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## ASSEMBLY INSTRUCTIONS FOR FUME EXTRACTOR KITS USED WITH METCAL SOLDERING SYSTEMS

1. Position the black clip and steel tube assembly at the base of the soldering iron handle, making sure that the tapered end of the tube is positioned towards the soldering iron tip.
2. Feed the slot in the black clip around the handle cord.
3. Gently slide the assembly up the handle until a reasonably tight friction fit is obtained. Because the handle has a slight taper, the clip will tighten when pushed towards the tip of the handle. The tightening process also provides a clamping force on the steel tube.
4. To adjust the distance between the end of the steel tube and the tip of the soldering iron, gently pull the black clip back down towards the base of the handle. This will loosen the grip of the clamp on the steel tube.
5. Slide the steel tube through the clip to the appropriate position, then slide the clamp and tube assembly back onto the soldering iron handle. For best results, position the tapered end of the steel tube as close to the soldering iron tip as possible.
6. Connect one end of the 2.5m length of silicon hose over the end of the steel tube nearest the base of the handle.
7. The 'E' clips are provided to secure the silicon hose to the irons electric cord. Position the clips at approximately 30cm (12") intervals from the base of the handle.
8. A clear plug is provided which can be inserted into the vacuum trunking if desired. Drill a 14mm (.552") hole into the trunking and push the tapered end of the plug into the hole tight to the shoulder. The other end of the silicon hose can then be attached to the extraction nipple on the plug.
9. The plug can be capped off when not in use.
10. If the soldering iron stand is not slotted to accept the soldering iron handle and steel tube, a slotted cradle can be purchased to accept the converted iron handle.
11. A brass wire brush is provided for cleaning purposes. See extraction tip maintenance instruction.

## EXTRACTION TIP MAINTENANCE

1. Insert the brass wire brush into the tapered end of the steel tube.
2. Push the brush the full length of the steel tube in backward and forwards motion two or three times. Do not push the brush into the silicon hose as this will cause damage to the hose.
3. Extract the brush.
4. With forefinger and thumb, roll approximately the first 15 to 23cm (6" to 9") of the silicon hose closest to the steel tube. This rolling process will break away all particles built up by the solder fumes. Once dislodged, these particles will be sucked down the hose and collected in the main filter unit.
5. Make sure the silicon hose is free from kinks, knots, or being trapped. The 'E' clips that attach the silicon hose to the handle cord should be evenly spaced so that the hose and cord run parallel to each other.
6. Cleaning should be performed once or twice daily. However, this can vary from operator to operator. When the steel tube starts to become blocked or restricted, the operator will hear a hissing sound coming from the tube.

**CAUTION: UNDER NO CIRCUMSTANCES SHOULD THIS TUBE BE ALLOWED TO BECOME TOTALLY BLOCKED.**

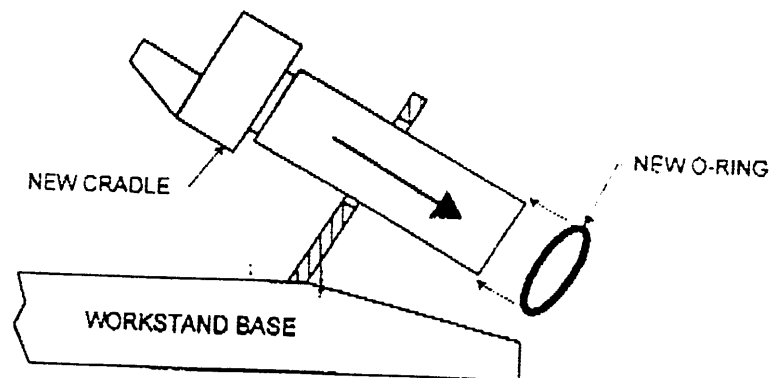
## INSTRUCTIONS FOR INSTALLING THE SP200 WORKSTAND CRADLE

### REMOVE THE OLD CRADLE

1. With a sharp knife or razor blade, cut out the old o-ring holding the cradle in place. Remove and discard.
2. Slide the old cradle out of the workstand and discard.

### INSTALL THE NEW CRADLE

1. Slide the new cradle into the workstand hole from the top (shown below).
2. Slide the new O-ring all the way up the installed cradle until it seats into the groove on the cradle and is snug against the workstand.



## EXTRACTION TIP MAINTENANCE.

1. Insert the brass brush provided into the front tapered end of the stainless steel tube.
2. Push the brush the full length of the stainless steel tube in a back and forward motion two or three times.
3. Extract the brush.
4. With forefinger and thumb, roll the first 6" to 9" of silicone tube immediately after the stainless steel tube which will be at its worst over these first few inches after the steel tube. This rolling process breaks away all particles built up by the solder fume. On breaking away, the particles are sucked down the tube, and eventually collect in the main filter unit.
5. Make sure the silicon tube is free from kinks, Knots or being trapped. The white "E" Clips that attach the silicon tube to the power cord should be evenly spaced allowing the silicon tube to run parallel down the power cord
6. Normal periods of cleaning are once or twice a daily. This can vary from operator to operator. When the stainless steel tube starts to become blocked or restricted, the operator will hear a hissing coming from the extractor tube.

**UNDER NO CIRCUMSTANCES ALLOW THIS TUBE TO  
BECOME TOTALLY BLOCKED**