

# **JBC**

[www.jbctools.com](http://www.jbctools.com)

## **INSTRUCTION MANUAL**



### **AP250**

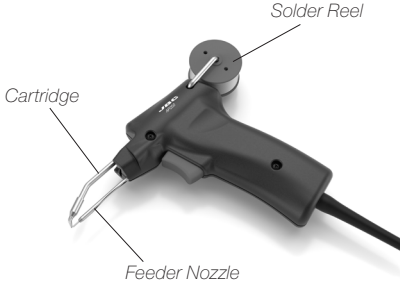
Manual-Feed Soldering Iron

This manual corresponds to the following references:

**AP250-B**

## Packing List

The following items are included:



**Manual-Feed Soldering Iron** ..... 1 unit

*Already assembled in the soldering iron:*

- Ref. 0019212 - **ø1 mm Feeder Nozzle**
- Ref. C250403 - **Cartridge**
- Ref. SN5450 - **Solder Reel**

**ø1.5 mm Feeder Nozzle** ..... 1 unit

Ref. 0019211



**Philips Screwdriver PH1x50** ..... 1 unit

Ref. 0031586



**Cartridge Extractor Pliers** ..... 1 unit

Ref. PLR195



**Reel** ..... 1 unit

Ref. 0031587

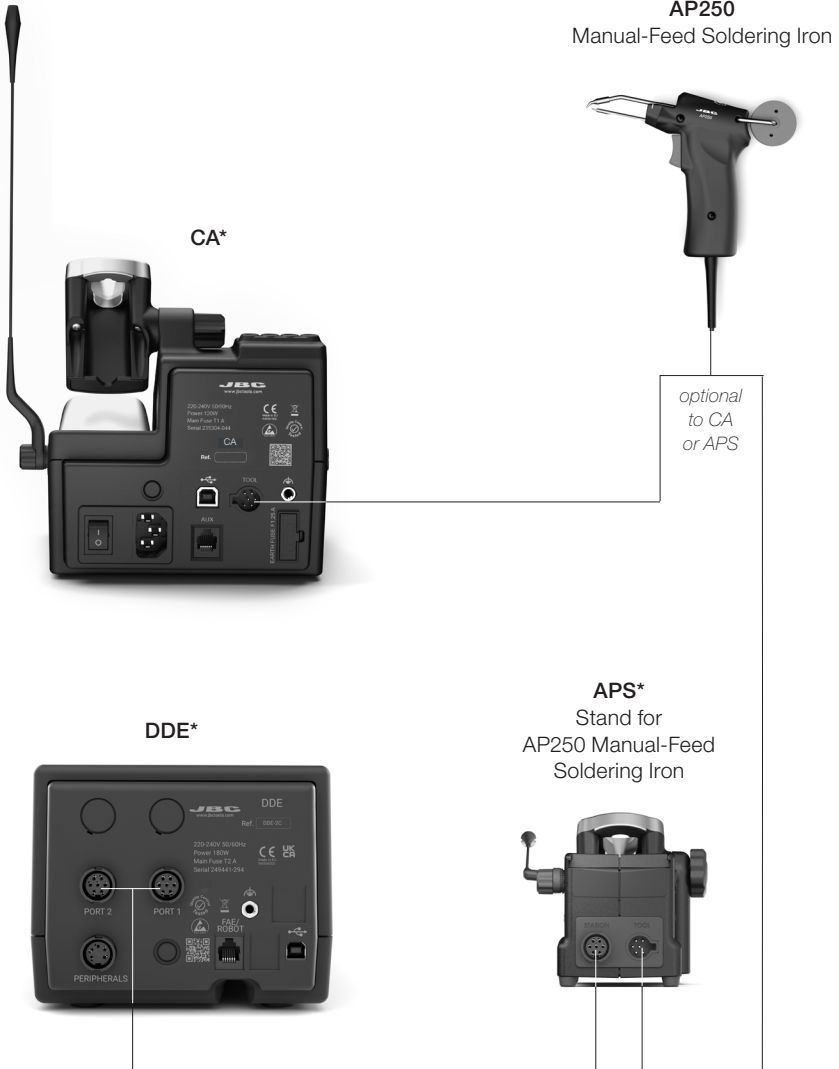


**Manual** ..... 1 unit

Ref. 0031412

## Features and Connections

AP250 works with DI, DDE, DME Control Units by using APS Stand or optional with CA Manual-Feed Soldering Station.

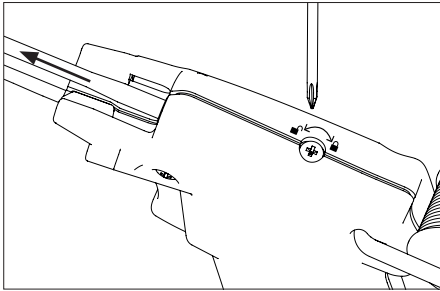


\* not included, sold separately.

# Changing Cartridges

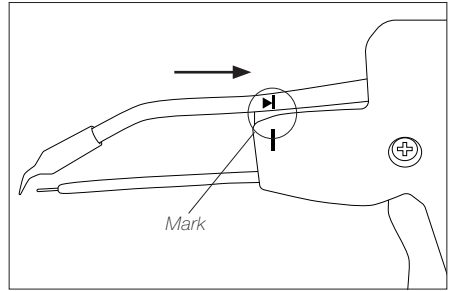
For a safe cartridge change, unplug the tool or turn the station off before following these guidelines:

## 1. Removing



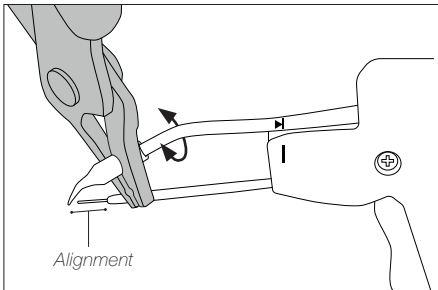
Loosen the screw and remove the cartridge. Use JBC's PLR195 cartridges extractor pliers to remove it if still hot.

## 2. Inserting



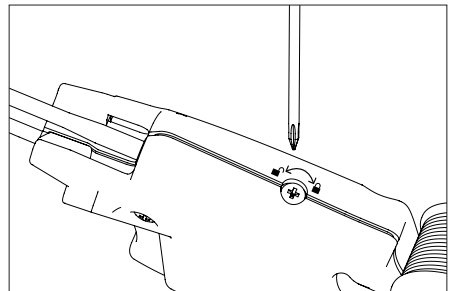
**Important:** Insert the cartridge as far as the mark for a correct connection.

## 3. Aligning



Align the tip of the cartridge with the feeder nozzle. Use JBC's PLR195 cartridge extractor pliers for a correct tip alignment.

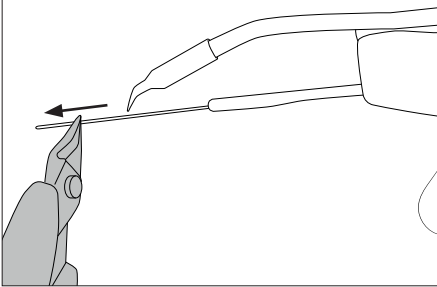
## 4. Fixing



**Important:** Tighten the screw again. This is necessary for the tool to function.

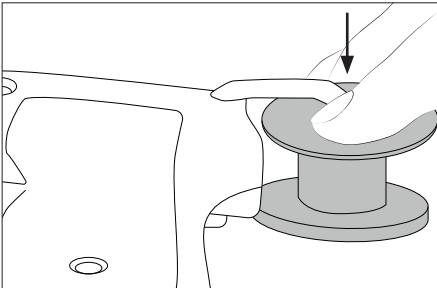
## Solder Wire Replacement

### 1. Removing Remaining Solder Wire



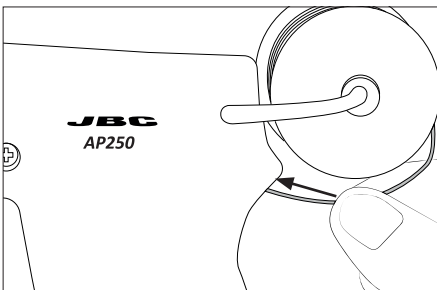
Pull out the remaining solder wire from inside the feeder nozzle. Use a pliers if necessary.

### 2. Replacing Solder Reel



Remove the empty reel as shown and fit the new one in the same direction.


### 3. Inserting New Solder Wire



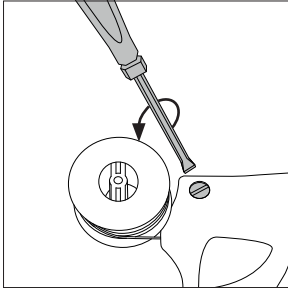
Insert the solder wire while pushing the trigger repeatedly until the solder wire appears at the nozzle.

**Note:** Use solder wire  $\varnothing 0.8 - 1.0$  mm with Nozzle Ref. 0019212 and  $\varnothing 1.1 - 1.5$  mm with Ref. 0019211

# Changing the Feeder Nozzle

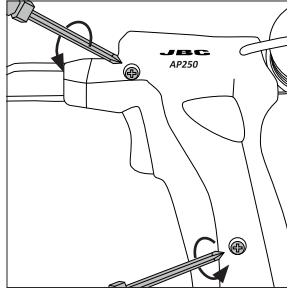
 Make sure the tool is unplugged.

## 1. Remove the Reel

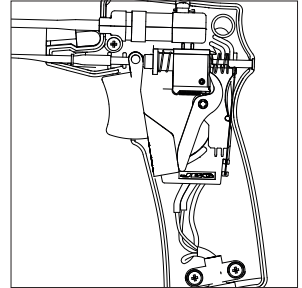


Open and take out the back side screw to remove the reel and to take out the solder wire from the nozzle.

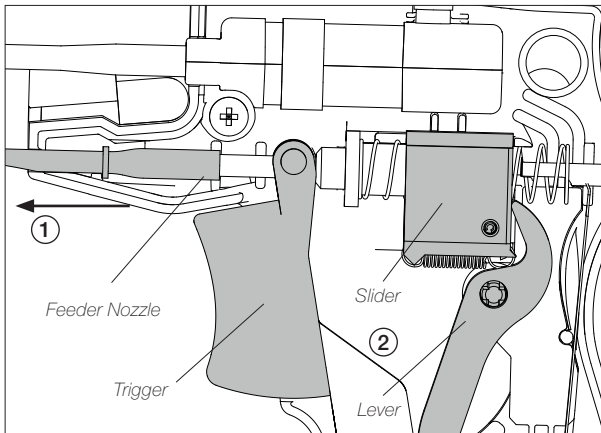
## 2. Remove the Cover



Then remove the two front side screws and lift the cover off.



## 3. Remove the Nozzle



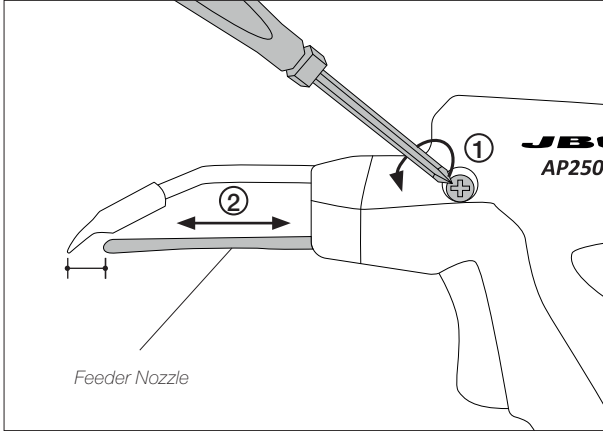
Take out the feeder nozzle and replace it with the new one (1) while holding the following three highlighted components in place (2): the trigger, the lever and the slider.

Reassemble the handpiece and tighten the 3 screws.

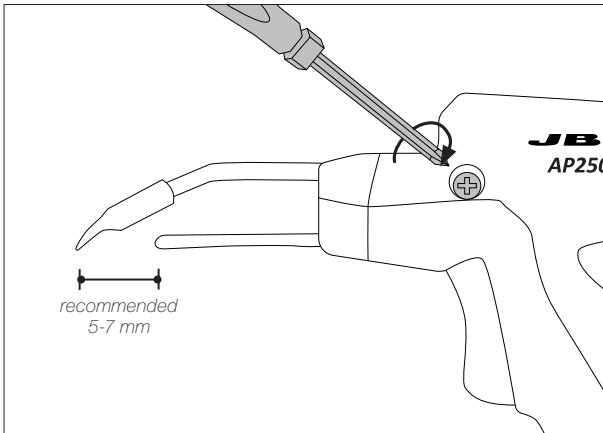
**Note:** Do not disassemble these 3 components. It is imperative to hold them in its placen (2).

## Regulating the Feeder Nozzle

Depending on the components that are being soldered or on the cartridge being used, the length of the feeder nozzle can be either shortened or lengthened (max 10 mm / 0.394 in).



Loosen the screw (1) to change the length of the feeder nozzle (2).



Adjust the feeder nozzle to the recommended length (5-7 mm / 0.19-0.27 in) and tighten the screw.

# Compatible Cartridges\*

AP250 Solder Feed works with C250 cartridges. Find the model that best suits your soldering needs in [www.jbctools.com](http://www.jbctools.com)



Conical Bent



Chisel



Chisel Bent



Bevel

## Accessories

### Solder Reel Stand\*

For production line work, BES Solder Reel Stand is the ideal solution for easy solder wire supply. Suitable for Solder Reels up to 2.5 kg / 5.512 lb.

Wrap the solder wire twice around the empty reel as shown and then guide it into the AP250.

BES\*  
Solder Reel Stand



AP250  
Manual-Feed Soldering Iron

\* not included, sold separately.

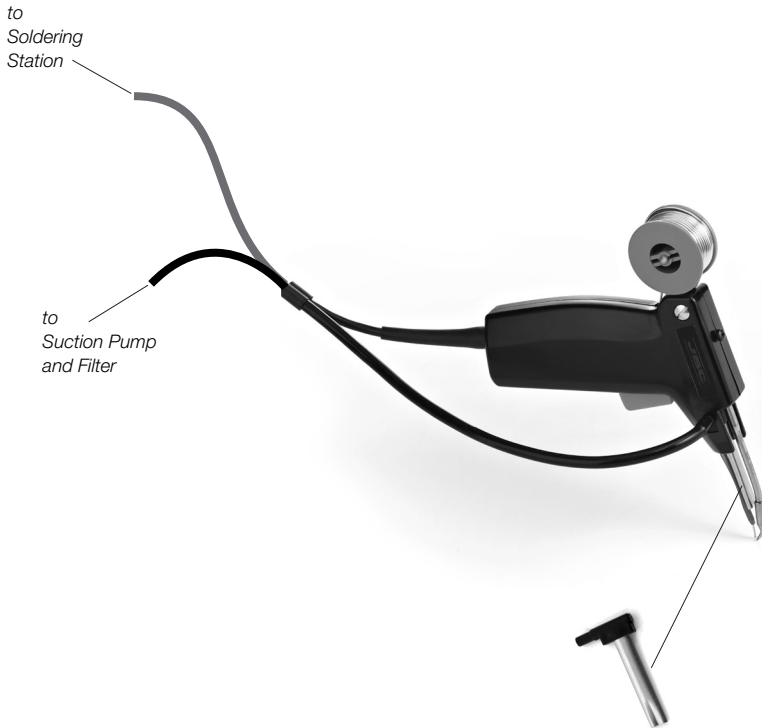


## Accessories

### Fume Extractor Accessory\*

The fume extractor accessory is an easy & safe solution for extracting the fume generated at the solder joint while soldering.

If you already have a high pressure suction system (filter required) on your workbench, you can connect it to the AP250 by means of the fume extractor accessory for occasional fume extraction.



to  
Soldering  
Station

to  
Suction Pump  
and Filter

**F1204**

Fume Extractor Accessory

*\* not included, sold separately.*





# Specifications

## AP250

### Manual-Feed Soldering Iron

Ref. AP250-B

- Solder Wire Diameter:	Up to 1.5 mm / 0.06 in
- Total Net Weight:	232 g / 0.51 lb
- Package Dimensions / Weight: (L x W x H)	245 x 185 x 45 mm / 367 g 9.65 x 7.28 x 1.77 in / 0.81 lb

Complies with CE standards  
ESD safe

# JBC

## Warranty

JBC's 2 year warranty covers this equipment against all manufacturing defects, including the replacement of defective parts and labour.

Warranty does not cover product wear or misuse.

In order for the warranty to be valid, equipment must be returned, postage paid, to the dealer where it was purchased.



This product should not be thrown in the garbage.

In accordance with the European directive 2012/19/EU, electronic equipment at the end of its life must be collected and returned to an authorized recycling facility.



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