

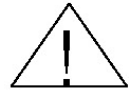


SOLDERING STATION **4204**
Multi-functional anti-static
2-in-1 maintenance system
Operation instructions

Made in China

www.tmatlantic.com

1. Warnings and Safety Instructions



WARNING

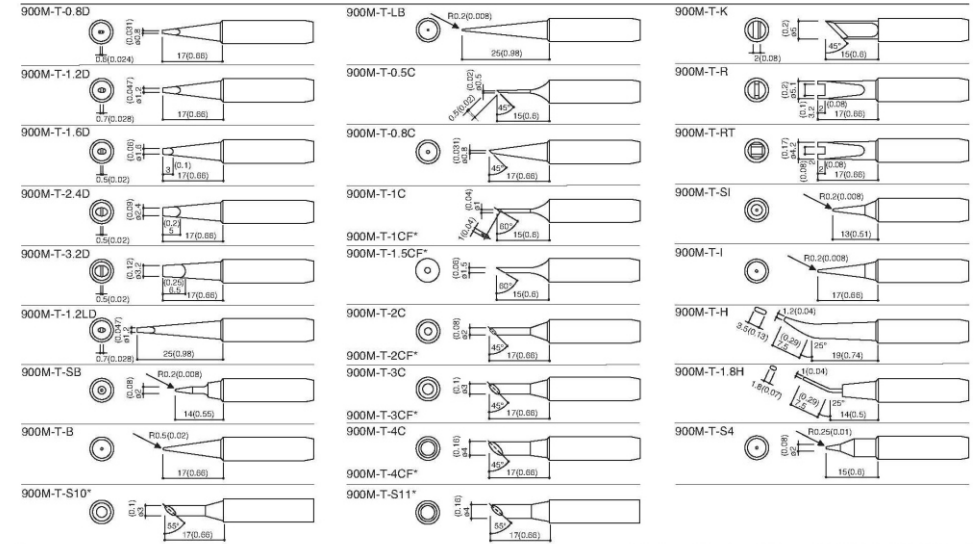
A fire may result if this equipment is not used with care and for intended applications. To avoid electric shock or injury, please follow the instructions below strictly:

- This appliance must be grounded.
- The temperature of this equipment can reach 500°C. Never touch any metal part of this equipment.
- The unit can output extremely hot air; to avoid serious injury, never point the nozzle towards any part of the body.
- Never use this equipment near any flammable materials or gases.
- Never operate the equipment with wet hands.
- All the electrical circuitry within this equipment is rated to operate at the relevant mains line voltage (depending on model). Always disconnect the power cord before beginning any repairs and maintenance work.

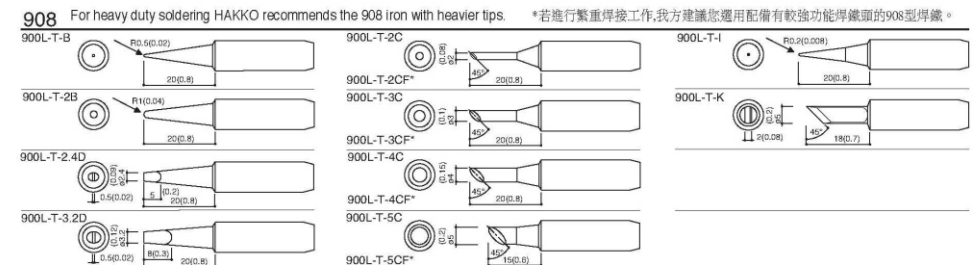
! CAUTION – Important Instructions

In order to avoid damage to the equipment, and ensure a proper working environment, please follow the instructions below:

- Operate this equipment in a well ventilated room away from any combustible materials.
- When not be in use, make sure the unit is unplugged from outlet.
- Place handle in stand when not in use.
- Do not drop. Do not use excessive force on the handle. Too much shock and/or vibration may damage the quartz crystal inside the handle's thermal tube.
- Do not operate on uneven surfaces.
- Do not pull or carry the equipment by the handle; this may break the wire inside the handle or disconnect the air tube.
- Allow to cool down before storage.
- When resting the handle on the hander holder, make sure there are no objects within 30 cm of the tip of the nozzle as nearby objects maybe damaged.
- Do not leave the equipment unattended when switched on.
- Do not disconnect from the mains voltage until pump has stopped running.



*900M tip Outer Dia. ϕ 6.5 *900M型焊鐵頭外徑為 ϕ 6.5



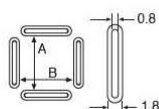
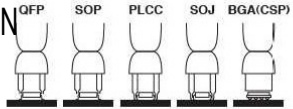
*900L tip Outer Dia. ϕ 8.5 *900L型焊鐵頭外徑為 ϕ 8.5
*These tips are tinned flat only. *此款焊鐵頭只在平坦部份鍍錫。



*900S tip Outer Dia. ϕ 5.8 *900S型焊鐵頭外徑為 ϕ 5.8

9. Buy accessories

ATTENTION
By the size of the commodity specification refers to the size of the room IC put out.



No.	C0.8 D1.8	C1.0 D2.0	C0.8 D2.0
	A1125B~A1129B A1131~A1141B A1180B~A1189B A1203B~A1266B	A1191	A1192

噴氣嘴適用於全部噴氣嘴

● 可以使用真空機能的噴氣嘴

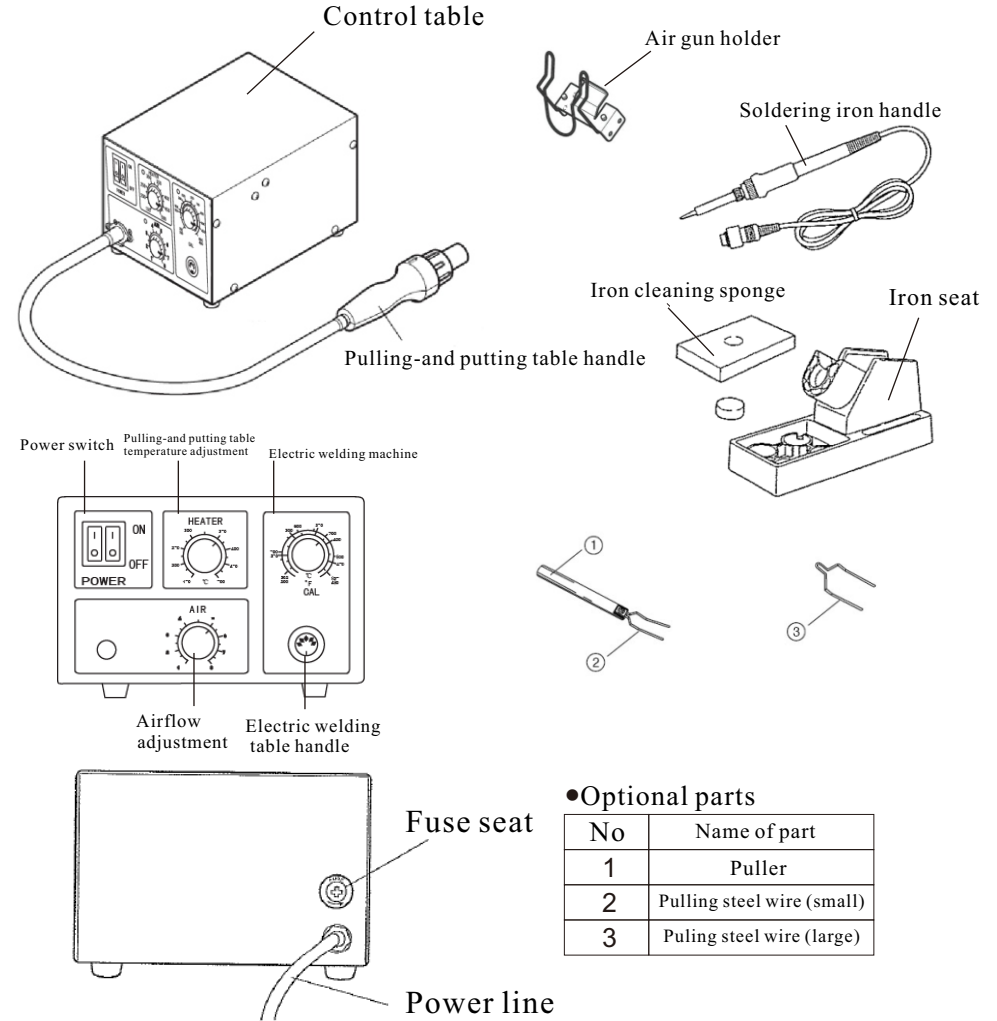
*HAKKO FR-801、FR-802無真空功能。

單位：mm

A1125B QFP 10 × 10 A:10.2 B:10.2	A1126B QFP 14 × 14 A:15.2 B:15.2	A1127B QFP 17.5 × 17.5 A:19.2 B:19.2	A1129B QFP 14 × 20 A:15.2 B:21.2	A1129B QFP 28 × 28 A:29.7 B:29.7	A1135B PLCC 17.5 × 17.5 (44針) A:18.5 B:18.5
A1136B PLCC 20 × 20 (52針) A:21 B:21	A1137B PLCC 25 × 25 (68針) A:26 B:26	A1138B PLCC 30 × 30 (84針) A:31 B:31	A1139B PLCC 12.5 × 7.3 (18針) A: 9 B:14	A1140B PLCC 11.5 × 11.5 (28針) A:13 B:13	A1141B PLCC 11.5 × 14 (32針) A:15 B:13
A1180B BQFP 17 × 17 A:18.2 B:18.2	A1181B BQFP 19 × 19 A:19.2 B:19.2	A1182B BQFP 24 × 24 A:24.2 B:24.2	A1184B SOJ 18 × 8 A:11 B:11	A1185B TSOL 13 × 10 A:11.9	A1186B TSOL 18 × 10 A:18.2
A1187B TSOL 18.5 × 8 A:18.5	A1188B PLCC 9 × 9 (20針) A:11 B:11	A1189B PLCC 34 × 34 (100針) A:36.5 B:36.5	A1203B QFP 35 × 35 A:35.2 B:35.2	A1214B SOJ 10 × 26 A:25.9	A1215B QFP 42.5 × 42.5 A:42.5 B:42.5
A1257B SOP 11 × 21 A:11.7	A1258B SOP 7.6 × 12.7 A:8.2	A1259B SOP 13 × 28 A:13.5	A1260B SOP 8.6 × 18 A:8.7	A1261B QFP 20 × 20 A:20.2 B:20.2	A1262B QFP 12 × 12 A:12.2 B:12.2
A1263B QFP 28 × 40 A:27.7 B:39.7	A1264B QFP 40 × 40 A:40.2 B:40.2	A1265B QFP 32 × 32 A:32.2 B:32.2	A1470 BGA 8 × 8 A:9	A1471 BGA 12 × 12 A:13	A1472 BGA 13 × 13 A:14
A1473 BGA 15 × 15 A:16	A1474 BGA 18 × 18 A:19	A1475 BGA 27 × 27 A:28	A1476 BGA 35 × 35 A:36	A1477 BGA 38 × 38 A:39	A1478 BGA 40 × 40 A:41

2. Packing list and name of parts

4204 control table	1	Operation instruction	1
Electric welding table handle	1		
Electric welding table handle holder	1		
Air nozzle	3		



● Optional parts

No	Name of part
1	Puller
2	Pulling steel wire (small)
3	Pulling steel wire (large)

3. Specifications

Model	ASE-4204
Total power	700W
Overall package size (mm)	330 (L) * 275 (W) * 195 (H)
Weight	3.7 kg

● Part of pulling-and-putting table

Input voltage	AC 220V ±10% 50Hz-60Hz
Power consumption	640W
Air pump	Diaphragm type
Volume	24L/min (max)
Temperature of hot air	100°C-450°C
Temperature display	Noise < 45dB
Scale	Indication

● Part of electric welding table

Power consumption of soldering iron	60W
Temperature range of soldering iron	200-480°C
Leakage voltage of soldering iron tip	<0.5mV

8.Maintenance and use of soldering iron tip

● Temperature of soldering iron tip.....

Too high temperature may reduce function of soldering iron tip, so you should select the lowest temperature if possible. It can sufficiently weld at lower temperature, and temperature sensitive elements can be protected accordingly.

● Cleaning

You should regularly clean soldering iron tip with clean sponge. The oxide and carbon compound of residual soldering agent on soldering iron tip after welding will damage soldering iron tip and cause welding error, or make heat conduction function of soldering iron tip reduced.

● If no use

If you do not use the electric welding table, you should not let it at high temperature for long time, or otherwise the welding flux at the soldering iron tip will be converted to oxide and cause great decrease of heat conduction function of soldering iron tip.

● After use

After use, you should clean soldering iron tip, coat new tin layer to prevent oxidation on soldering iron tip.

Maintenance

Check and clean soldering iron tip



- 1.Setting temperature is 250°C or 482.°F.
- 2.After the temperature is stable, clean soldering iron tip with clean sponge, and check status of soldering iron tip.
- 3.If the tin-plating part of soldering iron tip contains black oxide, you can coat new tin layer, and then clean soldering iron tip with clean sponge and so on, until the oxide is fully removed, and then new tin layer is coated. A new one shall be replaced if the soldering iron tip deforms.

7. Maintenance (pulling-and-putting table)

● How to check heating elements

⚠ ATTENTION

It is very dangerous to replace a heating element. You should switch off the power line and then replace it according to the following procedures.

A. Turn on hot-air gun

1. Pull fuse pipe down
2. Unscrew three screws for fixing hot-air handle
3. Open hot-air handle, separate the cover of grounding

wire and take out sleeve of heating element

⚠ ATTENTION

Quartz glass and other fragile materials are contained in the sleeve of heating element. Do not drop or loss.

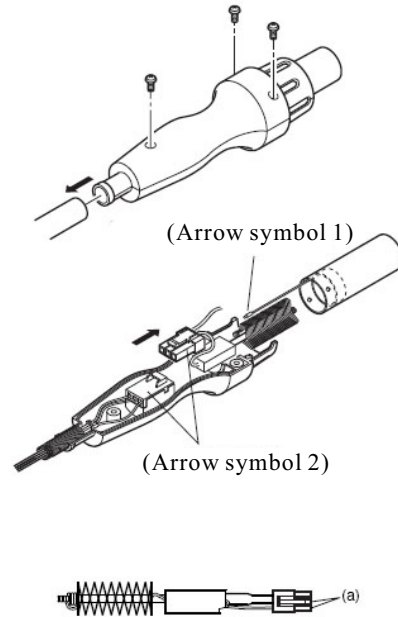
4. Take apart the terminal and pull out heating element

B. Measure electric resistance value

Measure the normal value of electric resistance value (a) of heating element as 26-40 ohm (100 120V) 70 100 ohm (220-240V) (at normal temperature). Please replace it if abnormal.

⚠ ATTENTION

Careful, do not contact frictional heating elements
The line will handle component protruding part with fever
Components inside casing



4. Assembly

A. assembly of control table

● Install soldering iron holder

Take the screws for fixing the soldering iron holder on the body, and install the soldering iron holder on the body (Fig. 1)

B. Assembly of air nozzle

● Unscrew the screws fixing air nozzle, and install the screws locking air nozzle (Fig. 2)

C. Connect power cable and switch on power

1. Insert soldering iron handle into 5-hole socket
2. Put hot-air gun onto hot-air gun holder
3. Insert the power plug into socket
4. Turn on the power switch and the lamp will be lit

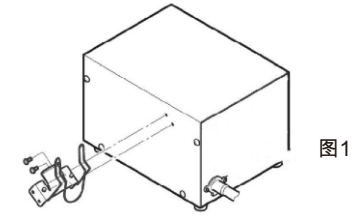


图1

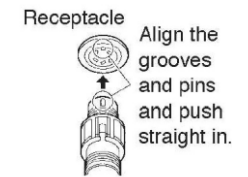
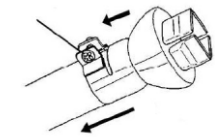


图3

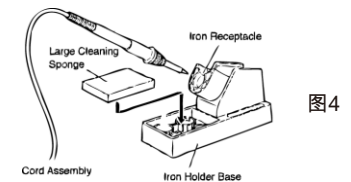


图4

⚠ Attention

This product has anti-static treatment and should be grounded.



⚠ Attention

The handle shall be put on air gun holder when it is not used.

5. Operation instructions (for pulling-and-putting table)

● Take down (QFP)

1. Adjust air volume and temperature control knob

2. Install puller

Make the puller cover the lower part of element (Fig. 1)
If the element width is not suitable for size of pulling steel wire, you can squeeze the steel wire width to accommodate it. Please use small tweezers to dismantle PLCC, integrated circuit's resistance and other parts.

3. Heating

Put hot-air gun onto the front of integrated circuit, make air nozzle align with the soldering tin to be melt, make the released hot air dissolve the soldering tin. The air nozzle shall not contact lead wire of element.

4. Disassembly of parts

When the soldering tin is being dissolved, raise the puller and move parts (Fig. 2)

5. Remove soldering tin

After moving parts, remove residual soldering tin with tin absorbing line or tin-removing tool.

Installation (QFP)

1. Apply appropriate tin paste

Apply appropriate tin paste and put components onto circuit board

2. Ready for heating

Refer to (Fig. 3) preheating components

3. Welding

Spray hot air to the lead wire frame (Fig. 4)

4. Cleaning

After welding, remove residual welding flux

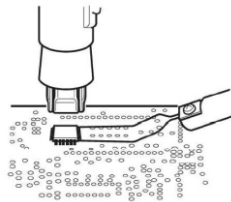
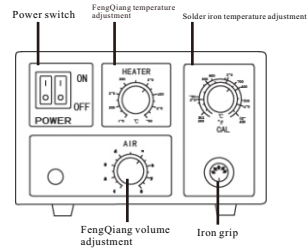


Figure 1

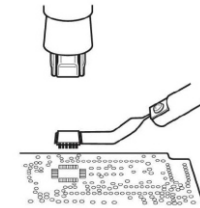


Figure 2



Figure 3

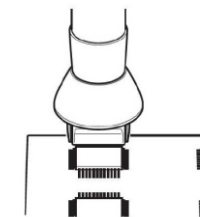
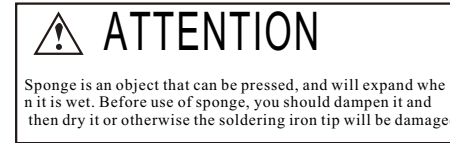


Figure 1

6. Operation instructions (electric welding table)

1. Assembly of soldering iron seat

● Put the cleaning sponge onto the seat



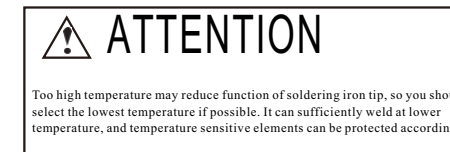
2. Insert soldering iron handle into the welding table holder on the seat

3. Connect soldering iron to the control table

● Insert the plug on wire combination into the socket on control table



4. Set temperature with temperature control button



5. Turn on power

● Insert power plug into power socket

