the soldering tip with a layer of solder when the cleaning is complete, then place the soldering iron into the holder. When the soldering iron is not in use for an extended period, turn OFF the power switch and DISCONNECT the power cord.

4. °C/°F Temperature Unit Display: *(This function allows users of different regions to select their preferred temperature unit on display.)*

- 4.1 Press and hold the menu dial button (it functions as both the dial and menu button) for 2 seconds, and then the station will display "C".
- 4.2 Turn the dial button to select C or F temperature unit display mode.
- 4.3 Complete and exit the setting interface by pressing the dial button 3 consecutive times.

5. Sleep Mode Timer Configuration: *(The use of this function help extends the lifespan of the soldering iron while conserving energy.)*

- 5.1 Press and hold the dial button for 2 seconds, and press the dial button 1 time. The station will display "L10" to indicate the timer is set to 10 minutes of sleep mode.
- 5.2 Turn the dial button to set the sleep mode timing. Set timer value to "L00" if sleep mode is not needed.
- 5.3 Complete and exit the setting interface by pressing the dial button 2 consecutive times.

The sleep mode timer can be set to 0/5/10/30 minutes, set the timer value to 0 to deactivate sleep mode.

To start up the soldering station:

- A. Pick up the soldering iron and gently shake the iron;
- B. Press any button on the control panel;
- C. Turn OFF the power then turn ON the power.

When the temperature setting is greater or equal to 250°C (482°F), the temperature will drop to 200°C(392°F) in sleep mode; When the temperature setting is smaller than 250°C(482°F), the temperature will drop to 90°C (194°F) in sleep mode.

6. Digital Temperature Calibration: *(Temperature discrepancies may occur due to the change in the operating environment, and the replacement of the heating element, soldering tip or other parts. This function can help improve work efficiency and extend the lifespan of the soldering iron.)*

- 6.1 After the temperature of the soldering iron has stabilized, press and hold the dial button for 2 seconds, then press the dial button 2 consecutive times. The station will display "CAL".
- 6.2 Turn the dial button to enter the calibrated temperature, confirm your entry by pressing the dial button once.
- 6.3 Press the dial button one time to complete and exit the setting interface. Repeat the above steps if temperature differentials remain.

IV. MAINTENANCE

1. If a layer of oxidization forms on the surface of the soldering iron tip, a misconception can be created that the soldering tip cannot heat up properly to melt the solder and do the tinning. But the actual temperatures of both the heating element and soldering tip are high. In such an instance, please do not increase the temperature value confusedly but use a metal wool ball to remove the oxidization following the steps below:
 - A. **Set the temperature to 300°C (572°F)**
 - B. **After the temperature has stabilized, gently rub the soldering iron tip inside the metal wool.**
 - C. **When the oxidization is partially removed, continue applying the solder on the soldering tip while rubbing until the iron tip is completely coated with a layer of solder. If the oxidization is too severe beyond cleaning, replace your soldering iron tip.**
2. Do not use files to remove the oxidization on the soldering iron tip. If the iron tip is deformed or rusted, you need to change it into a new soldering iron tip.
3. Do not apply excessive forces on the soldering tip when soldering. Doing so will not only damage the iron tip but also not improve the heat transfer.
4. When returning the soldering iron to the holder after a high-temperature operation, always turn the temperature down to below 250°C(482°F) to idle. Allowing the soldering iron to idle in high-temperature will shorten the lifespan of the soldering iron and heating element. Additionally, this will also result in the premature aging of the heating element.
5. After every operation, always clean and tin the iron tip with a layer of solder to prevent oxidization.

V. TROUBLESHOOTING

1. S-E - The soldering iron's errors in the sensor modules. To solve this, change the heating element (heating element and sensor modules)
2. SLP - The station in sleep mode
3. When replacing the heating element, take notice of the original connecting order and colors of the wires which MUST NOT be connected incorrectly.