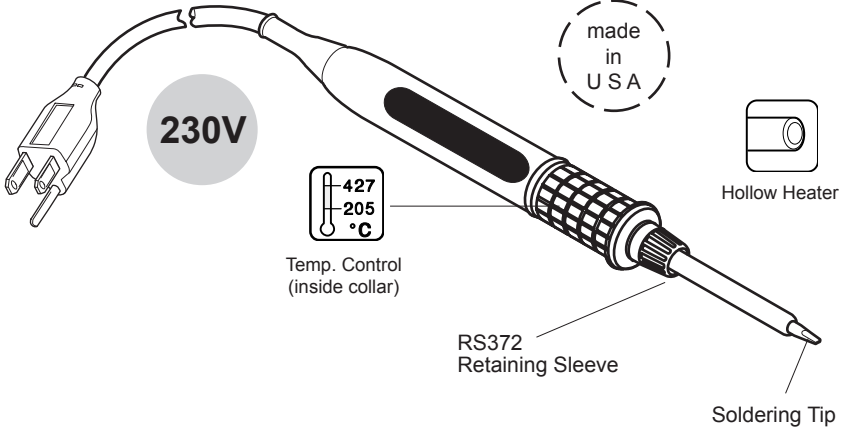


EDSYN^{INC}®

CL1280I LONER[®] Temperature Controlled SOLDERING INSTRUMENT

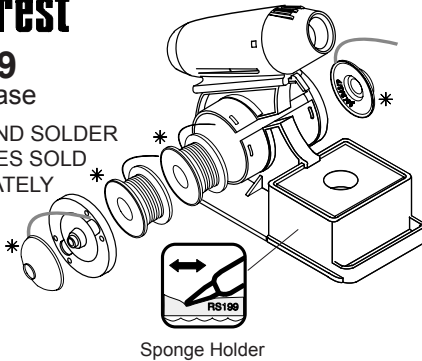
- 230V, 50/60Hz, 70W, 5 Oz (142 gm)
- TEMP. RANGE: 400°F - 800°F (205°C - 427°C)
- TEMP. REGULATION: ±6°F (±3°C)
- TIP TO GROUND LEAKAGE: < 2MV
- TIP TO GROUND RESISTANCE: < 2 OHMS
- COMPLIES WITH DOD-STD-2000-1B, MIL-STD-2000A and ESD SPEC. DOD-STD 1868, DOD-HDBK-263



idle-rest

IP329 Tool Base

WICK AND SOLDER
SUPPLIES SOLD
SEPARATELY

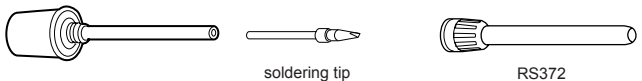


TIP CARE

1. Plug-in Tool. Set to desired temperature. (Blinking lamp means set temperature is reached.)
2. TIN the Tip (apply solder) before soldering.
3. Do not rub, bend or file Tip.
4. Always clean the Tip by wiping it against the saturated sponge, then re-tin.
5. ALWAYS RE-TIN THE TIP BEFORE AND AFTER USING.

CHANGING TIP

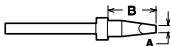
1. MAKE SURE YOUR TOOL IS COOL!
2. Turn RS372 counter-clockwise to remove.
3. Remove old Soldering Tip.
4. Insert new Tip.
5. Install RS372. (should be "finger" tight only.)



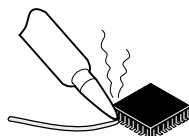
SOLDERING TIPS

Iron Plated for long life • Nickel and Chrome Plated for optimum heat transfer

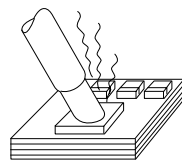
CONTACT EDSYN FOR MORE SELECTIONS



			a	b
	LT374	Standard Probe	.03 (0.8 mm)	.48 (12.2 mm)
	LT375	Standard Spade	.06 (1.5 mm)	.48 (12.2 mm)
	LT392	Extra-Long Needle Point	.02 (0.5 mm)	1.13 (28.8 mm)
	LT394	Extra-Long Spade	.07 (2.0 mm)	.93 (23.6 mm)
	LT446	SMD Probe	.03 (0.8 mm)	.48 (12.2 mm)
	LT373BC	Heavy Duty Terminal Spade	.10 (2.5 mm)	.74 (18.8 mm)
	LT223BC	Heavy Duty Fine Spade	.06 (1.5 mm)	1.21 (30.7 mm)
	LT222BC	Extra long Needle Point	.04 (1.0 mm)	1.21 (30.7 mm)
	LT153BH	Jumbo Spade	.20 (4.9 mm)	.93 (23.6 mm)
	LT155BH	Jumbo Angle Spade	.32 (8.3 mm)	.97 (21.1 mm)



Fine point tip for SMD soldering.

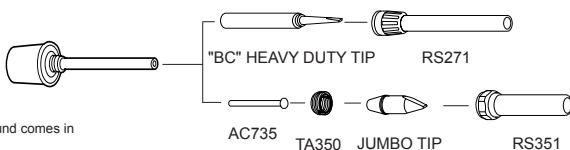


Large and heavy tip for heavy duty soldering.

SET-UP & REQUIRED ACCESSORIES FOR HEAVY DUTY AND JUMBO TIPS

Apply AN112 or AN122* Anti-Seize Compound to Heater and area of Tip contact.

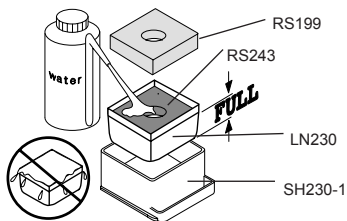
*AN122 Anti-Seize Compound comes in syringe dispenser.



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.

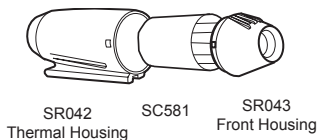


CAUTION:

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

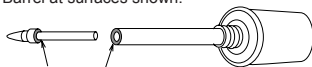
• Replace SC581 Solder Collector

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.

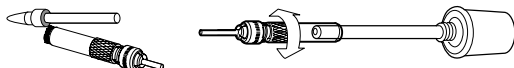


TIP CLEANING To maintain proper Tip to Ground resistance.

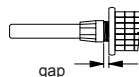
1. Remove Tip from Heater Assembly.
2. Using a ST707 Soldering Tool Maintenance Brush, clean Tip and Heater Barrel at surfaces shown.



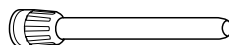
clean these areas



3. Install the tip and tighten RS372 Retaining Sleeve. Take note of the gap to ensure proper fitting.



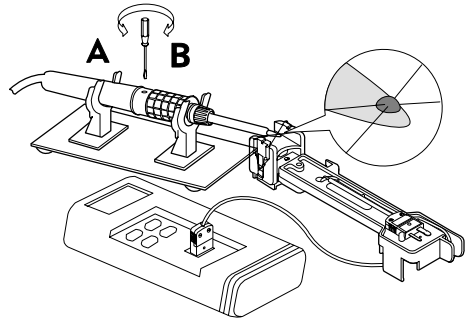
If there is no gap, try replacing the RS372 Retaining Sleeve.



TEMPERATURE ADJUSTMENT

YOU WILL NEED THE MS412 TEMPERATURE CALIBRATION SYSTEM TO MONITOR TEMPERATURE.

1. Loosen RC334 to expose Temp. Control Screw.
2. Using a clean and well-tinned tip do set up according to illustration so that the thermocouple wire is hanging on the tip.
3. Apply a small amount of solder on the Tip, just enough to form a solder bead on top of the Tip. Place the center of the thermocouple wire on top of the solder bead.
4. Again, apply a small amount of solder on the center of the cross wire, just enough to embed the center.
5. Turn Temp. Control Screw clockwise to increase temperature or counter-clockwise to decrease temperature.
6. Tighten RC334.

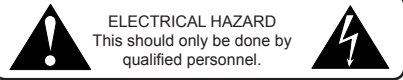


TEMPERATURE CALIBRATION

AIR MOVEMENT WILL AFFECT THE TEMPERATURE READING.

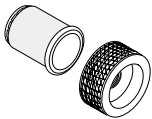
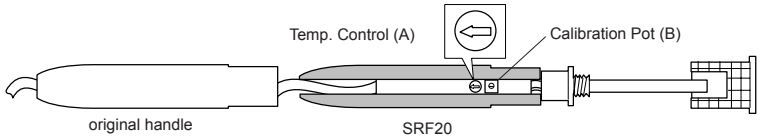
WORK IN AN AREA WHERE THIS IS MINIMUM.

1. Use the SRW01 to pull out heater assembly, PCB & power cord from handle. Leave enough power cord slack to install SRF20.
2. Place heater assembly, PCB & power cord inside SRF20. Install tip that is clean and well tinned.
3. With the use of the MS412 Temperature Calibration System. Follow set-up shown below.
4. Plug in tool and by using the Pot Adjustment Tool supplied, turn Temp. Control (A) to "solder-melt" temperature.
5. Apply a small amount of solder on the Tip, just enough to form a solder bead on top of the Tip. Place the center of the thermocouple wire on top of the solder bead.
6. Again, apply a small amount of solder on the center of the cross wire, just enough to embed the center.
7. Turn Temp. Control (A) fully clockwise. Adjust Calibration Pot (B) until reading stabilizes at 800°F.
8. Assemble unit in original handle.

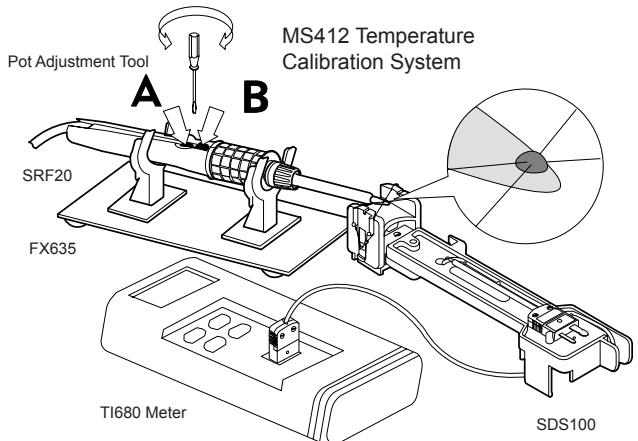


Tools Needed

- SRW01
- SRF20
- MS412
- Pot Adjustment Tool



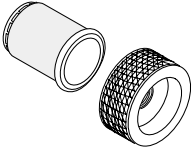
SRW01



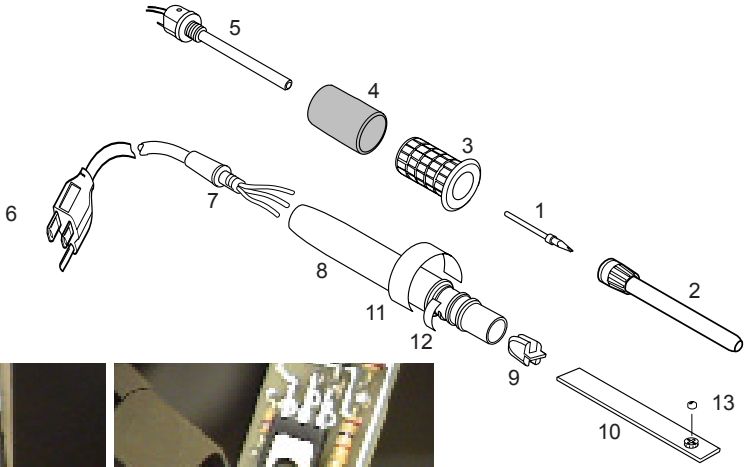
CL1280I LONER® Soldering Instrument, 230V

Spare Parts List

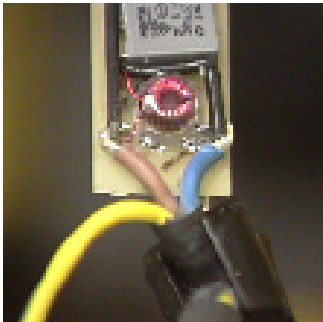
Disassembly of this Tool will require the use of **SRW01** Heater Removal Tool.



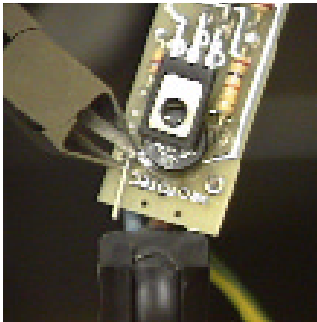
ITEM	PART NO.	DESCRIPTION	QTY
1	LT375	LONER®Standard Spade Soldering Tip	1
2	RS372	Retaining Sleeve Assembly (RS382 & RB386)	1
3	RC334	Retaining Collar	1
4	SR081	Foam Grip, Vinyl	1
5	SR076	Heater Assy. 230V, 95W	1
6	SR028	Power Cord Assy. 230V for CL1280I	1
7	SR171	Boot, for Power Cord	1
8	SR172	Handle, Model 920	1
9	SR032	Strain Relief, For Tool Cord	1
10	SR079	Circuit Board Assy., 230V	1
11	SR338	Label, Wrap-around	1
12	SR320	Label, Calibration	1
13	SR322	Spacer, Temp. Adjustment, For Control Pot	1



**POWER CORD
& PCB HOOK-UP**



Solder power cord to capacitor leads.



Cut off excess capacitor leads AFTER soldering.



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Property



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