



# Soldering Gun User Instruction

## Safety Instructions to Operation and Maintenance

1. This appliance has a polarized plug (one blade is wider than the other). To reduce the risk of electric shock, this plug is intended to fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician. Do not modify the plug in any way.
2. Arrange a secure resting place on your worktable where the tip will never contact a flammable surface, your body, or the power cord. With a peak temperature of about 1000°F, the tip may remain hot for several minutes after you release the trigger switch.
3. To reduce the risk of burns, remove excess hot molten solder from the tip by wiping with a damp cloth, damp sponge, or solder brush made for that purpose. Never swing the gun.
4. To protect eyes from splatter, wear safety goggles.
5. To reduce the risk of destroying the tool, observe the 20% "On" time duty cycle rating of a soldering gun. This rating means a maximum of 1 minute of "On" time over 5 minutes total time. Never tie down the trigger switch.
6. To reduce the risk of respiratory, eye, or skin irritation, keep your head out of the soldering fumes.
7. To reduce the risk of electrical shock, fire, injury, or explosion, work only in surroundings that are dry, and are free from flammable materials including vapors and liquids.
8. After use, unplug the power cord and let tip cool down. Store soldering gun in a dry secure place, out of the reach of children.

## Assembly

1. Soldering Gun comes complete with solder tip(s).
2. Loosen screws located on the front of the soldering tool using a #2 Phillips screwdriver.
3. Insert solder tip into openings and tighten down the screws.

## Operation - Using Soldering Gun

1. Screws holding tip must always be snug for soldering gun to function properly. Use a #2 Phillips screwdriver to tighten screws when necessary. To avoid stripping screws, be careful not to over-tighten.
2. Clean the surfaces to be soldered together to insure a good bond. Use a wire brush or sandpaper to remove paint, varnish, or rust. To remove oil or grease, use alcohol. **WARNING:** To reduce the risk of fire, burns, or toxic vapors, do not use solvents other than alcohol for oil or grease removal.
3. Select the proper solder type. Rosin core solder is recommended for work on electrical items such as PC boards, radio and TV kits, model railroads, etc. The rosin, or flux, as it is sometimes called, helps clean the soldering joint as the solder is being melted and helps in the bonding process. Another type of solder is ACID core solder. Do not use acid core solder when soldering electrical connections. Damage to electrical components may result. Acid core solder is recommended when soldering some types of steel plates together, but not for electrical connections.
4. For best results, tin the tip of the soldering gun with a coating of rosin core solder. This is done by cleaning the tip with steel wool, then pulling the trigger to heat the tip and then applying a light coating of new solder to the tip. Excess solder may be removed with a solder brush, damp sponge or damp cloth.
5. When soldering, hold soldering gun tip to the two surfaces (the "joint") to be soldered at the same time. Pull trigger to apply heat to the joint. It takes approximately 12 seconds for the tip to reach soldering temperature. Apply solder to the joint, NOT to the TIP, but close to the tip. When the surfaces are sufficiently heated, the solder will flow into the joint. Do not apply too much solder to the joint. Use just enough to give strength and a good appearance.
6. Release trigger of gun and set soldering gun in a safe position to cool.

**IMPORTANT: Remember to use your soldering gun with a 20% duty cycle. Never use it continuously for more than one minute without letting it cool for 4 minutes. Never tie down the trigger expecting the tip to remain at peak temperature for soldering. This will damage the tip and the remainder of the soldering gun.**

## Maintenance - Taking Care of Your Soldering Gun

**WARNING:** To avoid burns or electrical shock, always unplug the soldering gun and allow to cool before servicing.

Keep tip screws snug. Periodically inspect the tip screws for looseness and tighten when necessary. However, to avoid stripping screws, do not over-tighten.

Keep the soldering tip clean. Use steel wool or very fine sandpaper to clean.

Tin tip before using. Refer to Step 4 of Operation.

## Changing Tip

1. Remove tip after loosening both screws holding tip.
2. Insert new tip and tighten screws. To avoid stripping screws, do not over tighten.

## Troubleshooting

Trouble	Problem Cause	Action
Tip does not heat although unit is plugged in and trigger is depressed.	<ol style="list-style-type: none"> <li>1. Tips screws are loose.</li> <li>2. Tip is cracked or broken.</li> <li>3. Tip is dirty.</li> </ol>	Unplug gun from power receptacle <ol style="list-style-type: none"> <li>1. Tighten tip screws</li> <li>2. Replace with new tip</li> <li>3. Clean tip with steel wool or fine sandpaper.</li> </ol>

## Limited Warranty

Wall Lenk Corporation warrants its products and accessories to be free from defective materials and workmanship for a period of 5 years from date of original purchase. This warranty does not apply to any product which has been disassembled, damaged or defaced, subjected to misuse, abnormal service or mishandling, nor any product altered, repaired or disassembled by anyone other than Wall Lenk Corporation. During this warranty period Wall Lenk Corporation, at its option, may repair or replace such product at no cost to the purchaser for labor and/or materials when returned with transportation cost pre-paid to Wall Lenk Corporation., together with proof of purchase. THIS WARRANTY IS THE ONLY WARRANTY APPLICABLE TO WALL LENK CORPORATION'S PRODUCTS AND ACCESSORIES AND IS EXPRESSLY IN LIEU OF ANY AND ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THE WALL LENK CORPORATION SHALL NOT BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES RESULTING FROM BREACH OF WARRANTY. THE REMEDIES EXPRESSLY SET FORTH HEREIN ARE EXCLUSIVE AND NO OTHER REMEDY FOR BREACH OF WARRANTY EXISTS.