

**SHENZHEN ATTEN TECHNOLOGY CO.,LTD.**

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- Soldering Iron •Soldering Station •Hot Air Rework Station
- Multi-function Rework System •BGA Rework System
- Regulated DC Power Supply •Switching DC Power Supply
- Programmable Power Supply

# ATTEN

**AT-937/AT-937A/AT-989**

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# SOLDERING STATION

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**Thermo-control Anti-Static  
User's Manual**

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SHENZHEN ATTEN TECHNOLOGY CO., LTD.

## Precautions

In this instruction manual, “**WARNING**” and “**CAUTION**” are defined as follows.

### CAUTION!

*Before use this unit, make sure comply with the following measures, against risk of electric shock or give rise to fire.*

*In order to ensure body safe, must use the components or accessories that recommended by original factory, otherwise it may cause serious consequences.*

*It should be maintained by qualified electric technician or service personnel specified by original factory.*

When the power is on, the tip temperature is between 200°C/392 °F and 480°C/896 °F.

**Since mishandling may lead to burns or fire, be sure to comply with the following precautions.**

- Do not touch the metallic parts near the tip.
- Do not use the product near flammable items.
- Advise other people in the work area: the unit can reach a very high temperature and should be considered potentially dangerous.
- Turn the power off while taking breaks and when finished using the unit.
- Before replacing parts or storing the unit, turn the power off and allow the unit to cool down to room temperature.

**To prevent damage to the unit and ensure a safe working environment, be sure to comply with the following precautions.**

- Do not use the unit for applications other than soldering.
- Do not rap the soldering iron against the workbench to shake off residual solder, or otherwise subject the iron to severe shocks.

- Do not modify the unit.
- Use only genuine ATTEN replacement parts.
- Do not wet the unit or use the unit when your hands are wet.
- The soldering process will produce smoke, so make sure the area is well ventilated.
- While using the unit, don't do anything that may cause bodily harm or physical damage.

### WARNING!

**WARNING:** *The Soldering Iron Must be Use ATTEN Heating Element.*

**CAUTION:** *Misuse may potentially cause injury to the user or physical damage to the objects involved. For your own safety, be sure to comply with these Precautions.*

## Packing list

**Please check the contents of the AT-937 package and confirm that all the items listed below are included.**

Station	1pcs
Soldering Iron	1pcs
ATTEN Iron Holder (With Cleaning Sponge)	1pcs
Instruction Manual	1pcs

## Specification

Mode	AT-937	AT-937A	AT-989
Power Voltage	230VAC/50Hz 110VAC/60Hz		
Power Consumption	50W	65W	65W
Heater	Stainless steel heater	Stainless steel heater	Ceramic heater
standby function	NO	YES	YES
sleep function	NO	YES	YES
Temperature Range	200~480 °C		
Tip Leakage Voltage	<2mV		
Standard Tip	T900Series		

### Warranty

This product warranty period cover 24 months from the day this product purchased. We will make free maintenance for any quality problem itself if this card and receipt provided. We will repair and return your device within 2 workdays after receiving repairing-req device.

Note: please attach this warranty card if you want your device to be repaired without charge.

### Certificate of Product

Model: \_\_\_\_\_ Product NO.: \_\_\_\_\_

QC: \_\_\_\_\_ Production date: \_\_\_\_\_

Sales clerk: \_\_\_\_\_ Sale date: \_\_\_\_\_



## Tip Care and Use

### 1. Tip Temperature

High soldering temperatures can degrade the tip.

Use the lowest possible soldering temperature. The excellent thermal recovery characteristics ensure efficient and effective soldering even at low temperature<sup>S</sup>.

### 2. 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 tip's 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.

### 3. 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.

### 4. After Use

Wipe the tip clean and coat the tip with fresh solder. This helps prevent tip oxidation.

## Maintenance

### 1. Inspect and Clean the Tip

**CAUTION:** Never file the Tip to remove oxide.

- Set the temperature to 250°C (482°F).
- When the temperature stabilizes, clean the tip with the cleaning sponge and check the condition of the tip.
- If there is black oxide on the solder-plated portion of the tip, apply new solder (containing flux) and wipe the tip on the cleaning sponge.  
Repeat until the oxide is completely removed. Coat with new solder.
- If the tip is deformed or heavily eroded, replace it with a new one.

### 2. Calibrating the Iron Temperature

*The soldering iron should be recalibrated after changing the iron, or replacing the heating element or tip.*

- Connect the cord assembly plug to the receptacle on the station.
- Set the temperature control knob to 400°C (750°F).
- Turn the power switch to “ON” and wait until the temperature stabilizes. Remove the CAL pot plug.
- When the temperature stabilizes, use a straightedge (–) screwdriver or small plus (+) screwdriver to adjust the screw (marked CAL at the station) until the tip thermometer indicates a temperature of 400°C (750°F). Turn the screw clockwise to increase the temperature and counterclockwise to reduce the temperature. Replace the CAL pot plug.

*We recommend the ATTEN 191/192 thermometer for measuring the tip temperature.*

### 3. Tips

The tip temperature will vary according to the Shape of the tip. The preferred method of adjustment uses a tip thermometer (See “Calibrating the Iron Temperature”).

## Troubleshooting Guide

### WARNING!

*Disconnect the power plug before servicing. Failure to do so may result in electric shock.*

*If the power cord is damaged, it must be replaced by the manufacturer, its service agent or similarity qualified person in order to avoid personal injury or damage to the unit.*

### Problem 1.

**The heater lamp does not light up.**  
[Check 1.]

*Is the power cord and/or connecting plug disconnected?*

- Connect it.

[Check 2.]

*Is the fuse blown?*

- Determine why the fuse blew and eliminate the cause, then replace the fuse.

- Is the inside of the iron short-circuited?*
- Is the grounding spring touching the heating element?*
- Is the heating element lead twisted and short-circuited?*

### Problem 2.

**The heater lamp lights up but the tip does not heat up.**

[Check 3.]

*Is the soldering iron cord broken?*

- Refer to “Checking for breakage in the cord assembly.”

[Check 4.]

*Is the Heating Element broken?*

- Refer to “Checking for breakage in the heating element.”

### Problem 3.

**The tip heats up intermittently.**  
[Check 3.]

### Problem 4.

**The tip is not wet.**

[Check 5.]

*Is the tip temperature too high?*

- Set an appropriate temperature.

[Check 6.]

*Is the tip clean?*

- Refer to 'Tip Care and Use '.

### Problem 5.

**The tip is not wet.**

[Check 7.]

*Is the tip coated with oxide?*

- Refer to “Insect and clean the tip” .

[Check 8.]

*Is the iron calibrated correctly?*

- Recalibrate.

### Problem 6.

**The tip cannot be pulled off.**

[Check 9.]

*Is the tip seized?*

*Is the tip swollen because of deterioration?*

- Replace the tip and the heating element.

### Problem 7.

**The tip doesn't hold the desired temperature**

[Check 8.]