YIHUA

Portable Soldering Iro

OPERATION INSTRUCTION

English

Made in China

Thank you for purchasing this product. Please read the manual carefully before operating & keep this manual for future reference.

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

● *This product should not be thrown in the garbage. In accordance with European directive 2012/19/EU, electronic equipment at the end of their must be collected & returned to an authorized recycling facility.* ● *Este produ no debe desecharse en la basura. De acuerdo a la directiva europea 2012/19/ los equipos electrónicos al final de su vida se deberán recoger y trasla a una planta de reciclaje autorizada.* ● *Dieses Produkt sollte nicht mit d Hausmüll entsorgt werden. In Übereinstimmung mit der europäischen Richtl 2012/19/EU müssen elektronische Geräte am Ende ihrer Lebensda eingesammelt und einem autorisierten Recyclingbetrieb zugeführt werd*

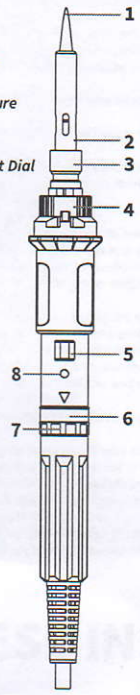
Control Unit Dimensions	L220xW28xH28mm ±5mm
Operating Ambient Temperature	0~40°C/32°F~104°F
Temperature Range	220°C~480°C/428°F~896°F
Temperature Contro	Sensor-Controlled Temperature
Operation Indicator Light	Yes

I. APPLICATIONS

Suitable for desoldering and soldering applications on surface-mounted and through-hole components such as SOP, DIP, SOIC, and more.

II. PART LIST

1. *Soldering Iron Tip*
2. *Soldering Tip Enclosure*
3. *Fastener*
4. *Heating Element Enclosure*
5. *Function Switch*
6. *Temperature Marking*
7. *Temperature Adjustment Dial*
8. *Operation Indicator*



III. OPERATION

1. Place the soldering iron on the holder.

2. Connect the soldering iron to a power outlet and turn ON the soldering iron's function switch. The soldering iron's heating element will begin heating with the indicator light ON. Begin operation after the soldering iron's temperature stabilizes. The indicator stays ON when the soldering iron is heating, blinks rapidly and regularly when the temperature stabilizes, and turns OFF when the soldering iron is cooling.

   CAUTION:Upon the first use of the soldering iron, set the temperature to 250°C/482°F. When the temperature is just enough to melt solder wire, coat the soldering iron tip with a new layer of solder (the use of rosin-core solder wire is recommended) before adjusting the soldering iron to your desired temperature.

3. When the operation is complete, use a damped sponge or metal wool ball to clean the residues off the soldering iron tip. Tin the tip with a new layer of solder again, then put the soldering iron back to the holder. Turn OFF function switch, and DISCONNECT the power cord if the station is not in use for an extended period.

IV. MAINTENANCE & PRECAUTIONS

1. If a layer of oxidization forms on the surface of the soldering iron tip, a misconception can be created that the soldering tip cannot heat up properly to melt the solder and do the tinning. But the actual temperatures of both the heating element and soldering tip are high. In such an instance, please do not increase the temperature value confusedly but use a metal wool ball to remove the oxidization following the steps below:
   A. Set the temperature to 300°C (572°F).
   B. Once the temperature stabilizes, gently rub the soldering iron tip inside the metal wool ball.
   C. When the oxidization is partially removed, continue applying solder onto the tip while rubbing it until the soldering tip is completely coated with solder. If the tip is too severely oxidized beyond cleaning, replace the tip with a new one.

2. DO NOT use metal files to remove the oxidization on the soldering iron tip. If the soldering iron tip deforms or rusts, replace the soldering iron tip with a new tip.

3. DO NOT apply excessive force on the soldering iron tip when soldering. Doing this will NOT IMPROVE the heat transfer but damage the soldering iron tip instead.

4. When placing the soldering iron back in the holder to idle after a high-temperature operation, adjust the temperature to 250°C (482°F) or below for idling. Failure to do so, and leaving the soldering iron tip to idle on a high-temperature setting will cause the accelerated aging of the heating element, and shorten the lifespan of the heating element and soldering iron tip.

5. After every operation, always wipe off the soldering tip, then tin the tip with a layer of solder to prevent oxidization.

V. TROUBLESHOOTING

The operation light stays ON, but the soldering iron is not heating up – This is an indication that the heating element is damaged. To resolve this issue, you need to replace the heating element.