

iroda.



SOLDERPRO™ 150

Instruction Manual

READ INSTRUCTIONS AND WARNINGS BEFORE USE

www.pro-iroda.com.tw

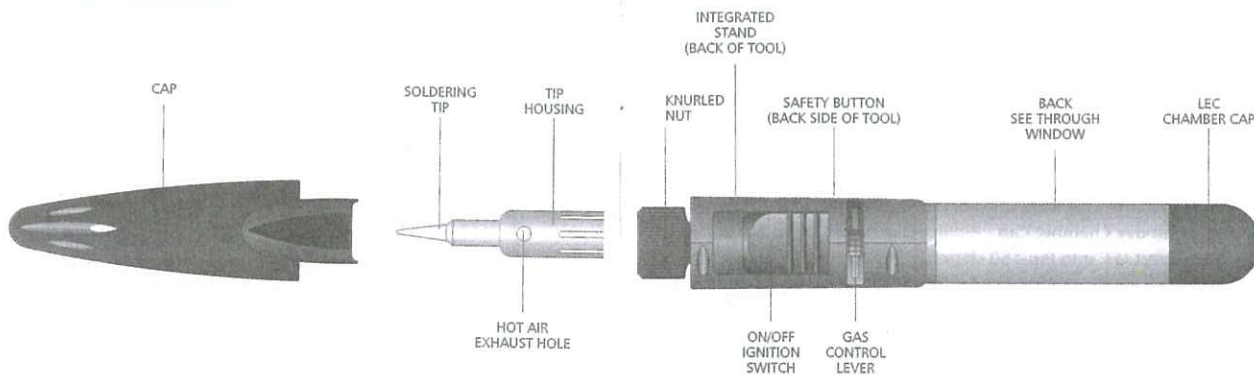
© 2006.03

IMPORTANT SAFETY INSTRUCTIONS

Warnings:

- 1.1 Unit contains flammable gas (Butane) under pressure - use with care.
- 1.2 DO NOT expose to heat above +50°C (120°F) and avoid prolonged exposure to the sun.
- 1.3 DO NOT puncture or incinerate.
- 1.4 Excessive gas flow, flaming or catalyst pulsing red may occur when the GAS CONTROL LEVER is incorrectly adjusted, i.e., set too high.
- 1.5 DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials.
- 1.6 KEEP WORK AREA CLEAN. Cluttered areas and benches invite injuries.
- 1.7 KEEP CHILDREN AWAY. Visitors should be kept away from work area.
- 1.8 STORE WHEN NOT IN USE. Store in dry, locked cabinet out of reach of children.
- 1.9 BE extremely careful as torch flame tip temperature is over 1300°C (2500°F)
- 1.10 BE extremely careful as torch flame is almost invisible in daylight or strong light.
- 1.11 USE SAFETY GLASSES.
- 1.12 DONT OVERREACH. Keep proper footing and balance at all times.
- 1.13 STAY ALERT. Watch what you are doing. Use common sense. Do not operate when you are tired.
- 1.14 DO NOT TOUCH THE HEATED TIP OR BARREL OF THE UNIT.
- 1.15 DO NOT leave unit unattended when it is operating or hot.
- 1.16 ALWAYS BE SURE THE UNIT IS COOL BEFORE STORING.
- 1.17 DO NOT REPLACE CAP WITHOUT SWITCHING UNIT OFF AND ENSURING TIP HAS COOLED.
- 1.18 USE ONLY IN WELL VENTILATED AREA.
- 1.19 DO NOT attempt to readjust or repair, unit is not user serviceable.

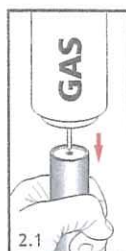
DESCRIPTION



REFUELING

2.1 Fill LEC

- a. Use standard Butane Fuel
- b. Invert butane can to allow gravity assist (Fig1)
- c. Allow up to 5 minutes at room temperature for fuel to stabilize before use.



2.2 Insert LEC into Chamber

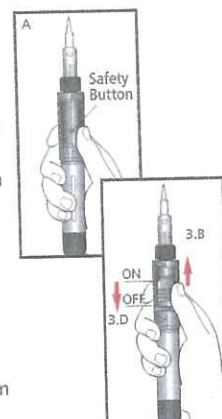
- a. Remove Chamber Cap
- b. Insert LEC into Pro-150 chamber (fig 2.1)
- c. Insert with gray flat side toward inside of chamber.
- d. Do not force LEC into chamber as cap will properly seat LEC in chamber
- e. Replace Chamber Cap



HOW TO USE SOLDERING IRON

3. Ignition

- a. Set Gas Control level at mid position
- b. While pushing in and holding ignition safety button "A" lift up ON/OFF IGNITION SWITCH to the "ON" position to start the flow of gas.
- c. Push the switch upward toward the tip to the maximum point to ignite and then release. The switch will move back to the "ON" position automatically.
- d. To turn off, slide the ON/OFF ignition switch downward toward the bottom of tool.



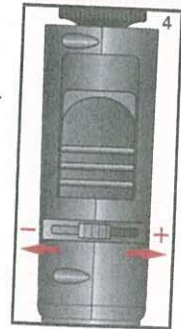
IGNITION WARNINGS

- 3.C Do not touch Tip, Tip Housing or Knurled Nut while igniting.
- 3.D Do not ignite the unit when "Tip Assembly" is not screwed on.



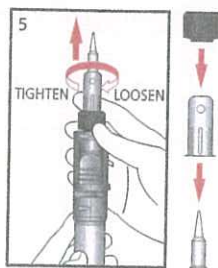
ADJUSTMENT

- 4.1 The tip temperature can be adjusted by turning the GAS CONTROL LEVER observing the - + signs on the body.
- 4.2 Ideally set the GAS CONTROL LEVER to mid position when soldering or brazing.
- 4.3 It is not necessary for the catalyst inside the tip to glow bright red to achieve satisfactory soldering temperatures. Experience will dictate the adjuster setting required.



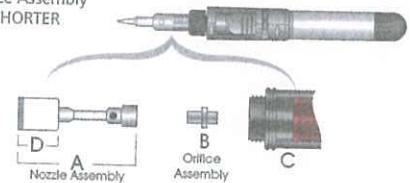
CHANGING TIPS

- 5.1 Be sure the tip has cooled before removal.
- 5.2 The catalyst seen through the Hot Air Exhaust Hole of the soldering tip is very delicate and will not sustain mechanical abuse without serious damage.
- 5.3 The soldering tip is easily removable allowing the installation of other style tips or the replacement of a worn tip. After the soldering tip is cool, simply unscrew it with a counterclockwise motion. Be careful not to overtighten as this could damage the nozzle assembly and thread in the body.



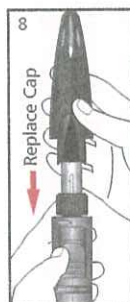
CLEAN OR REPLACE ORIFICE ASSEMBLY

- 6.1 Remove soldering tip and flame collar in the normal manner.
- 6.2 While holding the torch straight up in the vertical position, unscrew Nozzle Assembly (A) from the Torch Body (C). You may have to use a pliers or other tool to start unscrewing. Do not grasp and turn the Ceramic Head (D).
- 6.3 Carefully remove Orifice Assembly (B) by lifting it out of torch body. NOTE THAT THE SHORTER SIDE OF ORIFICE ASSEMBLY FITS INTO TORCH BODY.
- 6.4 Soak Orifice Assembly in Naphtha or other similar solvent for approximately 5 minutes.
- 6.5 Replace clean (or new) Orifice Assembly remembering to insert the SHORTER SIDE INTO TORCH BODY.
- 6.6 Replace Nozzle Assembly and hand tighten or tighten gently with a pliers grasping the shank of the Nozzle Assembly.



REPLACE CAP

- 7.1 When replacing cap please refer as shown picture 7.1



CLEANING

- 8.1 Use only mild soap and a damp cloth to clean the housings of the tool. Many household cleaners contain chemicals which could seriously damage the plastic. Also do not use gasoline, turpentine, lacquer or paint thinner, dry cleaning fluids or similar products. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

ACCESSORIES

- 9.1 The accessories listed below are available from your local retailer.

	PART	NO	DESCRIPTION	TYPE
	Soldering Tip	PS-01	1.6mm	Conical
	Soldering Tip	PS-02	3.2mm	Conical
	Soldering Tip	PS-03	2.4mm	Chisel
	Soldering Tip	PS-04	3.2mm	Chisel
	Soldering Tip	PS-05	2.4mm	Angle
	Soldering Tip	PS-06	3.2mm	Angle

	PART	NO
	Heat Blower	PS-10
	Orifice Assembly	PS-14
	Deflector	S-30
	Hot knife	PS-09

CAUTION : Do not use other than recommended accessories or attachments.

TROUBLE SHOOTING

10. To reduce the risk of personal injury, property damage, or damage to your **SOLDERPRO 150**, do not attempt to repair the unit body.

PROBLEM	PROBABLE CAUSE	HOW TO CORRECT
10.1 Does not ignite	a. Empty LEC b. Too high or low fuel pressure c. Push on/off ignition switch too fast. d. Clogged orifice assembly	a. Refill with butane fuel b. Adjust control lever to a higher or lower position. c. Re-read "How to use as a soldering iron" d. Clean or replace with new orifice assembly
10.2 Low gas pressure or low flame	a. Clogged orifice assembly b. Cold fuel c. Low fuel	a. Clean or replace with new one. b. Hold body in hands to allow unit to warm up. c. Refuel
10.3 Tip does not heat up	a. Used-up catalyst b. Insufficient fuel pressure c. Clogged orifice assembly	a. Replace with new tip. b. Adjust control lever to a higher position. c. Clean or replace with new one.