



ATAS80 SOLDERING STATION

Instruction Manual





I. FEATURES

- Sleep mode available
 - resulting 10~20 times longer service life
- Quick temperature rise
 - ~2s
- Quick temperature fall
 - better solder quality
 - cleaner soldering tip

II. SOLDERING TEMPERATURE REFERENCE TABLE

A proper tip temperature plays an important role in hand-soldering. The most common mistake made when hand-soldering results from the parts being joined not exceeding the liquidus temperature of solder, resulting in a ‘cold solder’ joint.

Proper soldering temperatures and time for different components are recommended in the Table 1.

Table 1.

Component Name	Soldering Temperature	Soldering Time
High-pin-density IC (Pin pitch <2mm)	350±10°C	≤3s
Low-pin-density IC (Pin pitch ≥2mm)	300±10°C	≤3s
Optical coupler	350±10°C	≤3s
MOSFET	300±10°C	≤3s
Transistor	300±10°C	≤3s
Infrared light tube	300±10°C	≤3s
LED	300±10°C	≤3s
Crystal oscillator	300±10°C	≤3s
Resistor	300±10°C	≤5s
Capacitor	300±10°C	≤5s
Inductor	300±10°C	≤5s

Note: data in Table 1 are for reference only.

III. CAUTIONS

When the power is connected, the tip temperature is between 150°C to 450°C.

For your own safety, please strictly comply with the following cautions:

- Do not touch the metallic parts near the tip.
- Do not use the unit near flammable items.
- Turn off the power supply before replacing parts or performing maintenance.
- During application, do not try to rap the soldering tips to clean or shake off residual solder.



IV. INSTALLATION

1. Connection between the soldering handle and the main body

A. Aim the indication point of the soldering handle knob towards the corresponding point of the plug. See Figure 1.

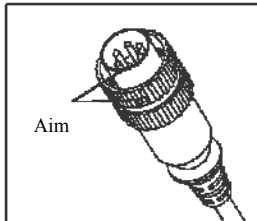


Figure 1

B. Aim the salient point of the plug of the soldering handle with the indent point of the main body socket, then insert and tighten. See Figure 2.

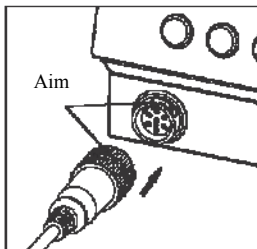


Figure 2

C. Turn the plug knob of the soldering handle clockwise again. See Figure 3.

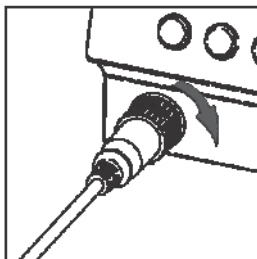


Figure 3

2. Disassembly of the soldering handle from the main body. (removal)

Wring the indication point of the plug knob at the center, and then remove. See Figure 4.

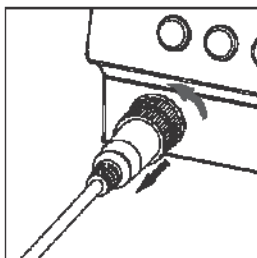


Figure 4



3. Assembly of the heating core with the soldering handle

A. Aim and locate the salient point of the heating core with the sign ‘▲’ on the handle, then insert into the bottom. See Figure 5.

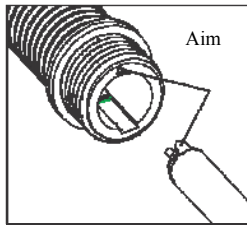


Figure 5

B. Place the nut on the heating core above the screw thread of the handle, and tighten clockwise. See Figure 6.

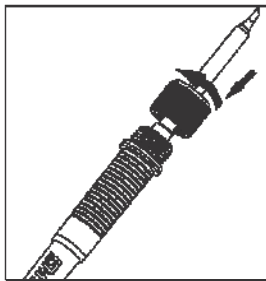


Figure 6

4. Connection between the iron holder, the main body and the grounding wire. See Figure 7.



Figure 7



V. INSTRUCTIONS FOR THE FUNCTION SETTINGS

A. Password setting:

1. press '*' button to enter into 'password setting' mode
2. press '#' to confirm
3. press '▲' '▼' to set the password
4. Press '#' to confirm and enter the unit into locked status.

B. Release locked status:

1. press '*' to enter into 'password setting'
2. press '*' '▼', meantime press '#' for one second
3. release the button '#' and the password will be released

C. Temperature setting:

1. press '*' button twice to enter into 'temperature setting'
2. press '#' to confirm
3. press '▲' '▼' to set the temperature
4. press the '#' to confirm

D. Sleep temperature setting

1. press '*' button three times to enter into 'sleep temperature setting'
2. press '#' to confirm
3. press '▲' '▼' to set sleep temperature

E. Sleep time setting

1. press '*' button four times to enter into 'sleep time setting'
2. press '#' to confirm
3. press '▲' '▼' to set the required value
4. press '#' to confirm

Note: When you will not be using your soldering unit, remember to put the soldering handle into the iron holder. When it reaches the preset sleep time, the temperature will fall automatically to the set sleep temperature. When you are again ready to work, just pick up the soldering handle from the iron holder. The main body will wake up and enter into working status mode.



VI. SPECIFICATION

Table 2.

Model	ATAS80
Power Consumption	80W
Power Supply Voltage	AC110V/AC220V
Temperature Stability	±1°C (no load)
Output Voltage	AC 24V
Impedance between soldering tips and grounding	below 2Ω
Potential between soldering tips and grounding	below 2mV
Password setting range	001~999 (000 no password)
Temperature setting range	150°C ~450°C
Sleep temperature range	50°C (the lowest)
Sleep time setting range	1~60mins (0 = no sleep)



VII.TROUBLE SHOOTING

Table 3.

PHENOMENA	TROUBLE CAUSES	SOLUTIONS
Display 'E01'	Heating core short circuited	Replace a new heating core
	Connector of soldering handle short circuited	Replace a new soldering handle
Display 'E02'	Heating core loosen from handle	Insert heating core into handle in place
	Handle loosen from main machine	Insert handle into main machine in place
	Sensor of heating core open circuited	Replace a new heating core
Display 'E03'	Sensor of heating core short circuited	Replace a new heating core
	Connector of handle wire short circuited	Replace a new handle



VIII. SOLDERING TIP SPECIFICATION

Table 4.

Product model	Reference diagram	Front view	Product model	Reference diagram	Front view
ATAS80-B			ATAS80-3CC		
ATAS80-B2			ATAS80-0.8CF		
ATAS80-B3			ATAS80-1CF		
ATAS80-B4			ATAS80-2CF		
ATAS80-BL			ATAS80-3CF		
ATAS80-4CF			ATAS80-4C		
ATAS80-0.8C			ATAS80-0.8D		



<p>ATAS80-1C</p>	<p>ATAS80-1.2D</p>
<p>ATAS80-2C</p>	<p>ATAS80-1.6D</p>
<p>ATAS80-3C</p>	<p>ATAS80-2.4D</p>
<p>ATAS80-3.2D</p>	<p>ATAS80—K</p>
<p>ATAS80-4D</p>	<p>ATAS80-KS</p>
<p>ATAS8-5.2D</p>	<p>ATAS80-I</p>

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