

INSTRUCTION MANUAL

Thank you for purchasing 474 Desoldering Station.
Please read the manual before using the unit.
Keep manual in accessible place for future reference.



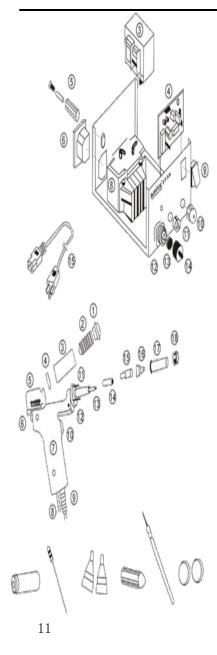
Please remember to remove the pump securing screw (M4×10 marked red) from the bottom of the station before using. Failure to do so may cause damage to the unit.

Manufacturer:

AOYUE TONGYI ELECTRONIC EQUIPMENT FACTORY

Jishui Industrial Zone, Nantou, Zhongshan City, Guangdong Province, P.R.China http://www.aoyue.com

SPARE PARTS LIST



No.	Part No.	Part Name
1	20411	Station Top Cover
2	201412	Spring Holder
3	10046	80W Transformer
4	10474A	Circuit Board
5	10017	Fuse Holder
	10020	3A Fuse
6	10014	Power Cord Receptacle
7	20401	Station Base
8	P006	Diaphragm Pump
9	10117	Switch
10	30120X	Control Knob
11	10127	Soldering Iron Receptacle
12	3001X	Vacuum Receptacle
13	30180X	Carbon Filter
14	3006X	Vacuum Cover
15	10009	Power Cord
No.	Part No.	Part Name
1	3024X	Casing
2	201252	Spring Filter
3	3022X	Filter Pipe
4	30180X	Ceramic Paper Filter
5	3025X	Back Holder Assembly
6	3021X	Release Knob

Housing

Trigger

3*6 Screw Metal Ring

Cord Assembly

Heating Element

Tip Cylinder Tip Lock Cylinder

Nozzle Tip Enclosure

Hose

3072D

3043J 10050

3020X

4023

201282 C004

20129

10232

20130

18	20169	Outer Nut
No.	Part No.	Part Name
1	3022X	Filter Pipe
2	201242	Cleaning Pin
3	201212 202092 202082	1.8 mm 1.5 mm 1.2 mm
4	201252	Spring Filter
5	20178	Cleaning Drill
6	30180X	Ceramic Paper Filter

MAINTENANCE

I. Care for the Nozzle.

- 1. Plug in the power cord, turn on the power switch on and let the nozzle heat up.
- After the nozzle has heat up, clean the nozzle using the cleaning pin. The cleaning pin will not pass through the nozzle unless the solder inside the nozzle melts, so please make sure that nozzle is properly heated up. If the cleaning pin still did not pass through, clean with the cleaning drill instead.
- 3. Check the condition of the solder plating on the tip of the nozzle. If it is slightly worn, recoat the tip with fresh solder to prevent oxidation.
- 4. Check the condition of the surface and hole of the nozzle, if either is worn, eroded or inside diameter seems unusually wide, replace the nozzle.

II. Replacing the Heating Element

 \triangle

Unplug the power cord before starting this procedure.

The resistance value of the heating element is 30Ω , the resistance value of the snesor is $1.5-2\Omega$. If the value reading you get is outside this range, replace the heating element.

Desolder these points to remove old heating element an replace with a new one. Bend the leads at the

1. Disassemble the heating parts.

2. Separate the housing.

Straighten tube Bend tight angle

- 3. Detach t he terminal and remove the heating element.
- 4. Insert a new heating element and reassemble.
- 5. Recalibrate the temperature.

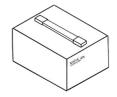
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PACKAGE INCLUSION



474 Main Station



Desoldering Gun



201252 Spring Filter



3022X Filter Pipe



30180X Ceramic Filter Paper



Gun Holder



3006X Vacuum Cover



20178 Cleaning Drill



201242 Cleaning Pin



Power Cord



202092 Desoldering Tip 202082 Desoldering Tip

Silicon Grease Instruction Manual

OPERATION GUIDELINES

II. Clean the tip of the nozzle.

Keep the solder-plated section of the nozzle coated with a small amount of solder. If the tip of the nozzle is coated with oxide, the nozzle's heat conductivity will be lowered. Coating the tip with a small amount of fresh solder ensures maximum heat conductivity.

III. Melt the solder

- 1. Apply the nozzle to the soldered part and melt the solder.
 - * Do not touch nozzle to board.
- 2. Try to check the inside of the hole and the backside of the PCB if solder is melted.
- 3. Try moving the solder using the desolder gun nozzle, if it moves easily then it means that solder is completely melted but do not force it.

IV. Absorb the solder

- 1. After checking that solder is completely melted, position the desolder gun then absorb the solder by pulling the trigger.
 - * Be careful not to leave any solder remain in the hole.
- 2. After fully absorbing all the solder, cool the soldering junction in order to prevent it from becoming resoldered.

OPERATION GUIDELINES

I. Connections

- 1. Connect the cord assembly of the Desoldering Gun to the receptacle.
- 2. Connect the tube to the vacuum outlet cap.
- 3. Connect the power cord.

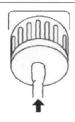


Insert the cord assemble by keying the plug to the key on the receptacle.



Secure the plug by turning it clockwise.

VACUUM



Fully insert the vacuum tube in the vacuum outlet cap.

NOTE:

- Confirm that the power switch is set to "OFF", before connecting the power plug to the power supply
- Check if the *indicator light* lights up when you turn the unit "ON".
- The suction nozzle begins to heat up as soon as the desoldering switch is turned on.
- After turning the switch to "ON", wait for a few minutes (until suction nozzle fully heats up) before beginning desoldering operations.

CARE and SAFETY PRECAUTIONS



CAUTION: Misuse may cause extensive damage to the unit. For your own safety, be sure to comply with the following precautions.

- Upon using, please make sure that the plug is properly grounded.
- Do not disassemble/modify unit, high voltage pressure inside unit may cause damages.
- Do not allow nozzle tip to touch board directly.
- Do not turn on when it is empty. Pour in adequate cleansing liquid. (around 10mm below the rim)
- Unit produces heat, use under ventilated environment.
- Do not pour flammable / acidic cleansing liquid.
- Handle with Care
 - Never drop or sharply jolt the unit.
 - Do not beat or drum the bottom of the cleaner.
- Disconnect plug when not to be used for a long period of time.

SPECIFICATIONS

Power Input :	available in 110V / 220V
Power Consumption:	70W
Temperature Range:	150°C - 380°C
Heating Element:	PTC Heating Element
Output Voltage:	24V
Tip to Ground Resistance:	Below 2 Ω
Tip to Ground Potential:	Below 2mV
Suction Flow:	15 I /min (max)
Vacuum Generator:	Double Cylinder
Vacuum Pressure:	600mm Hg
Station Dimensions:	188(w) x 127(h) x 244(d) mm
Weight:	5.3Kg

FEATURES

- Compact unit with air cylinder type strong suction vacuum pump.
- Suited for multi-layered PCB reworking.
- The heating element and tip are designed closely to guarantee enough temperature during desoldering.

PARTS GUIDE

