

# EDSYN<sup>INC</sup>®

## 981C-230

### LONER<sup>®</sup>

## Temperature Controlled Soldering Station

- COMPLIES WITH MIL-S-45743E, MIL-STD-2000-1B, WS6536E AND ESD SPEC, DOD-STD-1686, DOD-HDBK-263



**Instruction manual**

# EDSYN<sup>INC</sup>®



Static Safe



Temp. Regulation Indicator



Digital Panel Meter



Temp. Control Knob



Sponge Holder

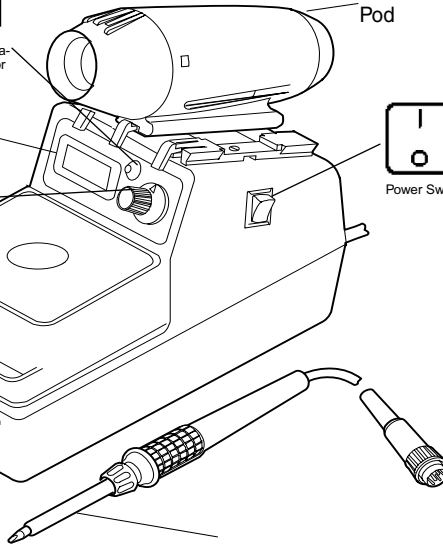


24V

PD528 Tool Pod



Power Switch



Direct Tip-Heater Configuration

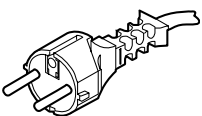
## WARNING:

**DO NOT HIT OR TAP THE SOLDERING TOOL. THE HEATER ELEMENT WILL BREAK!!!**

## DISTINGUISHING FEATURES

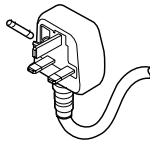
### Power Cord

For 981C-230

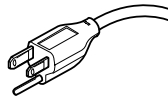


For 981C-230B

13A Fuse inside



For 981C-230I



For 981C-230P

POWER CORD WIRING

BROWN to LINE

BLUE to NEUTRAL

GRN/YEL to GROUND



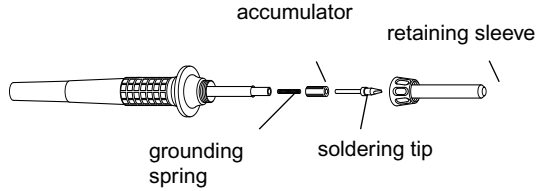
## SPECIFICATIONS

- 230V, 50 Hz, 2.5 lbs. (1.13 kg.)
- 24V, 30W Heater rating
- COMPLIES WITH DOD-STD-2000-1B, MIL-STD-2000A and ESD SPEC. DOD-STD 1868, DOD-HDBK-263
- TEMP. RANGE: 400°F - 800°F (205°C - 427°C)
- TEMP. REGULATION: ±6°F (±3°C)

# REPLACING TIPS

## CHANGING TIP for 981

1. MAKE SURE YOUR TOOL IS COOL!
2. Turn Retaining Sleeve counter-clockwise to remove.
3. Remove old Soldering Tip.
4. Insert new Tip.
5. Install Retaining Sleeve.



## General Purpose Soldering Tips

Iron Plated for long life-Nickel and Chrome Plated for optimum heat transfer.

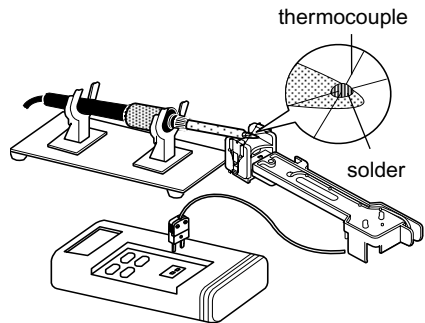
EDSYN has over a 100 varieties of standard and custom-made Tips. CONTACT EDSYN FOR MORE SELECTIONS.



	Part No. & Description	a	b
	LT374 Standard Probe	.03 (0.8 mm)	.48 (12.2 mm)
	LT375 Standard Spade	.06 (1.5 mm)	.48 (12.2 mm)
	LT376-7 SMD Channel	.12 (3.0 mm)	.48 (12.2 mm)
	LT392 Extra-Long Needle	.02 (0.5 mm)	1.13 (28.8 mm)
	LT394 Extra-Long Spade	.07 (2.0 mm)	.93 (23.6 mm)
	LT399 Large Face	.17 (4.3 mm)	.49 (12.4 mm)
	LT444 SMD Mid-Length Fine Spade	.04 (1.0 mm)	.78 (19.8 mm)
	LT446 SMD Probe	.03 (0.8 mm)	.48 (12.2 mm)
	LT382 Long Cone	.02 (0.5 mm)	.62 (15.6 mm)
	LT395 Mid-Length Stubby Spade	.09 (2.3 mm)	.74 (18.8 mm)
	LT431 Mid-Length Spade	.07 (1.8 mm)	.74 (18.8 mm)
	LT439 SMD Thin Probe	.03 (0.8 mm)	.50 (12.7 mm)
	LT439-1 Same as LT439, Angled		
	LT445 SMD Angle Face	.03 (0.8 mm)	.48 (12.2 mm)

## CALIBRATION SET-UP USING MS412

1. Install desired Soldering Tip.
2. Turn on power and set Temperature Control Knob to 400°F (205°C).
2. Apply a small amount of solder on the Tip, just enough to form a bead on top of the Tip.
3. Place the center of the thermocouple wire of the SDS100 on top of the bead.
4. Again, apply a small amount of solder on the center of the thermocouple wire, just enough to embed the center.

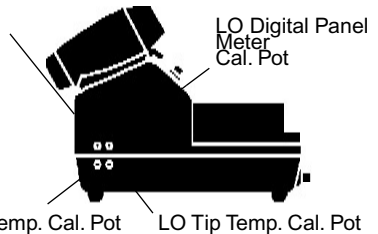


## TEMPERATURE CALIBRATION

AIR MOVEMENT WILL AFFECT THE TEMPERATURE READING. WORK IN AN AREA WHERE THERE IS MINIMUM AIR MOVEMENT.

1. Do "calibration set-up using MS412" procedure (above)
2. Set Temp. Control Knob to MIN.
3. Adjust LO Tip Temp. Cal. Pot so the Digital Panel Meter will read 385°F (196°C).
4. Set Temp. Control Knob to MAX.
5. Adjust HI Tip Temp. Cal. Pot so the Digital Panel Meter will read 825°F (441°C).
6. Set Temp. Control Knob to MIN.
7. Adjust LO Digital Panel Meter Cal. Pot so the Digital Panel Meter will read 385°F (196°C)
8. Set Temp. Control Knob to MAX
9. Adjust HI Digital Panel Meter Cal. Pot so the Digital Panel Meter will read 825°F (441°C)

HI Digital Panel Meter Cal. Pot

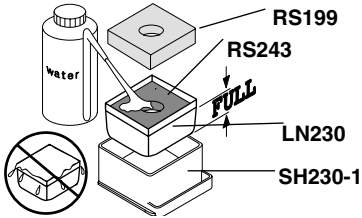


# 981C-230 instruction manual

## MAINTENANCE

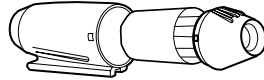
### • Replace RS199 Cleaning Sponge

1. Fill water only up to the top of the RS243 Leveling Pad.
2. Depress RS199 to moisten it completely.



### • Replace SC581 Solder Collector

1. Hold the Housing firm and turn Cap counter-clockwise and pull it away from the Housing.
2. Remove used SC581 and replace with a new one.
3. Reassemble Pod with TOP of the Cap in proper position.



**SR042**  
Thermal  
Housing

**SC581**  
Solder Col-  
lector

**SR043**  
Front Hous-  
ing

### CAUTION:

Over-filling can cause thermal shock to the tip or heating element during tip cleaning.

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