

Pro'sKit®

SS-955

Automatic Solder Feeder Soldering Station



User's Manual

1st Edition, 2022

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1.Product introduction

Thank you for purchasing the SS-955 Automatic Solder Feeder Soldering Station; This product optimize the combination of automatic solder wire feed control device and soldering station; The solder wire output is accurate and can be flexibly adjusted, the feeding speed, time and return quantity can be controlled to achieve excellent effect, Suitable for all kinds of lead and lead-free operations, help you improve productivity.

Please read this manual carefully before use and operate in accordance with the instructions strictly. we will not bear any responsibility for product damage and other losses caused by incorrect use. Please keep it properly for future reference.

2.Safety precautions

warning

When the soldering iron is working, the tip of the soldering iron is at high temperature. If you want to replace the tip of the soldering iron or store the product, please turn off the power supply and unplug the wire plug, and then replace or store the soldering iron after it returns to room temperature, so as to avoid personal injury and fire hazards.

attention

- Please use correct voltage source for this product.
- Do not operate in humid environment.
- Do not operate in flammable and explosive environment.
- Please keep the product clean and dry.
- Turn off the power supply when unused or leaving to prevent fire.
- Careful to prevent scalding when the soldering iron is working.
- Do not expose the product to the water or touch with wet hands, prevent electric leakage.
- Do not drop the product, or it may be damaged.
- Repaired and replaced must by professionals.
- Please use original parts when replacing.

3.Characteristic

- 2 in 1 design, soldering iron+ automatic solder wire feed, can be used separately.
- LCD display with backlight.
- Chinese simplified, traditional and English interface are optional.
- Encoder used conveniently, reliable and long service life.
- Temperature range: 200 ~ 480 °C.
- The feeding mechanism adopts brushless stepping motor to control the solder wire output accurately.
- 60W copper transformer.
- Digital temperature calibration function, accurate and convenient.
- The soldering iron uses ceramic heating core (9SS-900N-HT), with long service life and fast heating up.
- The solder wire feed is controlled by handle or foot switch meet different requirement.
- Adopt aviation plug connected reliably.
- Design for anti-static operation with anti-static socket, grounding port, metal case, etc.

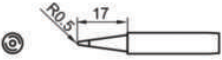
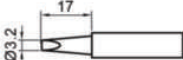
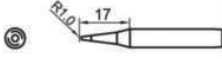
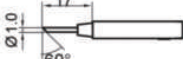
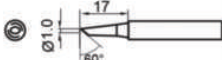
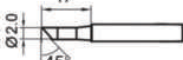
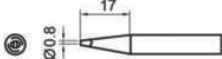
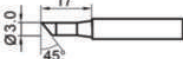
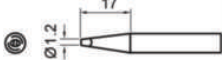
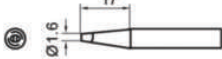
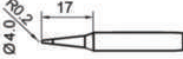
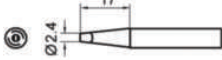
3.1 Specification

	Model	SS-955B
Automatic solder feeder	Voltage	220V-240 V ~ 50Hz
	Power	Soldering iron (60W)
	Soldering iron temperature	200~480°C
	Shell	Steel sheet
	Display	LCD
	Setting	Encoder knob
	Calibration function	Y
	Password lock function	Y
	Restore settings	Y
	Sleep function	Y
	Transformer	60W (copper wire)
	Fuse	2A/250V (Ø5*20mm)
	Anti static socket	Ø4.2mm (impedance 1MΩ)
	Power cord	VDE 1.5m(3*0.5mm ²)
	Accessory	Foot switch 、 Soldering iron 、 Soldering iron frame (with sponge) 、 Handle bracket solder wire support (includ shaft) 、 elbow tube(10cm)/nozzleΦ1.2mm &Φ1.5mm each one 、 straight tube (17.5cm)/nozzle Φ1.8mm 、 screwdriver
	Dimension	200*160*135mm (Including soldering iron support)
Soldering iron	Weight	About 2.9kg
	Packing	Box
	Dimension / Weight	270*230*175mm/ about 3.5kg
	Heating core	Ceramic heating core (9SS-900N-HT)
	Working voltage	AC24V
Solder wire feed	Transfor hose	100cm (Anti scalding silicone pipe)
	Iron tip	Ø1.0mm (B type) (5SI-216N series available)
	Sleeve of handle	Silica gel material
	Applicable solder wire	Ø0.5-1.5mm(0.5/0.6/0.8/1.0/1.2/1.5mm)
Solder wire feed	Control	Foot / hand
	Electric machinery	Stepper motor
	Solder wire feeding tube	80cm(Internal Teflon tube, outer anti scalding silicone hose)
	Working mode	Manual 0 / auto 1-9
	Wire feeding length(Len)	0~99.5mm
	Wire feeding speed(SPD)	1~40mm/s
	Interval time(INR)	0~9.5S
	Return wire length(RET)	0~19.5mm

※Any change without notice, please subject to the actual product.

※It is recommend not to set temperature than 450 °C for a long time use.

3.2 Soldering iron tips

	5SI-216N-B		5SI-216N-3.2D
	5SI-216N-B1.0		5SI-216N-1C
	5SI-216N-BC		5SI-216N-2C
	5SI-216N-0.8D		5SI-216N-3C
	5SI-216N-1.2D		5SI-216N-4C
	5SI-216N-1.6D		5SI-216N-I
	5SI-216N-2.4D		5SI-216N-K

Soldering iron : 5SS-955-SI

Soldering iron heating core : 9SS-900N-HT

Foot switch : 5SS-955-TS

4. Packing list

Main device	1 set
Soldering iron	1 pc
Handle bracket	1 pc
Shaft	1 pc
Foot switch	1 pc
Elbow tube	3 pcs (1pc assembled on soldering iron)
Straight tube	1 pc
Power cord	1 pc
Screwdriver	1 pc
Instruction manual	1 pc

5. Instructions

5.1 Function and display content

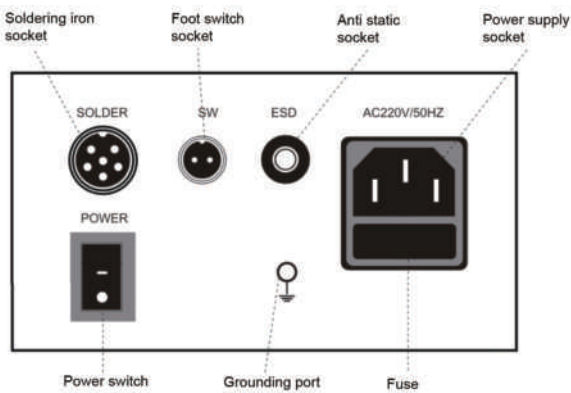
Function setting

1. Language setting
2. Temperature unit setting
3. Password setting
4. Calibration function
5. Restore settings
6. Sleep time setting

Parameter settings

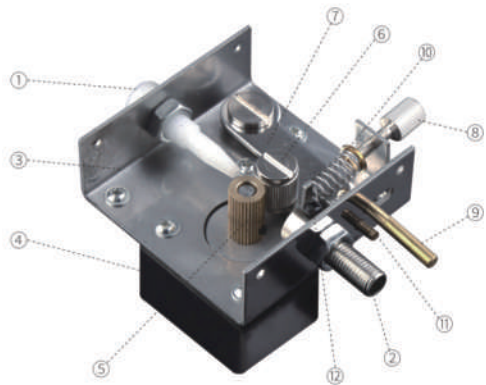
1. Working mode setting
2. Temperature setting
3. Wire feeding length setting
4. return wire length Setting
5. Wire feeding interval setting
6. Wire feeding speed settin

5.2 Schematic diagram of rear panel



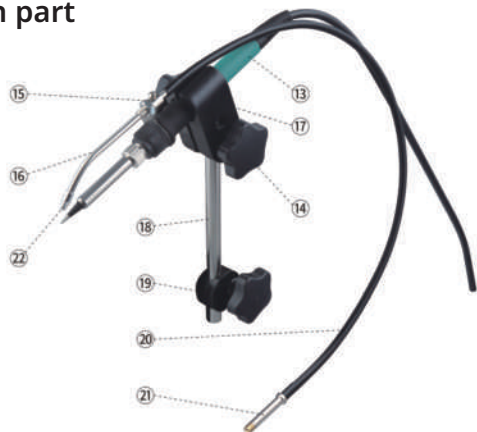
5.2.3 Structrue of feeding

- ① solder wire input port
- ② outlet joint
- ③ Bottom case
- ④ Motor
- ⑤ drive gear
- ⑥ pressure gear
- ⑦ clutch iron plate
- ⑧ pressure adjusting nut
- ⑨ clutch lever
- ⑩ pressure regulating spring
- ⑪ gap adjusting screw
- ⑫ fixing screw



5.2.4 Structure of soldering iron part

- ⑬ soldering iron
- ⑭ tight nut
- ⑮ handle tube separator
- ⑯ elbow tube
- ⑰ handle fixing clip
- ⑱ bracket
- ⑲ bracket fastener
- ⑳ transfer hose
- ㉑ hose connector
- ㉒ nozzle



5.2.5 Solder wire support

- ②③ shaft
- ②④ metal support



5.2.6 Soldering iron

- ②⑤ button for solder wire feeding

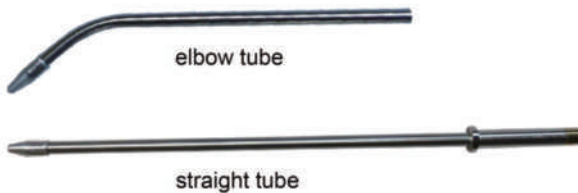


5.2.7 Foot switch

- ②⑥ foot pedal
- ②⑦ foot switch plug



5.2.8 elbow and straight tube



5.3 Install and connection

5.3.1 Straight tube install: loosen the fixing screw ⑫ on the outlet joint ② , insert the straight tube to the outlet joint ② and tighten the screw ⑫ .

5.3.2 Elbow tube install: loosen the fixing screw ⑫ on the outlet joint ② , insert the hose connector ②① into the outlet joint ② and tighten the screw ⑫ . Loosen the locking screw on the handle tube separator ①⑤ of the soldering iron, insert the other end of the hose into the elbow tube, cover the outer skin about 1 cm around the hose, and relock the screw.

Nozzle of the tube (Φ 1.8mm assembled), refer to the following:

nozzle of elbow tube	corresponding solder wire
Φ1.2mm	0.5-0.8mm
Φ1.5mm	0.5-1.2mm
Φ1.8mm	0.5-1.5mm
nozzle of straight tube	
Φ1.8mm	0.5-1.5mm

5.3.3 adjustment of the solder wire and the soldering tip position: rotate the handle tube separator⑮to change the combined position of the nozzle ②②and the tip, loosen the locking screw of the elbow tube, and pull the tube to change the length of its extension.

5.3.4 Foot switch install: insert the foot switch plug ②⑦ into the SW jack on the back of the machine.

5.3.5 Solder wire install:

A 、Thread the shaft ②③into the solder wire , then put on the support ②④ .

B 、Pull out the solder wire and thread it through the solder wire input port ① at the back of the upper cover, push the clutch lever ⑨to increase the gap between the two gears ⑤and ⑥to make the solder wire penetrate into the outlet joint, adjust the gap adjusting screw ①①and the pressure adjusting nut ⑧ , the solder wire between the drive gear and the pressure gear can be well fixed by the gear without slipping, and the solder wire is not deformed due to too much extrusion.

C 、Loosen the fixing screw ①②of the outlet joint , pull off the hose connector ②① , Insert the solder wire pass through the outlet joint ②into the hose connector , fastening the fixing screw ①② .

D 、Connect the power plug on the back of the machine to the power correctly, turn on the power switch, straighten the transfer hose ②①as possible, and press the switch of the foot switch ②⑤or handle button ②⑥until the solder wire is sent to the nozzle.

5.3.6 bracket installation: loosen the bracket fastener ①⑨ on the machine, install the bracket into the bracket seat hole, tighten the tight nut to fix it.

5.3.7 Solder iron installation: loosen the tight nut ①④ , remove the handle fixing clip , ①⑦place the handle into the fixing clip, reinstall and tighten the tight nut ①④ , insert the soldering iron aviation plug into the SOLDER socket on the back of the machine, and lock the screws.

5.3.8 Soldering iron position adjustment: the bracket fastener ①⑨ can adjust the height of the handle, and the angle up or down (not too large to prevent the passage of the solder wire, keep the solder wire in the appropriate position).

⚠ Note:

When unscrewing the handle tube separator, be more careful not to damage the heating core; If the foot switch ②⑥ is pressed and the solder wire cannot be sent out automatically, adjust the pressure adjusting nut ⑧; The outlet joint shall not be excessively bent or forcibly twisted to prevent the solder wire from blocking; If the soldering iron is installed, it will be heated when the power switch is turned on (the display screen will be on). Please pay attention to avoid scalding during installation.

5.3.9 operation mode: two operation modes can be selected as required, elbow mode and straight mode.



(elbow mode)



(Straight mode)

- **Use of ESD socket for anti-static**

This port provides the connection of anti-static working pad, wrist strap and other similar devices.

- **Use of Grounding port**

1. This port provides a connection to a ground point.
2. Pay attention to the connection of power supply and grounding to ensure it is reliable.

5.4 Operating instructions

5.4.1 Language and temperature unit setting:

Turn on the power, long press the panel knob to enter the function setting menu first, rotate the encoder's knob (here in after the knob). When the LCD interface appears on the display screen, select the "ENG" language and press the knob again to confirm.

Rotate the knob, and when the arrow indicator goes to the next column, it indicates to "°C / °F", select the required temperature unit, and press the knob again to confirm.



5.4.2 Working parameter setting:

Rotate the knob, and "TOOL " flashes on the right side of the second column (the "TEMP" is displayed on the left), or "FEED" (related to wire feeding), indicating that the working parameter setting state is entered. At this time, continue to rotate the knob to set the data, and press the knob to enter the corresponding parameter. On any parameter page, press the knob to directly enter the temperature setting before entering the setting state °

1) Temperature setting: when "TEMP" is displayed in the second column on the left of the display screen, press the knob to enter the temperature setting state, rotate the knob to set the required temperature, adjustment range is 200 ~ 480 °C, and press the knob to save the setting.

 XXX°C 
 TEMP XXX°C

 XXX°C 
 SET XXX°C TOOL

- 2) Feeding length: rotate the knob, when "LEN" is displayed in the second column on the left, press the knob to set the feeding length, the adjustment range is 0 ~ 99.5mm, and press the knob to save the setting;
- 3) Return length: rotate the knob, when "RET" is displayed in the second column on the left, press the knob to set the return length, the adjustment range is 0 ~ 19.5mm, and press the knob to save the setting;
- 4) Interval time: rotate the knob, and when the "INR" is displayed in the second column on the left, press the knob to set the interval time, the adjustment range is 0 ~ 9.5s, and press the knob to save the setting;
- 5) Feeding speed: rotate the knob, when the "SPD" is displayed in the second column on the left, press the knob to set the output speed, with the adjustment range of 1 ~ 40mm / s, and press the knob to save the setting;
- 6) Working mode: rotate the knob. When the "MODE" is displayed in the second column on the left, press the knob to enter the working mode. The adjustment range is 0 ~ 9. Press the knob to save the setting;
 - "0" is the manual working mode. The feeding time is manually controlled by the foot switch or by the handle button.
 - "1-9" is the automatic working mode. Just press the foot switch or handle button to automatically complete the feeding according to the set length. When the number is "1", it completes one automatic control cycle, and when the number is set to "2", it completes two control cycles. The pause between cycles is determined by setting the "interval time" parameter.
 - set "1" and the feeding length is set "0", once working it will continues till the foot switch or handle button press again to stop.
 - The temperature set less than 200°C, the soldering iron will be closed , solder wire feeding function can be use seperatly.

 ---°C
 TEMP ---°C 米 —

5.4.3 Password setting:

Long press the knob and turn it to "PASSWORD". Press the knob to enter the password setting. only when "1 PWD" and "2 PWD" are the same number you can save the setting parameters and exit after "LOCKED!" displayed. If the number input are different, "FAIL!" will displayed.

 **PASSWORD**
 CALIB

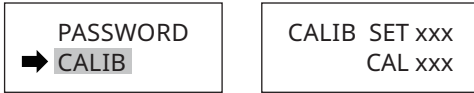
PASSWORD 1PWD xxx
 2PWD xxx

The LCD display show a symbol of "🔒" under the Password Setting Mode, you can't set parameters and there will be "ENTER THE PWD!" required, enter the Password setting and input the password to unlock, the symbol of "🔒" disappeared and then you can set parameters .

When "1PWD" input "0" and "2PWD" input "0", press the knob can clear the password set before. once you forget password, you can input number "166" to unlock.

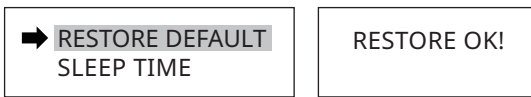
5.4.4 Temperature calibration:

First to measure the temperature of the soldering iron and record the reading used by temperature tester. then long press the knob to enter the parameter setting, select the "CALIB", at SET position input the data which setting temperature, and CAL position input the data which test value(reading), and click the knob to save the setting and exit. (temperature calibration set 2 points, one higher than 350°C, another one lower than 350°C which can obtain the linearity of a wide temperature range).



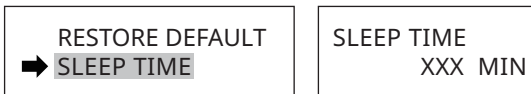
5.4.5 Restore settings:

Long press the knob and rotated to "RESTORE DEFAULT", press the knob again and the parameters setting will automatically return to the initial state.



5.4.6 Sleep time setting:

Long press the knob and rotate to "SLEEP TIME". Press the knob to enter the sleep setting, set turn off the sleep mode or sleep time from 1-240min according to needs ; no operation (foot pedal, handle button) for a long time arrived sleep time setting, the "SLEEPING" will be displayed on the LCD, the tip temperature is down to 200°C. turn the knob, touch foot switch or handle button can wake up directly, and the soldering iron will return to the working set quickly.



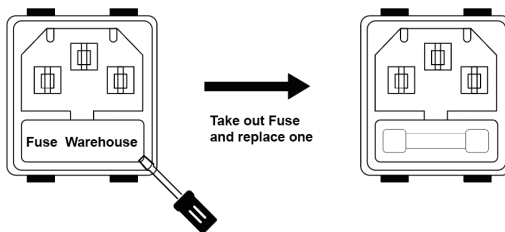
⚠ Note:

It will not remember and exit automatically while no operations for 5 seconds of the knob.

5.5 Fuse replacement

When fuse is blown, replace it with the same type of fuse(refer to the picture below).

- 1) Unplug the power cord from the power receptacle.
- 2) The fuse holder is located under the AC power receptacle. Use a slotted (-) screwdriver to open the fuse holder.
- 3) Replace the fuse with a new one (Φ 5*20mm 2A).
- 4) Put the fuse holder back in place.



5.6 Troubleshooting

Faults	Causes	Solution
Not work	Fuse blown	Replace the fuse (2A/250V)
	Power not connected reliably	Check the power connection and plug it in
Shows“H-E” “S-E”on display	Loose connection	Reconnect the soldering iron plug or replace the heating core
	The heating core is burned or the assembly wire is damaged	Reference the heating core connection circuit
LCD display confusion	Chip failure	Return to dealer
Unable to set temperature	Password set	Enter password or clear it
Temperature deviation of soldering iron tip	Poor temperature calibration	Recalibration
The soldering iron tip can not adhere with tin	Soldering iron tip oxidized	Clean or replace tips
	The temperature of soldering iron was set too high	Set temperature no more than 450°C for long use.
Feeding failure	Chip or motor failure	Return to dealer
	Transfer hose is blocked or deformed	Rearrange the hose and dredge it
	Button switch failure	Replace switch component or soldering iron
	Foot switch failure	Replace the Foot switch

warning

Turn off the power and remove the power cord before maintenance, otherwise electric shock may occur.

Please contact the dealer beyond the above faults.

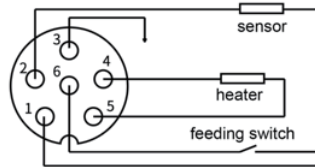
6. How to inspection the soldering iron

Check the resistance between the pins of the connecting plug as follows:



4~5 (Heater)	≈4Ω
1~2 (Temperature sensor)	≈50Ω
1~6 (feeding switch)	ON
3~soldering iron tip(Earthing)	<2Ω

- 1) The resistance value between the plug pins is different from the resistance value in the table, disassembly the soldering iron to confirm whether the resistance value of the PCB is correct.
- 2) The measured resistance value on PCB is correct, indicate that the soldering iron wire is damaged, refer diagram to check the wire connect situation as below.



- 3) The resistance between the 3 pin of the plug and the soldering iron tip is greater than the table value, wipe the point of junction where oxidized with sandpaper.



SS-955自动出锡焊台----使用手册

一、产品简介

感谢您购买宝工 SS-955 自动出锡焊台；本产品将自动出锡控制装置、防静电恒温焊台优化组合；出锡精确且可灵活调节控制送锡速度、时间、回锡量以达到优良焊接效果，适用于各种有铅及无铅作业。

使用前请详细阅读本说明书，并严格按照说明操作，对于未能正确使用而造成产品损坏及其他损失本公司不承担任何责任，阅后请妥善保管以备日后查阅。

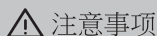
二、安全注意事项

本说明书中所提到警告及注意事项请在操作前详细阅读了解，错误的操作将造成产品损坏或人员的伤害。



警告

烙铁工作时，烙铁头部等处处在高温，若要更换烙铁头或是产品收纳，请将电源关闭及电线插头拔除，待烙铁回到室温后再进行更换或收藏，以避免人员免伤害及火灾危害。



注意事项

请只使用本产品适合电源。

请勿在潮湿环境下操作。

请勿在易燃易爆的环境中操作。

请保持产品表面清洁干燥。

使用结束或要离开时关闭电源，慎防火灾。

当电源接通时，烙铁头温度会达到 200℃ ~ 480℃ 慎防烫伤。

切勿将产品整体泡水或用湿手使用，慎防漏电。

控制器由精密元器件组成，避免跌落。

对产品不熟悉的人员使用时，旁边必须有熟悉操作的人指导使用。

烙铁头首次使用时，因电热原件烘热而可能轻微发烟，这属于正常现象。

如果产品损坏，为了避免危险，必须由制造商、其维修部或类似部门的专业人员维修更换。

更换零件时请选用原厂零件。

当长时间不使用或是附近没人的时候将产品的电源关闭。

三、性能特点

二合一设计，焊台（60W）+ 送锡机功能，可单独也可同时操作使用。

LCD 显示屏，高亮背光。中文简体，繁体，以及英文显示可选。编码器操控，调节顺滑，可靠寿命长。

调温范围：烙铁 200~480℃。

送锡机构采用无刷步进电机，精准控制出锡量。

60W 纯铜变压器。

数字温度校准功能，精确便捷调整。

烙铁使用陶瓷发热芯（宝工 9SS-900N-HT），寿命长升温快。

出锡丝由烙铁手柄按键及脚踏开关双控制。

烙铁引线及出锡管外皮是防烫硅胶材料，安全性好。

烙铁引线接头、脚踏开关引线均采用航空插头，连接可靠。

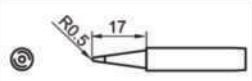
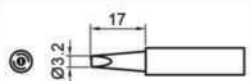
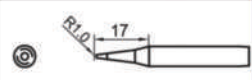
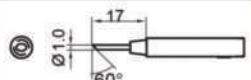
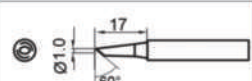
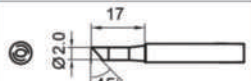
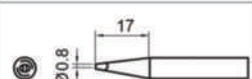
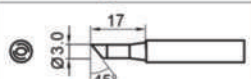
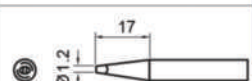
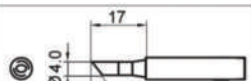
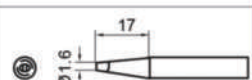
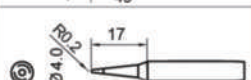
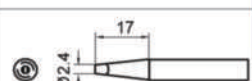
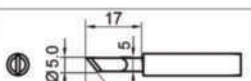
金属机箱外壳，防静电接地插座，适合防静电焊接作业。

产品规格

整机	电压	220V-240 V~ 50Hz
	功率	烙铁（60W）
	烙铁温度	200~480℃
	外壳	冷轧钢板
	显示	LCD
	调节方式	编码器旋钮
	校准功能	有
	密码锁功能	有
	恢复出厂设置	有
	睡眠功能	有
	变压器	纯铜(60W)
	保险管	Ø5*20mm 2A/250V
	防静电插座	Ø4.2mm（阻抗 1MΩ）
	电源线	H 插品字尾，CCC 线 1.5m 长，3*0.5mm²
	配件	脚踏开关、烙铁、烙铁架（附海绵）、手柄支架、锡丝支架（含转轴）、备用出锡弯管（10cm）出锡嘴 Φ12mm 和 Φ1.5mm 各一、出锡直管（17.5cm）出锡嘴 Φ1.8mm、螺丝刀
	尺寸	200*160*135mm（含烙铁支架）
	重量	约 2.9kg
	包装方式	工业盒
	尺寸/重量	270*230*175mm/约 3.5kg
烙铁	发热芯	陶瓷发热芯(9SS-900N-HT)
	发热芯电压	AC24V
	引线	100cm 长，防烫硅胶线
	烙铁头	标配 Ø1.0 (B 型)（通用 5SI-216N 系列）
	隔热套	硅胶
送锡机	适用锡丝范围	Ø0.5-1.5mm(0.5/0.6/0.8/1.0/1.2/1.5mm)
	控制方式	脚踏/手按
	电机	步进电机
	送锡管	80cm 长,内管特氟龙, 外管防烫硅胶软管
	送丝长度	0~99.5mm
	送丝速度	1~40mm/s
	工作模式	手动 0/自动 1-9
	间隔时间	0~9.5S
	回丝长度	0~19.5mm

※上述规格如有更改不另行通知，请以产品实物为准
※不建议长时间将温度设置高于 450℃，以保障机器的寿命尽可能延长

选购烙铁头

	5SI-216N-B		5SI-216N-3.2D
	5SI-216N-B1.0		5SI-216N-1C
	5SI-216N-BC		5SI-216N-2C
	5SI-216N-0.8D		5SI-216N-3C
	5SI-216N-1.2D		5SI-216N-4C
	5SI-216N-1.6D		5SI-216N-I
	5SI-216N-2.4D		5SI-216N-K

选购烙铁手柄：5SS-955-SI

选购烙铁发热芯：9SS-900N-HT

选购脚踏开关：5SS-955-TS

四、包装清单

主机	1 台
烙铁	1 只
手柄支架	1 只
转轴	1 根
脚踏开关	1 只
出锡弯管	3 根（含烙铁上装配 1 根）
出锡直管	1 根
电源线	1 条
螺丝刀	1 条
说明书	1 本

五、使用说明

按钮功能及显示内容

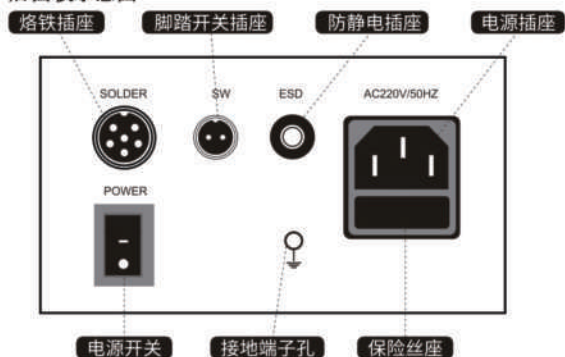
功能设定

- 1· 语言选择
- 2· 温度单位选择
- 3· 密码设置
- 4· 校准功能
- 5· 恢复出厂设置
- 6· 睡眠时间设置

作业设定

- 1· 工作模式设置
- 2· 温度设置
- 3· 送丝长度设置
- 4· 回丝长度设置
- 5· 送丝间隔设置
- 6· 送丝速

后面板示意图



出锡系统示意图

①进锡嘴

②出锡接头

③底壳

④步进电机

⑤驱动齿轮

⑥被动齿轮

⑦离合器铁片

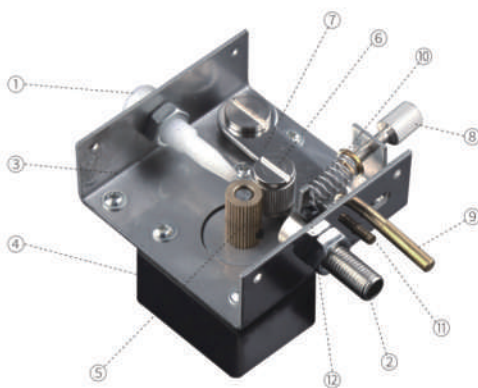
⑧压力调节螺母

⑨离合器拨杆

⑩压力调节弹簧

⑪间隙调节螺丝

⑫出锡接头固定螺丝



手柄示意图

⑬焊台手柄

⑭五角星型螺帽

⑮柄管分离片

⑯出锡嘴弯管

⑰手柄固定夹

⑱支架

⑲支架锁紧铝件

⑳导锡软管

㉑软管接头

㉒出锡嘴



锡丝支架示意图

- ② 锡丝转轴
- ④ 锡丝支架



烙铁手柄示意图

- ⑤ 送锡按键



脚踏开关示意图

- ⑥ 脚踏板
- ⑦ 脚踏开关插头



出锡弯管和出锡直管示意图



2、安装连接

- 出锡导管安装 :安装办法将出锡接头②上面固定螺丝⑫拧松 ,将导管软管接头⑭从出锡接头插入并旋紧螺丝⑫。
- 出锡直管安装方法：将出锡接头②上面固定螺丝⑫拧松，将出锡直管的接头插入②并旋紧螺丝⑫便可。出锡弯管安装办法：将出锡接头②上面固定螺丝⑫拧松，将导锡软管的接头⑭插入出锡接头②并旋紧螺丝⑫。旋松烙铁手柄的柄管分离片⑮上的锁紧螺丝，将导锡软管另外一端插入选用的出锡弯管，导锡软管外皮套在出锡软管大约 1cm 左右，重新锁紧螺丝。

选择使用出锡导管 (Φ1.8mm 规格已装配) ，请参考以下：

出锡弯管孔径	适合焊锡规格	说明
Φ1.2mm	0.5-0.8mm	0.8mm 以下出锡定位更稳定
Φ1.5mm	0.5-1.2mm	0.8-1.2mm 出锡定位更稳定
Φ1.8mm	0.5-1.5mm	1.2-1.5mm 出锡定位更稳定
出锡直管孔径		
Φ1.8mm	0.5-1.5mm	通用兼容

- 出锡嘴与烙铁头位置调节：转动柄管分离片 ⑮ 可以改变出锡嘴弯管与烙铁头的组合位置，旋松出锡嘴弯管的锁紧螺丝，转动出锡嘴 ② 弯管也可改其与烙铁头的组合位置，拉动可改变其伸出的长短；综合以上功能调节出锡嘴弯管与烙铁头的位置，使之符合焊接所要求。
- 脚踏开关安装：将脚踏开关插头 ⑭ 插入机器背面的 SW 插孔，连接完成后将开关放置在所需位置。
- 焊锡丝安装：
 - A、将焊锡丝转轴 ③ 穿在焊丝圆筒中，再将焊锡丝转轴两端槽口卡在支架 ② 两端即可。
 - B、拉出锡线头，将其从上盖后侧的进锡嘴 ① 穿入，右推离合器拨杆 ⑨ 增大两转齿轮的间距，使焊锡丝穿入在出锡接头内，松开离合器拨杆，调节间隙调节螺丝 ⑪ 和压力调节螺母 ⑩ 使得驱动齿轮和被动齿轮之间的焊丝既能被齿轮良好固定、不打滑又不过多的挤压造成焊锡丝变形为宜。
 - C、松开出锡接头固定螺丝 ⑫，拔出软管接头，将穿过出锡接头 ② 的锡丝插入软管接头内，并固定好出锡接头固定螺丝 ⑫。
 - D、将机器背面的电源插头正确连接供电插座，打开电源开关，尽可能拉直导管，踩住脚踏开关，直到焊锡丝送至出锡嘴即可。
- 手柄支架组件安装：旋松机器上的手紧五角星螺帽 ⑬，将支架安装在支架座孔内，旋紧螺帽使之固定，并拧紧支架座侧面六角螺丝。
- 焊台手柄安装：松开支架组件五角星螺帽，取下手柄固定夹片 ⑯，将焊台手柄放置固定夹中，重新装回并旋紧五角星螺帽，将焊台手柄航空插头插入机器背部 SOLDER 插座中，并锁紧螺丝。
- 焊台手柄方向调节：调节方向时，先要旋松对应方向的五角星形螺帽，在进行调节。旋松支架组件下端的五角星形螺帽，可调节焊台手柄的高度位置；同时旋松支架上端的两支五角星形螺帽可以调节焊台手柄的俯仰角度和左右方向（幅度不能太大，以免阻碍锡丝通过）综合各种调节使烙铁头的焊接点与焊丝处于合适的位置。

⚠ 注意

旋下套头手柄管分离片时需多加小心，不要损伤发热芯；如果踩住脚踏开关 ⑭，焊锡丝不能自动送出时，则需调节压力调节螺母 ⑩；出锡导管不能过度弯曲或强行扭曲，以免锡丝发生阻塞；若焊台手柄安装好，电源开关打开时便会加热（显示屏就会亮）安装时敬请注意，以免烫伤。

- 作业方式示意：可以根据需要，选择两种作业方式，弯管方式和直管方式。



（出锡弯管方式）



（出锡直管方式）

有关防静电插座 ESD 的使用

- 1.该端口提供连接防静电工作垫，腕带等类似装置的连接。

有关接地端子的使用

- 1.该端子提供一个接地点的连接。
- 2.注意电源接地的连接确保是可靠的。

3、操作说明

- (1) 语言和温度单位选择：开机后长按面板按钮，进入功能菜单选择，旋转编码调整旋钮（下称旋钮），显示屏出现“简繁 ENG”界面时，选择需要的显示文字界面，背景会暗显，再次按下旋钮确认。旋转旋钮，箭头指示符到下一栏时，指示到“℃/F”，选择需要的温度单位，再次按下旋钮确认。



- (2) 工作参数设定：转动旋钮，第二栏右侧闪烁显示“熔铁”（左侧显示“温度”参数），或“送丝”（左侧显示与送丝相关参数）时，表示进入工作参数设定状态，此时继续转动旋钮切换参数项，点按旋钮进入对应参数更改页面。温度设置比较常用，设有快捷方式：在任意参数页，在未进入设置状态前点按旋钮直接进入温度设置。

- 1) 温度设定：显示屏左侧第二栏显示“温度”时，点按旋钮进入温度设定状态，旋转旋钮设置所需温度，调温范围200~480℃，点按旋钮保存设定。



- 2) 送锡长度：旋转旋钮，左侧第二栏显示“送丝”时点按旋钮可设置送锡长度，调节范围0~99.5mm，点按旋钮保存设定；

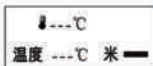
- 3) 退锡长度：旋转旋钮，左侧第二栏显示“回丝”时点按旋钮可设置退锡长度，调节范围0~19.5mm，点按旋钮保存设定；

- 4) 间隔时间：旋转旋钮，左侧第二栏显示“间隔”时点按旋钮可设置间隔时间，调节范围0~9.5s，点按旋钮保存设定；

- 5) 出锡速度：旋转旋钮，左侧第二栏显示“速度”时点按旋钮可设置出锡速度，调节范围1~40mm/s，点按旋钮保存设定；

- 6) 工作模式：旋转旋钮，左侧第二栏显示“模式”时点按旋钮可设置工作模式，调节范围0~9，点按旋钮保存设定；

- 设置为“0”时为手动工作模式，送锡时间由脚踏开关 / 手柄按钮手动控制，接通开关送锡，断开开关停止；
- 设置为“1~9”时为自动工作模式，只需点按脚踏开关 / 手柄按钮，自动按照设定长度完成送锡，当数字为“1”时完成1次自动控制循环，当数字设定为“2”时完成2次控制循环；循环之间的停顿通过设置“间隔时间”参数确定。
- 设置为“1”时且送锡长度设为“0”，则按压工作为持续出丝，再次按压停止。
- 温度设定小于200℃时，熔铁进入关闭状态，此时送锡功能可以继续使用。



- (3) 密码设定：长按旋钮，旋转到“密码”时点按旋钮进入密码设置功能，只有当密码1(1码)和密码2(2码)相同后才能保存设置参数后退出，并显示“锁成!”，若密码不同则显示“错误”并退出。



- (4) 密码功能开启时，显示屏显示“🔒”标识，当调整参数时点按旋钮会显示“输入密码”，提示需要输入密码解锁，密码正确后显示“解锁成功!”，若输入密码错误，点按旋钮后显示“错误!”；解锁成功后，显示屏“🔒”标识消失。关闭本机电源后重新开机依旧处在参数锁止状态，显示“🔒”标识，调整参数需要重新解锁才可进行。

- (5) 重新设定密码，使用原密码设定进行解锁，显示“OK!”后可设定新的密码；当密码1(1码)输入“0”和密码2(2码)输入“0”点按旋钮可以清除密码设定。如果忘记密码可输入万能密码“166”解锁。

- (6) 温度校准：当温度平稳状态下测定熔铁温度并记下该读数，长按旋钮进入系统参数设置，选择“校准”项，旋转旋钮调整校准参数，使数值和实测的读数相同，点按旋钮保存设定退出。（温度校准设定2点，以350℃为界，低温点以最低设置温度点校准，高温点以最高设置温度点校准，可以获得较宽温度范围的线性度。如果使用温度范围小可以选择合适的低点温度和高点温度校准以减小常用温度点的温度偏差。）



- (7) 恢复出厂设置：长按旋钮，旋转到“恢复出厂设置”时点按旋钮，内部参数自动恢复到出厂状态，并显示“恢复成功!”。



- (8) 睡眠时间设置：长按旋钮，旋转到“睡眠时间”时点按旋钮进入休眠设置功能，可根据自身需要设置为关闭休眠功能或者对应0-240min的休眠时间；当焊台长时间不操作（脚踏、手柄按键、按钮无操作），满足休眠时间设定时，将显示“睡眠模式”进入休眠状态，此时焊台为200℃降低能耗；转动旋钮、脚踏开关、手柄按钮均可直接唤醒，焊台迅速回温，恢复到工作设定状态



**注意：**

编码调整旋钮不操作停止 5 秒，会自动退出，不存储设定。

4、烙铁头维护

- ① 定期使用清洁海绵清理烙铁头，焊接后残余焊剂会损害烙铁头导热功能
- ② 使用完后，应抹净烙铁头且立刻挂新锡，以防烙铁头空烧氧化。
- ③ 切勿用刀片消除烙铁头的氧化物
- ④ 如镀锡部分有黑色氧化物时可镀上新锡层，再用高温海绵抹净烙铁头，如此重复清理，知道彻底去除氧化物为止，然后再镀上新锡层。
- ⑤ 弯曲烙铁头会导致其镀层破裂，缩短寿命；若烙铁头变形必须新的烙铁头。
- ⑥ 选择助焊剂时，尽量选择较少活性的松香芯助焊剂，含量高的活性助焊剂或酸性焊油会加速烙铁头的腐蚀，缩短寿命。
- ⑦ 每次更换烙铁头和发热芯后，如有必要应重新校准温度；因为不同款式和型号的烙铁头，由于材料、形状等诸多因素，温度可能略有误差，可用烙铁温度测试仪校准温度。

5、更换保险丝

当有误用情况而造成保险丝烧断时，可以自行更换新的同规格保险丝。（保险盒在机器背部电源线连接处，拉出盒子即可看见保险丝，保险丝规格为 $\Phi 5 \times 20\text{mm}$ 2A



6、简易故障排除

故障现象	可能原因	解决办法
打开电源不工作	保险丝烧毁	更换同规格保险丝
	电线或连接插头未连接可靠	重新接妥
LCD 屏显示正常，但温度显示数值不上升	连接松动显示 H-E S-E	重新连接烙铁插头或更换发热芯
	发热芯烧毁或组装电线破损	参考“发热芯和组装电线破损检测方法”
死机	器件损毁	返厂维修
LCD 显示混乱	芯片故障	返厂维修
无法设置温度	是否设置密码	输入或清除密码
烙铁头温度偏差大	是否正确校准	重新校准
烙铁头不沾锡	烙铁头氧化	清理或更换配件
	烙铁头温度设定过高	重新设定头部温度
出锡控制失效	芯片或电机故障	返厂维修
	出锡管堵塞或变形	重行整理软管或清理疏通
	手柄按键开关失效	更换手柄
	脚踏开关失效	更换脚踏开关

**警告：**进行维修之前应关掉电源，否则可能发生触电事故。

上述故障现象以外之问题，请联络经销商

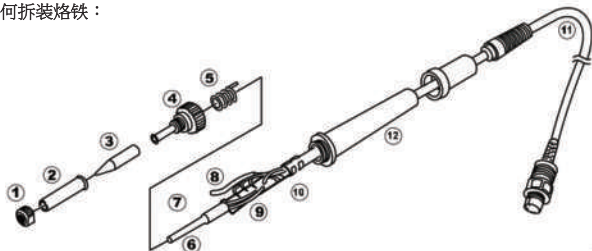
发热芯和组装电线破损检测方法：

1. 如果插头引脚之间的电阻值与右表电阻值有差异，则需将烙铁拆开后，确认印刷电路板电阻值是否正常，检测方式请参考替换发热组件。
2. 如印刷电路板（PCB）上测量电阻值正常，而插头引脚之间的电阻值有差异，表示烙铁电线破损，请参考烙铁电线破损之测试方法。
3. 如果插头第 3 脚与烙铁头之间电阻值大于上表电阻值，则要用砂纸或钢绒轻轻擦除氧化层。拔出插头，测试连接插头的脚与脚之间的电阻值如下：



第 4 脚与第 5 脚之间(发热丝)	$\approx 4\Omega$
第 1 脚与第 2 脚之间(温度传感器)	$\approx 50\Omega$
第 1 脚与第 6 脚之间(出锡开关)	常开
第 3 脚与烙铁头之间 (接地)	2Ω 以下

如何拆装烙铁：



- 1.向反时针方向扭开螺帽 1，取出烙铁头护套 2 和烙铁头 3。
- 2.向反时针方向扭开套头 4，从烙铁中拉出套头。
- 3.从手柄 12 中取出发热组件 6 和电线 11 (向着烙铁头方向拉出)



注意：送锡开关按钮勿遗失。

测量方法：

注意:当烙铁恢复到室温时测量

1. 发热丝电阻值(短引线): $\approx 4\Omega$
2. 传感器电阻值(长引线): $\approx 50\Omega$



如果电阻值反常，更换发热组件。

替换发热组件

1. 将不良的发热芯进行解焊拆除。
2. 替换新的发热芯，点焊于 PCB 上。

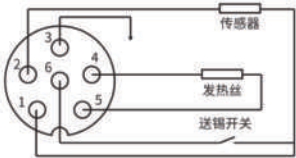
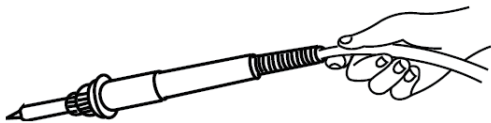


注意：

1. 发热丝及传感器无正负之分，但发热丝与传感器接线混淆可能导致其他组件的损坏。
2. 测量烙铁插头第 1 脚和第 3 脚之间，第 4 脚和第 3 脚之间，第 1 和第 4 脚之间电阻值。如果不是 ∞ ，则可能是发热组件或传感器，接地外壳之间有接触，必须排除。否则这将会损坏印刷电路板。
3. 测量各线间电阻值是否符合，确定引线未被扭曲，而接地弹簧也连接妥当。

烙铁电线破损

测试烙铁电线破损方法：



测试烙铁插头脚和终端板电线之间的电阻值。

脚 1-红色 脚 2-绿色 脚 3-蓝色 脚 4-白色 脚 5-黄色，脚 6-黑色，电阻值应 $<2\Omega$ (欧姆)，若大过 2Ω (欧姆)或 ∞ ，应更换烙铁。

⚠ 注意：实际接线方式以线路图为准，变更引线外皮颜色时，恕不另行告知。

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- ※ 在正常使用情况下, 自原购买日起 12 个月免费维修保证 (马达, 变压器, PCB, 不含耗材、消耗品)。
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- 机件本体之外之配件: 如电源线、支撑架等配件。

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