



Instruction Manual

for

LF-1560

Analog Soldering Station

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)

* 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.

LF-1560 Analog Station: Non display, just sets temperature by rotating temperature control knob on the front panel stopping at the desired temperature.

First time to 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. Model 169 uses 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 Soldering Iron-208/208ESD

