

本产品由于出厂需要经过测试,所有烙铁头会带有少量锡,钢套略有泛黄,属于正常现象。

## 恒温电焊台使用说明书 AT-939



# ATTEN



## AT-969 Soldering Station User Manual

The soldering iron needs to be tested before it leaves the factory, so the soldering tip may cover small amount of tin, and the casing will be slightly yellowing, which is a normal phenomenon.

# ATTEN



# 目录

01	包装清单及外形图示.....	01
01	包装清单.....	01
01	外形功能图示.....	01
01	功能特点.....	01
02	产品规格.....	02
02	技术参数.....	02
02	包装参数.....	02
03	安全及使用注意事项.....	03
04	使用方法.....	03
03	操作步骤说明.....	03
03	温度锁定.....	03
03	温度调校.....	03
03	LED灯显示模式.....	03
03	烙铁头不沾锡原因.....	03
05	保养与维护.....	04
04	日常清理.....	04
04	烙铁头使用.....	04
04	烙铁头维护.....	04
04	烙铁头的更换及处理.....	04
06	部件详解.....	05
06	产品保修.....	06
07	烙铁头型号参照图.....	07

# Content

01. Package list and appearance description.....	01
Packing list.....	01
Appearance description.....	01
Features.....	01
02. Specification.....	02
Technical parameters.....	02
Packing parameter.....	02
03. Safety and cautions.....	02
04. Application method.....	03
Operation steps.....	03
Temperature lockout.....	03
Temperature calibration.....	03
LED display mode.....	04
The reason of why solder tip don't stick the tin.....	04
05. Maintenance.....	05
Daily clear.....	05
Soldering tip use.....	05
Soldering tip maintenance.....	05
Replacing soldering tips.....	06
06. Details of components.....	06
Product warranty.....	07
Iron tip type.....	08

# 01/Package list and appearance description

## ● Packing list

		
● Soldering station host *1	● Soldering iron handle *1	● Iron stand *1
		
● cleaning sponge *1	● Certificate *1	● Manual *1

## ● Appearance description

- ① Soldering iron handle
- ② LED indicator light
- ③ Power master switch
- ④ Power cord
- ⑤ Iron stand
- ⑥ Soldering iron handle interface
- ⑦ Temperature regulation hole
- ⑧ Temperature knob
- ⑨ Temperature locking screw



## ● Features

- Imported heat resistant materials with long life.
- The heater using low voltage AC power to ensure the antistatic and no leakage, no interference.
- 200°C~480°C / 392°F~896°F temperature adjustment, rapid heating, stable and accurate control.
- Legerity handle suitable for long time operation.
- The main power of heating element is completely isolated from the grid.
- Seperate design, easy to use and replace.

1

1

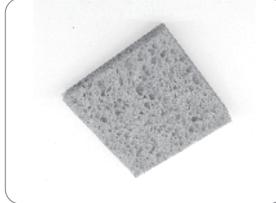
- 发热芯采用进口耐高温材料，先进工艺制成，使用寿命长。
- 发热芯使用低压交流源供电，无漏电、无干扰。
- 200°C~480°C/392°F~896°F温度范围设定，升温快速，控制稳定、准确。
- 手柄轻巧，长时间使用无疲劳感。
- 发热芯所使用的主电源完全隔离电网。
- 分体式设计，使用方便快捷。

## ● 功能特点

- ① 烙铁手柄
- ② LED指示灯
- ③ 电源开关
- ④ 主机电源线
- ⑤ 烙铁座
- ⑥ 烙铁手柄接口
- ⑦ 温度调校孔
- ⑧ 温度旋钮
- ⑨ 温度锁定螺钉



## ● 外形图示

		
● 使用说明书 *1	● 合格证 *1	● 清洁海绵 *1
		
● 烙铁座 *1	● 烙铁手柄 *1	● 电焊台主机 *1

## ● 包装清单

# 01/包装清单及外形图示

## 02/产品规格

## ● 技术参数

产品型号	AT-939
输入电压	220-240V~ 50/60Hz
功率	60W
温度范围	200°C~480°C
手柄型号	AP-61
烙铁咀型号	T900系列
发热芯	四芯陶瓷发热芯(拔插式)
产品尺寸	(L) 140mm x (W) 115mm x (H) 90mm

## ● 包装参数

整机包装	内箱尺寸: 250x210x134mm 产品重量: ≈1.6kg 毛重: ≈1.7kg
外箱包装	外箱尺寸: 515x435x425mm 装箱规格: 12台/箱 毛重: ≈21.4kg

## 03/安全及使用注意事项



- 使用电焊台前, 请务必遵守以下事项, 以免触电或对生命造成伤害或火灾等危害。  
(本产品必须使用本公司专用发热芯)

- 为确保人身安全, 必须使用由原厂认可或推荐的零件及配件, 否则将导致严重后果!

- 必须由合格的电器技师或本厂指定人员进行维修!

## ⚠ 注意

- 当电源接通时, 烙铁头温度高于200°C~480°C/392°F~896°F。鉴于滥用可能导致灼伤或火灾隐患, 请严格遵守以下事项:

- 切勿触及烙铁头附近的金属部分。
- 切勿在易燃物体附近使用本产品。
- 烙铁头温度过高状态下, 可能引发危险事故, 休息或完工后应切断电源。
- 更换部件或装置烙铁头时, 应切断电源, 并待烙铁头冷却到室温。

- 为避免损坏电焊台和作业环境安全, 应遵守以下事项:

- 切勿使用本产品进行焊接以外的工作。
- 切勿敲击工作台以清除烙铁上异物, 该行为可能严重损坏烙铁。

## 02/Specification

## ● Technical parameters

Model	AT-969
Rated operating voltage	220-240V~ 50/60Hz (100-120V~ 60Hz)
Power	60W
Temperature range	200°C~480°C/392°F~896°F
Handle model	AP-61
Soldering tip type	T900-B
Heater	High quality four-core heater
Dimension	(L) 140mm x (W) 115mm x (H) 90mm

## ● Packing parameter

Inner box package	Outer carton package
Inner box size: 250x210x134mm Product weight: ≈1.6Kg G.W: ≈1.7kg	Outer carton size: 515x435x425mm Package: 12pcs/carton G.W: ≈21.4kg

## 03/Safety and cautions

## ⚠ warning

- Before use this unit, make sure comply with the following measures, against risk of electric shock or give rise to fire.(The soldering iron must use ATTEN heating element.)
- In order to ensure body safe, must use the components or accessories that recommended by original factory, otherwise it may cause serious consequences.
- It should be maintained by qualified electric technician or service personnel specified by original factory.

## ⚠ Attention

- When the power is on, the tip temperature is between 200°C/392°F and 480°C/896°F, since mishandling may lead to burns or fire, be sure to comply with the following precautions.
  - Do not touch the metallic parts near the tip.
  - Do not use the produce near flammable items.
  - The tip can reach a very high temperature and should be considered potentially dangerous. Turn the power off while taking breaks and when finished using the unit.
  - Before replacing parts or storing the unit, turn the power off and allow the unit to cool down to room temperature.

## ● To prevent damage to the unit and ensure a safe working environment, be sure to comply with the following precautions.

- Do not use the unit for applications other than soldering.
- Do not tap the soldering iron against the workbench to shake off residual solder, or otherwise subject the iron to severe shocks.
- Do not modify the unit.
- Do not wet the unit or use the unit when your hands are wet.
- The soldering process will produce smoke, so make sure the area is well ventilated.
- While using the unit, don't do anything that may cause bodily harm or physical damage.

## 04/Application method

### ● Operation steps

- ① Set the temperature knob to 200°C/392°F.
- ② Connect the soldering iron handle and soldering station host.
- ③ Connect the Soldering Station host power, turn on the power switch, and the power indicator LED will light up.
- ④ Turn the temperature control knob to the desired temperature position, the temperature rises to work.

### ⚠ Attention

- If the temperature is too low, the flow of solder will be slowed down. If the temperature is too high, the flux in the solder will be scorched and turned into white smoke, caused false soldering or burning the circuit board. The temperature of the soldering tip needs to be set according to the soldering temperature. The common used solder alloy for electronic components is 60% tin, 40% lead (60/40). The suitable soldering temperature of tip varies according to the manufacturer. Here are some examples:

Melting points	215°C/419°F
Normally used temperature	270°C~320°C/518°F~608°F
Assembly line used temperature	320°C~380°C/608°F~716°F

### ⚠ Attention

- Usually used temperature should not exceed 380°C/716°F. If there is a need to use a higher temperature, please use it with in a short time.
- Temperature lock
  - Set the temperature control knob to the desired temperature.
  - After setting the desired temperature, tighten the hex nut on the underside of the knob mount. (Please refer to page 1 for the description of the appearance description) turn the nut clockwise to tighten the knob lock.
  - When resetting the temperature, turn the screwdriver counterclockwise, loosen the screw.
- Temperature calibration
  - The soldering iron temperature needs to be corrected regularly, and the temperature is also different due to the different types of soldering iron.
  - Calibration method: use a screwdriver to rotate in the panel "CAL" hole to adjust the temperature.

## 04/使用方法

### ● 1. 操作步骤说明

- ① 首先将温度控制旋钮转至200°C/392°F的位置。
  - ② 连接好烙铁手柄和电焊台主机。
  - ③ 接通电焊台主机电源，打开电源开关，电源指示灯LED即亮起。
  - ④ 将温度控制旋钮转至工作所需温度位置，温度升起，即可工作。
- ⚠ 注意
- 大低温度会减缓锡锡的流动，温度过高会把焊锡中的助焊剂烧焦而转为白色浓烟，造成虚焊或烧伤电路板。烙铁头温度需要根据焊锡温度正确设定。电子元器件普遍使用的焊锡合金是60%锡、40%铅(60/40)。烙铁头适合的焊锡使用温度，根据制造厂而有所不同，如下示例说明：

熔点	215°C/419°F
一般使用温度	270°C~320°C/518°F~608°F
流水生产线使用温度	320°C~380°C/608°F~716°F

### ⚠ 注意

- 一般使用温度不应该超过380°C/716°F。如果需要使用较高温度，短时间内使用可允许。
- 2. 温度锁定：
  - 将温度控制旋钮，转至工作所需温度位置。
  - 使用螺丝批，旋转温度控制旋钮侧面螺钉(具体位置请翻阅第1页外形图示介绍)，顺时针拧紧锁定螺钉，直至温度控制旋钮不动。
  - 温度重新设定时，逆时针旋转螺丝批，松动锁定螺丝。
- 3. 温度调校
  - 烙铁需要定期校正温度，另外由于选用烙铁型号不同，温度也有所不同。
  - 调校方式：使用螺丝批在面板“CAL”孔内旋转做温度调校。
- 4. LED灯显示模式：
  - 常亮模式：机器一直处于加热状态。
  - 熄火模式：机器处于不加热状态。(温度过冲、未连接手柄、发热芯损坏)
  - 闪烁模式：机器处于恒温状态。
- 5. 烙铁头不沾锡的原因：
  - 烙铁头温度超过400°C/752°F以上，会导致烙铁头氧化。
  - 待使用中的烙铁头沾锡面没给予适当加锡。
  - 在焊接、除锡、修理、补焊等作业中缺少助焊剂。
  - 烙铁头在高锡含量或干燥的海绵以及碎布上擦拭，会导致烙铁头氧化。
  - 接触到有机物，如塑胶料、砂(硅)质油脂及其他化学品。
  - 使用不纯净或低含锡量的焊锡。

- 切勿擅自改动本产品。
- 切勿弄湿电焊台，或手湿时使用本产品。
- 焊接时会冒烟，应保证有良好的通风工作环境。
- 使用本产品时不作任何可能伤害身体或损坏物体的行为。

● 为了确保机器运作正常，请仔细阅读以下内容：

#### ① 一般清理

- 烙铁手柄或电焊台外壳可以使用布沾少量液态清洁剂擦拭。
- 请勿将本产品浸入液体中或让液体流入机器。
- 请勿使用任何溶剂清理机器。

#### ② 烙铁头使用

- 更换烙铁头请使用本公司T900系列。
- 按照以下操作步骤能延长烙铁头使用寿命：
  - 1). 开机使用时，先将温度控制旋钮转至低温位置。
  - 2). 加热达到200°C/392°F，在烙铁头沾锡面加含助焊剂的锡丝。
  - 3). 在200°C/392°F持续加热五分钟后，再将温度控制旋钮，转至所需的温度位置。
  - 4). 到达设定温度后，即可开始使用。

#### ③ 烙铁头维护

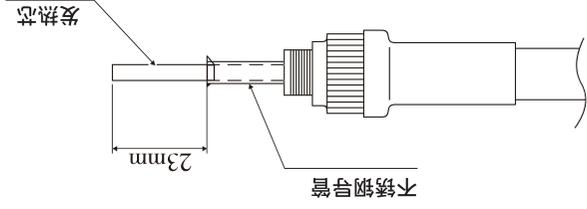
- 关机停用前建议在烙铁头沾锡面加适当量的锡。
- 请勿让烙铁头长时间停留在过高温度，否则易使烙铁头表面电镀层龟裂。
- 在焊接时，请勿以太大的压力摩擦烙铁头中的焊点，此过程并不会改变导热性能，反而会使烙铁头受损。
- 请勿使用粗糙的材料或锉刀清理烙铁头。
- 如果表面已氧化不沾锡，视情况可以用600~800目的金刚砂布小心擦拭，并用异丙醇或适当的溶液清理，加热至200°C/392°F后立即沾锡以防止氧化。
- 请勿使用含氧或酸过高的助焊剂。本产品仅适用合成树脂或已活性的树脂助焊剂。

#### ④ 烙铁头的更换及处理

- 更换烙铁头时务必关闭电焊台电源，并且等待烙铁头冷却至室温。
- 拧开固定螺母，拆下外层套筒，即可取出需要更换的烙铁头。
- 在清除套筒固定处所形成的异物时，请注意避免异物进入到眼睛。

● 安装要素如下图所示：

- 更换发热芯时，应将发热芯拉出不锈钢导管3mm，再锁紧手柄内发热芯螺丝。



△ 注意

- 请勿过度锁紧套筒装置，否则会损坏发热芯。

## ● LED display mode:

- **The LED indicator light is steady on:** Means this device is heating up.
- **The LED indicator light is off:** Means this device is not heating up.(it may mean temperature overshoot, unsuccessfully connecting soldering iron handle or broken heating core.)
- **Flash mode:** Means this device is under constant temperature.

## ● The reason of why solder tip don't stick the tin

- If the temperature of the soldering iron tip exceeds 400°C, it will cause oxidation.
- The tinned surface of the soldering tip to be used has not been properly tinned.
- There is a lack of flux in soldering, tin removal, repair, repair soldering etc.
- Wiping the tip on a high sulfur content or dry sponge or rag can cause the tip to oxidize.
- Exposure to organic matter, such as plastic materials, silicon (silicon) oils and other chemicals.
- Use impure and low-tin solder.

## 05/Maintenance

### ● To make sure machine is working properly, read the following carefully:

#### ● ① Daily clear

- Soldering iron handle or soldering station shell can be wipe with a cloth with a small amount of liquid detergent.
- Do not immerse the product in liquid or allow liquid to flow into the machine.
- Do not use any solvent to clean the machine.

#### ● ② Soldering tip use

- Please use ATTEN T900 series to replace the soldering tip.
- Follow the following steps to extend the service life of the soldering tip.
  - 1) Before switch on, turn the temperature control knob to the low temperature position.
  - 2) After heating up to 200°C/392°F, add tin wire to the surface of soldering tip.
  - 3) After continuous heating at 200°C/392°F for five minutes, turn the temperature control knob to the required temperature position.
  - 4) After reaching the set temperature, is can start to work.

#### ● ③ Soldering tip maintenance

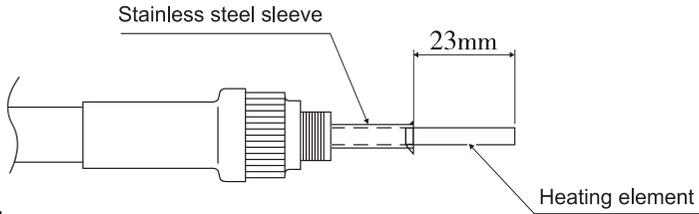
- Before shutdown, it is recommended to add an appropriate amount of tin to the surface of the tip.
- Do not let the tip stay at an excessively high temperature for a long time, otherwise it is easy to crack the electroplating layer on the surface of the tip.
- When soldering, do not rub the solder joints of the soldering tip with too much pressure, this process will not change the thermal conductivity, but will damage the soldering tip.
- Do not use abrasive materials or file to clean the tip.
- If the surface has been oxidized and non-wetting, it can be carefully wiped with 600~800 mesh emery cloth according to the situation, and cleaned with isopropyl alcohol or an equivalent solution. After heating to 200°C/392°F, dip tin immediately to prevent oxidation.
- Do not use fluxes that contain too much chlorine or acidic. This product is only suitable for synthetic resin or activated resin flux.

#### ④ Replacing soldering tips

- Before replacing the soldering tip, be sure to turn off the power and wait until it's cool down to room temperature.
- Unscrew the retaining nut and remove the outer sleeve.
- When removing the formed at the fixed place of the sleeve, please take care to avoid this from entering the eye.

#### Installation method as shown in Figure

- When replacing a new heater, the heater should be pulled out of the stainless steel pipe by 23mm, and then lock the heater screw in the handle.



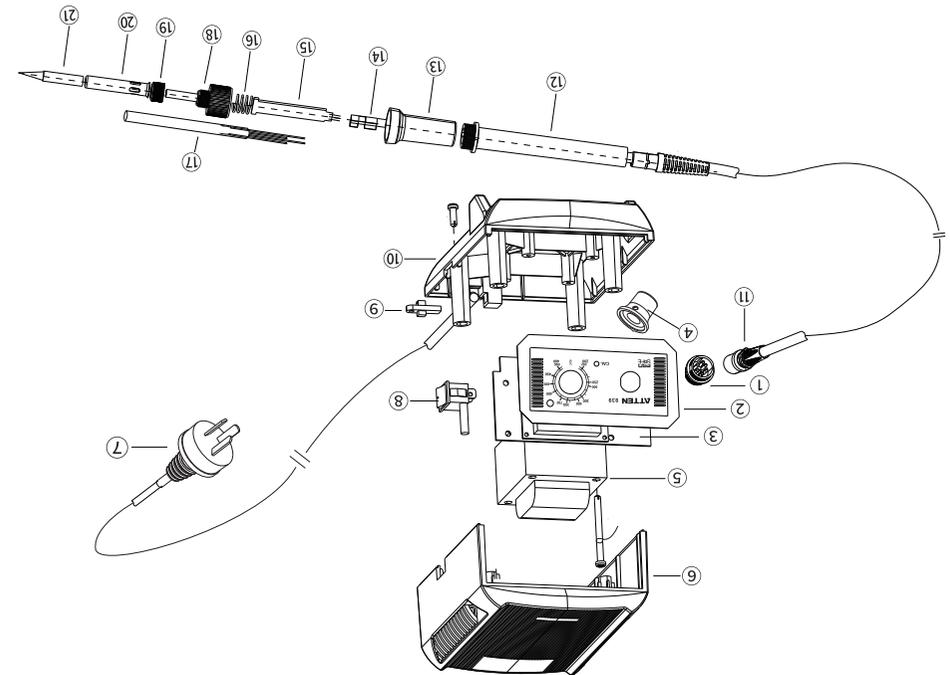
#### ⚠ Attention

- Do not over-lock the sleeve device, otherwise it will damage the heating element.

#### ● 售后服务

- 如果机器故障，或不明原因造成无法正常工作，请联系当地经销商或厂家咨询。
- 售后服务部联系电话：400-998-6633

⑤	变压器	⑥	机器外壳	⑦	主机电源线	⑧	电源开关	⑨	电源压线板	⑩	底壳	⑪	手柄插头线	⑫	手柄筒	⑬	手柄护套	⑭	壳体	⑮	手柄板	⑯	螺母	⑰	发热芯	⑱	胶水接头	⑲	螺母	⑳	钢套	㉑	烙铁头
---	-----	---	------	---	-------	---	------	---	-------	---	----	---	-------	---	-----	---	------	---	----	---	-----	---	----	---	-----	---	------	---	----	---	----	---	-----



本产品经检验符合技术标准，产品合格。

联系人：\_\_\_\_\_

联系电话：\_\_\_\_\_

通信地址：\_\_\_\_\_

产品名称：\_\_\_\_\_

产品类型号：\_\_\_\_\_

出厂编号：\_\_\_\_\_

购货日期：\_\_\_\_\_

用户保修卡

注：本产品返厂维修时，必须附上保修卡，否则将不予以免费维修，谢谢合作。  
凡属产品自身质量问题，凭此卡及购买凭证由本公司负责免费维修。

用户须知

产品保修卡

产品名称：\_\_\_\_\_ 出厂编号：\_\_\_\_\_ 购货日期：\_\_\_\_\_

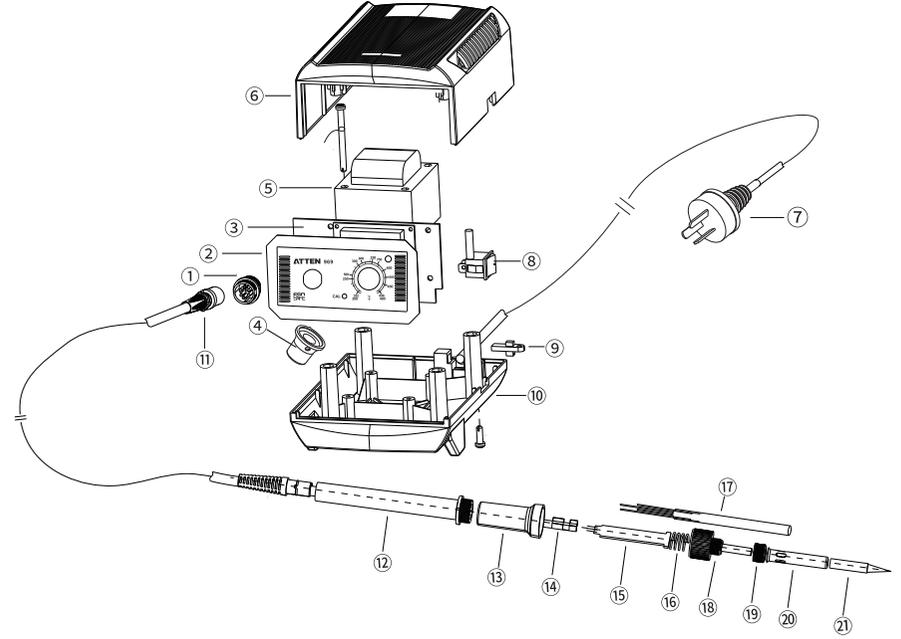
产品类型号：\_\_\_\_\_

- ① 本产品自购买之日起计算保修期，保修期内，正常使用本产品因产品自身质量问题而发生的故障，可根据此保修卡条款的内容，出示保修卡原件在本公司指定授权维修处（或本公司）享受免费服务。请用户保留购买凭证及此保修卡，并在维修时一并出示。
- ② 在保修期内，以下情况将实施有偿维修服务：
  - a. 不能出示有效保修卡或有效凭证；
  - b. 购买产品日期、销售单位名称等项目未完整填写或涂改保修卡；
  - c. 由于未按照使用说明书中所写的使用方法和注意事项操作，而造成的损坏；
  - d. 自然灾害或不可抗力等因素造成的损坏；
  - e. 未经厂家授权而对产品进行拆卸、修理、改装，造成的损坏；
- f. 易损、易耗品更换。
- ③ 保修卡各项目需由代理商或用户直接完整填写清楚，以获得24个月保修期。
- ④ 本保修卡请妥善保管，遗失不补。
- ⑤ 特殊情况双方协商解决。
- ⑥ 最终解释权归本公司所有。

● 保修条例：

产品保修

06/Details of components



①	Iron Socket
②	Front Panel
③	PCBA
④	Temperature Knob
⑤	Transformer
⑥	Top Housing
⑦	Power Cord
⑧	Power Switch
⑨	Power Cord Pressing Board
⑩	Bottom Housing

⑪	Iron Plug
⑫	Iron Handle
⑬	Iron Handle Sleeve
⑭	Heating Element Board
⑮	PCB
⑯	Ground Spring
⑰	Heating Element
⑱	Connector
⑲	Nut
⑳	Stainless Steel Sleeve
㉑	Tip

● After-sales contact

- If the machine fails, or cannot work normally due to unknown reasons, please contact the local dealer or manufacturer for consultation.
- After-sales service department Tel: (+86) 0755-8602 1266.

# Product warranty

## • Warranty regulations:

- ① The warranty period of this product is calculated from the date of purchase. During the warranty period, under the condition of normal use of this product, if the fault occurs due to the quality problem of the product itself, according to the content of this warranty card, you can enjoy free maintenance serve at the authorized repair place designated by the company (or the company) by presenting the original warranty card. Please keep the proof of purchase and this warranty card, and present them together when maintenance.
- ② During the warranty period, paid maintenance services will be implemented in the following situations:
  - a. Failure to provide a valid warranty card or valid certificate.
  - b. Items such as the date of purchase and the name of the sales unit are not completely filled in or the warranty card is altered.
  - c. Damage caused by failure to operate in accordance with the usage methods and precautions written in the instruction manual.
  - d. Damage caused by natural disasters or force majeure.
  - e. Damage caused by dismantling, repairing or modifying the product without the authorization of the manufacturer.
  - f. Replacement of fragile and consumable parts.
- ③ All items of the warranty card must be filled in completely by the agent or user directly to obtain a 24-month warranty period.
- ④ Please keep this warranty card properly, it will not be reissued if it is lost.
- ⑤ In special circumstances, the two parties shall negotiate and deal with it.
- ⑥ The final interpretation right belongs to our company.

### User Notice

The warranty period of this product is valid within 24 months from the date of purchase. For any product quality problem, the company will be responsible for free maintenance with this card and purchase certificate.

Note: When this product is returned to the factory for maintenance, the warranty card must be attached, other wise it will not be repaired for free, thank you for your cooperation (please read the warranty regulations for warranty related instructions)

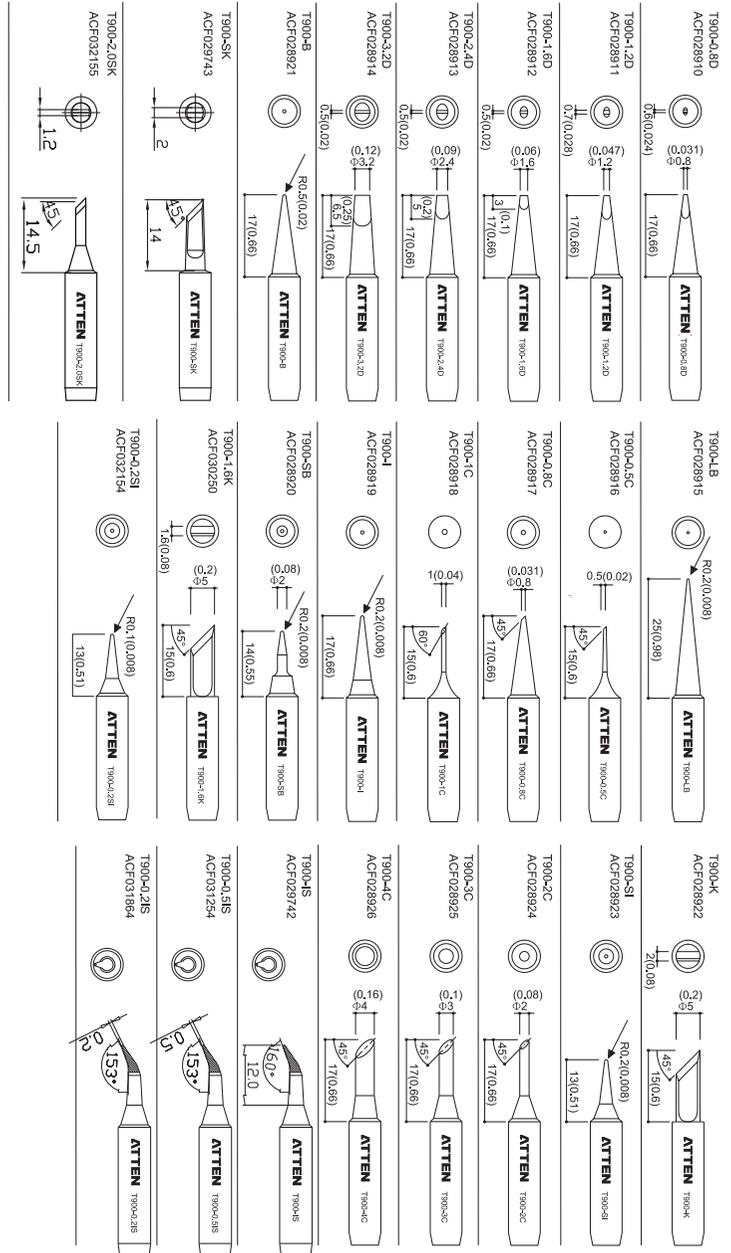
### Product warranty card

Product Model: \_\_\_\_\_ Product No.: \_\_\_\_\_

EX-Factory No.: \_\_\_\_\_ Sold Date: \_\_\_\_\_

This product test result is qualified and met the technical standard.

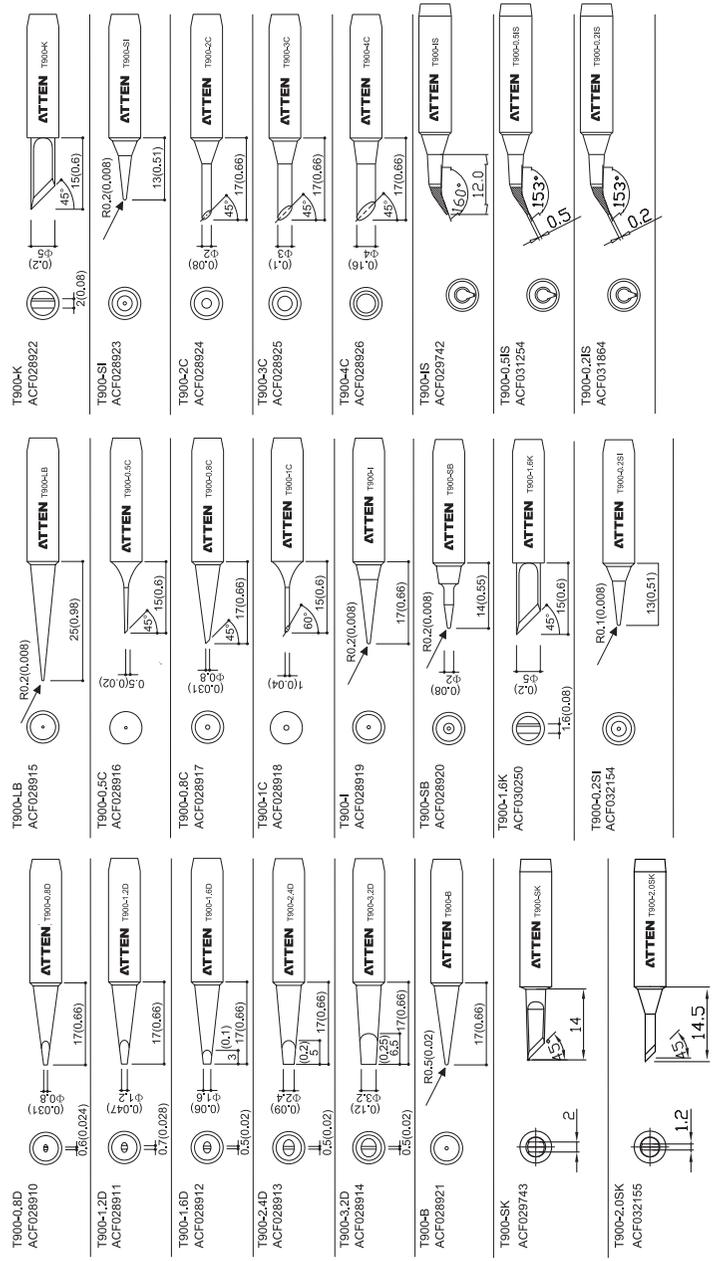
# 附：T900系列电焊台使用烙铁头型号图



T900 型焊铁头外径为6.5

更多烙铁头型号请联系厂家或登录[www.attem.com](http://www.attem.com)获取

### Attachment: Model diagram of soldering iron tip used in T900 series soldering station



□ T900 tip OutDiam φ 6.5

For more soldering iron tips, please contact the manufacturer or visit [www.attn.com](http://www.attn.com)

## SHENZHEN ATTEN TECHNOLOGY CO.,LTD.

---

- Soldering Iron
- Soldering Station
- Hot Air Rework Station
- Multi-function Rework System
- Switching DC Power Supply
- Regulated DC Power Supply
- Solder smoke purify machine
- Programmable Power Supply

## SHENZHEN ATTEN TECHNOLOGY CO.,LTD.

Add: 8 Floor, Building 2, Senyang High-tech Park, No. 7 Road,  
Guangming District, Shenzhen 518132, China

Tel: +86 0755-8602 1389 400-998-6633

Web: [www.atten.com](http://www.atten.com)

Email: [sales@atten.com.cn](mailto:sales@atten.com.cn)

MADE IN CHINA  
CBN036013 (C)

MADE IN CHINA  
CBN036013 (C)

深圳市安泰信科技有限公司  
SHENZHEN ATTEN TECHNOLOGY CO., LTD  
地址: 广东省深圳市光明新区七号路森阳高新科技园2栋8楼  
电话: 0755-8602 1389 (总机) 400-998-6633  
网址: [www.atten.com.cn](http://www.atten.com.cn) (中文) [www.atten.com](http://www.atten.com) (英文)  
邮箱: [sales@atten.com.cn](mailto:sales@atten.com.cn)

- 
- 单支烙铁
  - 恒温电焊台
  - 热风拆焊台
  - 多功能维修系统
  - 直流稳压电源
  - 直流开关电源
  - 可编程电源
  - 焊锡烟雾净化器

深圳市安泰信科技有限公司