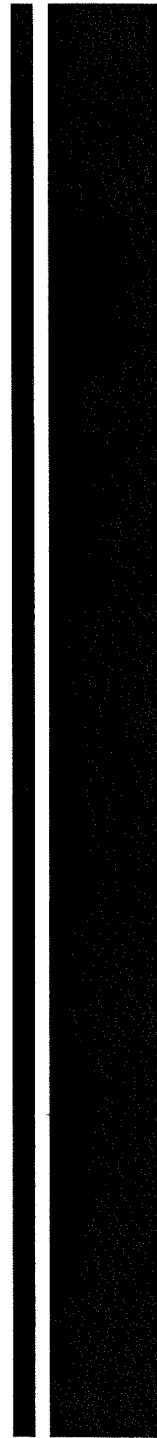




# INSTRUCTION MANUAL

TEMPERATURE CONTROLLED  
SOLDERING STATION



## PRODUCT DESCRIPTION

The electronically temperature controlled soldering station was developed to meet the present and future needs of the electronic production industry. The many features of the Xytronic product make it the ideal tool for both service and repair as well as production line soldering operations.

Tip temperature is maintained to within  $\pm 3^{\circ}\text{C}$  ( $\pm 6^{\circ}\text{F}$ ) of any setting from 150-450°C (300-850°F) for the nichrome heater and for the ceramic heater is from 200-480°C (392-896°F) by any electronic circuit which has a temperature sensor located at the end of the heating element. The variable temperature design means no tip or the heating element changes are necessary to adjust temperature.

**Analog station** include a linear-scale meter which indicates the current tip temperature. LEDs indicator lights are used to signal Power "ON" (Green) and Heater "ON" (Red).

**Digital station** include a 14.2 mm (.560") three digit LED display to accurately indicate the current tip temperature directly with a tolerance of  $\pm 1^{\circ}\text{C}$  (1°F), and one red 5mm LED to indicate heater "ON".

**Non-Display** stations include a multi-color LED to indicated power "ON" (Green) or Heater "ON" (Red).

This soldering station incorporated a temperature lock to prevent unwanted temperature adjustments by the operator. Lock in the selected temperature by an allen head screw located on the front panel. An allen key for this purpose is included.

A new feature for the 136, 136ESD, & 137ESD is a calibration port located on the face of the unit that allows for quick and convenient fine tuning of the electronic temperature control system.

The detachable soldering iron is connected to the base unit by a fire-resistant silicone rubber cable fitted with a heavy duty, 5 or 6 pin plug and a steel locking ring. All housings are molded of tough, heat resistant PC resin to better withstand high impact bumps and abrasions. All materials used comply with DOD, CE, and MIL Specs.

**Caution:** The ergonomic mini handle irons (P/N#107,107ESD) incorporate a long life Japanese made ceramic heater with PTC sensor and is standard equipment on Xytronic model 136, 136ESD, & 137ESD. The heating element for P/N#207,207ESD soldering iron assembly is made of wound nichrome heater with a "K" type thermocouple sensor and comes standard on Xytronic model numbers 168-3C, XY9-60A, XY9-60D, XY9-60A/ESD, XY9-60D/ESD. The two types of iron assemblies are incompatible and use of the wrong type of iron can lead to premature heating element failure. The 5pin configuration of the 207/207ESD can be easily distinguished from the 6pin connector of the 107/107ESD iron. Please refer to Figures 1&2.

The Power unit is isolated from the AC line by a high efficiency 24Vac output transformer for user safety and to prevent unwanted high voltage leakage that may damage current sensitive componets. Zero-voltage switching circuit is incorporated to protect the C-MOS IC from damage by transient voltage spikes.

Fig. 1

SOLDERING IRON ASSEMBLY 207/207ESD

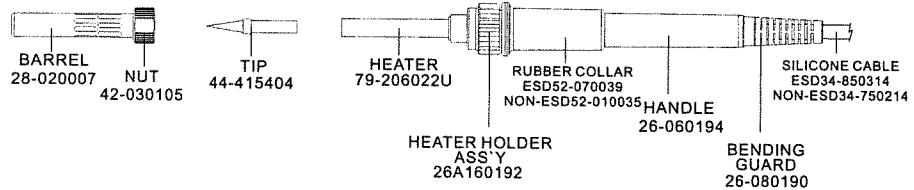
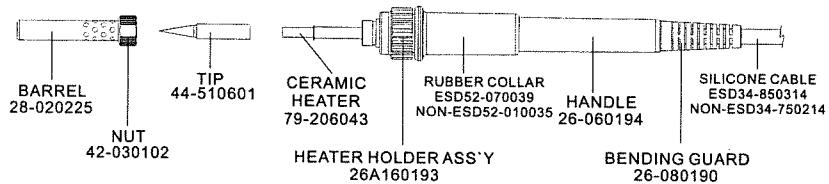


Fig. 2

SOLDERING IRON ASS'Y 107/107ESD



## WORKING TEMPERATURE

A low iron temperature will slow the rate of flow of the solder. A high temperature will burn the flux in the solder, which in turn will emit a heavy white smoke resulting in a dry joint, or damage to the P.C.B. When the tip working temperature is set to the correct temperature parameters suited to the particular solder being used, a good joint is assured.

The most common solder alloy used in the electronic industry is 60% tin, 40% lead (Sn60/Pb40), but to meet RoHS requirements, the Sn60/Pb40 solder alloys are not allowed in the production process for RoHS compliant products. **Lead free solder alloys require a working temperature about 30°C (86°F) higher than previous generation electrical soldering.**

Below are listed the common temperature for the specific job with Sn60/Pb40 solder alloy.

### SOLDERING

Melting point	215°C	(419°F)
Normal operation	270-320°C	(518-608°F)
Production line operation	320-380°C	(608-716°F)

### DESOLDERING

Desoldering operation for smaller joint	320-360°C	(608-680°F)
Desoldering operation for larger joint	370-400°C	(698-752°F)

\* The temperature above 410°C (770°F) is not recommended for normal soldering functions, but can be used for short periods of time when high temperatures are required.

## OPERATING INSTRUCTIONS

\* Ensure that the working voltage matches your power supply before plugging in the station.

\* Check carefully for any damage during transportation.

**Analog Stations-** linear analog meter, Model: 168-3C, XY9-60A, & XY9-60A/ESD. Set temperature by rotating temperature control knob on the front of the front panel stopping at the desired temperature.

**Digital Stations-** digital display, Model: XY9-60D, & XY9-60D/ESD & 137ESD. Set temperature by moving "SET-READ" switch to "SET" position, rotate temperature control knob until the digital display reads the desired temperature, then move "SET-READ" switch to "READ" position. The station will then maintain the pre-set temperature.

**No Digital Stations-Model: 136, 136ESD**

Set temperature by rotating temperature control knob on the front of the front panel.

### First time Use:

1. Ensure that the base unit's power switch is in the "OFF" position.
2. Set the temperature control knob to the MIN setting.
3. Switch the base unit power switch to the "ON" position. Note that the LED light will turn off when the tool reaches the set temperature. Models 136 & 136ESD use a multi-color LED to indicate that the iron has reached the desired temperature by changing from green to orange in color.
4. Rotate the temperature control knob to 250°C (480°F), waiting until the LED turns off to begin liberally tinning the soldering tip with a protective layer of solder.
5. Adjust the temperature to the desired setting. When the LED turns off (or changes color) you are ready to begin.

**CAUTION:** Soldering irons operate at high temperatures and can easily burn people or objects. **Do not touch** the tip and heater at any time while the unit is on and keep it a safe distance from inflammable materials. Please allow sufficient time for it to cool before changing tips or servicing the unit!

## COMMON CAUSES OF TIP UNWETTING

1. Tip temperature higher than 410°C (770°F).
2. The tip working surfaces are not tinned while the iron idling.
3. Lack of flux in soldering. Wicking, repairing, and touch-up operations.
4. Wiping the tip on a high sulfur content, dirty or dry sponges and rags.
5. Touching with organic substances such as plastic, resin, silicone, grease and other chemicals.
6. Impurities in solder and/or low tin content.

## CARE OF TIPS

**Caution:** The solder iron can reach very high temperatures. Be sure to turn the unit off prior to carrying out any maintenance or trouble shooting steps listed below!

### IMPORTANT

Remove the tip and clean after moderate to heavy use or at least daily if on the production line. Remove any loose build up in the tip retaining assembly to prevent tip freezing.

The solder tips supplied are iron clad copper and if used properly, they should maintain optimum life.

1. Always tin the tip before returning it to the holder, turning off the station, or storing it for long periods of time. Wipe the tip on a wet sponge prior to use. .
2. Keeping the iron set at high temperatures (more than 400°C or 750°F) will shorten tip life.
3. Do not use excessive pressure on the tip or rub the joint with the tip while soldering, it does not improve the heat transfer and may damage the tip.
4. Apply solder to the joint, not the tip when soldering. The flux is naturally caustic and thus will eat away the tip.
5. Never clean the tip with a file or abrasive materials.
6. Do not use fluxes which contain chloride or acid. Use only rosin or resin or resin activated fluxes.
7. If an oxide film forms on the tip, it can be removed by careful buffing with a 600-800 grit emery cloth, isopropyl alcohol or equivalent and then wrapping rosin core solder around the newly exposed surfaces. Coat the tinned areas with rosin-core solder after the rosin-core has melted.

## NEW TIP

Following these steps will lead to optimum tip life.

1. Set temperature to min, then turn the main power switch to the "ON" position .
2. Set temperature to 250°C (482°F).
3. Coat the tinned surfaces with rosin-core solder after reaching 250°C (482°F).
4. Set to desired temperature after allowing the unit to idle at 250°C for 3 minutes.
5. The iron will be ready for use once it reaches the preset temperature.

**IMPORTANT:** Remove and clean the tip daily. If a new tip is installed, remove any loose build up in the barrel assembly, otherwise tip may fuse to the heating element or retaining barrel.

## MAINTENANCE

### TIP MAINTENANCE AND DRESSING

Tips can be changed or replaced simply by unscrewing the knurled nut barrel assembly.

The station must be switched off and allowed to cool before this operation as damage may result if the system is left on without the tip in place!

After removing the tip, blow out any oxide dust that may have formed in the tip retaining area of the barrel. Be careful to avoid getting this dust in your eyes. Replace the tip and screw back the knurled nut barrel assembly using only firm hand pressure to tighten. Pliers should only be used to tighten the nut to avoid burning your fingers, but care should be taken not to over-tighten as this could damage the element.

### GENERAL CLEANING

The outer cover of the iron and station may be cleaned with a damp cloth using small amounts of liquid detergent. Never submerge the unit in liquid or allow any liquid to enter the case of the station. Never use any solvent to clean the case.

### SERVICE

If the iron or station should become faulty or, for some reason not operate normally, the system should be returned to the service department of your authorized dealer or agent. If the supply cord is damaged, it must be replaced by the manufacturer or its service agent or a similarly qualified person in order to avoid a hazard.

**WARNING:** This tool must be placed on its stand when not in use.

**WARNING:** Keep out of the reach of children.

**WARNING:** Do not inhale solder fumes.

**WARNING:** Keep tip and heating element away from the body, clothes and flammable material when in operation.

## INTERCHANGEABLE TIPS

For Nichrome Heater-207,207ESD  
For Stations: XY9-60D,XY9-60D/ESD  
XY9-60A, XY9-60A/ESD  
168-3C

For Ceramic Heater-107,107ESD  
For Stations: 136,136ESD, 137ESD

