turn on station



(diagram 1)

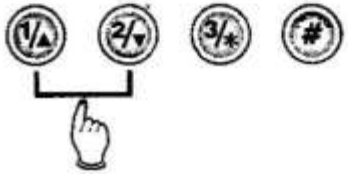
heating station



(diagram 2)

3. Adjusting temperature:

Under normal working condition, pressing and holding button "▲"or "▼", you can either increase or decrease the temperature quickly. Keeping the knob in pressed will adjust the temperature setting quickly; short pressing knob, you can adjust temp step by step. The display screen shows the temperature value simultaneously. Release knob for 3s to store. (Diagram 3)



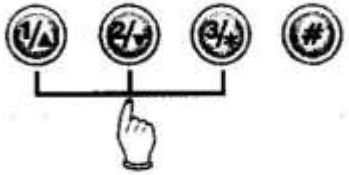
Temp adjustment status



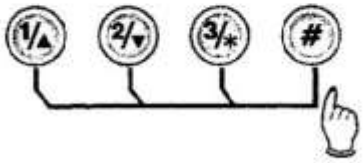
(diagram 3)

4. Quickly adjusting temperature

4.1. Under working condition, you can set working temperature quickly by programmable buttons. Press the button once to extract setting temperature stored in button "1, 2 & 3", this way you can easily set the working temperature.



4.2. Pressing button "#" and buttons "1, 2, 3", you can store the setting temperature into fast channel knobs "1, 2, 3".



4.3. Temperature hotkey



5. Temperature calibration

You need calibrate the temperature of tip after you replace with a new heating element or tip.

5.1. Enter into calibrating station by long pressing knob "✱" (>3s).
5.2. You can directly adjust the value of calibration by pressing knob "▲"or"▼".
5.3. The value of calibration is temperature measured minus the settings. (e.g. Actual value 380℃ - setting value 350 ℃ = +30 ℃. Pressing knob"▲"adds 30 ℃; Actual value 320 ℃ -setting value 350 ℃=-30 ℃. Pressing knob "▼" minus 30 ℃).
5.4. The calibrating temp range is +50 ℃ = -50 ℃.
5.5. You can press knob"✱" to store after you finish calibration. (diagram 4)



Temp correction status

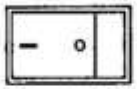


(diagram 4)

6. Temp. unit exchange

In the power off condition, press and hold knob "#", then turn on the station, the temp unit will be changed between "℃" and "℉" and store automatically.





POWER

7. Temperature lock function

Temperature LockDisplay: "Loc", short of Lock, located in right bottom of LCD display screen.
Temperature lock&unlock function can be realized by pressing "#" for three second or longer.
Whenever the machine is locked as above photo shows, the functional key in panel lose effect.

Locking state on display



8. Dormant Function

If AT980D doesn't work within 10 minutes, it will enter into dormancy and iron temperature keeps at 100℃. Any touch of handle or key can activate machine and return to previous working status.

display

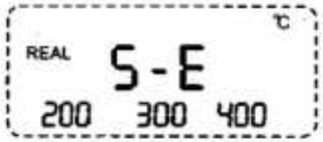


9. False alarm

When "H-E" or "S-E" is displayed on the screen, there is some wrong in heating element or the circuit. (diagram 5, 6). Turn off the unit and follow the instructions to replace the heating element.



(diagram 5)

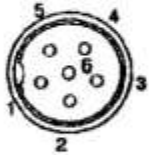


(diagram 6)

How to check and replace heating element

⚠ **Notice:** Please be sure the machine is power off and the temperature of solder tip is down to room temperature.

Pull out the plug; test the impedance between connector pins referring to bellowing table:
If the test results are different from a, b, then heating sensor or wire should be renewed.
If item C tested results is bigger than the referenced value, we should utilize sand paper or steel wool to softly remove the oxidized layer of iron tip.

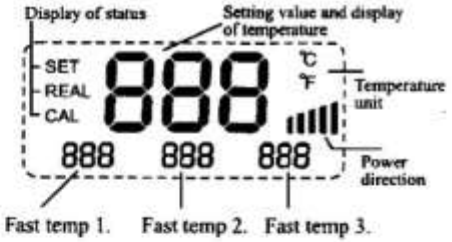


Main Specifications:

Input Voltage	220VAC ±10% 50Hz /110VAC±10% 60Hz	
Output Voltage	AC28V	
Power Consumption	150W(MAX)	300W(MAX)
Temperature Control Range	150℃~450℃ (302℉-842℉)	
Measurement	138x125x100mm	
Set method	Key regulator, Fast access	
Temperature Stability	1℃ (Still air, No load)	
Display	HD LCD	
Max surrounding temperature	40℃	
Calibrating method	Digital calibration	
Temperature range for calibration	50℃~-50℃ (122℉~-58℉)	
Ground impedance	<2Ω	
Ground voltage	<2mV	
Heating element	150H	300H

** Specifications are subject to change without prior notice.*

Introduction for LCD display:



Display of status:
SET: Set Temperature
REAL: Real Temperature
CAL: Calibration Temperature

Operating Guidelines

Please refer to the "Control Panel Guide" section for buttons and display panel details

1. Connection:

1.1. Insert soldering iron's plug into the socket and tighten the nut on the plug securely and place it in iron holder.
1.2. Inset station's power cord into power plug on the back panel and plug the cord into a power source.

2. Power on:

2.1. Turn on the unit.
2.2. The Digital display will initially display the current set temperature (the value of last time using) for 3 seconds. After few seconds it would display the actual temperature with temp unit "°C or °F". (diagram 1), (diagram 2)

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User's Manual

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LEAD-FREE Pb SOLDERING STATION