



# SOLDERING GUN INSTRUCTION SHEET

## Safety Instructions

- Toxic chemicals contained in some solders and flux can cause respiratory illness when inhaled. Work in a well ventilated area with a fan to move the air, or wear a NOISH approved respirator.
- Toxins can be absorbed through cuts, sores, eyes, mouth, and nostrils. Bandage cuts or sores before soldering. DO NOT eat, drink, or smoke while soldering. Wash your hands with soap and water when finished.
- Solder melts at 375° F (190° C) and the soldering gun bit will reach temperatures up to 450° F (230° C). Wear eye protection, gloves, long pants, and a long sleeve shirt to protect eyes and hands from burns and skin rashes.
- DO NOT touch the soldering gun tip until it has completely cooled. DO NOT allow the soldering gun tip to rest against anything. When hot, it will burn whatever it touches.
- Avoid touching the workpiece. The workpiece can heat up and cause burns. When working with small parts, use a soldering work stand, hold the part with pliers, or use a heat sink.
- Keep the solder, flux, and soldering gun out of the reach of children and pets.

## WARNING

**Solder and flux contain toxic chemicals and can cause respiratory illness. Work in a well ventilated area with a fan to move the air, or wear a NOISH approved respirator.**

## To operate the soldering gun:

1. Plug the soldering gun into a 110V power outlet and pull the trigger for 6-8 seconds to allow the gun to heat up. **Note:** *Holding the trigger constantly will cause the gun to overheat and shorten the lifespan of the soldering gun.*
2. Prepare the tip by applying a small amount of solder to the tip, then spread the solder with a wet sponge until the solder forms a thin film.
3. Prepare the items to be soldered by brushing on flux if using non-rosin core solder.
4. Pull the trigger, apply more solder to the tip, then heat both items equally by touching the soldering tip to them for a few seconds.
5. Feed the solder into the joint. It will melt and flow into and around all the parts and areas that are above the melting point.
6. Remove the solder, then the soldering gun.

**Tips:** Insufficient solder on the iron causes poor heat transfer to the joint, resulting in a weak mechanical and electrical bond. Too much solder results in strings of solder causing bridges to other contacts. A good soldered joint should be smooth, shiny, and completely surround the joint.

## To replace the soldering tip:

1. Unplug the soldering gun and wait until the soldering gun tip has completely cooled.
2. Loosen the nuts securing the soldering tip, and pull to remove it.
3. Slide in the replacement soldering tip and tighten the nuts.

*If you need additional help with this your soldering gun, call our Tech Support at: (570) 546-9663.*

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