



Vacuum Pick Replacement Manual for the
SODRTEK®
ST 350 Digital Convective
Soldering/Desoldering System
P/N 5050-0545



Shown with optional ST 450 Pre-Heating System

TITLE	PAGE
Removal	3
Installation	6

Vacuum Pick Replacement

Removal

1. Turn the knob counterclockwise to remove it from the shaft. Hold the shaft when loosening in order to keep the shaft from rotating.

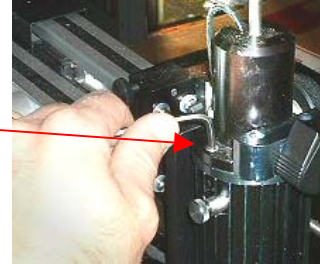


2. Remove the vacuum hose.



3. Remove the Pick Shroud. (Requires a 9/64" hex key).

2 hex socket
head screws



4. Carefully lift the Pick Shroud from the Reflow Head Assembly.



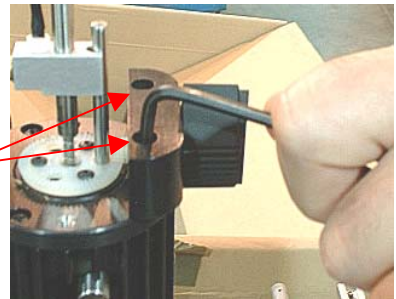
5. Make sure that the Theta Knob is centered as shown.

Must be pointing up.



6. Remove the Theta Knob Assembly. (Requires a 9/64" hex key).

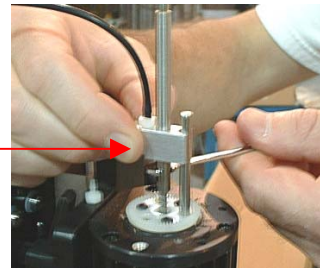
2 hex socket head screws



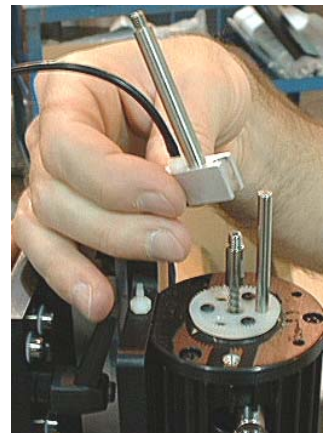
7. Loosen the vacuum pick with a 7/32" open-end wrench.

NOTE: Failure to hold the manifold assembly may result in damage to the vacuum tube.

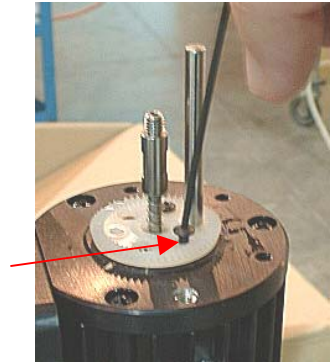
Hold the manifold to keep the assembly from rotating



8. Carefully lift the assembly from the vacuum tube.



9. Remove the 3 button head screws with a 1/16" hex key.



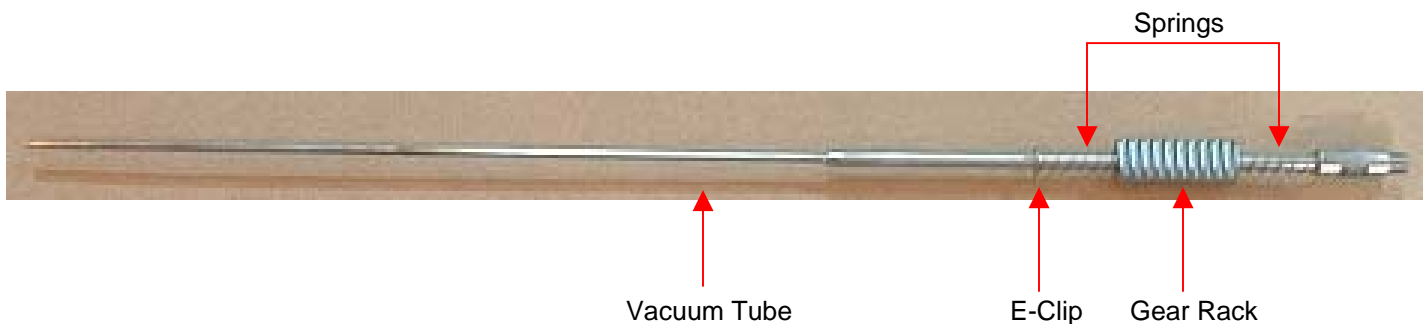
10. Gently lift the Beveled Gear from the Reflow Head.



11. Carefully remove the vacuum tube assembly from the Reflow Head.

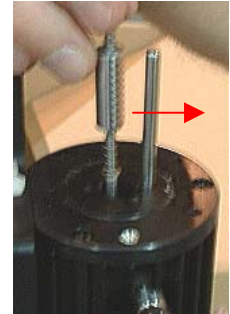


12. Remove the E-Clip and slide the Springs and Gear Rack from the Vacuum Tube. With the exception of the Vacuum Tube, these parts will be reused on the new Vacuum Tube.



Installation

1. Install the Springs, Gear Rack, and E-Clip on the new Vacuum Tube.
2. Insert the Vacuum Tube Assembly into the Reflow Head. Be sure to face the teeth of the Gear Rack to the front.

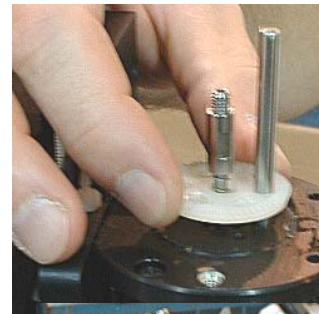


3. Use the Vacuum Pick Control Knob to verify engagement of the Vacuum Tube Assembly.

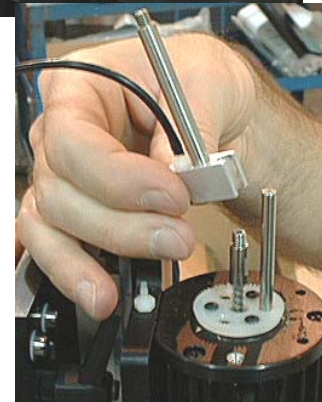


Vacuum Pick Control Knob

4. Install the Beveled Gear. Install and tighten the three button head screws with a 1/16" hex key. Must be snug but do not over tighten!



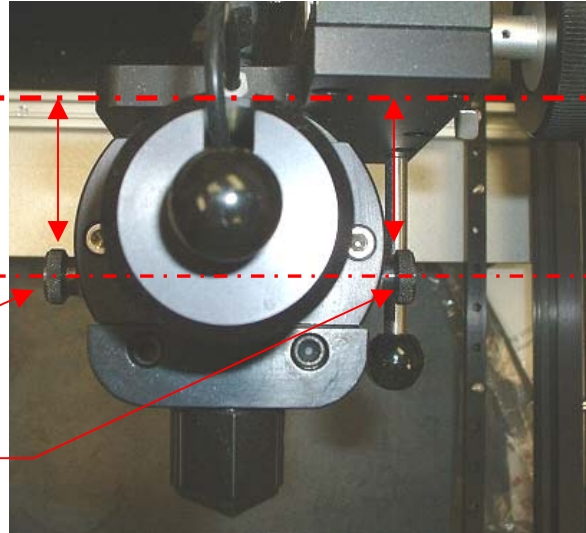
5. Insert the Manifold Vacuum Assembly and tighten the vacuum pick with a 7/32" open-end wrench. Must be snug but do not over tighten!



6. Before installing the Theta Knob Assembly, be sure to properly line up the Vacuum Pick Control Knobs.

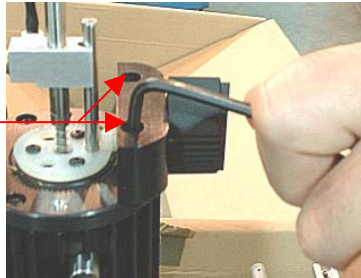
Knob axis centerline

Make sure that the knobs are parallel to the Reflow Head Mounting Heat Mounting Plate.

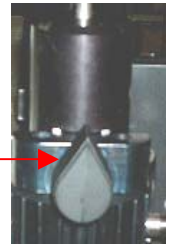


7. Install the Theta Knob Assembly.

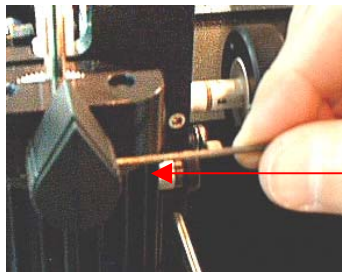
Install the Theta Knob Assembly. (Requires a 5/64" hex key).



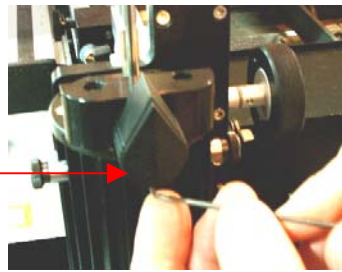
Theta Knob must be pointing up.



NOTE: It is also possible to adjust the Theta Knob by adjusting its position on the shaft. This will require a 5/64" hex key to loosen the two setscrews.



2 Set Screws



8. Carefully install the Pick Shroud onto the Reflow Head Assembly. Make sure that the Vacuum Pick moves freely when turning the Vacuum Pick Control Knob.



9. Install the vacuum hose.



10. Turn the knob clockwise to install it on the shaft. Hold the shaft when tightening in order to keep the shaft from rotating.

11. Verify proper operation.



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