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YIHUA 936A II

YIHUA 936A II Soldering Iron Station Kit User Manual

Model: 936A II

1. INTRODUCTION

Thank you for choosing the YIHUA 936A II Soldering Iron Station Kit. This manual provides essential information for the safe and efficient operation, maintenance, and troubleshooting of your new soldering station. Please read this manual thoroughly before use and retain it for future reference.

The YIHUA 936A II is a 65W soldering station designed for various soldering and desoldering applications on both Surface Mount Technology (SMT) and through-hole components, including SOP, DIP, and SOIC packages.

2. SAFETY INFORMATION

WARNING: Improper use of soldering equipment can cause serious injury or damage. Always follow these safety guidelines:

- Always work in a well-ventilated area to avoid inhaling solder fumes. Use a fume extractor if available.
- The soldering iron tip reaches very high temperatures (up to 896°F / 480°C). Avoid direct contact with skin or flammable materials.
- Always place the soldering iron in its designated stand when not in use.
- Wear appropriate personal protective equipment, including safety glasses, to protect against splashes of molten solder.
- Ensure the power cord is in good condition and properly connected to a grounded outlet (110-127V US-standard).
- Do not operate the soldering station near flammable liquids or gases.
- Keep children and unauthorized personnel away from the work area.

- Disconnect the power when performing maintenance or when the unit is not in use.
- Do not modify the soldering station or its components. Use only genuine YIHUA replacement parts.

3. PACKAGE CONTENTS

Verify that all items listed below are included in your package:

- 1 x YIHUA 936A II Soldering Station
- 1 x Soldering Iron Holder
- 5 x Assorted Soldering Tips
- 1 x Pack of Solder (1.0mm 15g)
- 1 x 817C Soldering Iron
- 1 x Power Cord



Figure 3.1: Complete YIHUA 936A II Soldering Iron Station Kit with included accessories.

4. PRODUCT OVERVIEW AND COMPONENTS

Familiarize yourself with the main components of your YIHUA 936A II Soldering Station.



Figure 4.1: Labeled diagram of the YIHUA 936A II Soldering Station and its main parts, including the power switch, temperature adjustment dial, operation indicator, soldering iron receptacle, heat-resistant silicone cord, interchangeable soldering iron tips, and heat-resistant bakelite sleeve.

4.1 Control Panel



Figure 4.2: The control panel features an ON/OFF switch, a temperature adjustment dial with Celsius/Fahrenheit markings, and a HEATING indicator light. The indicator light shows the status: ON (heating up), BLINKS (temperature stabilization, ready for use), OFF (cooling down).

4.2 Soldering Iron Stand

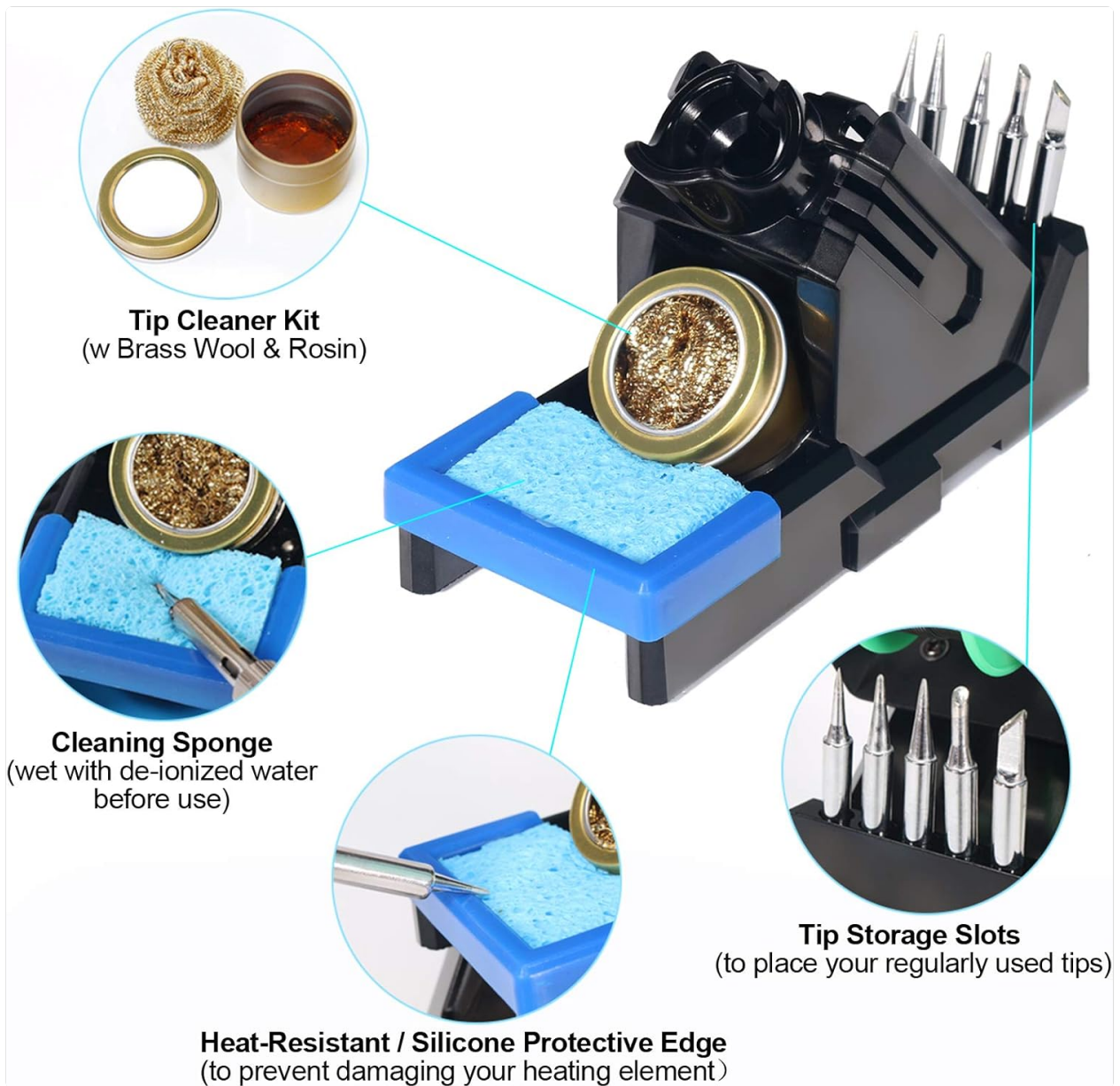


Figure 4.3: The soldering iron stand includes a tip cleaner kit (with brass wool and rosin), a cleaning sponge (to be wet with de-ionized water before use), tip storage slots for regularly used tips, and a heat-resistant silicone protective edge to prevent damage to the heating element.

5. SETUP INSTRUCTIONS

Follow these steps to set up your soldering station for first use:

1. **Place the Station:** Position the soldering station on a stable, heat-resistant surface in a well-ventilated area.
2. **Assemble the Iron Stand:** Attach the soldering iron holder to the main unit. Ensure it is secure.
3. **Prepare Cleaning Sponge:** Lightly dampen the cleaning sponge with de-ionized water. Do not over-saturate.
4. **Connect Soldering Iron:** Plug the 817C soldering iron's connector into the receptacle on the front of the soldering station. Ensure a firm connection.
5. **Insert Power Cord:** Connect the power cord to the back of the soldering station and then to a grounded 110-127V AC outlet.



Figure 5.1: Visual guide for initial setup and operation. Steps include connecting the iron, turning on the unit, coating the tip with solder, observing the indicator light, cleaning and tinning the tip, and safely storing the iron after use.

6. OPERATING INSTRUCTIONS

6.1 Power On and Temperature Setting

1. **Turn On:** Flip the ON/OFF switch to the "ON" position. The "HEATING" indicator light will illuminate.
2. **Set Temperature:** Rotate the temperature adjustment dial to your desired working temperature. The range is 392°F (200°C) to 896°F (480°C).
3. **Wait for Stabilization:** The "HEATING" indicator light will blink rapidly once the set temperature is reached and stabilized. The station is now ready for use.

6.2 Soldering Process

1. **Tin the Tip:** Before first use and periodically during operation, melt a small amount of solder onto the tip.

This "tinning" protects the tip and improves heat transfer.

2. **Clean the Tip:** Use the brass wool or damp sponge in the iron stand to clean any excess solder or oxidation from the tip.
3. **Apply Heat:** Place the hot soldering iron tip against both the component lead and the PCB pad simultaneously. Allow a moment for the joint to heat up.
4. **Apply Solder:** Touch the solder wire to the heated joint (not directly to the iron tip). The solder should flow smoothly and evenly around the joint.
5. **Remove Solder and Iron:** Once a good solder joint is formed, remove the solder wire first, then remove the soldering iron. Allow the joint to cool naturally without disturbance.
6. **Re-tin Tip:** Briefly re-tin the tip with a small amount of fresh solder before returning the iron to its stand.

6.3 Recommended Temperature Guidelines

The optimal soldering temperature depends on the type of solder, component, and application. General guidelines are provided below:

- For leaded solder (e.g., Sn60/Pb40): Typically 600-700°F (315-370°C).
- For lead-free solder (e.g., Sn-Ag-Cu): Typically 700-800°F (370-425°C).

General Rule of Thumb: Set the soldering iron/station temperature approximately 50°C / 90°F above the solder's melting point. For a smoother soldering experience, add an additional 100°C / 180°F to provide a heat reserve for quick thermal recovery of the tip after the solder connection is made.

Recommended Temperature for Soldering

General Rule of Thumb

Your preferred Solder's Melting Point + 50°C + 100°C = **Smoother Soldering Experience**

For example:



If you use **Lead-Free Solder**
Lead-Free Solder (Sn-Ag-Cu)
220°C

$$220^{\circ}\text{C} + 50^{\circ}\text{C} + 100^{\circ}\text{C} = 370^{\circ}\text{C}$$

1. The set temperature for a **soldering iron/station** should be approximately **50°C / 90°F** above its melting point to make a better solder connection.

2. The set temperature for a **soldering iron/station** should be an additional approximately **100°C / 180°F** higher to provide a heat reserve for the quick thermal recovery of the tip after the solder connection is made.



Figure 6.1: Illustration of recommended temperature calculation for soldering, using lead-free solder as an example (220°C melting point + 50°C + 100°C = 370°C).

7. MAINTENANCE

Proper maintenance ensures the longevity and performance of your soldering station.

7.1 Soldering Tip Care

- **Clean Regularly:** Always clean the tip before and after each soldering session using the brass wool or damp sponge.
- **Tin the Tip:** Always tin the tip with a fresh coat of solder before storing the iron. This prevents oxidation.
- **Avoid Excessive Pressure:** Do not apply excessive pressure to the tip, as this can damage it.
- **Replace Worn Tips:** Replace tips when they become pitted, corroded, or no longer hold solder effectively.

7.2 Station Cleaning

- Ensure the unit is powered off and unplugged before cleaning.
- Wipe the exterior of the station with a soft, damp cloth. Do not use abrasive cleaners or solvents.
- Periodically clean the brass wool and replace the cleaning sponge as needed.

8. TROUBLESHOOTING

This section addresses common issues you might encounter with your YIHUA 936A II Soldering Station.

Problem	Possible Cause	Solution
Soldering iron not heating up.	Power switch is OFF. Power cord not connected. Soldering iron not properly connected to station. Faulty heating element or iron.	Ensure power switch is ON. Check power cord connection to station and outlet. Verify soldering iron is securely plugged into the station. Contact customer support if the issue persists after checking connections.
Solder not melting or poor solder joints.	Temperature set too low. Oxidized or dirty soldering tip. Incorrect soldering technique.	Increase the temperature setting. Clean and re-tin the soldering tip. Replace if severely oxidized. Ensure proper contact with both component and pad; apply solder to the joint, not the iron.
"HEATING" indicator light not blinking.	Station still heating up. Temperature sensor issue.	Allow more time for the station to reach the set temperature. If the iron is hot but the light doesn't blink after several minutes, contact customer support.

If you encounter issues not covered here, please refer to the Warranty and Support section for assistance.

9. SPECIFICATIONS

Feature	Detail
Model	YIHUA 936A II
Power Consumption	65 Watts
Input Voltage	110-127 Volts AC (US Standard)
Temperature Range	392°F ~ 896°F (200°C ~ 480°C)
Temperature Stability	Excellent

Feature	Detail
Heating Element	Ceramic
Dimensions (Station)	5.63 x 4.92 x 3.78 inches (14.3 x 12.5 x 9.6 cm)
Item Weight	4.38 pounds (1.99 kg)
Materials	Ceramic, Plastic, Bakelite

10. WARRANTY AND SUPPORT

YIHUA provides a **12-month US-exclusive manufacturer technical coverage** for the 936A II Soldering Iron Station Kit.

For technical assistance, troubleshooting, or warranty claims, please contact YIHUA customer support. You can typically find **24/7 professional assistance on Amazon** or through the official YIHUA website.

Please retain your proof of purchase for warranty validation.