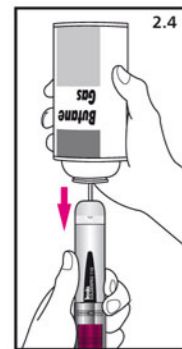


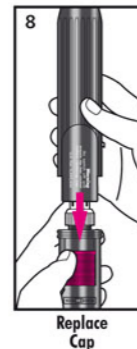
REFUELING

- 2.1 Make sure ON / OFF switch is at "OFF" position before filling.
- 2.2 Adaptors are not normally required when refilling.
- 2.3 To refill hold refill can as pictured (fuel transfer is dependent upon gravity).
- 2.4 Observe fuel level in transparent window and stop filling when 90% FULL.(PRO-110)



REPLACE CAP

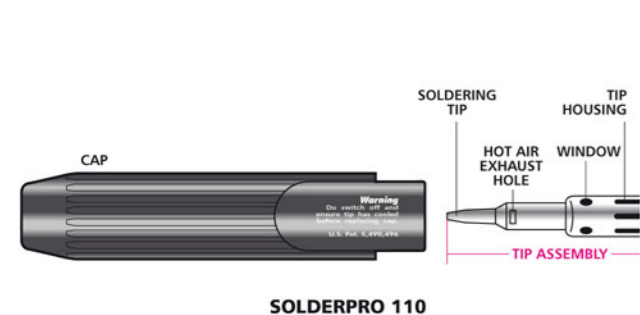
- 8.1 When replacing cap please refer as shown picture 8.



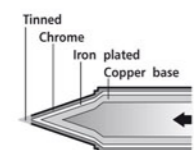
CLEANING

- 9.1 Use only the mild soap and a damp cloth to clean the housings of the tool. Many household cleaners contain chemicals which could seriously damage the plastic. Also do not use gasoline, turpentine, lacquer or paint thinner, dry cleaning fluids or similar products. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

DESCRIPTION



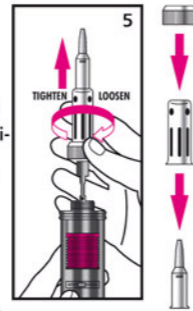
SOLDERPRO 110



- *iroda Soldering Iron Tips are shaped from a copper bar, then coated with protective iron plating.
- *Though the Coating is thick for improved durability, it has good heat conductivity for more efficient thermal recovery.

CHANGING TIPS

- 5.1 Be sure the tip has cooled before removal.
- 5.2 The catalyst seen through the Hot Air Exhaust Hole of the soldering tip is very delicate and will not sustain mechanical abuse without serious damage.
- 5.3 The soldering tip is easily removable allowing the installation of other style tips or the replacement of a worn tip. After the soldering tip is cool, simply unscrew it with a counterclock wise motion. Be careful not to overtighten as this could damage the nozzle assembly and thread in the body.



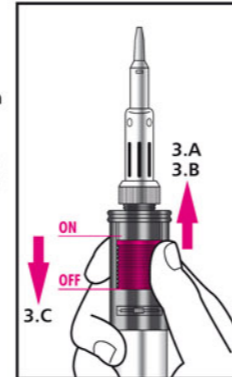
SOLDERING

- 7.1 BE SURE THE END OF THE SOLDERING TIP IS CLEAN AND WELL TINNED (COATED WITH SOLDER). The solder on the tip will melt rapidly and create a conductive path for the heat to reach the workpiece. A small additional amount of solder may be added to the tip while it is in contact with the workpiece to ensure good heat conduction.
- 7.2 If possible connect the workpieces mechanically, or position them as rigidly as possible.
- 7.3 Allow the soldering tip to heat sufficiently: 15 seconds minimum to about 30 seconds for optimum operating temperature.
- 7.4 Apply the heated soldering tip directly to the work. Heat the work surfaces sufficiently for the solder to melt on them. Apply the solder to the work surface directly. Do not just melt the solder on the tip of the iron allowing it to fall onto the work. This will cause poor bonding between the solder and the surfaces to be joined. Remove the iron tip quickly after the solder flows on the work surfaces.

NOTE: The heating catalyst in the tip has a limited life (approx. 200 hours) and will eventually need to be replaced. Replacements may be found at iroda distributor.

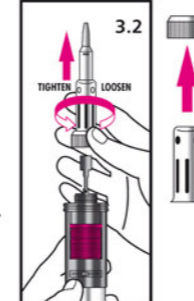
IGNITION SEQUENCE-1

- 3.A Lift up ON / OFF IGNITION SWITCH to the "ON" position to release gas.
- 3.B Push the switch upward toward tip to the maximum point to ignite then release the switch back to "ON" position to stay on.
- 3.C To turn off, slide the ON / OFF ignition switch downward toward the gas control lever.



HOW TO USE BLOW TORCH TIP

- 3.2.1 Remove tip and tip housing by untightening knurled nut.
- 3.2.2 Mount torch tip in place of removed tip housing.
- 3.2.3 Ignite gas by means of on/off ignition switch (Same as 3.A & 3.B)
- 3.2.4 Adjust flame length. Do not adjust to Maximum length as gas may flash and turn off.
- 3.2.5 To shut off the tool, same as soldering tip (3.1.6)

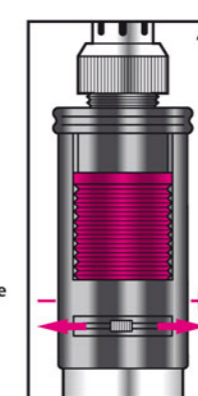


OTHER TIPS

- 3.3 How to use Heat blow tip same as soldering tip.
- 3.4 How to use Hot knife tip same as soldering tip.

ADJUSTMENT

- 4.1 The tip temperature can be adjusted by turning the GAS CONTROL LEVER observing the - + signs on the body.
- 4.2 Normally set the GAS CONTROL LEVER to mid position when soldering or brazing.
- 4.3 It is not necessary for the catalyst inside the tip to glow bright red to achieve satisfactory soldering temperatures. Experience will dictate the adjuster setting required.



TROUBLE SHOOTING

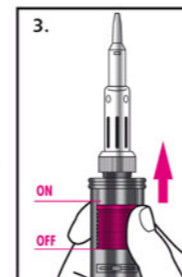
11. To reduce the risk of personal injury, property damage, or damage to your SOLDERPRO, do not attempt to repair the unit body.

PROBLEM	PROBABLE CAUSE	HOW TO CORRECT
11.1 Do not ignite	a. Empty tank b. too high or low fuel pressure c. Push on/off ignition switch too fast. d. Clogged orifice assembly	a. Refill with butane fuel b. Adjust control lever to a higher or lower position. c. Re-read "how to use as a soldering iron" d. Clean or replace with new orifice assembly
11.2 Low gas pressure or low flame	a. Clogged orifice assembly b. Cold fuel c. Low fuel	a. Clean or replace with new one. b. Hold body in hands to allow unit to warm up. c. Refuel
11.3 Tip does not heat up	a. Used-up catalyst b. Insufficient fuel pressure c. Clogged orifice assembly	a. Replace with new tip. b. Adjust control lever to a higher position. c. Clean or replace with new one.

- 1.8 STORE WHEN NOT IN USE. Store in dry, locked cabinet out of reach of children.
- 1.9 BE extremely careful as torch flame tip temperature is over 1300°C (2500°F)
- 1.10 BE extremely careful as torch flame is almost invisible in daylight or strong light.
- 1.11 USE SAFETY GLASSES.
- 1.12 DON'T OVERREACH. Keep proper footing and balance at all times.
- 1.13 STAY ALERT. Watch what you are doing. Use common sense. Do not operate when you are tired.
- 1.14 DO NOT TOUCH THE HEATED TIP OR BARREL OF THE UNIT.
- 1.15 DO NOT leave unit unattended when it is operating or hot.
- 1.16 ALWAYS BE SURE THE UNIT IS COOL BEFORE STORING.
- 1.17 DO NOT REPLACE CAP WITHOUT SWITCHING UNIT OFF AND ENSURING TIP HAS COOLED.
- 1.18 USE ONLY IN WELL VENTILATED AREA.
- 1.19 DO NOT attempt to readjust or repair, unit is not user serviceable.

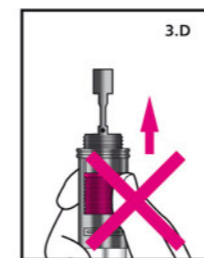
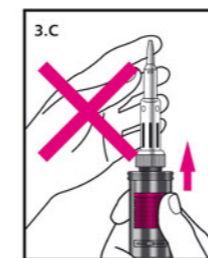
HOW TO USE SOLDERING IRON

- 3.1.1 Be sure the hot air exhaust hole is positioned upward as pictured.
- 3.1.2 Set gas control level at mid position.
- 3.1.3 Push the ON / OFF ignition switch slowly upward toward tip to the max. point and release the switch. (same as 3.A & 3.B)
- 3.1.4 You may hear the gas flow sound and tip housing becomes orange color after 1 or 2 seconds. If not, repeat #3.1.3
- 3.1.5 Tip temperature can be changed by adjusting the gas control lever.
- 3.1.6 To turn off, Same as 3.C. It is not necessary to move the gas control lever after the unit is turned off.



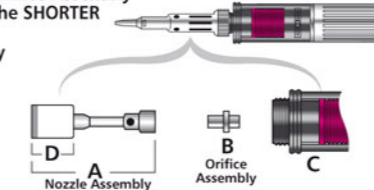
IGNITION SEQUENCE-2

- 3.C Do not touch Tip, Tip Housing or Knurled Nut while igniting.
- 3.D Do not ignite the unit when "Tip Assembly" is not screwed on.



CLEAN OR REPLACE ORIFICE ASSEMBLY

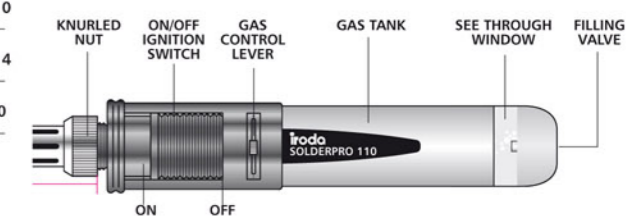
- 6.1 Remove soldering tip and flame collar in the normal manner.
- 6.2 While holding the torch straight up in the vertical position, unscrew Nozzle Assembly (A) from the Torch Body (C). You may have to use a pliers or other tool to start unscrewing. Do not grasp and turn the Ceramic Head (D).
- 6.3 Carefully remove Orifice Assembly (B) by lifting out of torch body. NOTE THAT THE SHORTER SIDE OF ORIFICE ASSEMBLY FITS INTO TORCH BODY.
- 6.4 Soak Orifice Assembly in Naptha or other similar solvent for approximately 5 minutes.
- 6.5 Replace clean (or new) Orifice Assembly remembering to insert the SHORTER SIDE INTO TORCH BODY.
- 6.6 Replace Nozzle Assembly and hand tighten or tighten gently with a pliers grasping the shank of the Nozzle Assembly.



ACCESSORIES

- 10 The accessories listed below are available from your local retailer.

SOLDERPRO 110	PART NO	DESCRIPTION	TYPE	PART NO
	PS-01	1.6mm	Conical	Heat Blower PS-10
	PS-02	3.2mm	Conical	Orifice Assembly PS-14
	PS-03	2.4mm	Chisel	Deflector S-30
	PS-04	3.2mm	Chisel	
	PS-05	2.4mm	Angle	
	PS-06	3.2mm	Angle	
	PS-09			



iroda.

SOLDERPRO™
PRO-110 • PRO-110K

Instruction Manual

READ INSTRUCTIONS AND WARNINGS BEFORE USE

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IMPORTANT SAFETY INSTRUCTIONS

- Warnings:
- 1.1 Unit contains flammable gas (Butane) under pressure - use with care.
 - 1.2 DO NOT expose to heat above +50°C (120°F) and avoid prolonged exposure to the sun.
 - 1.3 DO NOT puncture or incinerate.
 - 1.4 Excessive gas flow, flaming or catalyst pulsing red may occur when the GAS CONTROL LEVER is incorrectly adjusted, i.e., set too high.
 - 1.5 DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials.
 - 1.6 KEEP WORK AREA CLEAN. Cluttered areas and benches invite injuries.
 - 1.7 KEEP CHILDREN AWAY. Visitors should be kept away from work area.

SPECIAL WARNING

- 12.1 This product, when used for soldering and similar applications, produces chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.
- 12.2 Department of Transportation Hazardous Materials Regulations forbid the carriage of butane or other flammable gas products on passenger aircraft. Do not pack this item or any other flammable gas item, in any checked or carry-on baggage.