SHENZHEN ATTEM TECHNOLOGY CO., LTD.

- Soldering Iron
- Soldering Station
- Hot Air Rework Station
- Multi-function Rework System
- BGA Rework System
- Regulated DC Power Supply
- Switching DC Power Supply
- Programmable Power Supply

AT-937/AT-937A/AT-989

SOLDERING STATION

Thermo-control Anti-Static

User’s Manual

MADE IN CHINA

CBN029927 (E)
Precautions

In this instruction manual, "WARNING" and "CAUTION" are defined as follows.

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CAUTION!

Before use this unit, make sure comply with the following measures, against risk of electric shock or give rise to fire.

In order to ensure body safe, must use the components or accessories that recommended by original factory, otherwise it may cause serious consequences.

It should be maintained by qualified electric technician or service personnel specified by original factory.

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When the power is on, the tip temperature is between 200°C/392°F and 480°C/896°F.

Since mishandling may lead to burns or fire, be sure to comply with the following precautions.

- Do not touch the metallic parts near the tip.
- Do not use the product near flammable items.
- Advise other people in the work area: the unit can reach a very high temperature and should be considered potentially dangerous.
- Turn the power off while taking breaks and when finished using the unit.
- Before replacing parts or storing the unit, turn the power off and allow the unit to cool down to room temperature.

To prevent damage to the unit and ensure a safe working environment, be sure to comply with the following precautions.

- Do not use the unit for applications other than soldering.
- Do not rap the soldering iron against the workbench to shake off residual solder, or otherwise subject the iron to severe shocks.

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WARNING: The Soldering Iron Must be Use AT-TEEN Heating Element.

CAUTION: Misuse may potentially cause injury to the user or physical damage to the objects involved. For your own safety, be sure to comply with these Precautions.

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Packing list

Please check the contents of the AT-937 package and confirm that all the items listed below are included.

- Station 1pcs
- Soldering Iron 1pcs
- AT-TEEN Iron Holder (With Cleaning Sponge) 1pcs
- Instruction Manual 1pcs

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Specification

<table>
<thead>
<tr>
<th>Mode</th>
<th>AT-937</th>
<th>AT-937A</th>
<th>AT-989</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power Voltage</td>
<td>230VAC/50Hz</td>
<td>110VAC/60Hz</td>
<td></td>
</tr>
<tr>
<td>Power Consumption</td>
<td>50W</td>
<td>65W</td>
<td>65W</td>
</tr>
<tr>
<td>Heater</td>
<td>Stainless steel heater</td>
<td>Stainless steel heater</td>
<td>Ceramic heater</td>
</tr>
<tr>
<td>standby function</td>
<td>NO</td>
<td>YES</td>
<td>YES</td>
</tr>
<tr>
<td>sleep function</td>
<td>NO</td>
<td>YES</td>
<td>YES</td>
</tr>
<tr>
<td>Temperature Range</td>
<td>200~480°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Tip Leakage Voltage</td>
<td>≤2mV</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Standard Tip</td>
<td>T900Series</td>
<td></td>
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</tr>
</tbody>
</table>

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Warranty

This product warranty period cover 24 months from the day this product purchased. We will make free maintenance for any quality problem itself if this card and receipt provided. We will repair and return your device within 2 workdays after receiving repairing-request device.

Note: Please attach this warranty card if you want your device to be repaired without change.
5. Auto standby function
When the soldering iron is not in use and put the soldering iron on the iron holder, it will auto standby after 10 minutes, heater is heating up to 200°, pick up the soldering iron and back to normal working mode. (P.S. AT-937 without the functions)

6. Auto sleep function
In auto standby mode, the soldering station will auto sleep after 20 minutes, heater is heating up to 100°, pick up the soldering iron and back to normal working mode. (P.S. AT-937 without the functions)

7. The LED indicator light display status when this device is power on
1. The LED indicator light is steady on: Means this device is heating up
2. The LED indicator light is off: Means this device is not heating up(it may mean temperature overshoot, unsuccessfully connecting soldering iron handle or broken heating core)
3. Breathing state(The LED indicator light turn into lighter from dark then turn into darker, loop): Means this device is under constant temperature.
4. The LED indicator light is flash: Means this device enter into sleep or standby status (Only AT-937A, AT-989 have this function).
Tip Care and Use

1. Tip Temperature
High soldering temperatures can degrade the tip.
Use the lowest possible soldering temperature. The excellent thermal recovery characteristics ensure efficient and effective soldering even at low temperature.

2. 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 tip’s 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.

3. When Not in Use
Never leave the soldering iron sitting at high temperature for long periods of time, as the tip’s solder plating will become covered with oxide, which can greatly reduce the tip’s heat conductivity.

4. After Use
Wipe the tip clean and coat the tip with fresh solder. This helps prevent tip oxidation.

Maintenance

1. Inspect and Clean the Tip
CAUTION: Never file the Tip to remove oxide.

2. Calibrating the Iron Temperature
The soldering iron should be recalibrated after changing the iron, or replacing the heating element or tip.
- Connect the cord assembly plug to the receptacle on the station.
- Set the temperature control knob to 400°C (750°F).
- Turn the power switch to “ON” and wait until the temperature stabilizes. Remove the CAL pot plug.
- When the temperature stabilizes, use a straightedge (+) screwdriver or small plus (+) screwdriver to adjust the screw (marked CAL at the station). Until the tip thermometer indicates a temperature of 400°C (750°F). Turn the screw clockwise to increase the temperature and counterclockwise to reduce the temperature. Replace the CAL pot plug.

We recommend the ATTEN 191/192 thermometer for measuring the tip temperature.

3. Tips
The tip temperature will vary according to the shape of the tip. The preferred method of adjustment uses a tip thermometer (see “Calibrating the Iron Temperature”).

Troubleshooting Guide

WARNING!
Disconnect the power plug before servicing. Failure to do so may result in electric shock.
If the power cord is damaged, it must be replaced by the manufacturer, its service agent or similarity qualified person in order to avoid personal injury or damage to the unit.

Problem 3.
The tip heats up intermittently.
[Check 3.]

Problem 4.
The tip is not wet.
[Check 5.]
Is the tip temperature too high?
- Set an appropriate temperature.
[Check 6.]
Is the tip clean?
- Refer to ‘Tip Care and Use’.

Problem 5.
The tip is not wet.
[Check 7.] Is the tip coated with oxide?
- Refer to “Inspect and clean the tip”.
[Check 8.]
Is the iron calibrated correctly?
- Recalibrate.

Problem 6.
The tip cannot be pulled off.
[Check 9.] Is the tip seized?
Is the tip swollen because of deterioration?
- Replace the tip and the heating element.

Problem 7.
The tip doesn’t hold the desired temperature
[Check 8.]