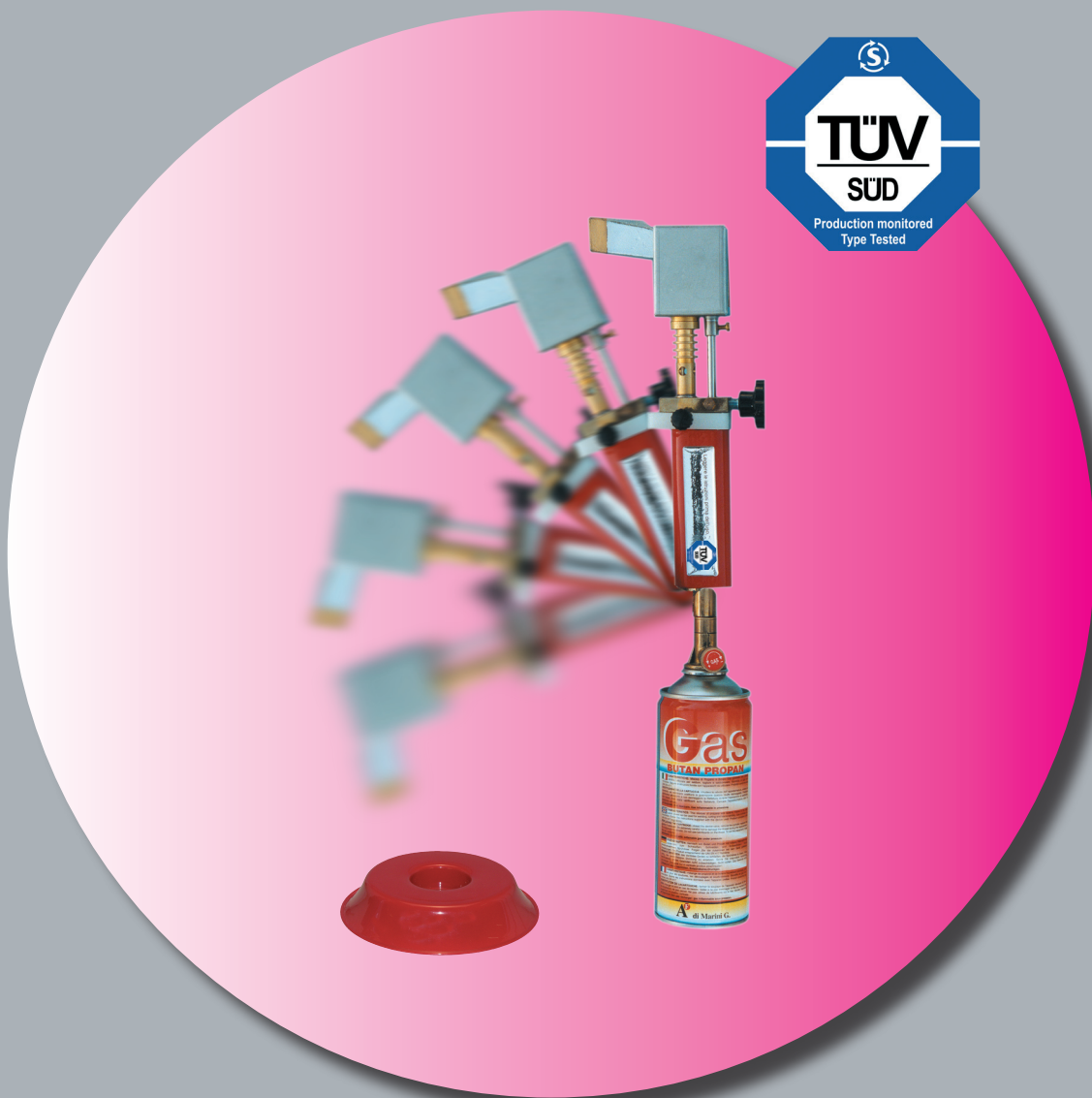


ROTATING SOLDERING IRON "TYPE O"



**QUICK
SAFETY VALVE
LONG LIFE SPECIAL BIT**

APPLIANCE FOR SOFT SOLDERING OPERATED BY BUTANE PROPANE INSTRUCTIONS (to be read carefully before use, see also www.afmarini.com)

Description of the appliance

Appliance for soft soldering which operates exclusively with non refillable cartridges of propane-butane. It is a soldering iron . During pause phase, the appliance stands vertically on the cartridge. The appliance must stay in pause phase for at least 5 minutes after ignition before operating to avoid dangerous exits of the flame or to avoid that the appliance burns out. When held by the operator, the handle will move along the axe of the soldering iron thus releasing the 180° articulation. This articulation allows the cartridge to dangle in a vertical position . Nevertheless in case of particular necessities, the articulation can be blocked by the revolving plug (N). The cartridge is screwed on the safety tap which opens and closes the gas feeding to the soldering iron. The soldering bit is protected by a baffle plate in stainless steel which allows a quick temperature increase. The baffle plate is fixed to the rod of the soldering bit by means of a screw. After the tap there is a safety valve. Inside the nozzle there is a little sintered dust filter which filters gas and provides protection against backfire.

Principal rules for use of the soldering iron

- A.** The instructions must be read before use and stored for eventual further consultation
- B.** Assembly and positioning effected by the manufacturer must not be altered. It may be dangerous to effect alterations on the appliance such as removing pieces or using different pieces not allowed by the manufacturer.
- C.** This appliance is devised only for soft soldering and not for other uses.
- D.** Make attention not to solder metals with coatings that may produce toxic fumes, or varnished materials or material containing flammable or explosive products.
- E.** Make attention that the soldering iron is not exposed or put in contact with temperatures above 50°

- F.** Start the soldering iron in pause position and far from flammable products and flammable gases or fumes . Hold the non refillable cartridge in a vertical position, or a big sudden flame may occur.

- G.** In pause position the appliance must always rest on a perfectly horizontal surface. Or in an appropriate support.

- H.** Do not touch the bit, the baffle plate or the blocking screw or remove any of these parts until they are completely cooled down.

- I.** Never cool the iron in water

- J.** Never leave the iron lighted for long if not in use.

- K.** The soldering iron complies with norm EN 521 and is manufactured for the category: direct pressure of Butane-Propane- mixture.

- L.** Operate with A.F. Marini non refillable cartridges of Butane/Propane weight 210 gr. volume 400 ml.

M. Instructions for use of non refillable cartridges

- Use only non refillable cartridges which comply to norms (cartridges: type A.F. MARINI code SP056, volume ml 400)
- The use of non refillable cartridges which are not recommended may be dangerous
- Never connect a non refillable cartridge before carefully reading the instructions
- non refillable cartridges must not and cannot be re charged
- do not, for any reason, bore holes in the non refillable cartridges

N. Measures to be taken before connecting the non refillable cartridge.

- Ensure that all closings or other connections are attached correctly and that they are not damaged;
- Control that the tubes are not damaged;
- do not, for any reason, use an appliance with any damage;
- close the access of gas to the appliance before connecting the non refillable cartridge
- regarding non refillable cartridges it is important to hold the cartridge always in a vertical position while screwing it on, to avoid spilling of liquid gas.

O. Connect the non refillable propane/butane cartridge in a well aired environment, far from flammable sources and not near other people; it is forbidden to smoke while replacing the container.

P. Instructions for connection of the appliance

- Ensure that the tap on the connection for the non refillable cartridge is well closed.
- Ensure that also the safety tap on the appliance is well closed
- Ensure that the closing is effected correctly

Q. Instructions for the connection of the non refillable cartridge

- screw on the non refillable cartridge clockwise and in vertical position
- Ensure that the connections are correctly closed
- Replace the washer on the connection for the non refillable cartridge when damaged
- Ensure not to damage the screw thread on the non refillable cartridge
- Warning: before operation test in open air that there are no gas leaks by means of the appropriate spray or of water.

R. Instructions for replacement of the non refillable cartridge:

- Non refillable cartridges cannot be replaced while the soldering iron is lighted and if it is not certain that they are completely empty
- It is forbidden to bore holes in the non refillable cartridges considered empty

S. Instructions for use of the appliance:

- Warm up the appliance before use for at least 5 minutes
- Do not set apart or abandon a lighted soldering iron.
- Take care not to heat the non refillable cartridge.
- Take care to light the soldering iron far from objects, flammable gasses or fumes.

T. Operating conditions:

- When the soldering iron is new take care for the first minutes not to inhale the fumes caused by the production oil
- Do not operate in closed environments, provide appropriate aeration
- Operate in a clean working place, far from flammable materials and greasy materials
- Use protection devices for eyes and hands
- Use protection clothing
- Take care that soldering and tinning gasses are not inhaled

U. Suggestions for correct operation:

- Store the non refillable cartridge at a temperature below 50° C.
- Replace the nozzle size 0,28 with another one of the same size in case the combustion noise becomes irregular or in case the soldering irons tends to burn out
- While operating always keep the non refillable cartridge in vertical position
- Do not cool the iron in water
- Never leave the iron lighted for long if not in use

V. How to put out the appliance:

- Bring the ducts to a normal pressure
- Let the soldering iron cool down before relighting it

W. Conditions for storage, transportation and disposal:

- In case of long storage periods or of transportation on vehicles, non refillable cartridges must be stocked in aired environments.
- Storage and transportation of non refillable cartridges must be effected in a vertical position
- Keep away from children
- Take care that non refillable cartridges are not exposed to temperatures above 50° C.
- Dispose of the non refillable cartridges in the appropriate containers

X. Maintenance:

- Use only prescribed spare parts
- Never light the appliance when one of its parts is damaged
- In case the combustion noise is not regular, clean the burner and the combustion chamber accurately

Y. Technical assistance and repairs address:

A.F. di Marini Giuliano Via S. Pertini, 9/b – 30030 – Martellago VE Italy
TEL. +39041/5403075 FAX. +39041/5403076
e-mail info@afmarini.com www.afmarini.com

Z. Behaviour in case of fire:

- In case of fire immediately close the gas feeding and ensure that the non refillable cartridge is properly screwed onto the connection.
- Remove the appliance from the fire as soon as possible

AA. Behaviour in case of leakage:

- In case of leakage close the gas tap and ensure that the non refillable cartridge is properly screwed on, then provide to repair in the authorised assistance centre.
- Test the leakage by immersion in water or by the appropriate Spray
- provide to repair in the authorised assistance centre.

RISK VALUATION: for soldering irons operating with non refillable cartridges

- Use the soldering iron preferably in aired environments and far from flammable products
- Always screw on the cartridge while in vertical position: leakage danger of liquid gas.
- Always operate with the cartridge in vertical position: danger of anomalous flames
- Never unscrew the cartridge while the soldering iron is lighted: fire danger.
- Caution do not touch the soldering bit when hot: burn danger
- For use of non refillable cartridges, use the appropriate support: danger of anomalous flame and fire
- Do not bore holes on the cartridge
- Never leave the iron lighted for long if not in use: danger of distortion and fire.
- Do not Smoke while replacing the gas container: danger for fire.

Technical features of the portable soldering iron “Type O”

Operation	Butane gas, Propane gas, mixture of Butane/Propane gas
Safety devices	Spring check valve, sintered filter
Nozzle	Ø 0,28
Nominal consumption	136 gr/h
Heat load	1,90 Kw
Weight of the bit	250/500 gr.
Weight of the appliance	850/1100 gr

Technical features of the non refillable cartridge

Contents	Mixture of Butane 60% Propane 40%
Use	Non rechargeable
Closing system	Incorporated valve
Weight	210 gr
Volume	ml. 400
Product standard	EN 417

PROBLEM	CAUSES	SOLUTION
Little flame during ignition operation	Spilling of liquid gas	Put the cartridge or the gas container in a vertical position
No ignition	The gas is not in pressure, leakage of gas between the container and the soldering iron	Control and resolve eventual leakages along the duct or near the connections
Irregular flame	Dirty nozzle	Replace the nozzle
	Dirty burner	Remove residual combustion products or replace the part
Exit of the flame on the front of the soldering iron	The pressure is too high	Reduce the operating pressure
	The bit is not perfectly centred inside the baffle plate	Centre the bit
The tin does not melt	The bit is cold	Heat the bit more
	The bit is dirty	Dress the bit to clean it
Gas leakage	Worn out or damaged elements	Put out the soldering iron and provide to replacement of defective elements in the authorised assistance center