

Anti-static Soldering Station Series

INSTRUCTION MANUAL

936/937/939/928

English



Thank you for purchasing this soldering station, this product is specially designed for lead-free soldering, please read the instructions carefully before use. After read, please keep it for future reference.

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

I. Overview

Warning!!!

Use the machine, the following basic measures should abide, avoid electric shock or cause injury or damage caused by fires.

- To ensure personal safety, after the machine completed work, please turn off the main power switch, and unplug the power cord if long time no use.
- You must use the original approval or recommendation of the parts, otherwise it will lead to serious consequences.
- Machine failure must be by professional or the company designated personnel for repair.
- This product is grounded three-wire plug, must be inserted within the three-hole grounded outlet, do not change the plugs or use ungrounded three adapter made it bad grounded.
- When the soldering station is open, its temperature are likely to reach 400 °C. Do not use it near flammable gas, objects. Tube and the heat emitted very hot, can burn the body, do not touch the hot pipe and direct injection to heat the human body.
- Before turned on the soldering station, please ensure it is in safety environment, do not leave the jobs site.
- When the machine opening do not install nozzle, the heat pipe and the nozzle must be cooling. Then installed the other nozzle.
- After use, the machine need to cool down when packing.
- Do not use a soldering iron to weld outside the work. Do not iron percussion table to clear the residual flux, this could seriously damage the iron.
- The machine welding will take smoke, please do proper ventilation.

II. Tip Maintenance And Use

Tip temperature	High soldering temperature can degrade the tip. Use the lowest possible soldering temperature. The excellent thermal recovery characteristics ensure efficient and effective soldering even at low temperatures. This also protects the solder de items from thermal damage.
Cleaning	Clean the tip regularly with a cleaning sponge. As oxides and carbides from the solder and flux can from impurities on the tip. These impurities can result in defective joints or reduce the tips heat conductivity. When using the soldering iron continuously, be sure to loosen the tip and remove all oxides at least once a week. This helps prevent seizure and reduction of the tip temperature.
When not in use	Never leave the soldering iron sitting at high temperature foe long periods of time, as the tip's solder plating will become covered with oxide, which can greatly reduce the tip's heat conductivity.
After use	Wipe the tip clean and coat the tip with fresh solder.

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III. Use Instructions

- When soldering iron is used for the first time, you should pay attention to monitor iron tip warming situation, wait until the temperature just melted tin wire, a layer of tin on the part of the gold-plated iron tip, and then the temperature was raised to the required temperature. Keep in mind when working iron tip should be long-term with a layer of tin to protection iron tip, in order to achieve optimal soldering function.
- As an oxide layer on the surface of iron tip, resulting in false low temperature soldering iron tip, unable to melt tin and the tin, in fact, at this time the heating elements with the soldering iron is high temperature state. This happens situation not to blind the temperature rises again, the application of clean sponge clear oxides, such as not clear, please turn off the power, soldering iron be dropped to room temperature, with No.0 sandpaper accidentally cleared the oxide, then repeat the operation of the first point iron initial use.
- Please pay more attention soldering iron in high temperature work back into iron holder, should be adjust temperature button below 250 °C stand-by use, stand-by time over 20 minutes, please turn off power. Otherwise the soldering iron in a high temperature for long time. Because between iron holder and soldering iron generate accumulated temperature, lead to heating elements accelerated aging, soldering iron tip derivative oxide, directly weakened soldering, severe will result in the connecting screw nut plastic melt of the handle or heating elements short circuit.
- If the tip deformation or the occurrence of heavy erosion, to replace the new one. (Note: Do not use knife file remove oxides of soldering iron tip.)
- Soldering, do not give iron tips too much pressure, this will not change the thermal conductivity, otherwise will lead to iron tip damage.

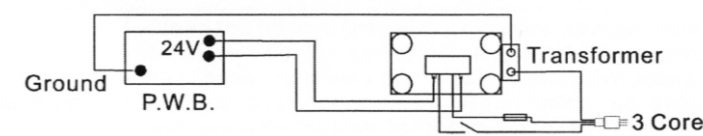
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IV. Specification

Product model	936/936B/936D/937D	936A/937D+/939/939D/928/928D
Power	45W	75W
Output voltage	24V AC	
Temperature range	200°C~480°C	200°C~480°C
	392°F~896°F	392°F~896°F
Display type	LED	
Temperature stability	±2°C (Static)	
Heating element voltage	AC 24V ±10% 50Hz	
Tip of ground resistance	<2ohm	
Tip of ground voltage	<2mV	
Weight	1.58kg(Common heater)	2.08kg(Imported heater)
Working temperature	0°C~40°C/32°F~104°F	
Storage temperature	-20°C~80°C/-4°F~176°F	
Storage humidity	35%~45%	

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V. Wiring Diagram



VI. Replacement of the soldering iron tip and soldering iron heating core's element

Soldering iron parts replacement Figure 1

- Unscrews the nut No.1, and then removes the steel tube No.2, followed by removing the tip which is going to be replaced.
- For the replacement of heating core's element can be performed by unscrewing the plastic cap No.4, pulls out gently the heating core, element No.6 along with the circuit board No.7, please carefully remember the connection of spring No.5.
- The iron core from the circuit board welding, the replacement of the heating core, can be fitted well. Note that the order of the iron core wire connection.

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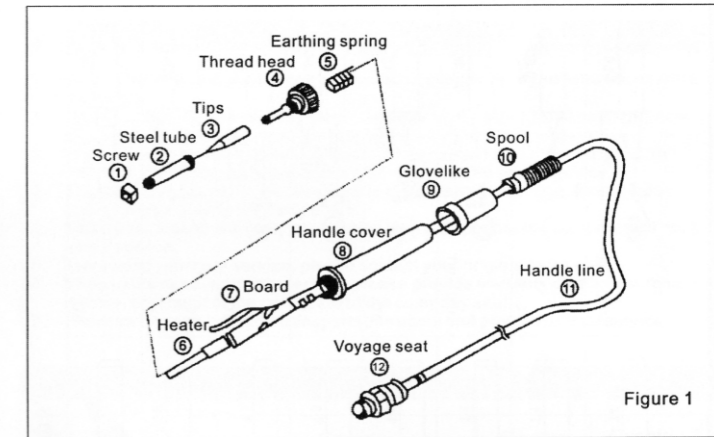
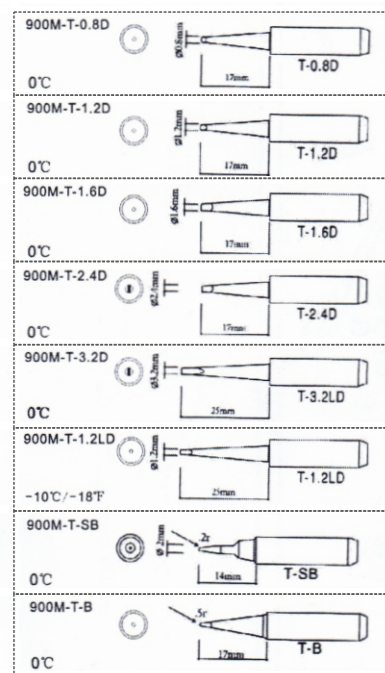


Figure 1

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Attachment: Electric welding machine using welding head model figure

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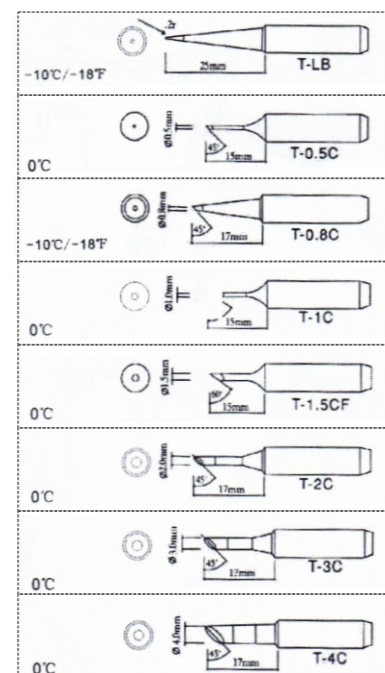


900M tip OutDiam Φ6.5

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Attachment: Electric welding machine using welding head model figure

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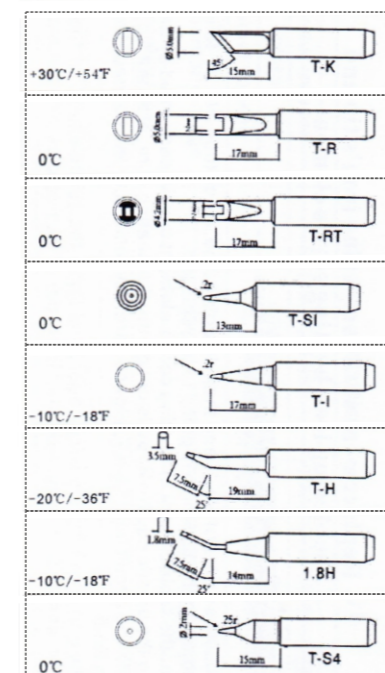


900M tip OutDiam Φ6.5

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Attachment: Electric welding machine using welding head model figure

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900M tip OutDiam Φ6.5

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Warranty Card

Note: Please keep the card carefully.

Model		Tester		Date of manufacture	
Name		Tel.		Product ID	
User Add.				Zip Code	
Store Add.				Date of sales	

- Caution**
- Please read the instruction manual carefully before using the product or in the event of a failure.
 - From the date of sales within one year, under normal use, if there are quality problem or failure, not be disassemble and repaired, enjoy free repair service. (According to the invoice.)
 - Return or rework due to quality problems, please fill out the warranty card to facilitate the factory to improve the quality of products in time.



Note: Please carefully fill in the failure phenomenon, the fault occurrence time and environment, and the working condition of the machine.

Records	Date	Cause	Repairer