

**iroda**



**SOLDERPRO™ 120K**  
Premium Butane Soldering Iron Kit

**Instruction Manual**

READ INSTRUCTIONS AND WARNINGS BEFORE USE

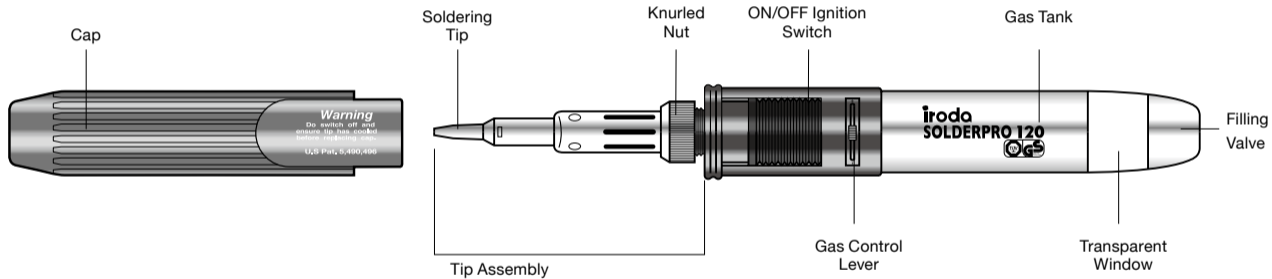
## IMPORTANT SAFETY INSTRUCTIONS

### Warnings:

- Unit uses flammable gas (Butane) under pressure – use with care.
- DO NOT expose to heat above +50°C (120°F) and avoid prolonged exposure to the sun.
- DO NOT puncture or incinerate.
- DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials.
- Keep work area clean. Cluttered areas and benches invite injuries.
- KEEP AWAY FROM CHILDREN. Visitors should be kept away from work area.
- Store in dry, locked cabinet out of reach of children.

- Be extremely careful as torch flame tip temperature is over 1300°C (2400°F)
- Be extremely careful as torch flame is almost invisible in daylight or under strong light.
- Use Safety Glasses.
- Do not touch the heated tip of the unit.
- DO NOT leave unit unattended when operating or hot.
- Always be sure unit is cool before storing.
- DO NOT replace cap without switching unit off and ensuring tip has cooled.
- If your torch malfunctions do not try to repair. Contact your dealer or online support for help.
- Butane-Propane mix or other fuel could create much higher temperatures and cause flare-up at the tip exhaust slots.

## DESCRIPTION



## HOW TO USE THE SOLDERPRO 120K

### REFILLING

Fig.1

- Use only high-quality butane gas.
  - Refill in a well-ventilated area away from any ignition source and other people.
1. Hold butane canister upside down when filling (Fig.1)
  2. Firmly press canister nozzle into **Gas Filling Valve**.
  3. Release canister when gas starts to overflow.  
(Gas overflow during refilling is normal and does not indicate a leak)
  4. Wait for a few minutes before use.

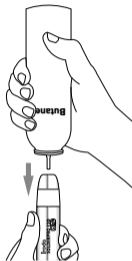


Fig.1

### IGNITION

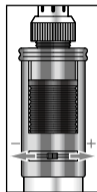


Fig.2

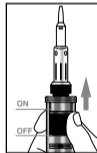


Fig.3

1. Set **Gas Control Lever** at mid position. (Fig. 2)
2. **Slowly** slide up the **ON/OFF Ignition Switch** (Fig. 3) to the "ON" position to start the flow of gas.
3. As gas is flowing, continue sliding the **Ignition Switch** toward the tip till you hear a click. The automatic ignition will light the gas.
4. Release the switch and it will automatically move back to the "ON" position.
5. The tip housing will start to glow red. If not, slide the **ON/OFF Ignition Switch** back to the "OFF" position and repeat steps 2 and 3.
6. To turn off, slide the **ON/OFF Ignition Switch** downward to the **OFF** position.

## IGNITION WARNINGS

- Do not touch Tip, Tip Housing or Knurled Nut while igniting. (Fig. 4)
- Do not ignite torch when Tip Assembly is not screwed on. (Fig. 5)

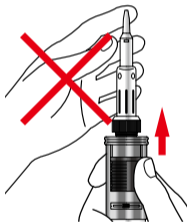


Fig.4

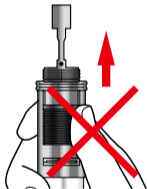
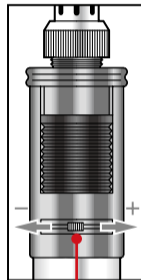


Fig.5

## TEMPERATURE ADJUSTMENT



Mid-Position

Fig.6

- The tip temperature can be adjusted by turning the **Gas Control Lever** left or right. (Fig. 6)
- Set to **mid-position** when soldering or brazing.
- Excessive gas flow, flare-up or catalyst pulsing red may occur when the **Gas Control Lever** is set too high.

## CHANGING TIPS

1. Be sure the tip has cooled before removal.
2. Unscrew Tip Assembly with a counterclockwise motion. (Fig. 7) Pliers may be required to lightly grasp the **Knurled Nut** in order to loosen the tip.
3. Replace with desired tip. Be careful not to overtighten as this could damage the thread in the cap.

**WARNING:** The catalyst inside the soldering tip is very delicate and will not sustain mechanical abuse without serious damage.

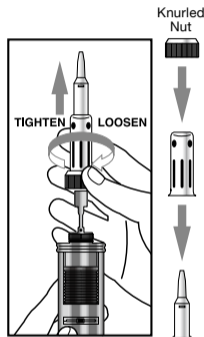


Fig.7

## CLEANING OR REPLACING NOZZLE ASSEMBLY

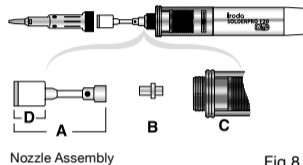


Fig.8

1. Remove Tip Assembly
2. Unscrew **Nozzle Assembly (A)** from the **Torch Body (C)**. (Fig. 8) Pliers may be used to lightly grasp the shank in order to loosen it. **Do not** grasp and turn the **Ceramic Head (D)**
3. Carefully remove **Orifice connector (B)** by lifting it out of the torch body. Note that the shorter side of Orifice Connector fits into the Torch Body.
4. Soak Orifice Connector in Naphtha or other similar solvent for approximately 5 minutes.

5. Replace new (or clean) Orifice connector (B) remembering to insert the **shorter side into the Torch Body**.
6. Replace Nozzle Assembly and hand tighten or tighten gently with pliers grasping the shank of the Nozzle Assembly not the ceramic head.
7. Replace Tip Assembly.

## CLEANING

- Use only mild soap and a damp cloth to clean the housings of the tool. Many household cleaners contain chemicals which could seriously damage the plastic. Also do not use gasoline, turpentine, lacquer or paint thinner, dry cleaning fluids or similar products. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

## TROUBLE SHOOTING

- To reduce the risk of personal injury, property damage, or damage to your **SOLDERPRO 120K**, do not attempt to repair the unit body.

PROBLEM	PROBABLE CAUSE	HOW TO CORRECT
Does not ignite	<ol style="list-style-type: none"> <li>a. Empty Gas Tank</li> <li>b. Too high or low fuel pressure</li> <li>c. Pushing on/off ignition switch too fast.</li> <li>d. Clogged orifice connector</li> </ol>	<ol style="list-style-type: none"> <li>a. Refill with butane fuel</li> <li>b. Adjust control lever to a higher or lower position.</li> <li>c. Re-read "How to use as a soldering iron"</li> <li>d. Clean or replace with new orifice assembly</li> </ol>
Low gas pressure or low flame	<ol style="list-style-type: none"> <li>a. Clogged orifice connector</li> <li>b. Cold fuel</li> <li>c. Low fuel</li> </ol>	<ol style="list-style-type: none"> <li>a. Clean or replace with new one.</li> <li>b. Hold body in hands to allow unit to warm up.</li> <li>c. Refuel</li> </ol>
Tip does not heat up	<ol style="list-style-type: none"> <li>a. Used-up catalyst (inside Tip Housing)</li> <li>b. Insufficient fuel pressure</li> <li>c. Clogged orifice connector</li> </ol>	<ol style="list-style-type: none"> <li>a. Replace with new tip.</li> <li>b. Adjust control lever to a higher position.</li> <li>c. Clean or replace with new one.</li> </ol>

## SPECIAL WARNING

- This product, when used for soldering and similar applications, produces chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.
- Department of Transportation Hazardous Materials Regulations forbid the carriage of butane or other flammable gas products on passenger aircraft. Do not pack this item or any other flammable gas item, in any checked or carry-on baggage.

## SPECIFICATIONS

Length	W / Cap	272 mm (10.7 inches)
	W / Soldering Tip	262 mm (10.4 inches)
Width		28 mm (1.1 inches)
Height	W / Stand	65 mm (2.6 inches)
	W / O Stand	36 mm (1.4 inches)
Weight	Empty Fuel Tank	193 g $\pm$ 2 g
Watt		30 W - 125 W
BTU		594
Approximate Temperature	Soldering Tip	$\approx$ 842 °F (450 °C)
	Heat Blower	$\approx$ 130 °F (650 °C)
	Deflector	$\approx$ 1300 °F (650 °C)
Capacity	Gas Container	15 ml (0.5 oz)
Flame Length	Mid Setting	1.2 cm (0.5 inches)
Operating Time	Mid Setting / One Gas Filling	40 min.
Heat Up Time	Working Temperature	25 seconds





This appliance may be filled with any cartridges marked  
“Butane” complying with EN 417.

**Warning:**

- Use outdoors only or use in well ventilated areas.
- Read the instructions before using the appliance.

**CAUTION:**

- Accessible parts may be very hot. Keep young children  
away from the appliance.

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