

## PRODUCT MANUAL

### 18 W VARIABLE TEMPERATURE - Soldering Iron

Part No. 218023

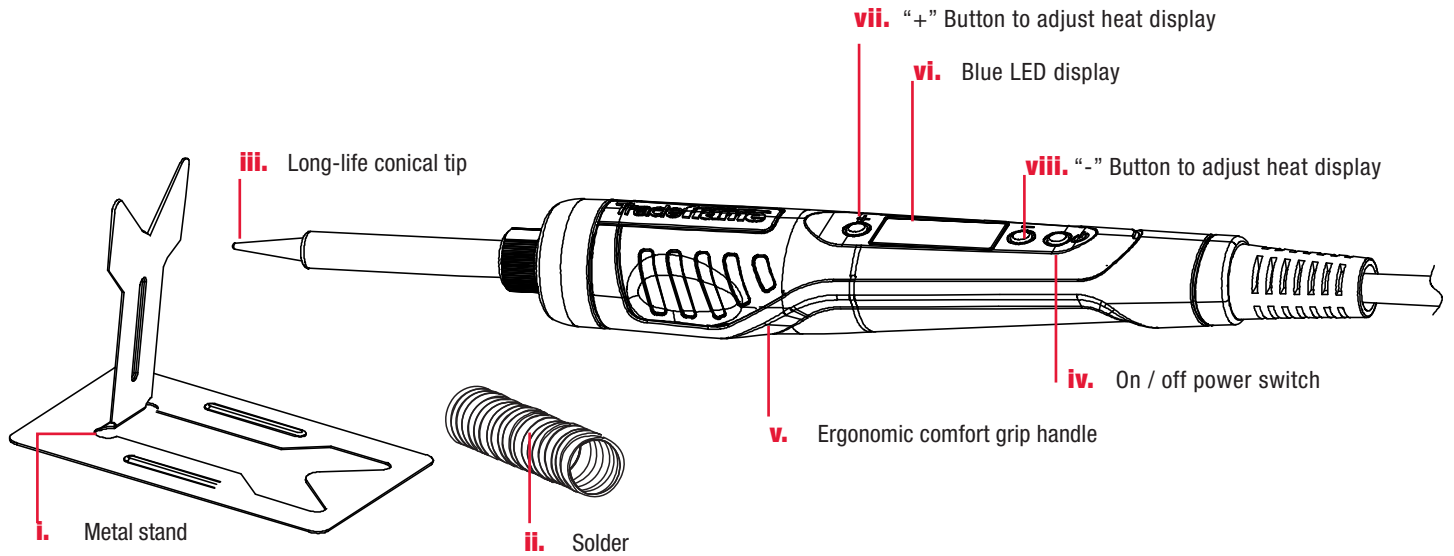


Fig. 1

NOTE CONTENTS FOR EACH SOLDERING IRON MIGHT VARY  
PLEASE CHECK PACKAGING FOR EXACT DESCRIPTION

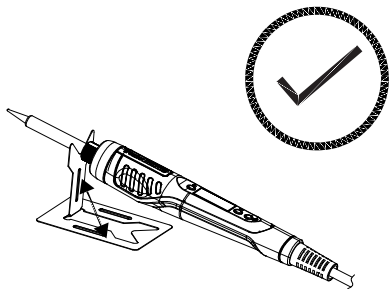


Fig. 2 - Correct storage of Soldering Iron when not in use

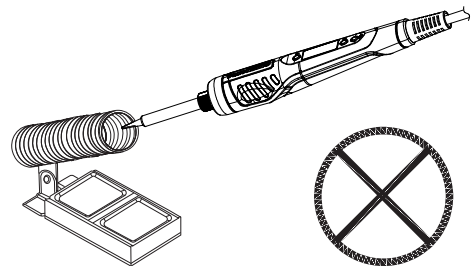


Fig. 3 - Do not place in coil holder

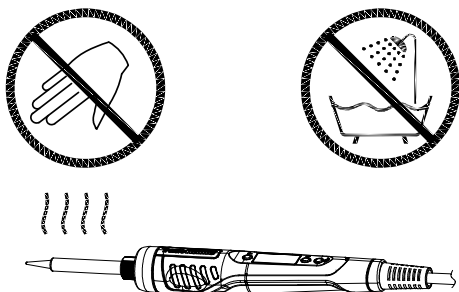


Fig. 4 - WARNING - hot tip when in use, do not touch, keep Soldering Iron clean and away from oils and lubricants. Do not immerse Soldering Iron in water

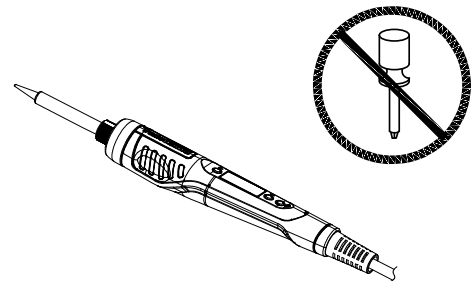


Fig. 5 - Do not modify or attempt to repair the Soldering Iron except as indicated in the instructions for use and care.

## SAFETY WARNINGS

Read all safety warnings, instructions, illustrations and specifications provided with this Soldering Iron. Failure to follow all instructions listed below may result in electric shock, and/or serious injury. Save all warnings and instructions for future reference. The term "Soldering Iron" in the warnings refers to your mains-operated (corded) Soldering Irons or battery-operated (cordless) Soldering Irons.

## WORK AREA SAFETY

- Keep work area clean and well lit. Cluttered or dark areas invite accidents.
- Do not operate Soldering Iron in explosive atmo-liquids, gases or dust. Soldering Irons create sparks which may ignite the dust or fumes.
- **Keep children and bystanders away while operating**

## ELECTRICAL SAFETY

- Indoor use. Do not expose Soldering Iron to rain or wet conditions. Water entering a Soldering Iron will increase the risk of electric shock (Fig. 4)

## PERSONAL SAFETY

- Stay alert, watch what you are doing and use common sense when operating a Soldering Iron. Do not use a Soldering Iron while you are tired/distracted or under the influence. A moment of inattention while operating a Soldering Iron may result in serious personal injury.
- Use personal protective equipment. Always wear eye protection. Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting. Ensure the switch is in the off position before connecting to power source, picking up or carrying the Soldering Iron.**
- Do not overreach. Keep proper footing and balance at all times. This enables better control of the Soldering Iron in unexpected situations.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair and clothing away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.
- Do not let familiarity gained from frequent use of the Soldering Irons allow you to become complacent and ignore Soldering Iron safety principles. A careless action can cause severe injury within a fraction of a second.

## SOLDERING USE AND CARE

- Do not force the Soldering Iron. Use the correct Soldering Iron for your application. The correct Soldering Iron will do the job better and safer at the rate for which it was designed.
- Do not use the Soldering Iron if the switch does not turn it on and off. Any Soldering Iron that cannot be controlled with the switch is dangerous and must be replaced.
- Disconnect the plug from the power source and/or turn off the battery, from the Soldering Iron before making any adjustments, changing accessories, or storing Soldering Iron. Such preventive safety measures reduce the risk of starting the Soldering Iron accidentally.
- Store idle Soldering Iron **out of the reach of children** and do not allow persons unfamiliar with the Soldering Iron or these instructions to operate the Soldering Iron. Soldering Iron are dangerous in the hands of untrained users.
- Maintain Soldering Iron and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the Soldering Iron's operation. If damaged, have the Soldering Iron repaired before use. Many accidents are caused by poorly maintained Soldering Iron.
- Use the Soldering Iron, accessories and Soldering Iron bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed. Use of the Soldering Iron for operations different from those intended could result in a hazardous situation.
- Keep handles and grasping surfaces dry, clean and free from oil and grease. (Fig. 4) Slippery handles and grasping surfaces do not allow for safe handling and control of the Soldering Iron in unexpected situations.
- Do not expose a Soldering Iron to fire or excessive temperature. Exposure to fire or temperature above 130°C (265°F) may cause explosion.

## SPECIFIC SAFETY RULES FOR SOLDERING IRONS

- Contact with a hot tip could ignite flammable materials. Contact with a hot tip could ignite a fire.
- While in use do not stand or store Soldering Iron on its side. Soldering Iron could tip resulting in contact between hot tip and flammable materials. Always set/store Soldering Iron on metal stand provided (Fig. 2)
- Do not place Soldering Iron in coil stand (Fig. 3).
- Keep hands clear of the tip serious burns can occur if skin contacts tip (Fig. 4)
- Work in well ventilated areas. Soldering can produce fumes and smoke.
- Use personal protective equipment when using
- This Soldering Iron is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.

## **KEEP AWAY FROM CHILDREN**

- To reduce the risk of fire, personal injury, and product damage due to a short circuit, never immerse your Soldering Iron, battery pack or charger in fluid or allow a fluid to flow inside them. Corrosive or conductive fluids, such as seawater, certain industrial chemicals, and bleach or bleach-containing products, etc., can cause a short circuit. (Fig. 4)
- To reduce the risk of injury, always wear safety goggles or glasses with side shields. Keep hands and fingers behind finger guard (Fig.1 / vii). Serious burns could occur if skin contacts a hot tip.(Fig. 4)

## ACCESSORIES

Use only recommended accessories. Others may be hazardous.

For a complete listing of accessories, go online to [www.tradeflame.com](http://www.tradeflame.com)

## CHANGING THE SOLDERING TIP

Ensure the tip is cool and Soldering Iron is switched off and unplugged from mains current and the tip temp indicator off before touching the tip as serious burns could occur to skin if touched

1. Loosen the sleeve - counter clockwise (Fig. 6)
2. Remove the tip and replace. (Fig.7)
3. Tighten the sleeve securely. - clock wise (Fig. 6)

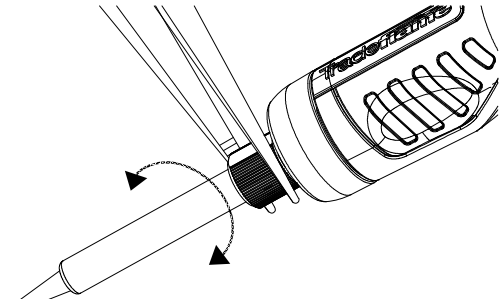


Fig. 6

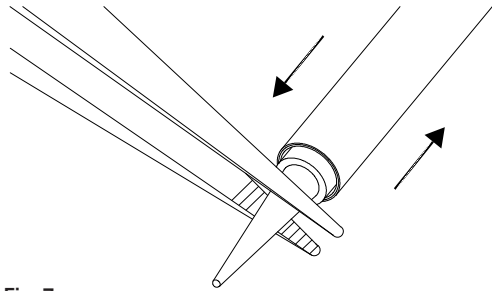


Fig. 7

## SOLDERING HINTS

- Ensure the soldering tip and work items are clean.
- Re-tin the tip (cover the heated tip with solder) prior to use.
- Use the soldering iron to heat the work items and apply solder directly to the work items – not to the soldering iron tip.
- Clean the tip with a damp sponge or Tradeflame's Brass Tip Cleaning brass wire (part number: 218167). after use – do not file tip.
- Use the metal stand when Soldering Iron not in use

## OPERATING 218023

1. Prepare the work area and piece
2. Make sure Soldering Iron tip is fixed in position and tightened.
3. Connect Soldering Iron to mains current and place on the metal stand provided. (Fig. 2)
4. Turn the Soldering Iron on by pressing the ON/OFF button for 2 seconds. (Fig. 1 / iv)
5. Default temperature is 350°C.
6. LED display will flash until the target temperature is reached. (Fig. 1 / vi)
7. Surfaces of the connection points must be clean.
8. "Tin" the tip by covering the heated tip with rosin core solder.
9. Use the Soldering Iron to heat the connection points, not the solder.
10. Apply only enough solder to the heated parts.
11. Allow the joint to cool undisturbed.
12. To turn off the Soldering Iron, press the ON/OFF button for 2 seconds (Fig. 1 / iv).
13. While still hot, clean the tip with a lightly damp sponge or Tradeflame's Brass Tip Cleaning Brass Wire (Part Number: 218167).  
**WARNING! Avoid contact, tip is hot and could cause serious burns.**
14. Place Soldering Iron on Metal Stand provided on its side with the tip away from working area (Fig. 2)
15. Turn the mains current off and unplug the Soldering Iron.
16. Let the Soldering Iron to cool down naturally
17. Once tip has cooled store in a safe and dry space.

## HOW TO SET A DIFFERENT TEMPERATURE

1. To set a temperature other than the default temperature, simply press the "+" button to increase (Fig. 1 / vii), or the "-" button to decrease to reach your target temperature. (Fig. 1 / viii)
2. Pressing "+" or "-" each time will adjust 1°C.
3. Keep pressing "+" or "-" will adjust in 10°C increments.
4. The display will show the target temperature for 2 seconds, and will resume to flashing mode until the Soldering Iron reaches the target temperature.

## HOW TO CALIBRATE THE TIP TEMPERATURE

1. This Soldering Iron is equipped with PID and can be calibrated to reflect actual tip temperature.
2. An external tip temperature sensor is required (not included).
3. Clean off excess solder from the tip with brass wire or a damp sponge.
4. Tin new solder to the tip.
5. Set your desired temperature on the Soldering Iron LED display, and wait until the display stops flashing (i.e. Soldering Iron has reached the target temperature).
6. Gently place the soldering tip flat on the external tip temperature sensor and record the temperature reading on the sensor.
7. To enter calibration mode, press the ON/OFF button and the "+" button simultaneously. (Fig. 1 / iv & vii),
8. Use the "+" or "-" buttons to adjust display to be the same as the temperature sensor reading. (Fig. 1 / vii & viii)
9. Press the ON/OFF button to save the calibration. (Fig. 1 / iv)
10. The display will display the adjusted temperature, but will start flashing to reflect the Soldering Iron is cooling off or heating up to reach the pre-set temperature.

## ENERGY SAVING MODE AND AUTO SHUT-OFF MODE

- This Soldering Iron is equipped with an energy saving mode to enhance the life of the soldering tip and heater.
- Soldering Iron will enter energy saving mode if inactive for 15 minutes. Tip temperature will lower to 200°C.
- Soldering Iron will further enter auto shut-off mode if inactive after 30 minutes. Display will also shut off.
- Once the Soldering Iron is picked up physically, the Soldering Iron will start heating up again to reach the pre-set temperature.

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