

**Portable Solder Feed Iron  
with Constant Temperature**

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# **OPERATION GUIDANCE**

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**Circuit Specialists CSI929D-II  
English**

Thank you for choosing this product. Please read the operation guidance thoroughly before use and keep it for future reference.

## 1. Product Features

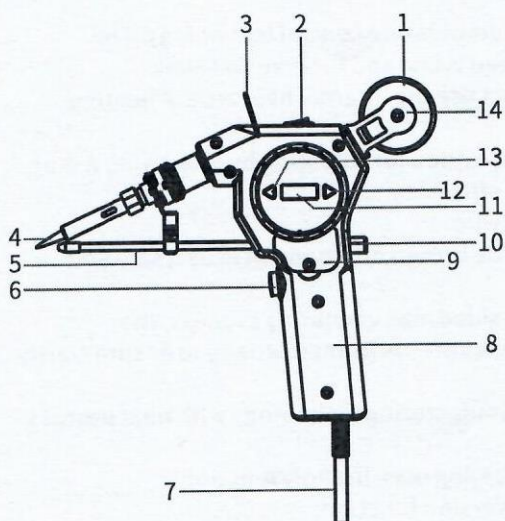
1. Using PID program-controlled temperature control technology. The temperature compensation speed is fast and the error is small.
2. High efficiency since this product use the internal heat type of heating element.
3. Solder Feed Iron which can be operated for soldering by one-hand, it is of comfort, convenience and high efficiency.
4. Simply to replace the solder tin wire.
5. With a power switch, which can be turned off when not in use, safe and energy efficient.
6. The internal use of SMT double-sided manufacturing process, the components installation processes are performed orderly to ensure clarity of electric signal flow.
6. Apply the SMT double-panel manufacturing technology with neat process and solid joints
7. The machine design has the following user-friendly functions:
  - A. with Fahrenheit / Celsius conversion function:

This temperature display mode designed to meet the needs of different markets, you can make choice according to your customary or interest.
  - B. 10 minutes sleep function:

The "SLP" is displayed as a sleep state prompt.
  - C. Digital temperature correction function:

It is suitable for the temperature deviation of the soldering iron from the display due to environmental influences or replacement of heating elements such as heater cores and soldering iron tips. It can be corrected by this function.

## 2. Schematic Diagram



1. Solder tin wire
2. Power switch
3. Hook
4. Soldering iron tip
5. Tin tube
6. Feed tin switch
7. End of the line
8. The handle case
9. Repair / disassembly piece
10. Tin pole
11. Temperature display
12. Temperature plus button
13. Temperature minus button
14. Solder tin frame

## 3. Instructions

### Operating Instructions

1. Install the solder wire on the soldering stand.
2. Clip the solder tin frame into the handle shell.
3. Pressing the tin pole, pull out the solder wire and thread the solder wire into the tin pole until the solder tin wire is exposed.
4. Connect the power and turn on the power switch.
5. If the tip is used for the first time, set the temperature to 300°C(572°F) in seconds. After the temperature rises to 300°C(572°F), apply tin on the soldering iron to prevent high temperature oxidation of the soldering iron tip.
6. Set the required temperature. After the temperature is constant, press the tin feed switch to send the tin and perform the soldering work.



1. Press and hold the temperature minus button, turn on the power switch and the display shows "F" for the Fahrenheit display system.

#### Fahrenheit/Celsius conversion settings

### 4. Function Setting Instruction

1. The soldering tip temperature exceeds  $400^{\circ}\text{C}$  ( $752^{\circ}\text{F}$ ) and remains unused for a long time.
2. The tin solder surface of the soldering iron to be used is not given proper tin.
3. Lack of flux in soldering, de-soldering, repair, repair welding and other operations.
4. The iron tip should be wiped with high sulfur content or dry sponges and rags.
5. Exposure to organic substances such as: plastic materials, tantalum (silicone) oils or other chemicals.
6. Use impure solder with low tin content.

#### The reason why tin does not stick to tin

The general use temperature should not exceed  $380^{\circ}\text{C}$  ( $716^{\circ}\text{F}$ ). If you need to use a higher temperature, please use it in the shortest possible time.

#### Notice

1. Unscrew the screw of the solder tin frame, put the solder wire into the solder tin frame (note the direction of the solder tin wire), and then tighten the screw.
2. Pressing the tin pole, pull out the solder wire and thread the solder wire into the tin pole until the solder tin wire is exposed then release the tin pole.

#### Install of solder tin wire

7. After the work is finished, turn off the power switch, the power cord should be unplugged if the soldering iron is not used for a long period of time.

2. Press the temperature plus or minus button to set the Fahrenheit or Celsius display.
3. After the operation is stopped for 5 seconds, the program exits the setting state and saves the data, then the setting is completed.

#### ● **Digital temperature correction**

1. Turn on the power switch. After the temperature is constant, press and hold the temperature plus or minus button for 2 seconds then the "CAL" will be flashed on the display.
2. Press the temperature plus or minus key to input the temperature tested with the thermometer. Press the temperature plus or minus button for confirm. The program exits the setting state and saves the data. The setting is completed. If the temperature still has a slight deviation, the correction can be repeated.

### ● **5.Care & Maintenance**

Please pay attention to the following to ensure the thermostat soldering iron can operate normally (If the soldering iron or temperature control is not in good work, please contact your nearest Service Center).

#### ● **General Cleaning**

1. In the event of a power failure, the iron handle can be cleaned with a cloth and a small amount of liquid detergent.
2. Do not allow liquid to flow into the handle case
3. Do not use any solvents to clean the casing.

#### ● **New Soldering Iron Tip**

1. When replacing the soldering iron tip, please use the model specified by the manufacturer.
2. When using a new soldering iron tip, please follow the steps below to extend its life.
  - A. Set the temperature to 200°C (392°F), turn off the iron and replace it



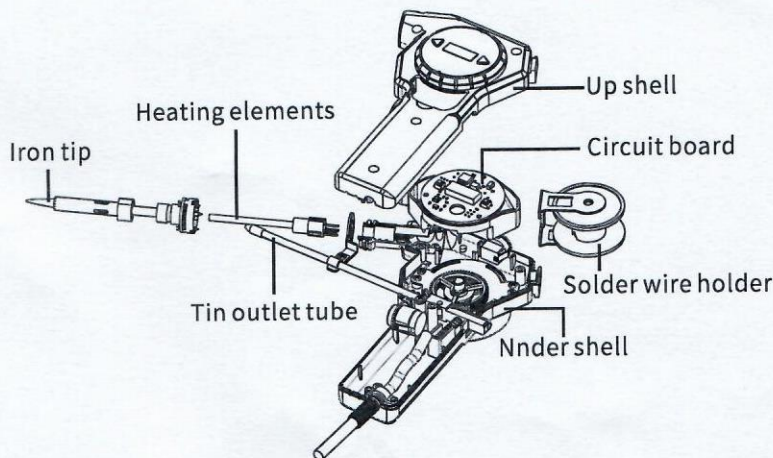
B. After heating to 200°C (392°F), add solder flux to the tip of the soldering iron.

C. Set the proper temperature, and after the temperature is constant, you can start using it.

#### ● Slightly oxidized tip

1. Set the temperature to 300°C.
2. Rub soldering iron tip with cleaning ball to clean oxide layer after the temperature is constant
3. After cleaning the oxide layer, put tin on the tip and rub the tip again and again with the cleaning ball until the tip can be attached on it.

## ● 6. Diagram of disassembly and assembly



**Statement: The company reserves the right to improve and upgrade products,  
product specifications and design are subject to change without notice.**

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