SOLDERPRO 50K

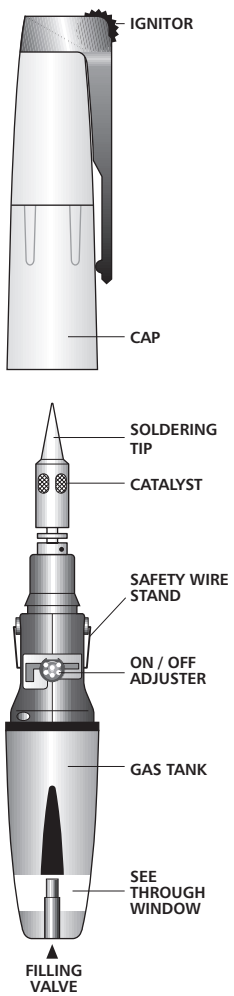
SPECIFICATIONS

Length: w/cap w/soldering tip w/blow torch tip	153 mm (6.0 in) 140 mm (5.5 in) 142 mm (5.6 in)
Weight (when gas-filled)	60 g
Approximate temperature Soldering tip Torch Hot Knife Heat Blower	 250~500°C (482~1005°F) 1300°C (2400°F) 200~350°C (400~660°F) 250~450°C (480~850°F)
Gas container capacity	7 ml
Operating Time (one gas filling)	30 min at mid setting

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, flare-up, or catalyst pulsing red may occur when the regulator is incorrectly adjusted, i.e., set too high.
1.5 DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials. It is essential, therefore, to keep unit away from face and body when igniting.
1.6 KEEP WORK AREA CLEAN. Cluttered areas and benches invite injuries.
1.7 KEEP AWAY FROM CHILDREN. All 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 (2400°F)
1.10 Be extremely careful as torch flame is almost invisible in daylight or under strong light.
1.11 WEAR SAFETY GLASSES.
1.12 DON'T 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 tip 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. Do ensure flame is extinguished before putting down.

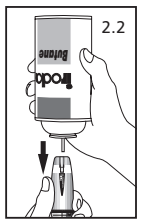


- **READ ENCLOSED INSTRUCTION MANUAL PRIOR TO USE.**
- **BUTANE NOT INCLUDED.**

HOW TO USE SOLDERPRO 50

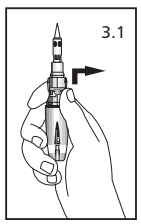
REFUELING

2.1 Adaptors are not normaly required when refilling.
2.2 To refill, hold refill can as pictured (fuel transfer is dependent upon gravity). Observe fuel level in transparent window and stop filling when 90% FULL.



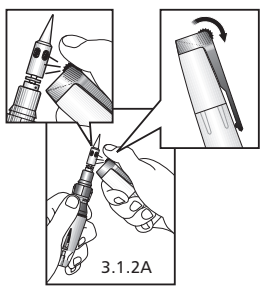
IGNITION SEQUENCE-1

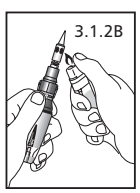
3.1.1 SOLDERING IRON.
Push the ON/OFF adjuster upward toward tip to release gas and turn to **mid** position. Then holding the unit away from the face and body, activate with the flint ignitor or regular lighter.



IGNITION SEQUENCE-2

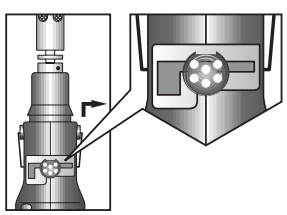
3.1.2 With the other hand, holding it in close proximity to the tip, spin the spark wheel while pointing the stream of sparks at the exhaust ports. The tip will now flame for a few seconds before starting to glow. The flame will then self-extinguish.
3.2 BLOW TORCH
Same as soldering iron but point stream of sparks into the open end of the Blow Torch tip.
3.3 HEAT BLOWER
Same as for soldering iron but point stream of sparks into the open end of the tip. Wait a short time for the flame to self extinguish and to reach operating temperatures.
3.4 HOT KNIFE
Same as for the soldering iron tip.





ADJUSTMENT

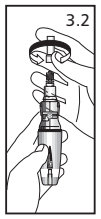
4.1 The tip temperature can be adjusted by turning the ON / OFF adjuster.
4.2 Normally set the ON/OFF adjuster forward to **mid** position when soldering or brazing.
4.3 It is not necessary for the tip to glow bright red to achieve satisfactory soldering temperatures. Experience will dictate the adjuster setting required.
4.4 Excessive gas flow, flare-up or catalyst pulsing red may occur when the regulator is incorrectly adjusted, i.e., set too high.



We love the Earth

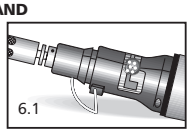
CHANGING TIPS

5.1 Be sure the tip has cooled before removal. The catalyst seen through the exhaust ports of the soldering tip is very delicate and will not sustain mechanical abuse without serious damage.
5.2 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. Pliers may be required to lightly grasp the tip in order to loosen it. Be careful not to overtighten as this could damage the thread in the cap.



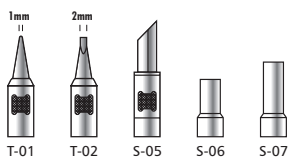
BUILT IN SAFETY WIRE STAND

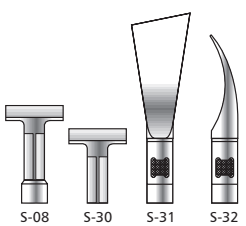
6.1 This built in safety wire stand is designed to hold the soldering iron still to prevent from rolling off.
6.2 For continuous use of the soldering tool, we recommend to use a separate metal stand, which requires the minimum height of 1 - 1.5 inchs from any flat surface.



IMPORTANT NOTE:
THIS TOOL HAS BEEN ESPECIALLY DESIGNED FOR USE WITH 100% BUTANE GAS. ANY OTHER BUTANE-PROPANE MIX OR OTHER FUEL GASES COULD CREATE MUCH HIGHER TEMPERATURES AND INDUCE 'FLARE UP' AT THE TIP EXHAUST SLOTS.

BASIC TIPS





PATENTS:
U.S.PATENT 5,135,389
R.O.C PATENT PENDING
EUROPEAN PATENT PENDING

DESIGNED & MANUFACTURED BY PRO-IRODA INDUSTRIES, INC.

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