

X-TRONIC USA



X-Tronic™ Model #3040-XR3 Instructions

PLEASE READ THIS MANUAL BEFORE USING YOUR NEW X-TRONIC Model #3040-XR3 SOLDERING STATION

This manual is provided to make a safe and effective use of the X-Tronic 3040-XR3 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. Digitally Controlled (200°C to 480°C / 392°F to 896°F)
2. Variable Temperature Control for Precise Heat Settings
3. 110/120 – 60Hz
4. 75 Watt Soldering Station Output - 60 Watt Heating Element
5. ESD SAFE

INITIAL SET-UP

The X-Tronic 3040-XR3 comes with two parts. First is the control module that contains all of the control electronics and the soldering iron. Second part is the cradle that is designed to hold the soldering iron during and after soldering use.

IMPORTANT: The soldering iron may smoke slightly until initial residue on the internal heat wrap comes off during the break in period. It is normal during break in to notice the iron will turn a darker color as it oxidizes.

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 Blue LED Screen located on the front of the control module will light up.
Note that this unit has a Toggle Switch on the bottom front of the unit where you can use in either a Celsius or Fahrenheit Mode.
4. Set the desired working temperature by turning the aluminum knob on the front of the control module. The temperature of the soldering iron can be set anywhere from 392°F ~ 896°F/200°C ~ 480°C.
5. 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.
6. Moisten the sponge and place it in the sponge holding space in the iron cradle.
7. **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.
8. 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.
9. The soldering iron is now ready to solder. Proceed according to your standard working practice.

SLEEP FUNCTION

When the soldering iron is placed in the holder, the iron will go into sleep mode after 10 minutes. The display will show "SLP" to signify this and the temperature of the soldering iron will ramp down to 200°C. When the

soldering iron is removed from the holder to use again, the temperature of the soldering iron will ramp back up in 5-10 seconds to the temperature it was previously being used at.

SE ERROR MESSAGE

When the display shows “SE” this means that the heating element needs to be replaced. The heating element could be worn out or cracked.

***Note** that if you run the soldering iron in the 230°C ~ 280°C range, which is the normal temperature range for most “all” soldering applications, your heating element should last for 6 to 12 months depending on hours of use.*



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. 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 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 soldering tip and metal soldering tip retaining collar using the above procedure. Unscrew the Black “Bakelite Polymer” Retaining Cap and slide off this secondary heating element retaining collar.

3. Push the Power Cord through the bottom of the soldering iron while (at the same time) gently pulling the heating element out of the top of the iron.
4. De-solder the 2 Red and 2 Blue wires that have heat shielding on them from the circuit board and pull the heating element away from the mother board. Please take note of the wire colors and location for installation of new heating element.
5. Install new heating element and solder Red & Blue Wires to the new heating element.
6. Pull the cord back gently and align the PC board to the slot so the cord can be pulled back to its original position.
7. Replace Bakelite Polymer Retaining Cap and screw back on and hand tighten.
8. 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 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.

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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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