

X-TRONIC USA

**Soldering Technology
Professionals Can Trust**



4008-PRO-X

Instructions

PRODUCT SPECIFICATIONS

Model	XTR-4008-PRO-X
Dimensions	6.75 x 5.5 x 6.0 in / 17.1 x 14.0 x 15 cm
Weight	4.5 lbs / 2.0 kg
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	392°F ~ 932°F / 200°C ~ 500°C
Temperature Stability	± 3.6°F / 2.0°C (Static)
Grounded Tip Voltage	< 1 mV
Tip Impedance	< 1Ω
Display Type	LED - Bright White
Cable Length (Material)	≥ 51.5 in / 130.8 cm (Silicone)

UNIT PARTS

1. Soldering Cord Extension Holder
2. Soldering Iron Holder
3. Brass Sponge Holder
4. Wet Sponge Holder
5. Temperature Unit Display
6. Temperature Control Buttons
7. Soldering Iron
8. Anti-Static Alligator Grounding Clip
9. Silicone Work Mat
10. Bright White LED Temperature Displays



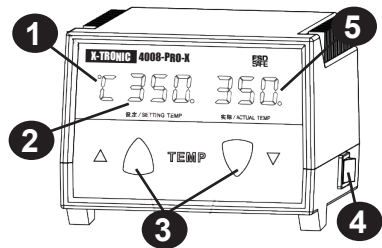
SAFETY PRECAUTIONS

1. Always use a grounded outlet for the unit.
2. Always turn the power off and unplug the unit when not in use.
3. Never use the soldering iron near any flammable substance, material, or gas.
4. Never touch the metallic components of the soldering iron while the unit is on. They are extremely hot and will cause serious burns instantly.
5. Always turn the power off, unplug the unit, and let it fully cool down before attempting to replace any parts (tips, heating element, etc.)
6. Use only genuine replacement parts for this unit.
7. Do not use the unit for any application other than soldering.
8. Do not tap the soldering iron against the work bench to remove residual solder.
9. Do not modify the unit in any way.
10. When replacing consumable parts, only use approved manufacturer parts.
11. Do not get the unit wet or use when your hands are wet.
12. The soldering process will produce smoke - ensure the area is well ventilated.

USER INTERFACE

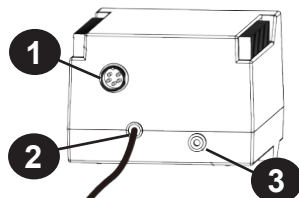
FRONT

1. Celsius / Fahrenheit Indicator
2. Set Temperature
3. Temperature Setting Buttons
4. Power Switch
5. Actual Temperature of the Soldering Iron Heating Element



BACK

1. Soldering Iron Socket
2. Power Cord (hard wired)
3. Ground Wire Socket



INITIAL SET-UP

1. Open the package and check that all parts are present and are not damaged. If anything is missing or damaged, please contact X-Tronic immediately for assistance (see back cover for contact information).
2. Place the soldering cord extension holder in the bracket on the right hand side of the soldering iron holder (see #1 in drawing above).
3. Plug the soldering iron into the back of the unit and place the soldering iron in the soldering iron holder (see #2 in drawing above). Secure the core in the extension holder (optional).
4. The brass sponge is in the silicone opening right below the soldering iron (see #3 in drawing above).
5. Wet the blue sponge and place in the space at the base of the soldering iron holder (see #4 in drawing above).
6. Plug the 3-prong AC cord into a grounded outlet to prevent electric shock or injury.

OPERATING INSTRUCTIONS

1. Place the soldering iron in the holder.
2. Turn the unit on with the power switch on the back of the unit.
3. Set the desired temperature using the TEMP UP and DOWN buttons on the right side of the unit or by pressing one of the Preset Memory Channels. This temperature will show in the lower left corner of the display.
4. Wait for the unit to stabilize at the desired temperature. The actual temperature of the heating element/soldering tip is displayed on the top of the display. See page 2 for a detailed diagram of the display screen.
5. Remove the iron from the holder and flood the tip with a good quality rosin core solder-preferably 63/37 or 60/40 grade solder.
6. Wipe the tip across the moist sponge or dip the iron into the brass sponge to remove excess solder. The tip should then be shiny.
7. The soldering iron is now ready to solder. Proceed according to your standard working practice.

FEATURES

TEMPERATURE CONVERSION

This unit can readout temperatures in either Fahrenheit or Celsius. To change from one to the other, when the unit is powered off, simply press the ▲ button and turn the unit on. The display will toggle between °C / °F.

MUTE / UNMUTE FUNCTION

The unit beeps when buttons are pushed or when it goes into sleep mode. To toggle between Mute and Unmute Mode, when the unit is off, press and hold the ▼ button and turn the unit on. When the unit is Muted the display will say “SPH off”, when the unit is Unmuted the display will say “SPH On” and the unit will beep.

SLEEP FUNCTION

If the soldering iron sits idle in the soldering iron holder for 10 minutes (default time), Sleep Mode will be activated. The screen will switch to “---” and the soldering iron will cool down to 200°C (392°F). To bring the unit out of Sleep Mode, simply pick up the soldering iron from the holder.

Note: The unit will NOT go into sleep mode unless the soldering iron is in the holder.

To change the default time before sleep mode is activated, turn the unit off with the switch on the front of the unit. Press and hold the ▲ and ▼ buttons and then switch the unit on. Use the ▲ and ▼ buttons to set the sleep time. The sleep timer can be set between 00-30 minutes, in 1 minute increments. Once the desired time has been set, the setting will automatically be saved after 5 seconds.

Note: Setting the sleep timer at “00” will turn the sleep function off and the unit will NOT go to sleep regardless of how long the unit sits idle in the soldering station holder. It is not recommended to turn the sleep timer off for normal use. The use of the sleep timer will help extend the life of the heating element and tip if the unit is left on for long periods of time.

MAINTENANCE

UNIT

1. Keep the unit plugged into a GROUNDED outlet at all times during operation.
2. Keep the unit and all components free from dirt, debris, and liquid at all times.
3. Make sure the power cord is plugged in correctly and safely off the floor to prevent accidents.
4. Keep all cords in the immediate workspace and avoid letting them hang off the side of a table or bench top.
5. Wipe the unit down, when needed, with a dry, static-free cloth.



WARNING



**DISCONNECT POWER CORD BEFORE REPLACING A
SOLDERING TIP AND/OR A HEATING ELEMENT**

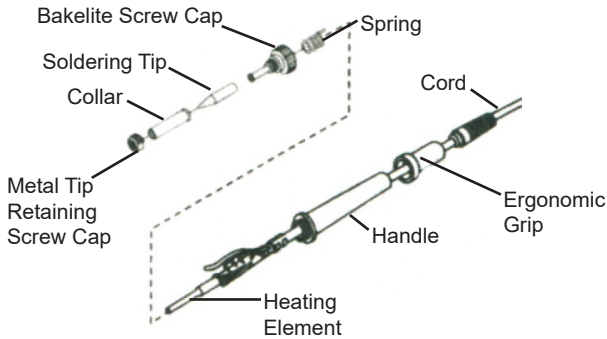
REPLACING THE SOLDERING TIP

1. Turn off the soldering station, 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 small metal tip retaining screw cap 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.
(There is NO need to remove the black Bakelite screw cap to change the tip.)
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 cap to secure the tip into place. Do not over tighten the metal tip retaining screw cap.
5. Plug the soldering iron AC cord into a grounded outlet to resume soldering.

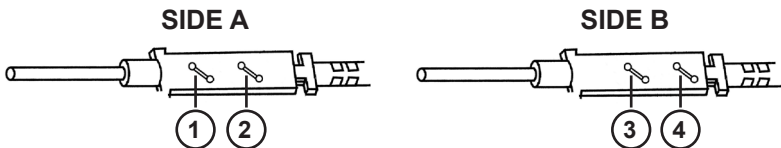
BLACK BAKELITE SCREW CAP TIPS

- Bakelite is a strong and stable material when handled correctly. This part cannot be made of metal for heat transfer safety reasons.
- The black Bakelite screw cap does NOT need to be removed to replace the tip. This is only removed to access the heating element.
- The Bakelite screw cap should never be tightened or re-tightened when the iron is hot. If the iron is not at room temperature when the Bakelite screw cap is removed it can cause it to crack.
- When tightening the Bakelite screw cap, at room temperature, it only needs to be snug - DO NOT OVER-TIGHTEN.

REPLACING THE SOLDERING IRON HEATING ELEMENT



1. Turn off the unit and unplug it from the outlet. Allow the soldering iron to cool down to room temperature.
Never attempt to handle the tip while the iron is hot.
2. Unscrew the Black Bakelite Screw Cap and slide off the full tip assembly.
3. Push the Cord through the bottom of the soldering iron while simultaneously pulling gently on the heating element to expose the heating element circuit board.
4. De-solder the 2 Thin (red or white) wires and the 2 Thick (blue) wires that have heat shielding on them from the circuit board and pull the heating element away from the board. Please take note of the location of the wire thickness/color for installation of new heating element (see diagram below).
5. On one side of the circuit board solder a thin wire to ① and a thick wire to ② (see diagram below).
6. Flip the circuit board over and solder a thin wire to ③ and a thick wire to ④ (see diagram below).
7. Pull the cord back gently and align the circuit board to the slots on the iron so the cord can be pulled back to its original position.
8. Replace black Bakelite Screw Cap and screw back on and hand tighten - **Do NOT over-tighten.**
9. Install the soldering tip, slide the metal soldering tip retaining collar and hand tighten it. Plug the AC cord back into a grounded outlet.



NOTE: The wires on the heating element can be soldered onto either side of the circuit board, as there is no polarity for the element.

TROUBLESHOOTING

ISSUE	POSSIBLE SOLUTIONS
Unit does not have power	<ul style="list-style-type: none">• Ensure the power cord is securely attached to both the unit and the outlet and that the unit is powered on at the back of the unit.• Ensure that the outlet is functional.• Check the fuse in the back of the unit to see if it is in good working condition. If not, replace fuse.
Soldering Iron "Rattles"	<ul style="list-style-type: none">• This is expected behavior. The "rattle" is a small ball that allows the unit to determine when the soldering iron is not in use and it should go into Sleep Mode
S-E Error	<ul style="list-style-type: none">• Ensure the soldering iron is securely plugged into the back of the unit.• The heating element may need to be replaced
Tip is not heating up as expected	<ul style="list-style-type: none">• Ensure the soldering iron is securely plugged into the back of the unit.• The soldering tip could be oxidized, it is important to always tin your tip and keep it clean. See Tip Maintenance section of manual.• The heating element may need to be replaced• Unit may need to be calibrated - see Calibration section of manual

X-Tronic International Inc.

3-YEAR LIMITED WARRANTY

THIS LIMITED WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS. YOU MAY ALSO HAVE OTHER RIGHTS, AS THEY VARY FROM STATE TO STATE.

THIS LIMITED WARRANTY CAN ALSO BE FOUND ON OUR WEBSITE AT WWW.XTRONICUSA.COM/SUPPORT/WARRANTY.

WE WARRANT THAT DURING THE WARRANTY PERIOD, THE PRODUCT WILL BE FREE FROM DEFECTS IN MATERIALS AND WORKMANSHIP.

WE LIMIT THE DURATION AND REMEDIES OF ALL IMPLIED WARRANTIES, INCLUDING WITHOUT LIMITATION THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE TO THE DURATION OF THIS EXPRESS LIMITED WARRANTY.

SOME STATES HAVE DIFFERENT LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

OUR RESPONSIBILITY FOR DEFECTIVE GOODS IS LIMITED TO REPAIR, REPLACEMENT OR REFUND AS DESCRIBED BELOW IN THIS WARRANTY STATEMENT.

WHO MAY USE THIS WARRANTY?

X-Tronic International Inc. located at 2159 Magnum Circle, Lincoln, Nebraska 68522 (“we”) extend this limited warranty only to the consumer who originally purchased the product in the United States, the District of Columbia or Canada (“you”). It does not extend to (a) any subsequent owner or other transferee of the product, (b) any product shipped outside of the United States, the District of Columbia or Canada, or (c) anyone who may have purchased it from someone other than X-Tronic International Inc.. Proof of purchase is required for in-warranty service. We recommend you promptly register this product on our website (www.XTronicUSA.com) to facilitate verification of the date of the original purchase. Keep the product manual and your sales receipt together for future reference.

WHAT DOES THIS WARRANTY COVER?

This limited warranty covers defects in materials and workmanship of the product for the Warranty Period as defined below. In addition, during the Initial Warranty Period, this limited warranty also covers defects occurring in the initial shipment of the product to you.

WHAT DOES THIS WARRANTY NOT COVER?

This limited warranty during the Warranty Period does not cover any damage due to: (a) improper use; (b) failure to follow the product instructions or to perform any preventive maintenance; (c) modifications; (d) unauthorized repair; (e) normal wear and tear that comes with household use; or (f) external causes such as accidents, abuse, or other actions or events beyond our reasonable control. It also does not cover consumable parts.

WHAT IS THE PERIOD OF COVERAGE?

This limited warranty starts on the date of your purchase and lasts for 3 years ("The Warranty Period"), which shall be divided into two periods: (1) the first 30 days from the date of your purchase ("Initial Warranty Period"); and (2) the remainder of the 3 year period after the Initial Warranty Period has expired (the "Remainder Warranty Period"). The Warranty Period is not extended if we repair or replace the product. We may change the availability of this limited warranty at our discretion, but any changes will not be retroactive.

WHAT ARE YOUR REMEDIES UNDER THIS WARRANTY?

With respect to any defective product during the Initial Warranty Period, we will, in our sole discretion either (a) replace such product (or the defective part) free of charge, or (b) refund the purchase price of such product.

With respect to any defective product during the Remaining Warranty Period, we will repair such product free of charge and provide a full-service inspection of your product. You will be responsible for all shipping and handling fees to and from our facility.

HOW DO YOU OBTAIN WARRANTY SERVICE?

To obtain warranty service, you must call 844-861-4762 or email us at Info@XTronicUSA.com during the Warranty Period to open a service request. Proof of purchase will be required to open a service request.

LIMITATION OF LIABILITY

THE REMEDIES DESCRIBED ABOVE ARE YOUR SOLE AND EXCLUSIVE REMEDIES AND OUR ENTIRE LIABILITY FOR ANY BREACH OF THIS LIMITED WARRANTY. OUR LIABILITY SHALL UNDER NO CIRCUMSTANCES EXCEED THE ACTUAL AMOUNT PAID BY YOU FOR THE DEFECTIVE PRODUCT, NOR SHALL WE UNDER ANY CIRCUMSTANCES BE LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL, SPECIAL OR PUNITIVE DAMAGES OR LOSSES, WHETHER DIRECT OR INDIRECT.

SOME STATES HAVE DIFFERENT LIMITATIONS OF LIABILITY AND EXCLUSIONS, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

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.**



Toll Free: 844-861-4762



Info@XTronicUSA.com

Our Business Hours are:
Monday - Thursday: 8am - 4pm CST
Friday: 8am - Noon CST

If you would like to shop for other X-Tronic International Products
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