

ENG

The ST45N Nitrogen Soldering Station consists of a microprocessor-based soldering station and SensaTemp-compatible PS80N Nitrogen Soldering Iron. The station is designed for manual soldering applications where the benefits of nitrogen-assist, including nitrogen preheating are required. The station is a derivative of the ST45 Digital Soldering Station and is identical to it in all operational aspects except for nitrogen connection and flow control. The ST45 manual is included with the system to provide station operation and maintenance information. Nitrogen-system specific information is contained within this addendum. PACE recommends use of the NF500 or NF1000 Nitrogen Farm with the ST45N Nitrogen Soldering Station. The nitrogen generators separate nitrogen from your compressed air supply and support multiple stations without requirement for compressed gas and preheaters. The nitrogen generator connects to the ST45N using standard compressed air tubing and fittings to supply nitrogen to the station for the nitrogen soldering iron.

Specifications

Refer to the ST45 manual for system specifications. Refer to the NF500 or NF1000 manual for nitrogen farm specifications and set-up instructions.

ST45N Nitrogen Supply Input Requirements:

Nitrogen Flow: .018 to .088 CFM (0.5 to 2.5 SLM)

Set-Up

Nitrogen Supply Connection

The ST45N system provides nitrogen to the PS80N Nitrogen Soldering Iron from an externally connected nitrogen source. PACE recommends use of the NF500 or NF1000 Nitrogen Farm with the ST45N.

1. Attach a length of small, flexible air hose (not supplied) to the air hose fitting on the rear of the PACE power source per the following instructions. PACE does not recommend direct attachment of quick-connect air hose fittings to the power source. The weight of standard large air hose lines will affect the stability of the system and requires more bench space.
 - a) **230 VAC Systems only:** A metric adapter fitting is installed on the air hose fitting of 230 VAC systems.
 - b) Install the connector (with small, flexible air hose) onto the air hose fitting (or metric adapter) finger tight. Using an appropriate wrench, tighten the connector an additional $\frac{1}{4}$ turn. **DO NOT** overtighten. (Refer to Figure 1.)
2. Connect the free end of the small, flexible air line hose to your nitrogen supply using the appropriate fittings.

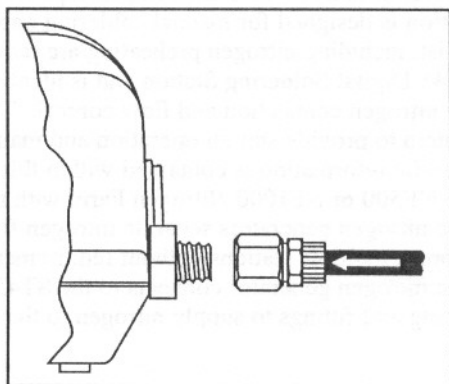


Figure 1

Nitrogen Iron Hose Installation

Set up your PS80N air hose connection per the following instructions:

1. Hose to PS80N Nitrogen Iron Connection
 - a) Attach one end of a 137cm (54 inch) length of air hose to the metal tube on the back of the iron.
 - b) Attach the hose to the iron using the supplied hose clamps. Space them evenly along the length of the power cable.
 - c) Insert the barbed end of the male quick connect hose fitting into the free end of the hose.
2. Insert the end of the quick connect hose fitting into the power source nitrogen port. (Refer to Figure 2.)
3. The ST45N station operates identically the same as the ST45 station. Refer to the ST45 manual for tool stand set up, and operation and maintenance instructions.

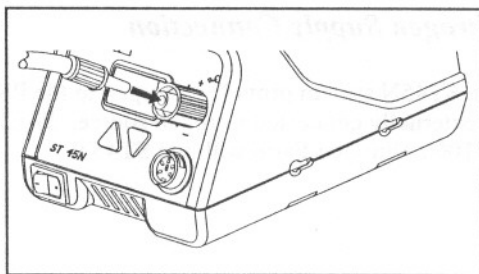


Figure 2

NOTE

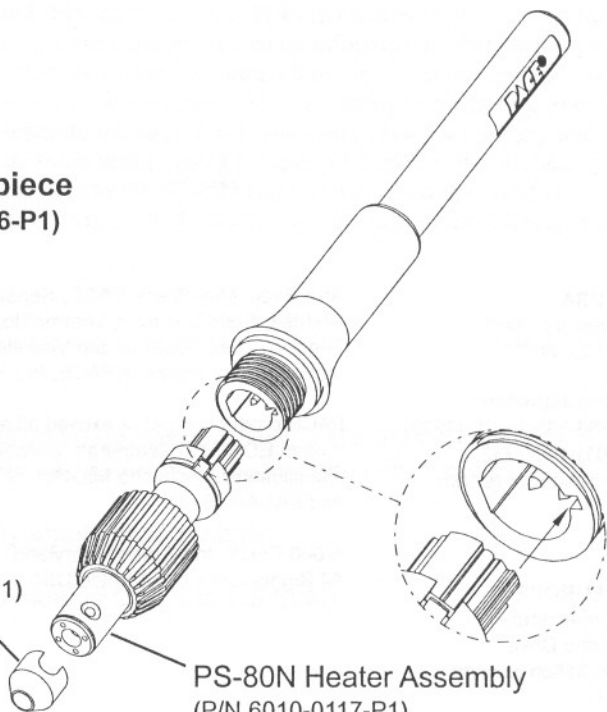
To ensure optimum soldering iron performance and heater life, the heater has been burned in. As a result, the heater shroud may be discolored.

Spare Parts

PS-80N Handpiece (Part # 6010-0116-P1)

Nitrogen Skirt
(P/N 1259-0121-P1)

PS-80N Heater Assembly
(P/N 6010-0117-P1)



PACE USA

9893 Brewers Court
Laurel, MD 20723
U.S.A.

Tel: (301) 490-9860

1-888-535-PACE (7223)

Fax: (301) 498-3252

www.paceworldwide.com

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications, including MIL-Std-2000, ANSI/J-Std-001, and IPC-A-610.

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PACE EUROPE

Sherbourne House,
Sherbourne Drive
Tilbrook, Milton Keynes
MK7 8HX
United Kingdom
Tel: (44) 01908 277666
Fax: (44) 01908 277777

PACE*