



HD937b

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# SOLDERING STATION

**Thermo-control Anti-Static**

**User's Manual**

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## Precautions

In this instruction manual, “**WARNING**” and “**CAUTION**” are defined as follows.

### CAUTION!

*Before use this unit, make sure comply with the following measures, against risk of electric shock or give rise to fire.*

*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.*

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 product near flammable items.
- Advise other people in the work area: the unit 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 rap the soldering iron against the workbench to shake off residual solder, or otherwise subject the iron to severe shocks.

- Do not modify the unit.
- Use only genuine SKY TOPPOWER replacement parts.
- 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.

### WARNING!

**CAUTION:** *Misuse may potentially cause injury to the user or physical damage to the objects involved. For your own safety, be sure to comply with these Precautions.*

## Packing list

**Please check the contents of the HD936b package and confirm that all the items listed below are included.**

Station	1pcs
Soldering Iron ( 907)	1pcs
Iron Holder (With Cleaning Sponge)	1pcs
Instruction Manual	1pcs

## Specification

Power Voltage	AC(100V/110V/120V   220V/230V/240V) 50/60Hz(Optional)
Power Consumption	50W
Temperature Range	200 ~ 480°C
Tip Leakage Voltage	<5mV
Standard Tip	900M



## Maintenance

### 1. Inspect and Clean the Tip

**CAUTION:** *Never file the Tip to remove oxide.*

- Set the temperature to 250°C (482°F).
- When the temperature stabilizes, clean the tip with the cleaning sponge and check the condition of the tip.
- If there is black oxide on the solder-plated portion of the tip, apply new solder (containing flux) and wipe the tip on the cleaning sponge.  
Repeat until the oxide is completely removed. Coat with new solder.
- If the tip is deformed or heavily eroded, replace it with a new one.

### 2. Calibrating the Iron Temperature

*The soldering iron should be recalibrated after changing the iron, or replacing the heating element or tip.*

- Connect the cord assembly plug to the receptacle on the station.
- Set the temperature control knob to 400°C (750°F).
- Turn the power switch to “ON” and wait until the temperature stabilizes. Remove the CAL pot plug.
- When the temperature stabilizes, use a straightedge (–) screwdriver or small plus (+) screwdriver to adjust the screw (marked CAL at the station) Until the tip thermometer indicates a temperature of 400°C (750°F). Turn the screw clockwise to increase the temperature and counterclockwise to reduce the temperature. Replace the CAL pot plug.

### 3. Tips

The tip temperature will vary according to the

Shape of the tip. The preferred method of adjustment uses a tip thermometer (See “Calibrating the Iron Temperature”).

## Troubleshooting Guide

### WARNING!

*Disconnect the power plug before servicing. Failure to do so may result in electric shock.*

*If the power cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified person in order to avoid personal injury or damage to the unit.*

#### Problem 1.

**The heater lamp does not light up.**

[Check 1.]

*Is the power cord and/or connecting plug disconnected?*

- Connect it.

[Check 2.]

*Is the fuse blown?*

- Determine why the fuse blew and eliminate the cause, then replace the fuse.
  - a. *Is the inside of the iron short-circuited?*
  - b. *Is the grounding spring touching the heating element?*
  - c. *Is the heating element lead twisted and short-circuited?*

#### Problem 2.

**The heater lamp lights up but the tip does not heat up.**

[Check 3.]

*Is the soldering iron cord broken?*

- Refer to “Checking for breakage in the cord assembly.”

[Check 4.]

*Is the Heating Element broken?*

- Refer to “Checking for breakage in the heating element.”

#### Problem 3.

**The tip heats up intermittently.**

[Check 3.]

#### Problem 4.

**The tip is not wet.**

[Check 5.]

*Is the tip temperature too high?*

- Set an appropriate temperature.

[Check 6.]

*Is the tip clean?*

- Refer to 'Tip Care and Use'.

#### Problem 5.

**The tip is not wet.**

[Check 7.]

*Is the tip coated with oxide?*

- Refer to “Insect and clean the tip”.

[Check 8.]

*Is the iron calibrated correctly?*

- Recalibrate.

#### Problem 6.

**The tip cannot be pulled off.**

[Check 9.]

*Is the tip seized?*

*Is the tip swollen because of deterioration?*

- Replace the tip and the heating element.

#### Problem 7.

**The tip doesn't hold the desired temperature**

[Check 8.]