

SHOW THE STYLE OF MASTER
MECHANIC



智能控溫防靜電焊臺

**INTELLIGENT TEMPERATURE
CONTROL ANTI-STATIC
SOLDERING STATION**

使用說明書 INSTRUCTION MANUAL

HK-936/936D/936D+/937D

香港始創 品質百年

Hong Kong pioneer, hundred years of quality.

香港維修佬運營合作企業 H.K. MECHANIC ENTERPRISE

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Statement: The company reserves the right to improve and upgrade products, product specifications and design are subject to change without notice.

安全守則

使用本機器，下列基本措施要遵守，以免觸電或對人體造成傷害，避免火災等現象的危害。

- 1、為了確保人身安全，該機器工作完畢后，請拔掉電源線!!!
- 2、必須使用原廠認可或推薦的零件，否則將導致嚴重后果。
- 3、機器故障必須由專業人士或本公司指定人員進行維修。
- 4、本產品使用三線接地插頭，必須插入三孔接地插座內，不要更改插頭或使用未接地三頭適配器而使接地不良。
- 5、電焊臺開啟后，其溫度都有可能達到400度以上。切勿在易燃、易爆氣體、物體附近使用。切勿觸摸烙鐵金屬部分，謹防燙傷。
- 6、電焊臺開啟后切勿離開工作崗位。
- 7、安裝或更換烙鐵部件時，必須在關閉電焊臺后進行，必須在烙鐵冷卻后方可進行安裝或更換。
- 8、切勿使用烙鐵進行焊接以外的工作；切勿將烙鐵敲擊工作臺面以清除焊劑殘余，此舉可能嚴重損壞烙鐵。
- 9、焊接時會冒烟霧，請做好應有的通風設施。

一、包裝清單

請檢查產品包裝，以證實所列清單項目正確無誤。

- 1、HK-936/936D/936D+/937D 主機 x1臺
- 2、908烙鐵 x1把
- 3、烙鐵架（包括清潔海綿） x1個
- 4、使用說明書 x1本

二、產品特點

HK-936D+

- 1、采用最新SAMSUNG微電腦處理器PID程控控溫技術，植入最高端精密PID程序，機器以每20毫秒為周期的超級速度跟蹤檢測烙鐵實際溫度，并進行校正。神奇的溫度補償速度，使其溫度更穩定，溫度誤差更小，能適應各種惡劣環境。
- 2、烙鐵發熱芯采用大功率進口發熱芯，溫度穩定，使用壽命長；防靜電設計，防止靜電損壞嬌嫩的SMD元件。

HK-937D

- 1、HK-937D系列是HK-936D+系列的升級版，具備HK-936D+系列所有優點，同時內部采用SMT雙面板工藝制造，內部工藝整齊，信號流向清晰明了，機器穩定和安全性進一步提高。另外設計有以下節能環保、實用的功能：

A、休眠功能：

烙鐵自動檢測自身工作狀態，在無人使用，處於靜止狀態時，到達設定的休眠時間，烙鐵溫度自動降溫到200°C進入休眠狀態，可有效的防止烙鐵頭氧化，延長了烙鐵頭的使用壽命，節能環保。休眠時間可設置範圍為：0 99分鐘，步進為1分鐘，用戶可根據使用情況設定，如不需要烙鐵休眠可把休眠時間設置為0。

B、自動關機功能：

烙鐵進入休眠狀態后，程序開始計時，在設置的自動關機時間內沒有喚醒休眠，機器則自動關機，節能環保。自動關機時間設置範圍：0 99分鐘，步進為1分鐘。

C、攝氏/華氏顯示溫度功能：

為滿足不同地區的市場需要而設計的溫度顯示模式，可根據習慣興趣選擇。

三、規格參數

產品型號	HK-936	HK-936D	HK-936D+	HK-937D
功率	45W		60W	
輸出電壓	AC24V		AC28V	
溫度範圍	200°C 480°C		200°C 480°C	
	392°F~896°F		392°F~896°F	
顯示形式	無		LED	
溫度穩定度	±2°C（靜態）		±1°C	
發熱絲電壓	AC 24V ±10% 50Hz			
焊咀對地阻抗	<2歐			
焊咀對地電壓	<2mV			
重量	1.58kg（普通芯）		2.08kg（進口芯）	
工作溫度	0~40°C/32°F~104°F			
儲存溫度	-20°C 80°C/-4°F~176°F			
儲存濕度	35% 45%			

四、性能對照表

性能 \ 型號	HK-936	HK-936D	HK-936D+	HK-937D
顯示形式	無	數碼顯示	數碼顯示	數碼顯示
烙鐵休眠功能	無	無	無	有
自動關機功能	無	無	無	有
攝氏/華氏轉換	無	無	無	有
溫度校正	無	無	無	無
三段儲存	無	無	無	無

五、操作說明及功能設置

- 1、連接好烙鐵和控制臺。
- 2、接上電源。
- 3、打開開關，數碼管顯示設置溫度，烙鐵開始加熱。

HK-937D功能設置說明

- 1、**溫度調節：**
按面板上的“▲/ ”的按鍵調節所需溫度。
- 2、**休眠功能設置：**
在開機狀態下，同時按下溫度加/減按鈕3秒，數碼管顯示“L00”（L00表示無休眠，L01表示休眠時間為1分鐘），然後按溫度加/減按鈕設置休眠時間。設置好需要的參數後，停止操作4秒，程序自動記憶並退出功能設置狀態，設置完成。可設置的休眠時間範圍：0 99分鐘。
喚醒烙鐵休眠：
A、拿起烙鐵輕甩兩下。
B、按下溫度加/減按鈕。
C、關閉電源開關，再打開開關。
- 3、**自動關機時間設置：**
在開機狀態下，連續兩次同時按下溫度加/減按鈕3秒，數碼管顯示“P00”（P00表示無自動關機，P01表示自動關機時間為1分鐘），然後按溫度加/減按鈕設置需要的自動關機時間。設置好需要的參數後，停止操作4秒，程序自動記憶並退出功能設置狀態，設置完成。可設置的自動關機時間範圍：0 99分鐘。
- 4、**攝氏/華氏顯示溫度功能設置：**
在開機狀態下，連續三次同時按下溫度加/減按鈕3秒，數碼管顯示“C”（C表示攝氏狀態，F表示華氏狀態），然後按加/減按鈕設置攝氏/華氏狀態。設置好後，停止操作4秒，程序自動記憶並退出功能設置狀態，設置完成。

六、烙鐵頭的維護和使用

烙鐵頭溫度	溫度過高會削弱烙鐵頭功能，因此應選擇盡可能低的溫度。此烙鐵頭的溫度恢復力優良，較低溫度也可充電焊接，可保護對溫度敏感的元件。
清理	應定期使用清潔海綿清理烙鐵頭，焊接後，烙鐵頭的殘余焊劑所衍生的碳化合物和氧化物會損害烙鐵頭，造成焊接誤差，或使烙鐵頭導熱功能減退。長時間連續使用烙鐵時，應每周一次拆開烙鐵頭清除氧化物，防止烙鐵頭受損而減低溫度。
當不使用時	不使用烙鐵時，不可讓烙鐵長時間處于高溫狀態，會使烙鐵頭上的焊劑轉化為氧化物，致使烙鐵頭導熱功能大為減退。
使用后	使用后，應抹淨烙鐵頭，鍍上新錫層，以防止烙鐵頭氧化。

- 1、當烙鐵初次使用時，要注意檢查烙鐵咀的升溫情況，待其溫度剛剛能融化錫絲時，在烙鐵咀部分鍍上一層錫，然後再將溫度升至所需的溫度。切記工作時烙鐵咀應長期附有一層錫保護烙鐵咀，才能達到最佳的焊接功能。
- 2、如烙鐵表面出現一層氧化物，造成烙鐵頭低溫的假象，無法熔錫和上錫，此時發熱芯與烙鐵都處于高溫狀態。出現這種情況時，不要盲目把溫度再調高。應用清潔海綿清除氧化物，如不能清除，請將電源關閉，待烙鐵溫度降低至室溫後，用砂紙小心把氧化物清除，然後重復第一點烙鐵初次使用的操作。
- 3、注意烙鐵處于高溫工作後，放回焊鐵架待用時，應把溫度旋鈕調至250℃以下待用。待用時間超過20分鐘請關閉電源。否則烙鐵長期處于高溫備用狀態下，由于烙鐵架與烙鐵之間產生積溫，使發熱芯加速老化，焊鐵咀衍生氧化物，直接減弱焊接功能，嚴重則導致連接螺母塑膠融化或發熱芯短路。
- 4、切勿用銼刀剔除烙鐵頭的氧化物，如果烙鐵頭變形或衍生鐵銹，必須更換新的烙鐵頭。
- 5、焊接時不要給烙鐵頭太大的壓力，這樣不會改變導熱性能，反而會使烙鐵頭受損。

七、烙鐵發熱芯和烙鐵頭的更換（圖1）

- 1、旋出螺母1，再將鋼管2取出，這時就可以取下烙鐵頭進行更換了。
- 2、如需更換烙鐵發熱芯可繼續旋出螺紋頭4，拔出烙鐵發熱芯6和線路板7，要注意彈簧5的連接綫。
- 3、將烙鐵發熱芯從線路板上焊下，更換新的發熱芯，裝好即可。注意烙鐵發熱芯引綫的連接順序。

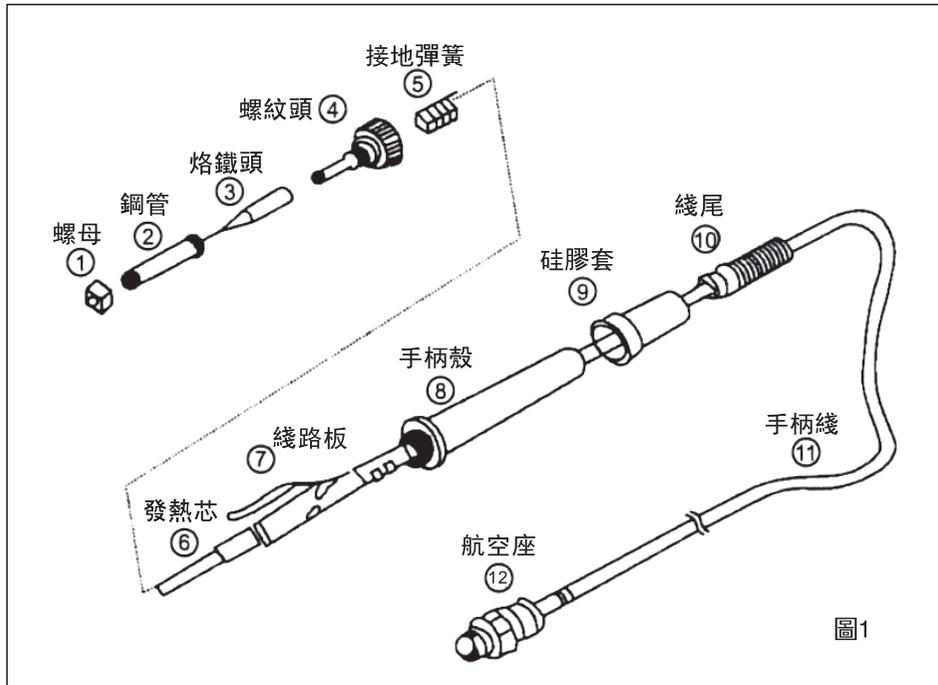
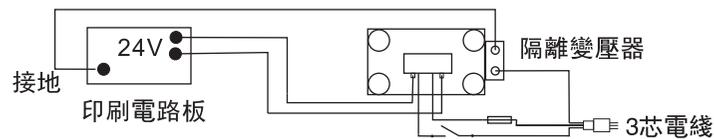


圖1

八、電路圖



Warning!!!

Use the machine, the following basic measures should abide, avoid electric shock or cause injury or damage caused by fires.

1. To ensure personal safety, after the machine completed work, please turn off the main power switch, and unplug the power cord if long time no use.
2. To ensure personal safety, you must use the original approval or recommendation of the parts, otherwise it will lead to serious consequences.
3. Machine failure must be by professionals or the company designated personnel for repair.
4. This product is grounded three-wire plug, must be inserted within the three-hole grounded outlet, do not change the plugs or use ungrounded three adapter made it bad grounded.
5. Hot air gun or soldering station is open, its temperature are likely to reach 400 degrees. Do not use it near flammable gas, objects. Tube and the heat emitted very hot, can burn the body, do not touch the hot pipe and direct injection to heat the human body.
6. Before hot air gun turned on, please ensure it is in safety environment, do not leave the jobs site.
7. When the hot air gun opening do not install nozzle, the heat pipe and the nozzle must be cooling. Then installed the other nozzle.
8. Do not use a soldering iron to weld outside the work; Do not iron percussion table to clear the residual flux, this could seriously damage the iron.
9. The machine welding will take smoke, please do proper ventilation.

I. Packing List

Please check the product packaging, to confirm the list item listed is correct:

- | | |
|---|-------|
| 1. HK-936/936D/936D+/937D soldering station | x1Pcs |
| 2. Soldering iron 908model | x1Pcs |
| 3. Iron holder (with cleaning sponge) | x1Pcs |
| 4. Instruction Manual | x1Pcs |

II. Product Features

HK-936D+

1. Using the new SAMSUNG microcomputer processor PID programmable temperature control technology and implantation of the most high-end precision PID program. The machine to every 20 ms as a cycle, using super speed to tracking detection the iron actual temperature and correction, the magic temperature compensation speed, to make it more stable temperature, the temperature error is smaller, and can adapt to a variety of harsh environments.
2. The iron adopt large imported heater, heating up rapidly, temperature stability, long life; antistatic design to prevent electrostatic damage to delicate SMD components.

HK937D

- HK-937D is HK-936D+series upgrade version, have all the advantages of HK-936D+, while internal SMT dual-panel manufacturing process, internal process neatly, the signal flow are clear, further improve the performance of machine stability and security. In addition the design of energy saving and environmental protection, practical features:
 - Sleep function:**

Soldering iron automatic detection of their work status are not in use in a quiescent state, arriving to set the sleep time, the temperature of the iron automatically lower the temperature to 200°C enter into sleep state, can effectively prevent the oxidation of iron head and prolong the iron tip service life, energy saving and environmental protection.
 - The sleep time can be set range:**

0 to 99 minutes in 1 minute steps, users can be set based on usage, if you do no need a soldering iron sleep, the sleep time is set to 0.
 - Automatic shutdown function:**

After soldering iron enter into sleep state, start the timer program, set the shutdown time did not wake up from sleep, automatic shutdown, energy saving and environmental protection. Auto power off time setting range: 0 to 99 minutes in 1minute steps.
 - Celsius/ Fahrenheit temperature display function:**

Designed to meet the market needs of the different regions of the temperature display mode, you can choose under customary interest.

III. Specification

Product model	HK-936	HK-936D	HK-936D+	HK-937D
power	45W		60W	
Output voltage	24V AC		28V AC	
Temperature range	200°C~480°C		200°C~480°C	
	392°F~896°F		392°F~896°F	
Display type	NO		LED	
Temperature stability	±1°C		±2°C (Static)	
Heating element voltage	AC 24V ±10% 50Hz			
Tip of ground resistance	<2ohm			
Tip of ground voltage	<2mV			
Weight	1.58kg (Common heater)		2.08kg (Imported heater)	
Working temperature	0~40°C/32°F~104°F			
Storage temperature	-20°C~80°C/-4°F~176°F			
Storage humidity	35%~45%			

IV. Performance Table

Performance \ Model	HK-936	HK-936D	HK-936D+	HK-937D
Display type	NO	LED	LED	LED
Soldering iron dormancy	NO	NO	NO	YES
Automatic shutdown function	NO	NO	NO	YES
Celsius/fahrenheit conversion	NO	NO	NO	YES
The temperature calibration	NO	NO	NO	NO
Three sections of storage	NO	NO	NO	NO

V. Operating instructions and feature set

- Connect well the iron and the machine
- Connect the power
- Turn on the power, the LED display the set temperature, the iron start to heating.

HK-937D Function Setting Description

- The temperature adjust:**

Press "▲ / ▼" button on the control panel to adjust the desired temperature.
- The iron sleep function settings:**

In the boot state , press the temperature plus / minus button three seconds, digital display " L00 " (L00 indicates no dormancy , L01 represents the sleep time is 1 minute) , then press the temperature plus / minus buttons to set the sleep time. After setting the parameters you need to stop operating four seconds, the program features automatic memory and exit setting mode, setup is complete. Sleep Time setting range: 0 to 99 minutes.

Wake iron Sleep:

 - Picked up the iron light thrown twice.
 - Press the temperature plus / minus button.
 - Turn off the power switch, and then turn on the switch.
- Automatic shutdown time setting:**

In the boot state, twice while pressing temperature plus / minus button three seconds, digital display " P00 " (P00 indicates no automatic shutdown , P01 automatic shutdown time of 1 minute), then press the temperature plus/ minus buttons to set require automatic shutdown time. After setting the parameters you need to stop operating 4 seconds, the program features automatic memory and exit setting mode, setup is completed. Automatic shutdown time can be set: 0~99 minutes.
- Celsius / Fahrenheit temperature display feature set:**

In the boot state , three times while pressing temperature plus / minus button three seconds, digital display "C" (C represents Celsius state , F represents Fahrenheit state) , and then press the plus / minus buttons to set the Celsius / Fahrenheit state. Set up, stop operating four seconds, the program automatically memory and exit function setting status, setup is completed.

VI. Tip Maintenance And Use

Tip temperature	High soldering temperature can degrade the tip. Use the lowest possible soldering temperature. The excellent thermal recovery characteristics ensure efficient and effective soldering even at low temperatures. This also protects the solder de items from thermal damage.
Cleaning	Clean the tip regularly with a cleaning sponge. As oxides and carbides from the solder and flux can form impurities on the tip. These impurities can result in defective joints or reduce the tips heat conductivity. When using the soldering iron continuously, be sure to loosen the tip and remove all oxides at least once a week. This helps prevent seizure and reduction of the tip temperature.
When not in use	Never leave the soldering iron sitting at high temperature foe long periods of time, as the tip's solder plating will become covered with oxide, which can greatly reduce the tip's heat conductivity.
After use	Wipe the tip clean and coat the tip with fresh solder.

1. When soldering iron is used for the first time, you should pay attention to monitor iron tip warming situation, wait until the temperature just melted tin wire, a layer of tin on the part of the gold-plated iron tip, and then the temperature was raised to the required temperature. Keep in mind when working iron tip should be long-term with a layer of tin to protection iron tip, in order to achieve optimal soldering function.
2. As an oxide layer on the surface of iron tip, resulting in false low temperature soldering iron tip, unable to melt tin and the tin, in fact, at this time the heating elements with the soldering iron is high temperature state. This happens situation not to blind the temperature rises again, the application of clean sponge clear oxides, such as not clear, please turn off the power, soldering iron be dropped to room temperature, with No.0 sandpaper accidentally cleared the oxide, then repeat the operation of the first point iron initial use.
3. Please pay more attention soldering iron in high temperature work back into iron holder, should be adjust temperature button below 250°C stand - by use, stand-by time over 20 minutes, please turn off power. Otherwise the soldering iron in a high temperature for long time. Because between iron holder and soldering iron generate accumulated temperature, lead to heating elements accelerated aging, soldering iron tip derivative oxide, directly weakened soldering, severe will result in the connecting screw nut plastic melt of the handle or heating elements short circuit.
4. If the tip deformation or the occurrence of heavy erosion, to replace the new one. (Note: Do not use knife file remove oxides of soldering iron tip.)
5. Soldering, do not give iron tips too much pressure, this will not change the thermal conductivity, otherwise will lead to iron tip damage.

VII. Replacement of the soldering iron's tip and soldering iron heating core's element (Figure 1)

1. Unscrews the nut No.1, and then removes the steel tube No.2, followed by removing the tip which is going to be replaced.
2. For the replacement of heating core's element can be performed by unscrewing the plastic cap No.4, pulls out gently the heating core, element No.6 along with the circuit board No.7, please carefully remember the connection of spring No.5.
3. The iron core from the circuit board welding, the replacement of the heating core, can be fitted well. Note that the order of the iron core wire connection.

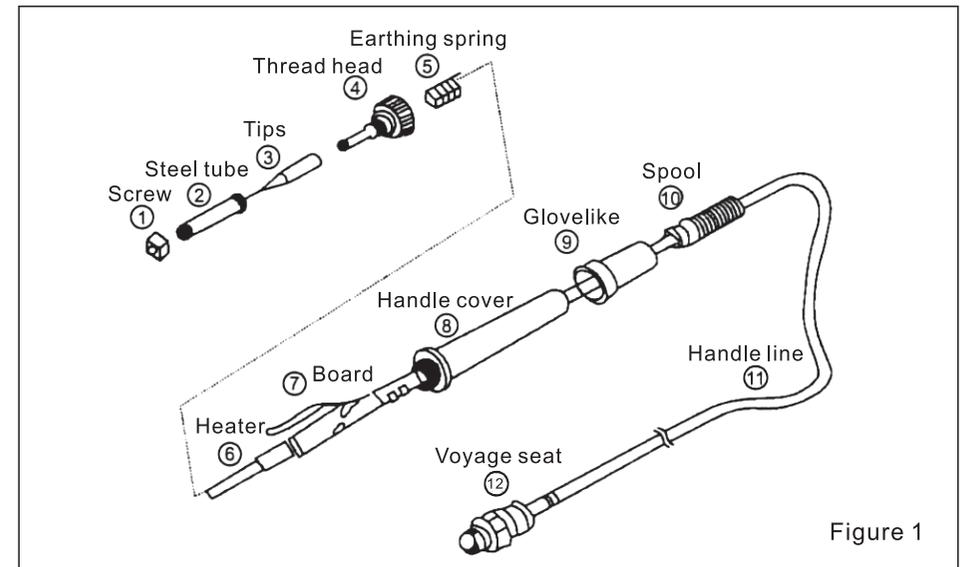
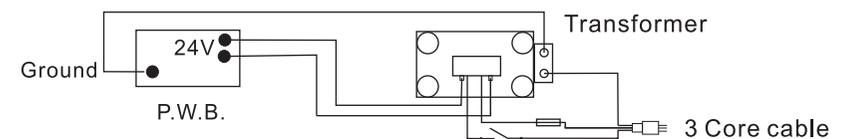


Figure 1

VIII. Wiring Diagram



附：電焊臺使用烙鐵頭型號圖

Attachment: Electric welding machine using welding head model figure

908

900M-T-0.8D 0°C				+30°C / +5.4°F
900M-T-1.2D 0°C				0°C
900M-T-1.6D 0°C				0°C
900M-T-2.4D 0°C				0°C
900M-T-3.2D 0°C				-10°C / -18°F
900M-T-1.2LD -10°C / -18°F				-20°C / -36°F
900M-T-SB 0°C				-10°C / -18°F
900M-T-B 0°C				0°C

900M tip OutDiam Ø6.5

產品合格證 Product certification

產品型號名稱(Model NO.)	
產品編號(Product ID)	
檢驗(Examine)	經檢驗產品符合技術標準 Upon examination products meet technical standards
售貨日期(Sales Date)	
出廠日期(Date of manufacture)	

產品保修卡 Warranty Card

感謝您購買本產品，在使用本產品前請認真閱讀以下條款：

Thank you for choosing this type of products, please read the following terms before using:

- 消費者由購買日起7天內，在正常操作情況下（非人為損壞），全新拆包，未經拆修，可享受包換服務。
From purchasing date within 7 days, under normal use(Artificial damage), new package, not be disassemble and repaired, enjoy replacement service.
- 消費者由購買日起1年內，在正常操作情況下，出現品質故障，未經拆修可享受保修服務。
From purchasing date within one year, under normal use, if there are quality problem, not be disassemble and repaired, enjoy free repair service.
- 在超過保修期終生提供保修服務，免收人工費，只收取零件費。
For more than warranty, we provide a lifetime warranty service, free of labor costs, charge only spare parts costs.
- 保修期內若未能出示保修卡，本公司不予免費服務。
Failure to present warranty card during warranty period, the company will not be a free service.
- 用戶需保修商品，請先與原銷售單位聯繫。
Users need warranty service, please contact your original sales unit.
- 用戶保修時需提供保修卡和購買發票或有本公司印章的收據憑證。
When users need warranty service, please provide warranty card and purchase invoice, or receipt of the certificate of the company seal.
- 保修不包括運輸費用和不提供上門服務。
Warranty does not include transportation costs and provide on-site service.

維修記錄 Maintenance records

序號 NO.	送修日期 Date for repair	故障原因 Cause	修好日期 Fix date	維修員 Repairer