

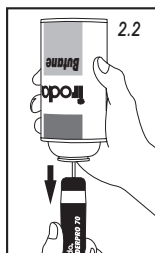
IMPORTANT SAFETY INSTRUCTIONS

Warnings:

- 1.1 Unit contains flammable gas (Butane) under pressure - use with care.
- 1.2 DO NOT expose to heat above +50°C (120°F) and avoid prolonged exposure to the sun.
- 1.3 DO NOT puncture or incinerate.
- 1.4 Excessive gas flow, flaming or catalyst pulsing red may occur when the regulator is incorrectly adjusted, i.e., set too high. It is essential, therefore, to keep unit away from face and body when igniting.
- 1.5 DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials.
- 1.6 KEEP WORK AREA CLEAN. Cluttered areas and benches invite injuries.
- 1.7 KEEP CHILDREN AWAY. All visitors should be kept away from work area.
- 1.8 STORE WHEN NOT IN USE. Store in dry, locked cabinet out of reach of children.
- 1.9 Be extremely careful as torch flame tip temperature is over 1300°C (2370°F)
- 1.10 Be extremely careful as torch flame is almost invisible in daylight or strong light.
- 1.11 WEAR SAFETY GLASSES.
- 1.12 DONT OVERREACH. Keep proper footing and balance at all times.
- 1.13 STAY ALERT. Watch what you are doing. Use common sense. Do not operate when you are tired.
- 1.14 DO NOT TOUCH THE HEATED TIP OR BARREL OF THE UNIT.
- 1.15 DO NOT leave unit unattended when it is operating or hot.
- 1.16 ALWAYS BE SURE THE UNIT IS COOL BEFORE STORING.
- 1.17 DO NOT REPLACE CAP WITHOUT SWITCHING UNIT OFF AND ENSURING TIP HAS COOLED.
- 1.18 USE ONLY IN WELL VENTILATED AREA.
- 1.19 DO NOT attempt to readjust or repair, unit is not user serviceable. Do ensure flame is extinguished before putting down. If flame does not self-extinguish within 30 seconds a new tip is required.

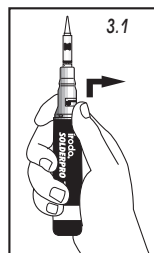
REFUELING

- 2.1 Adaptors are not normally required when refilling.
- 2.2 To refill hold refill can as pictured (fuel transfer is dependent upon gravity). Observe fuel level in transparent window and stop filling when 90% FULL.



IGNITION SEQUENCE-1

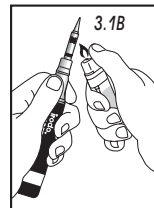
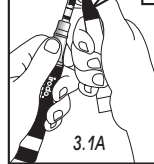
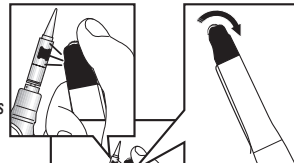
- 3.1 SOLDERING IRON. Push the ON/OFF adjuster upward toward tip to release gas and turn to **mid** position. Then holding the unit away from the face and body, activate with the flint ignitor or regular lighter.



IGNITION SEQUENCE-2

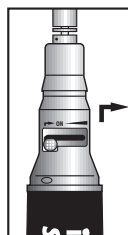
With the other hand, holding it in close proximity to the tip, pointing the stream of sparks at the exhaust ports. Suggest to choose the biggest hot air exhaust port to ignite. The tip will now flame for a few seconds before self-extinguishing.

- 3.2 BLOW TORCH
Same as soldering iron but point stream of sparks into the open end of the Blow Torch tip.
- 3.3 HEAT BLOWER
Same as for soldering iron but point stream of sparks into the open end of the tip. Wait a short time for the flame to self extinguish and to reach operating temperatures.
- 3.4 HOT KNIFE
Same as for the soldering iron tip.



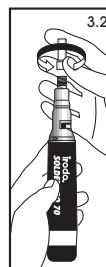
ADJUSTMENT

- 4.1 The tip temperature can be adjusted by turning the ON/OFF adjuster, observing **ON** signs on the body.
- 4.2 Normally set the ON/OFF adjuster forward to **mid** position when soldering or brazing.
- 4.3 If is not necessary for the tip to glow bright red to achieve satisfactory soldering temperatures. Experience will dictate the adjuster setting required.



CHANGING TIPS

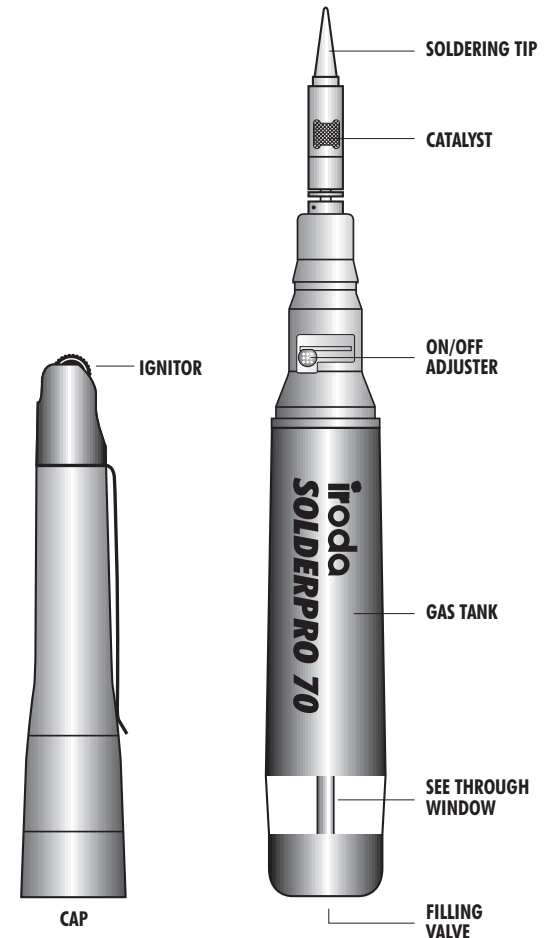
- 5.1 Be sure the tip has cooled before removal. The catalyst see through the exhaust ports of the soldering tip is very delicate and will not sustain mechanical abuse without serious damage.
- 5.2 The soldering tip is easily removable allowing the installation of other style tips or the replacement of a worn tip after the soldering tip is cool, simply unscrew it with a counterclock wise motion. Pliers may be required to lightly grasp the tip in order to loosen it. Be careful not to overtighten as this could damage the thread in the cap.



iroda®

4 IN 1

SOLDERPRO 70K



Pro-Iroda Industries, Inc. Taichung, Taiwan

PATENTS :
R.O.C PATENT PENDING
EUROPEAN PATENTS PENDING
U.S.PATENT 5,135,389
DESIGNED & MANUFACTURED
BY PRO-IRODA INDUSTRIES, INC.

MADE IN TAIWAN

