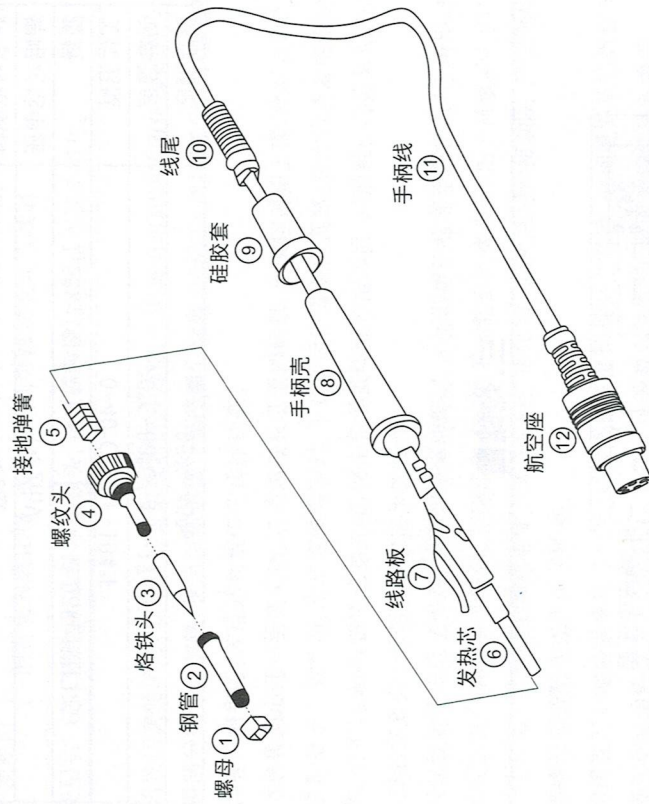


## 四、烙铁发热芯和烙铁头的更换

### 烙铁部件更换

1. 旋出螺母1, 再将钢管2取出, 这时就可以取下烙铁头进行更换。
2. 如需更换烙铁发热芯可继续旋出螺紋头4, 拔出烙铁发热芯6和线路板7, 要注意弹簧5的连接。
3. 将烙铁发热芯从线路板上焊下, 更换新的发热芯, 装好即可。注意烙铁发热芯引线的连接顺序。



## Safety Rules

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

1. 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.
2. You must use the original approval or recommendation of the parts, otherwise it will lead to serious consequences.
3. Machine failure must be by professionals or the company designated personnel for repair.
4. 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.
5. Hot air gun or 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.
6. Before hot air gun turned on, please ensure it is in safety environment, do not leave the jobs site.
7. When the hot air gun opening do not install nozzle, the heat pipe and the nozzle must be cooling. Then installed the other nozzle.
8. After use, the machine need to cool down when packing.
9. 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.
10. The machine welding will take smoke, please do proper ventilation.

## Warning!!!

1. If the supply cord is damaged, it must be replaced by a special cord or assemble available from the manufacturer or its service agent.
2. **WARNING:** This tool must be placed on its stand when not in use.
3. Be careful when using the appliance in places where there are combustible materials; Do not apply to the same place for a long time.
4. Be aware that heat may be conducted to combustible materials that are out of sight; Do not leave the appliance unattended when it is switched on.
5. This appliance is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge. Unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety. Children should be supervised to ensure that they do not play with the appliance.

## I. Tip Maintenance And Use

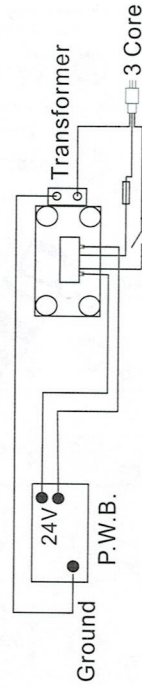
Tip temperature	High soldering temperature can degrade the tip. Use the lowest possible soldering temperature. The excellent thermal recovery characteristics ensure efficient and effective soldering even at low temperatures. This also protects the solder de items from thermal damage.
Cleaning	Clean the tip regularly with a cleaning sponge. As oxides and carbides from the solder and flux can form 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 for 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.

- 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.

## II. Specification

Product model	936/937D/936B	936A/937D+/939/939D
Power	45W	75W
Power supply voltage	AC 110V ±10% 60Hz/AC 220V~240V 50Hz	
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	0~40°C/32°F~104°F	
Storage temperature	-20°C~80°C/-4°F~176°F	
Storage humidity	35%~45%	

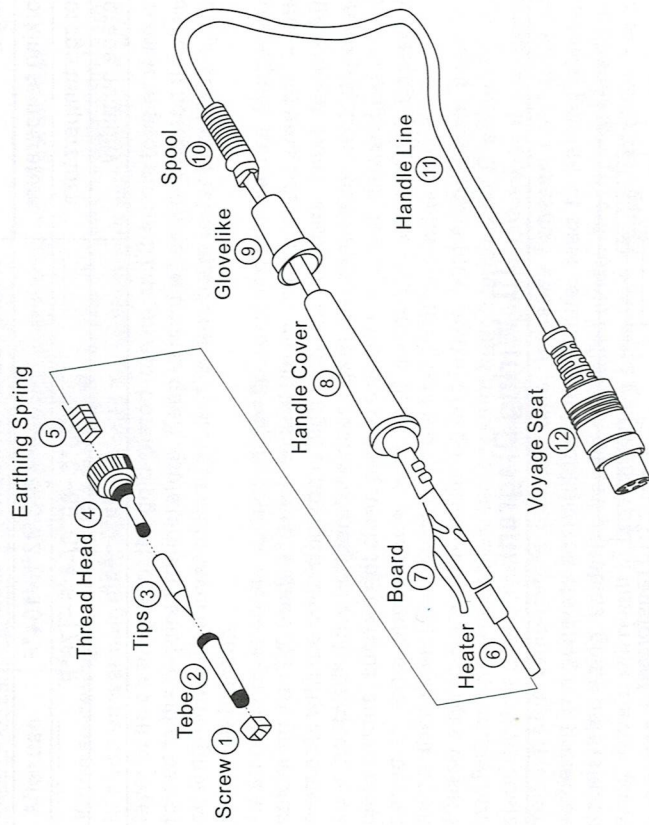
## III. Wiring Diagram



#### IV. Replacement of the Soldering Iron's Tip and Soldering Iron Heating Core's Element

##### Soldering iron parts replacement

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.
2. 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.
3. 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.



附：电焊机使用烙铁头型号图  
Attachment: Electric welding machine using welding head model figure

900M Series Tip Out Diam $\phi$ 6.5mm		900M系列外径 $\phi$ 6.5mm	
900M-T-K 30°C/54°F 5.0mm	900M-T-R 0°C 5.0mm 3.2mm 1.7mm	900M-T-RT 0°C 4.2mm 2.0mm 1.7mm	900M-T-SI 0°C 1.3mm 2r
900M-T-LB -10°C/-18°F 2r 25mm	900M-T-0.5C 0°C 1.5mm 45° $\phi$ 0.5mm	900M-T-0.8C 0°C 1.7mm 45° $\phi$ 0.8mm	900M-T-1C 0°C 1.5mm 45° $\phi$ 1.0mm
900M-T-1.2D 0°C 1.7mm $\phi$ 1.2mm	900M-T-1.5CF 0°C 1.5mm 60° $\phi$ 1.5mm	900M-T-1.6D 0°C 1.7mm $\phi$ 1.6mm	900M-T-2.4D 0°C 1.7mm $\phi$ 2.4mm
900M-T-1.2LD -10°C/-18°F 1.7mm $\phi$ 1.2mm	900M-T-2C 0°C 1.7mm 45° $\phi$ 2.0mm	900M-T-1.8B -10°C/-18°F 1.8mm 45° 1.5mm	900M-T-3.2D 0°C 1.7mm $\phi$ 3.2mm
900M-T-B 0°C 1.7mm 45° $\phi$ 2mm	900M-T-3C 0°C 1.7mm 45° $\phi$ 3.0mm	900M-T-1.8H -10°C/-18°F 1.8mm 45° 1.5mm	900M-T-4C 0°C 1.7mm 45° $\phi$ 4.0mm
900M-T-S4 0°C 1.5mm 25r $\phi$ 2.0mm	900M-T-2C 0°C 1.7mm 45° $\phi$ 2.0mm	900M-T-H -20°C/-36°F 3.5mm 25r 1.9mm	900M-T-4C 0°C 1.7mm 45° $\phi$ 4.0mm