

ELECTRIC SOLDERING GUN

SAFETY INSTRUCTIONS FOR OPERATION AND MAINTENANCE

1. This appliance has a polarized plug (one blade is wider than the other). To reduce the risk of electric shock, this plug is intended to fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician. Do not modify the plug in any way.
2. Arrange a secure resting place on your worktable where the tip will never contact a flammable surface, your body, or the power cord. With a peak temperature of about 1000°F, the tip may remain hot for minutes after you release the trigger switch.
3. To reduce the risk of burns to yourself and others, remove excess hot molten solder from the tip by wiping with a damp cloth, damp sponge or solder brush made for that purpose. Never swing the gun.
4. To protect eyes from splatter, wear safety goggles meeting requirements of ANSI Z87.1 (shown on safety goggle package).
5. To reduce the risk of destroying the tool, observe the 20% "On" time duty cycle rating of a solder gun. This rating means a maximum of 1 minute of "On" time over 5 minutes total time. Never tie down the trigger switch.
6. To reduce the risk of respiratory, eye or skin irritation, keep your head out of the soldering fumes.
7. To reduce the risk of electrical shock, fire or explosion, work only in surroundings that are dry, and are free from flammable materials including vapours and liquids.
8. After use, unplug the power cord and let it cool down. Store solder gun in a dry secure place...out of the reach of children.

Assembly

1. Solder Gun comes complete with solder tip located on the card.
2. With a #2 Phillips screwdriver, loosen screws located on the front of the soldering tool.
3. Insert tip into opening and tighten down screws.

Operation

Using Your Solder Gun

1. Screws holding tip must always be snug for solder gun to function properly. Use a #2 Phillips screwdriver to tighten screws when necessary. To avoid stripping screws, be careful not to over tighten.
2. Clean the surfaces to be soldered together to ensure a good bond. Use a wire brush or sandpaper to remove paint, varnish, or rust. To remove oil or grease, use alcohol.
3. Select the proper kind of solder. Rosin core solder is recommended for work on electrical items such as building radio and TV kits, model railroads, etc. The rosin, or flux as it is sometimes called, in the solder helps clean the soldering joint as the solder is being melted and helps in the bonding process. Another type of solder is ACID core solder. It must be remembered never to use acid core solder when soldering electrical connections. Damage to electrical components may result. Acid core solder is recommended when soldering some types of steel plates together but not for electrical connections.
4. Tin the tip of the soldering gun with a coating of rosin core solder for best results. This is done by cleaning the tip with steel wool. Then pull trigger to heat tip and while tip is heating apply a light coating of new solder. Excess solder may be removed with a solder brush, damp sponge or damp cloth.
5. Apply solder gun tip to the two surfaces or "joint" to be soldered at the same time. Pull trigger to apply heat to the joint. It takes approximately 12 seconds for the tip to reach soldering temperature. Apply solder to the joint--NOT the TIP--but close to the tip and the solder should begin to flow into the joint. Do not apply too much solder to the joint. Just use enough to give strength and a good appearance.
6. Release trigger and set gun in a safe position to cool

WARNING: To reduce the risk of fire, burns or toxic vapours, do not use solvents other than alcohol for oil or grease removal.

IMPORTANT: Remember your gun has a 20% duty cycle. Never use it continuously for more than one minute without letting it cool for 4 minutes. Never tie down the trigger expecting the tip to remain at peak temperature for soldering. This will damage the tip.

Maintenance

WARNING: To avoid burns or electrical shock, always unplug the soldering gun and allow to cool before servicing.

Taking care of your solder gun.

Keep tip screws snug. Periodically inspect the tip screws for looseness and tighten when necessary. However, to avoid stripping screws, do not over tighten.

Keep the soldering tip clean. Use steel wool or very fine sandpaper.

Tin tip before using. Refer to step 4 of Operation.

Changing Tip

1. Remove tip after loosening both screws holding tip.
2. Insert new tip and tighten screws. To avoid stripping screws, do not over tighten.

Troubleshooting

Trouble	Probable Cause	Action
tip does not heat although unit is plugged in and trigger is depressed.	1. Tip screws loose. 2. Tip cracked or broken. 3. Tip dirty.	Unplug gun from power receptacle. 1. Tighten tip screws. 2. Replace with new tip. 3. Clean tip with steel wool or fine sandpaper.