



BK969

SOLDERING STATION

Instruction Manual

NOTE:

- Please follow the instructions to avoid accidents.
- For your own safety, please read the instruction carefully. Fully understand how to use the product, to prevent any accidents due to improper use.
- Please keep it for your reference after reading.

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Safety Precautions

Warning!

Before using the soldering station, the following basic measures must be followed to avoid electric shock or harm to life or cause fire and other hazards. (This soldering iron must use our company' s special soldering iron core)

To ensure personal safety, accessories approved or recommended by the original manufacturer must be used, otherwise serious consequences will be incurred!

You must strictly find an electrical technician or a person designated by the factory for repairs!

When the power is turned on, the temperature of the soldering iron tip is higher than 200°C to 480°C (392°F to 896°F).

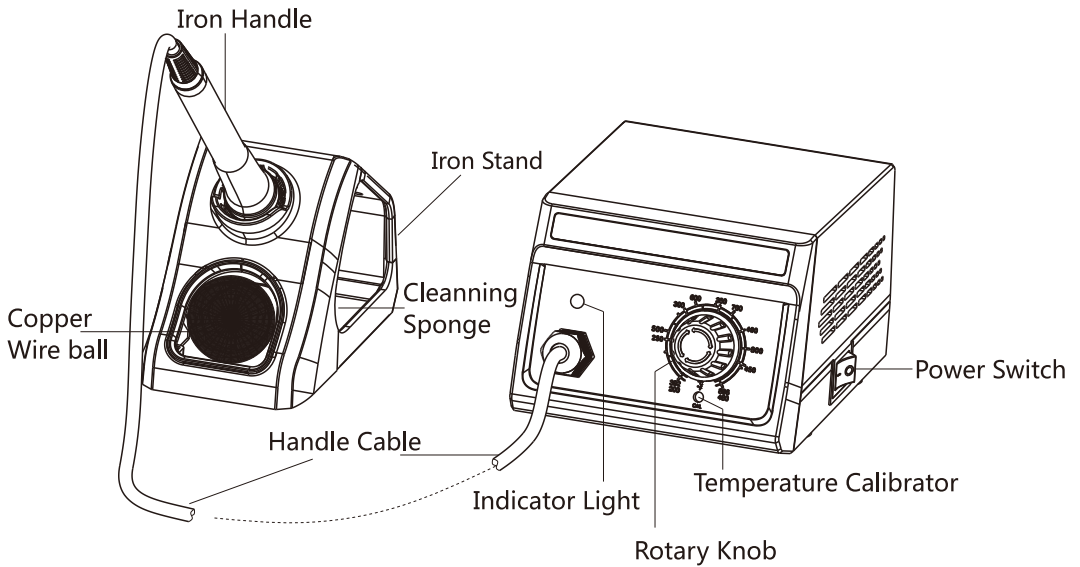
In view of the fact that abuse may cause burns or fire, please strictly observe the following:

- Do not touch the metal parts near the soldering iron tip.
- Do not use soldering iron near flammable objects.
- Notify other personnel in the workplace that the soldering iron tip is extremely hot and may cause a dangerous accident. The power should be turned off during a break or after completion of work.
- When replacing parts or installing the soldering iron tip, turn off the power and wait for the soldering iron tip to cool to room temperature.

In order to avoid damage to the soldering station and the safety of the working environment, the following items should be observed :

- Do not use the soldering iron tip for work other than soldering.
- Do not knock the soldering iron on the workbench to remove the residue, as this may seriously damage the soldering iron.
- Do not get the soldering station wet or use it when your hands are wet.
- Smoke will be emitted during soldering, and the workplace should have good ventilation facilities.
- When using the soldering station, do not make any rash actions that may harm your body or damage objects.

Product Diagram



Packing List

Soldering station	1PCS
Soldering handle	1PCS
Soldering stand (including copper wire ball)	1PCS
Power cable	1PCS
Manual	1PCS

Product Overview

1. Technical Parameters

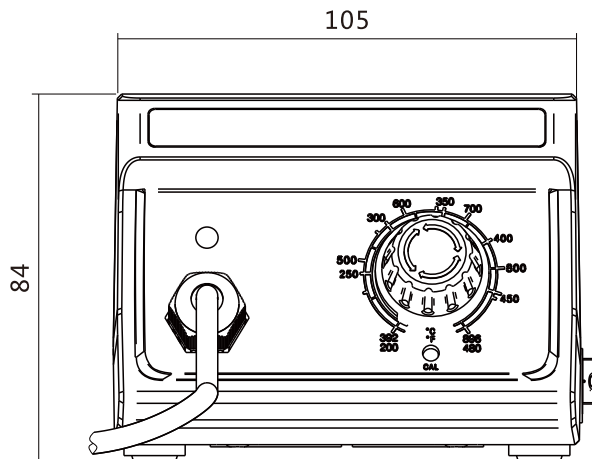
Power Voltage	AC230V/50Hz
Temperature range	200 ~ 480°C
Dimension	900M
Dimension	135X107X84mm
Power	90W
Tip ground resistance	2Ω
Heating core model	1370(Ceramic heating core)
Net/Gross weight:	≈0.8Kg/≈1.0Kg

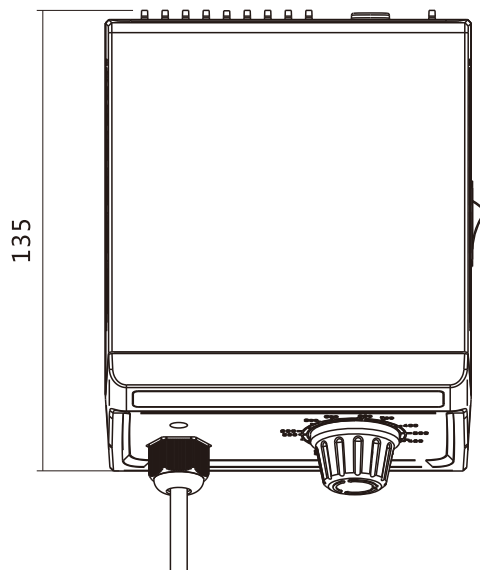
2. Function

- The station uses an integrated ceramic heating core, with long life and constant performance. Thermocouple sensor is located at the top of the heating core, sensitive to temperature and fast return temperature.
- Handle, host, soldering stand with novel appearance, with independent intellectual property rights.
- Handle is welding engineering design, long-term use of fatigue.

Product Size

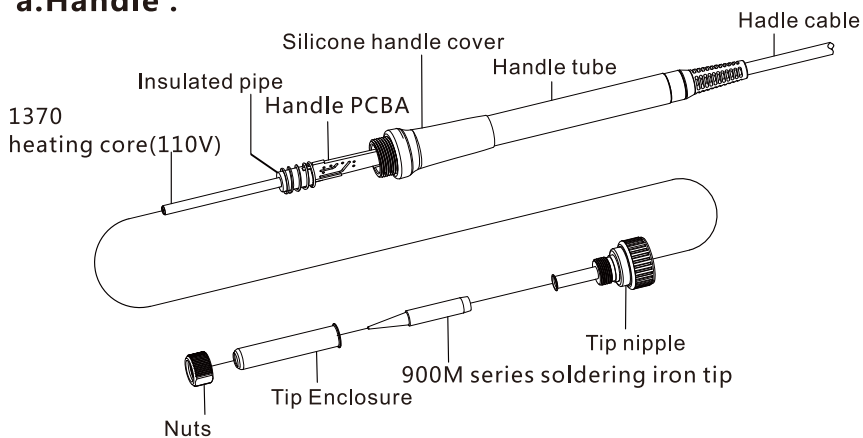
unit : mm





Handle/heating core replacement diagram

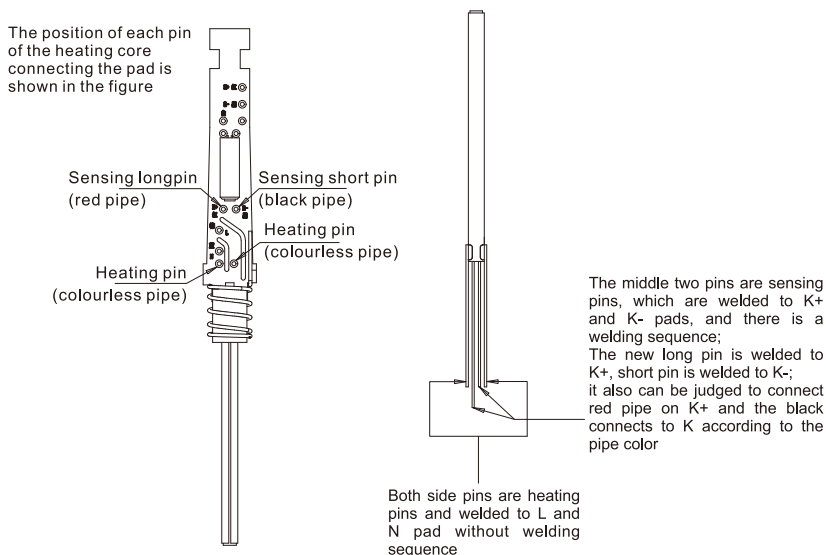
a.Handle :



Precautions for replacing the heating core:

1. Before replacing the heating core, be sure to unplug the power plug of the product and operate after the power is cut off;
 2. Please use our 1370 heating core (110V) for replacement;
 3. Please compare the handle diagram of this product and replace the heating core with the following operations;
 4. Unscrew the Nut and take out the soldering iron tip enclosure and iron tip
 5. Unscrew the tip nipple, take out the heating core and handle PCBA components, and take out the insulation pipe and put it aside;
 6. remove the heating core from the PCBA with an electric soldering iron, replace the new heating core and reinstall it;
 7. pay attention to the heating core pin position when welding, please compare the diagram of the heating core to replace, to prevent welding errors;
 8. note that the new heating core pin is equipped with teflon enclosure, if not, can not be welded directly;
 9. after the welding is completed, it can be assembled according to the opposite operation above (pay attention to the installation of the insulation pipe);
- Non-professionals can ask a professional maintenance personnel to help operate, or contact our company after sales.

B. Heating core



How to USE

1. Instructions

- Turn the temperature control knob to 350 ° position.
- Connect the soldering iron to the console, and connect the power supply.
- Turn on the power switch, the panel indicator LED will light up.
- Switch the temperature control knob to appropriate temperature position.

Low temperature will slow down the flow of solder, and too high temperature will scorch the flux in the solder and turn it into a thick white color, causing false soldering or burns to the circuit board. When the temperature of the soldering iron tip is set correctly according to the needs of the soldering point, a good soldering point can be ensured. The solder alloy commonly used in the electronics industry is 60% tin and 40% lead (60/40). The proper use temperature of the soldering iron tip for solder varies according to the manufacturer. Here are the following:

Melting point: 215°C	General use temperature: 350°C
Use temperature of assembly line: 350 ~ 380°C	

⚠ Note: Normal use should not exceed 380°C. If there is a need to use a higher temperature, short-term use is allowed.

2. The reason why the soldering iron tip does not stick to the tin

- The temperature of the soldering iron tip exceeds 400°C.
- The soldering iron tip dipping surface is not properly tinned during use.
- Lack of flux in operations such as soldering, tin removal, repair, repair soldering, etc.
- Wipe the soldering iron tip on a sponge or rag with high sulfur content or dry.
- Contact with organic hands such as plastic materials, silicon grease and other chemicals.
- Use impure and low tin content solder

Maintenance

In order to ensure that the soldering station functions well and normally, please pay attention to the following suggestions. (If the soldering station handle or soldering station has some factors that cause the function to operate abnormally, please contact the nearest service office for service support.)

1.General cleanup

- The handle of the soldering iron or the housing of the temperature control table can be cleaned with a cloth dipped in a small amount of liquid detergent.
- Do not immerse the temperature control platform in fluid or allow fluid to flow into the enclosure.
- Do not use any solvents to clean the case.

2.Brand-new soldering tips

- To replace the soldering iron tip, please use our 900M series soldering iron tip.
- When using a brand new soldering iron tip at any time, please follow the steps below to greatly extend the service life of the soldering iron tip.

- 1) Turn the temperature setting control knob to the low temperature position and turn on the power switch.
- 2) After heating up to 200°C, add solder wire containing flux to the soldering iron tip dipping surface.
- 3) After heating at 200°C for five minutes, turn the temperature setting control knob to the appropriate operating temperature position.
- 4) After reaching the appropriate temperature, you can start using it.

⚠ Note: When using a brand new soldering iron tip at any time, it is best to take out the soldering iron tip and clean the internal foreign objects every day!

3.Soldering tips maintenance

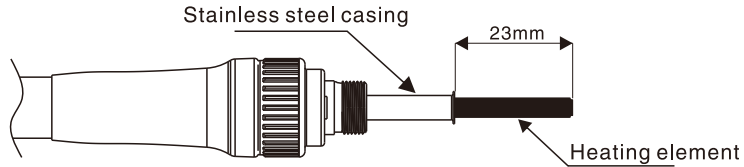
The soldering iron tips supplied are all alloy tips. If used properly, they will have a longer service life.

- Be sure to add proper tin to the sticking surface of the soldering iron tips before shutting down, and wipe it only before soldering.
- Don't let the soldering iron tip stay at too high temperature for a long time, it is easy to crack the plating layer on the surface of the soldering iron tip.
- When soldering, do not rub the solder joints with too much pressure on the soldering iron tips. This process will not change the thermal conductivity, but will damage the tips.
- Never use rough materials or a frustrated knife to clean the soldering iron tips.
- If the surface has been oxidized and does not stick to tin, if necessary, you can carefully rub it with a 600-800 mesh gold-steel emery cloth and clean it with propanol or an equivalent solution. Heat the tin to 200 °C and immediately stick the tin to prevent high temperature oxidation.
- Do not use flux containing chlorine or excessive acid, only use synthetic resin or activated resin flux.

⚠ Note: at least once a week, take out the soldering iron tips to clean up and remove foreign objects in the sleeve.

4.Soldering tips replacement

The soldering iron tips can be loosened and removed for replacement. The power of the soldering station must be turned off, and the tips can be removed after it has cooled to room temperature to remove the oxide dust formed in the socket fixing place. Care must be taken to prevent this dust from entering eye. Replace the soldering iron tips and lock the sleeve with normal hand strength. The installation elements are shown in the figure:



⚠ Note: Be careful not to lock it too tightly, otherwise the heating element will be damaged.

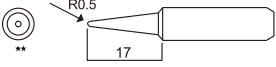
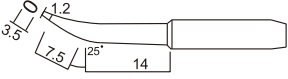
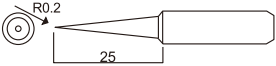
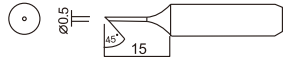
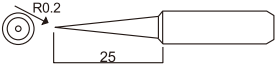
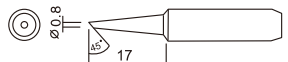
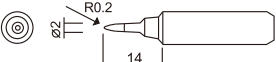
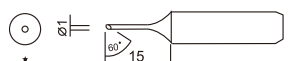
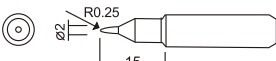
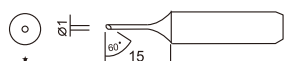
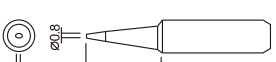
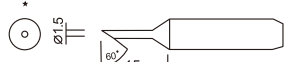
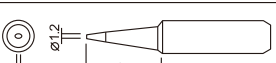
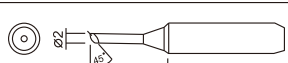
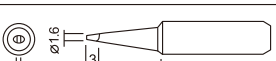
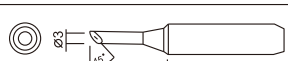
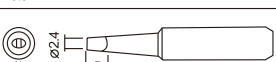
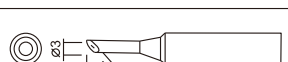

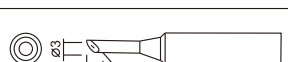




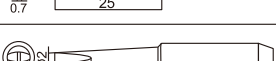

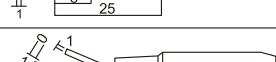
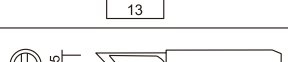
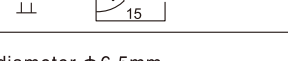
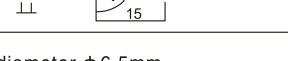
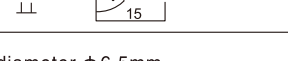
5.After-sales service

If the soldering iron or soldering station fails or is not used properly due to unknown reasons, it should be returned to the original factory or agent for professional repair.

6.Temperature adjustment

- 1) The temperature of the soldering iron needs to be calibrated regularly. In addition, due to the different types of soldering iron tips, the temperature is also different, and the temperature needs to be corrected.
- 2) The "CAL" hole on the panel can be fine-tuned by the customer with a screwdriver outside the chassis.
3. When calibrating the temperature, recommend to use BK191 thermometer.

900Mseries soldering tips

900M-T-B		900M-T-H	
900M-T-BF2		900M-T-0.5C	
900M-T-LB		900M-T-0.8C	
900M-T-SB		900M-T-1C	
900M-T-S4		900M-T-1CF	
900M-T-0.8D		900M-T-1.5CF	
900M-T-1.2D		900M-T-2C	
900M-T-1.6D		900M-T-2CF	
900M-T-2.4D		900M-T-3C	
900M-T-3.2D		900M-T-3CF	
900M-T-S3		900M-T-S10	
900M-T-1.2LD		900M-T-4C	
900M-T-2LD		900M-T-4CF	
900M-T-1.8H		900M-T-S11	
		900M-T-I	
		900M-T-SI	
		900M-T-K	

- ★ The tips is tin-plated only on the inclined surface ★ 900M outer diameter $\phi 6.5\text{mm}$
- ★ Suitable for 936/937 and various resistance ceramic heating soldering stations

Attention:

This soldering station uses ceramic heating cores, which can quickly heat up, have a long life, and are easy to replace. In order to ensure good performance of the soldering station, please choose the original matching heating core and soldering iron tip, thank you!

Repair Warranty (Principle)

Model: _____ Date of Production: _____

Customer: _____ Date of Purchase: _____

Product No: _____ Issued by: _____

From the date of purchasing, we provide ____months repair warranty

After Sale Suggestion (Subordinate)

Customer: _____

Delivery Date: _____ Tel: _____

Address: _____

Distributor: _____

Invoice NO: _____ Invoice Date: _____

Product Model: _____ Product NO: _____

Warranty Terms:

- 1.The table for feedback from customers should be returned to our company within a month after the date of purchase.In this way,customers may enjoy one-month repair warranty.
- 2.Repair Warranty and Purchase Certificate should be presented.The warranty only applies when all the required documents are available.
- 3.The warranty does not apply when the equipment has received damage through abuse, carelessness,improper installation,accident or mishandling during shipment,connecting to improper line voltage,or has been serviced by anyone other than an authorized factory representative.
- 4.After the warranty period,we are ready to provide charged repair service,perfect as always.

Dear Sir / Madam :

Thank you for purchasing our products.To improve our service and ensure the proper use of our products,please kindly write down your suggestions.

Name of Product: _____

Date of Purchase: _____

Your Suggestions: _____

Package: _____

Functions: _____

Others: _____

Date : _____

Bakon®

GUARANTEE CARD

The product conforms to the technical standards

Q C .



SHENZHEN BAKON ELECTRONIC TECHNOLOGY CO.,LTD.

Warranty card

The warranty is valid in one year since the purchase of this ,any quality problem found,please send back to us with courier fee to be collected,upon receipt of the returning unit,we will repair it and send back to customer within two working days.

Notice:Please enclose the warranty card along with the returning product, or else we have the right to reject the repairing,thanks for your corporation.



SHENZHEN BAKON ELECTRONIC TECHNOLOGY CO.,LTD.

ADD: Ruihui Building, Matian street, Guangming District, Shenzhen,
China 4 Floors 518105

MFR: Henan Bakon Tools Co., Ltd.

ADD: No.7 Building, Jinrong Technology Park, Airport Port Zone,
Zhengzhou City, Henan Province, China

TEL: 086-755-89575688 MP: BAKON白光

SITE: www.bakon.cn Email: postmaster@bakon.cn