

# ISO-TIP

## SOLDERPRO 90

### SPECIFICATIONS

W/Cap	198 mm (7.80 in)
Length: W/Soldering Tip	189 mm (7.44 in)
W/Heat Blower Tip	181 mm (7.13 in)
Weight (when gas-filled)	73 g
Approximate temperature-soldering tip	250°C~550°C (480°F~1020°F)
Torch	1100°C (2012°F)
Gas container capacity	10 ml / 0.34 oz.
Operating Time (one gas filling)	55 min. at mid setting

### IMPORTANT SAFETY INSTRUCTIONS

#### Warnings:

- Unit contains flammable gas ( Butane ) under pressure-use with care.
- DO NOT expose to heat above +50°C (120°F) and avoid prolonged exposure to the sun.
- DO NOT puncture or incinerate.
- Excessive gas flow, flaming or catalyst pulsing red may occur when the regulator is incorrectly adjusted, i.e., set too high.
- DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials.
- keep unit away from face and body when igniting.
- KEEP WORK AREA CLEAN. Cluttered areas and benches invite injuries.
- KEEP AWAY FROM CHILDREN.
- STORE WHEN NOT IN USE. Store in dry, locked cabinet out of reach of children.
- Be extremely careful as torch flame tip temperature is over 1300°C (2400°F)
- Be extremely careful as torch flame is almost invisible in drylight or strong light.
- WEAR SAFETY GLASSES.
- DON'T OVERREACH. Keep proper footing and balance at all times.
- STAY ALERT. Watch what you are doing. Use common sense. Do not operate when you are tired.
- DO NOT TOUCH the heated tip or barrel of the unit.
- DO NOT leave unit unattended when it is operating or hot.
- ALWAYS BE SURE THE UNIT IS COOL BEFORE STORING.
- DO NOT REPLACE CAP WITHOUT SWITCHING UNIT OFF AND ENSURING TIP HAS COOLED.
- USE ONLY IN WELL VENTILATED AREA.
- DO NOT attempt to readjust or repair. Unit is not user serviceable. Do ensure flame is extinguished before putting down.

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

DESIGNED & MANUFACTURED  
by PRO-IRODA INDUSTRIES, INC.  
MADE IN TAIWAN



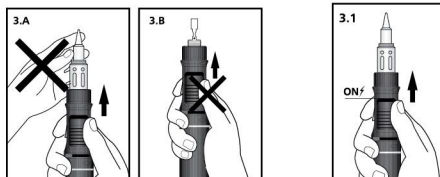
### HOW TO USE SOLDERPRO 90

#### REFUELING

- 2.1 Make sure ON / OFF switch is at "OFF" position before filling.
- 2.2 Adaptors are not normally required when refilling.
- 2.3 To refill hold refill can as pictured (fuel transfer is dependent upon gravity).
- 2.4 Stop filling when overflow gas.

#### IGNITION WARNINGS

- 3.A Do not touch tip, tip housing or knurled nut while igniting.
- 3.B Do not ignite the unit when "Tip Assembly" is not screwed on.

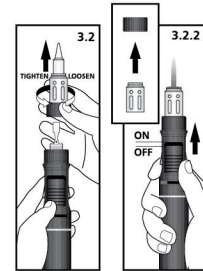


#### HOW TO USE SOLDERING IRON

- 3.1.1 Set gas control level at **mid** position.
- 3.1.2 Push the ON / OFF ignition switch slowly upward toward tip to the max. point and release the switch. (see 3.1)
- 3.1.3 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 3.1.2
- 3.1.4 Tip temperature can be changed by adjusting the gas control lever.
- 3.1.5 To turn off, pull ignition switch down to the OFF position. It is not necessary to move the gas control lever after the unit is turned off.

#### HOW TO USE BLOW TORCH

- 3.2.1 Remove tip and tip housing by untightening Knurled Nut.
- 3.2.2 Mount the same tip housing in place without tip.
- 3.2.3 Ignite gas by means of on/off ignition switch (Same as above).
- 3.2.4 Adjust flame length. Do not adjust to maximum length as gas may flare-up and turn off.
- 3.2.5 To shut off the unit, refer to (3.1.5)



#### HOW TO USE HEAT BLOW TIP

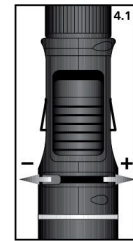
- 3.3 Same as soldering tip.

#### HOW TO USE HOT KNIFE TIP

- 3.4 Same as soldering tip.

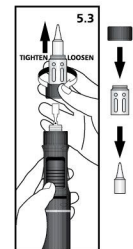
#### ADJUSTMENT

- 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.
- 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.



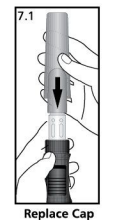
#### CHANGING TIPS

- 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.



#### 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.

#### IMPORTANT NOTE:

THIS TOOL HAS BEEN ESPECIALLY DESIGNED FOR USE WITH GOOD QUALITY BUTANE GAS. ANY OTHER FUEL GASES COULD CREATE MUCH HIGHER TEMPERATURES AND INDUCE 'FLARE UP' AT THE TIP EXHAUST SLOTS.

#### TROUBLESHOOTING

9. To reduce the risk of personal injury, property damage, or damage to your **SOLDERPRO 90**, do not attempt to repair the unit body.

PROBLEM	PROBABLE CAUSE	HOW TO CORRECT
Does not ignite	<ul style="list-style-type: none"> <li>• Empty tank</li> <li>• Too high or low fuel pressure</li> <li>• Push on/off ignition switch too fast.</li> </ul>	<ul style="list-style-type: none"> <li>• Refill with butane fuel</li> <li>• Adjust control lever to a higher or lower position.</li> <li>• Re-read "How to use as a soldering iron"</li> </ul>
Low gas pressure or low flame	<ul style="list-style-type: none"> <li>• Cold fuel</li> <li>• Low fuel</li> </ul>	<ul style="list-style-type: none"> <li>• Hold body in hands to allow unit to warm up.</li> <li>• Refuel</li> </ul>
Tip does not heat up	<ul style="list-style-type: none"> <li>• Used-up catalyst</li> <li>• Insufficient fuel pressure</li> </ul>	<ul style="list-style-type: none"> <li>• Replace with new tip</li> <li>• Adjust control lever to a higher position.</li> </ul>

#### BASIC TIPS

