

X-TRONIC USA



**X-Tronic™ Model
#3010-XTS
Instructions**

PLEASE READ THIS MANUAL BEFORE USING YOUR NEW X-TRONIC Model #3010-XTS SOLDERING STATION

This manual is provided to make a safe and effective use of the X-Tronic 3010-XTS soldering station 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.

SPECIFICATIONS

1. Variable Temperature (200°C to 480°C / 392°F to 896°F)
2. Variable Temperature Control for Precise Heat Settings
3. 110/120 – 60Hz
4. 70 Watts
5. ESD SAFE

INTRODUCTION

The X-Tronic 3010-XTS soldering station is an ESD-Safe variable temperature and electronically controlled unit for a demanding soldering environment, thereby providing flexibility to suit various types of soldering conditions.

INITIAL SET-UP

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

1. Plug the 3-Prong AC cord into a grounded outlet to prevent electric shock or injury.
2. Turn the power on by pushing the power switch on the top of the control module.
3. Once the power is on the Red LED located on the handle of the soldering iron will light up.

BREAK-IN PERIOD

1. Turn on the unit and set the temperature dial to the Medium setting which is half way between MIN and MAX.
2. Allow the unit to heat up and run at this temperature for 15 minutes.
3. After 15 minutes, turn the dial to the MAX setting and run it at this temperature for 10 minutes.
4. After 10 minutes on MAX, the unit is ready to use or can be turned off for future use.

Note: During this Break In Period the Soldering Iron will smoke and the Solder Tip/Metal Housing will turn a "Blue-ish" Color. This is expected behavior, the smoke is coming from the insulation on the new heating element being burnt off and the blue coloring is from varying degrees of oxidation from heating of the metal parts of the Iron.

It will take 5 to 10 hours of Total Use for this unit to be totally broken in. At that point it will not smoke when the unit is used for soldering. This is normal for all high power soldering irons.

OPERATION

1. Set the desired working temperature by turning the aluminum knob on the front of the control module. The front of the knob has a tick mark indicator to show the selected setting. The temperature of the soldering iron can be set anywhere from 392°F ~ 896°F/200°C ~ 480°C.
2. Moving the temperature control potentiometer clockwise will raise the temperature on the soldering iron, and rotating the temperature control potentiometer counterclockwise will lower the soldering iron tip temperature.
3. Moisten the sponge and place it in the sponge holding space in the iron cradle.
4. **IMPORTANT:** 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.
5. Wipe the tip across the moist sponge or dip the iron into the brass sponge to remove excess solder. The tip should then be bright and shiny.
6. The soldering iron is now ready to solder.



MAINTENANCE



*** WARNING: PLEASE DISCONNECT POWER CORD BEFORE
REPLACING A SOLDERING TIP AND/OR A HEATING ELEMENT! ***

IMPORTANT:

Do NOT put excess pressure on the tip. It can damage the element.

REPLACING THE 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. Loosen the larger tip retaining screw on the side of the soldering iron's metal shaft.
3. Remove the tip by sliding it forward.
4. Slide a new tip into the heater - the end of the tip should stick out approximately 1.5 inches.
5. Tighten the tip retaining screw to secure the tip into place. Do not over tighten the tip retaining screw
6. Plug the soldering iron AC cord into a grounded outlet to resume soldering.

REPLACING THE HEATING ELEMENT:

1. Allow the soldering iron to cool down to room temperature. Never attempt to remove the tip while the iron is hot.
2. Remove the tip (reference above instructions) but remove both screws on either side of the tip this time.
3. Remove the screw located directly above the LED and slide the blue shaft down to reveal the iron's control board.
4. De-solder the 2 wires that have heat shielding on them from the circuit board and pull the tip out from the end of the soldering iron.
5. Insert the new heating element and reverse the above listed instructions.
6. Plug the AC cord back into a grounded Outlet.

NOTE: The wires on the heating element can be soldered back onto the board on either solder pad as there is no polarity for the element.

SOLDERING TIPS PREPARATION & CARE

1. 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.
2. To tin the iron, do the following:
 - a. Plug in the iron and allow it to reach solder melt temperature.
 - b. Flood the tip with solder and let it stand for one minute.
 - c. 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.
3. 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.
4. 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 48 Contiguous United States. If you purchase this product and ship it to a destination outside of the 48 Contiguous United States 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.

X-Tronic International, Inc.
2159 Magnum Circle, Lincoln, NE 68522
844-861-4762

Info@XTronicUSA.com • www.XTronicUSA.com

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

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