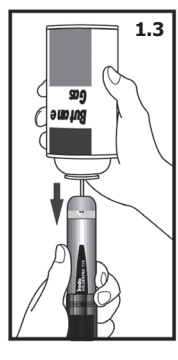
ISO-TIP

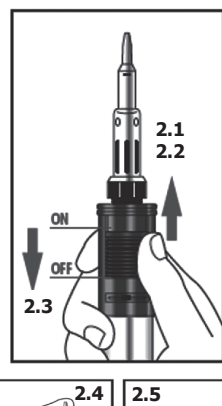
SOLDERPRO 120 #7977
- Automatic Ignition
- Portable Model Multi-function Heat Tool

How To Use SOLDERPRO 120

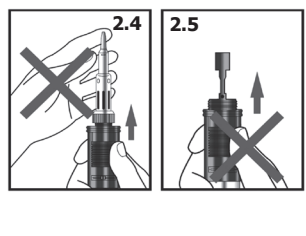
Refueling
1.1 Make sure ON/OFF switch is at "OFF" position before filling.
1.2 Adaptors are not normally required when refilling.
1.3 To refill, hold refill can as pictured in diagram 1.3 (fuel transfer is dependent upon gravity).
1.4 Observe fuel level in transparent window and stop filling when 90% full.



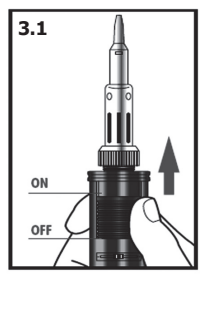
Ignition Sequence-1
2.1 Lift up ON/OFF Ignition Switch to the "ON" position to start the flow of gas.
2.2 Push the switch upward toward tip to the maximum point to ignite then release the switch back to "ON" position to stay on.
2.3 To turn off, slide the ON/OFF Ignition Switch downward toward to the Gas Control Lever.



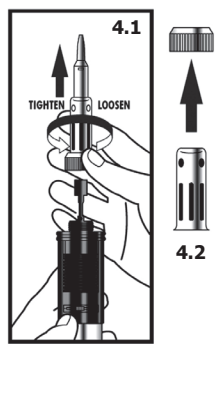
Ignition Warnings
2.4 Do not touch Tip, Tip Housing, or Knurled Nut while igniting.
2.5 Do not ignite the unit when Tip Assembly is not screwed on.



How To Use Soldering Iron
3.1 Be sure the hot air exhaust hole is positioned upward as pictured in diagram 3.1.
3.2 Set gas control level at **mid-**position.
3.3 Push the ON/OFF Ignition Switch slowly upward toward tip to the max. point and release the switch. (Same as 2.1 & 2.2.)
3.4 You may hear the sound of gas flowing and then the Tip Housing window will glow orange after 1 or 2 seconds. If not, repeat 2.1-2.3.
3.5 Tip temperature can be changed by adjusting the Gas Control Lever.
3.6 To turn off, same as 2.3. It is not necessary to move the Gas Control Lever after the unit is turned off.



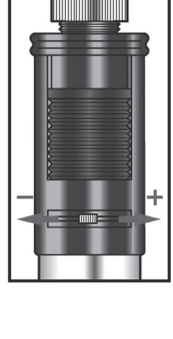
Blow Torch
4.1 Remove Tip and Tip Housing by untightening Knurled Nut.
4.2 Mount the same Tip Housing in place without tip.
4.3 Ignite gas by means of ON/OFF Ignition Switch (Same as 2.1 & 2.2).
4.4 Adjust flame length. Do not adjust to maximum length as gas may flare-up and turn off.
4.5 To shut off the unit, refer to 2.3.



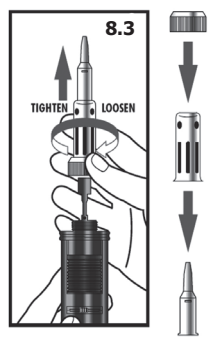
Heat Blow Tip
5.1 Same as soldering tip.

Hot Knife Tip
6.1 Same as soldering tip.

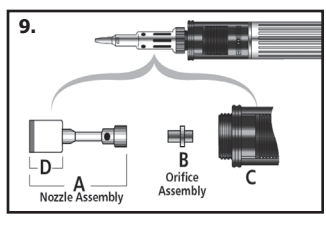
Adjustment
7.1 The tip temperature can be adjusted by turning the Gas Control Lever observing the - + signs on the body.
7.2 Ideally set the Gas Control Lever to **mid-**position when soldering or brazing.
7.3 It is not necessary for the catalyst inside the tip to glow bright red to achieve satisfactory soldering temperatures. Experience will dictate the adjuster setting required.



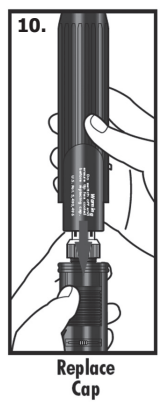
Changing Tips.
8.1 Be sure the tip has cooled before removal.
8.2 The catalyst seen through the Hot Air Exhaust Hole of the soldering tip is very delicate and will not sustain mechanical abuse without serious damage.
8.3 The soldering tip is easily removable allowing the installation of other style tips 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
9.1 Remove soldering tip and flame collar in the normal manner.
9.2 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).
9.3 Carefully remove Orifice Assembly (B) by lifting out of torch body.
NOTE: The shorter side of the Orifice Assembly fits into the Torch Body.
9.4 Soak Orifice Assembly (B) in Naptha or other similar solvent for approx. 5 minutes.
9.5 Replace clean (or spare) Orifice Assembly remembering to insert the SHORTER SIDE INTO TORCH BODY.
9.6 Replace Nozzle Assembly and hand tighten or tighten gently with a pliers grasping the shank of the Nozzle Assembly.



Replace Cap
10. When replacing cap please refer to diagram 10.



Cleaning
11. 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.

Troubleshooting
To reduce the risk of personal injury, property damage, or damage to your SOLDERPRO 120, do not attempt to repair the unit body.

Problem	Probable Cause	How to Correct
Does not ignite	a. Empty tank 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/lower position c. Reread "How To Use Soldering Iron" d. Clean or replace with the included spare Orifice Assembly
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
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

Warranty
Please contact us via phone or e-mail for specific product warranties or any other questions you may have.

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