1. SAFETY MARK DEFINITIONS

In this manual, the following safety marks are used.

WARNING
Failure to obey a safety warning could result in serious injury or death to yourself or to others, or other damages.

CAUTION
Failure to obey a safety warning could result in injury to yourself or to others, or other damages.

NOTE
A note or word of advice.

2. FOR SAFE OPERATION

1. Handle with care to avoid burning yourself. Be sure that the tip has sufficiently cooled down before set-up.
2. Do not insert the switch plug anywhere except the goot solder feeder jack.
3. Do not touch the solder nozzle, guide pipe, or other metal parts, to prevent personal injury or burning yourself.
4. Use the correct tube size to prevent solder clogs.
5. To prevent solder clogs, do not hold the tube. Also, follow the minimum bend radius.

3. SPECIFICATIONS

4. PACKAGE CONTENTS / NAMES OF PARTS

3. I. SAFETY MARK DEFINITIONS

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3. SPECIFICATIONS

5. SETTING

5-1 SETTING TO RX-80GAS/RX-85GAS
1. Remove the screw shown below, and take off the adapter ring, turning it counter-clockwise.
2. Pull off the grip rubber, and attach the tube assy there. Reassemble the adapter ring and fix the screw again.
3. Attach the soldering iron tip.

5-2 SETTING TO RX-72GAS
1. Slide the grip rubber in the direction of the arrow.
2. Remove three screws (shown below) and open the grip housing.

5-3 HOW TO SET THE FRONT OPENING OF THE IRON STAND

Take off the front opening of ST-21/27. Put on the PD-100TA front opening instead.

6. HOW TO USE

Push the feeder switch of the PD-100TA and feed the solder.
For details, please refer to the PD-100TA OPERATION MANUAL.

7. MAINTENANCE

Flux blocking-up the nozzle tip may result in solder clogs. If solder clogs occur frequently, disassemble the nozzle/guide pipe and clean inside.

The Teflon tube delivers the solder to the nozzle tip. When claps/buckling/damages occur in the Teflon tube, please replace it.

7-1 SOLDIER NOZZLE / GUIDE PIPE
Clean any stains and flux residue etc. inside with the brush or wire. If too badly clogged, please buy new nozzle and pipe.

7-2 HOW TO REPLACE THE TEFLON TUBE
1. Remove the screws that hold the joint plate. Then, at the solder receiving end, unscrew the white plastic tip.
2. Push the Teflon tube as shown below. It will come out the other end. Just pinch and pull it out.
3. Reassemble, reversing these steps.

8. REPLACEMENT PARTS / OPTION

SOLDERING IRON TIP:

Grip Rubber

Adapter Ring

Soldering Iron Tip

GUIDE PIPE:

RX-80GAS
RX-85GAS
FD-100P-85
FD-100P-80
FD-100TA-1.0
FD-100TA-1.2
FD-100TA-1.6
FD-100P-1.0
FD-100P-1.2
FD-100P-1.6
FD-100TA-1.0
FD-100TA-1.2
FD-100TA-1.6

TEFLON TUBE:

FD-100N-0.6
FD-100N-0.8
FD-100N-1.0
FD-100N-1.2
FD-100N-1.6
FD-100N-1.8
FD-100P-0.6
FD-100P-0.8
FD-100P-1.0
FD-100P-1.2
FD-100P-1.6

TUBE ASSY:

FD-100TA-1.0/1.6
FD-100TA-2.0/2.6
FD-100P-1.0/1.6
FD-100P-2.0/2.6

5-3 HOW TO SET THE FRONT OPENING OF THE IRON STAND

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6. HOW TO USE

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For details, please refer to the PD-100TA OPERATION MANUAL.