X-TRONIC USA

X-Tronic™ Model #1010-PRO Instructions

PLEASE READ THIS MANUAL BEFORE USING YOUR NEW X-TRONIC Model #1010-PRO SOLDERING IRON

This manual is provided to make a safe and effective use of the X-Tronic 1010-PRO soldering iron and to maintain this instrument in proper working condition. Be sure to keep this manual in a handy place near the unit for future reference.

PACKAGE CONTENTS

1 - X-Tronic 1010-PRO Soldering iron w/ Integrated LED Lights and LED Display

1 - Soldering Iron Holder

1 - Brass Sponge with Rosin Flux Tin

5 - Assorted Soldering Tips (some models only)

SPECIFICATIONS

Model	XTR-1010-PRO
Input voltage	110/120V 60Hz
Weight	.25 lbs / 104 g
Working Environment	32°F ~ 104°F / 0°C ~ 40°C
Storing Environment	-4°F ~ 176°F / -20°C ~ 80°C
Storage Humidity	35%-45%
Temperature Range	194°F ~ 896°F / 90°C ~ 480°C
Temperature Stability	± 2°C (static)
Tip to Ground Resistance	<2Ω

SET-UP & OPERATION

WARNING: Do NOT leave the unit on full power for a long period of time. This will greatly reduce the life of your soldering iron.

1. Remove all components from the box.

2. Assemble the soldering iron holder by placing the soldering iron holder coil in the base behind the rosin flux tin.

3. Determine where the soldering iron holder will be used and secure it to the workbench by removing the liner on the bottom of the holder and sticking it to the workbench.

4. Place the soldering iron in the soldering iron holder.

5. Plug the iron into the outlet.

6. Turn the power on by pressing the power switch on the side of the unit.

7. Once the power is on the LED Screen located on the side of the iron will light up.

8. Set the desired working temperature by pressing the "+" or "-" buttons on the side of the iron. The temperature of the soldering iron can be set anywhere from 194°F ~ 896°F/90°C ~ 480°C.

9. Remove the iron from the cradle and flood the tip with a good quality rosin core solder-preferably 63/37 or 60/40 grade solder (See page 4).

10. Dip the tip into the brass sponge to remove excess solder. The tip should then be bright and shiny.

11. The soldering iron is now ready to solder. Proceed according to your standard working practice.

12. When you are finished soldering, place the iron in the holder while it cools down. Unplug the unit from the outlet when not in use.

SLEEP FUNCTION

IMPORTANT: If you have this set to L00 the Sleep Function will NOT activate.

When the soldering iron is placed in the holder, the iron will go into sleep mode after 5/10/30 minutes (depnding on how you have the sleep timer set). The display will show "SLP" to signify this and the temperature of the soldering iron will ramp down to 194°F / 200°C. When the soldering iron is removed from the holder to use again, the temperature of the soldering iron will ramp back up to the temperature it was previously being used at within 5-10 seconds.

FUNCTION SETTINGS

FAHRENHEIT / CELSIUS CONVERSION

1. Turn off the power switch.

2. Press and hold the "+" button while turning the power switch on. The display will show "F" for Fahrenheith display mode.

3. Press the "-" button to select "C" (Celsius) or "+" button to select "F" (Fahrenheit).

4. Wait for approximately 4 seconds and the program will save and exit on its own. The temperature display will then show the temperature measurment being used.

SLEEP TIMER

1. Turn off the power switch.

2. Press and hold the "-" button while turning the power switch on. The display will show "LXX" (where XX is the number of minutes the iron must be still for the iron to go into sleep mode).

3. Press the temperature "+" or "-" to adjust the sleep timer. This can be set anywhere from "00" (where the sleep timer will NEVER turn on) to "99" (where the sleep timer will turn on after 99 minutes of inactivity).
    Note: Selecting L00 can greatly reduce the life of your soldering iron and heating element.

4. Wait for approximately 4 seconds and the program will save and exit on its own.

TEMPERATURE CALIBRATION

1. Turn on the power switch.

2. Press and hold both the "+"and "-" buttons until the display flashes "CAL". This indicates you are now in Calibration Mode.

3. While the display is flashing, press "+" or "-" to input the tested temperature.

4. Wait for approximately 4 seconds and the program will save and exit on its own.

MAINTENANCE

IMPORTANT:
Do NOT put excess pressure on the tip, it can damage the element.

TO REPLACE TIP:

1. Turn off the soldering iron, unplug the power cord from the power source and allow the soldering iron to cool down to room temperature. **Never attempt to remove the tip while the iron is hot.**

2. Unscrew the larger metal tip retaining screw ring at the bottom of the soldering irons metal shaft. Slide off or remove the soldering tip retaining collar. Now, remove the tip by sliding it forward.

3. Slide a new tip over the exposed ceramic heating element, slide the metal retaining collar over the new soldering tip back onto the soldering iron.

4. Tighten the metal tip retaining screw ring to snug the tip into place. Do not over tighten the tip retaining screw

5. Plug the soldering iron into an outlet to resume soldering.

SOLDERING TIPS PREPARATION & CARE

- Keep the soldering tip properly tinned. Always use solder with sufficient rosin flux or the tip will de-wet. A well tinned tip will be bright all over when hot, with no dull or discolored spots.

- To tin the iron, do the following:

  1. Plug in the iron and allow it to reach solder melt temperature.

  2. Flood the tip with solder and let it stand for one minute.

  3. Apply more solder to the tip, allow it to idle for one or two more minutes, wipe it lightly on the sponge. Do not remove all of the solder, but use the sponge to remove excess solder and wipe solder onto non-tinned areas.

- Do not file or attempt to reshape the tip. This will destroy the plating and shorten tip life. Do not use chloride and acid fluxes; they will also shorten tip and heater life.

- For maximum tip life, always apply solder to the heated connections or joints. Repeated application of solder directly to the tip will shorten the tip life.

WARNING: Do NOT use anti-seize or any other lubricant on the tip retainer or heater of the soldering iron.

X-TRONIC INTERNATIONAL, INC.

3-YEAR WARRANTY

All X-Tronic Products come with 3-Year Guarantee, valid only in the United States and Canada. If you purchase this product and ship it to a destination outside of the United States or Canada this warranty becomes null and void. This Guarantee covers the main unit itself. Consumable parts such as soldering tips, heating elements, nozzles, etc. are not covered by this warranty.

The first 30 Days are covered by a Money Back or Replacement Guarantee from the date of the receipt of the product. If your product becomes damaged in shipment or is found to be defective in any way during this period, we will replace or issue a complete refund for your product upon return. We will pay all shipping involved during this first 30-day period.

The remainder of the 3 Years (after the first 30 days) is covered by a FREE REPAIR Guarantee (parts and labor included). If anything becomes defective during this period we will fix the issue and provide a full service inspection to your product, shipping (to & from) will be paid by the buyer. Please email us at Info@XTronicUSA.com to set up a service request.

Returns of New/Unused Products

If you have Buyer's Remorse and decide that you do not want the product, it must be returned NEW & UNUSED in the original box and you will pay the return shipping. PLEASE NOTE: There will be a 10% Restocking Fee and original Shipping Costs (if applicable) will not be refunded. **Used product cannot be returned.**

How To Register Your Warranty

Go to www.XTronicUSA.com. Click on "Register Your Warranty" tab and fill out the form. This is a fully secure website. Your information will never be sold or misused in any way. This registration site is strictly for order verification that will be used to speed up the process should you ever need to use your Warranty for service.

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QUESTIONS, PROBLEMS OR COMPLIMENTS?

***Thank You for purchasing this
X-Tronic International Product!
We are grateful for your business!***

All of our X-Tronic International Products are inspected then sealed with our NEW Product Seal prior to shipment. Our goal is to ensure Quality, Completeness, and Satisfaction for your order.

For Any Questions, Problems, or Compliments please call or email us.

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