

Lead-Free Reflow Oven User Manual T-937S



User Manual

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1.Parameters

Drawer area	350mm × 370mm
Soldering area	Lead-Free Welding: 290 × 345mm Lead Welding: 315mm × 345mm
Dimension	438mm × 535mm × 290mm
N. Weight	20.7kg
Voltage/Frequency	AC220~230V/AC110V 50Hz /60Hz
Power rating	2960W
Cycle time	2~16 min
Temp range	Room temp~300℃

2.Packaging list

Name	Q'ty
T-937S Reflow oven	1
Fuse	220V:20A × 1pc 110V:32A × 1pc

3.Main parts

Main body



① LCD touch screen ② Drawer ③ Switch ④ Power line

others



① Exhaust ② Cooling fan of motherboard

4.Installation

- 1) Please put this reflow oven on the flat tabletop, reserve space for drawer-pull & push .
- 2) Avoid inflammable, explosive and other temperature sensitive articles nearby.
- 3) Please leave 20mm space around the machine, for heat dissipation.
- 4) Please connect the exhaust to the outdoor ventilation place or recovery device to avoid indoor pollution.
- 5) Ensure the machine is grounded reliably.

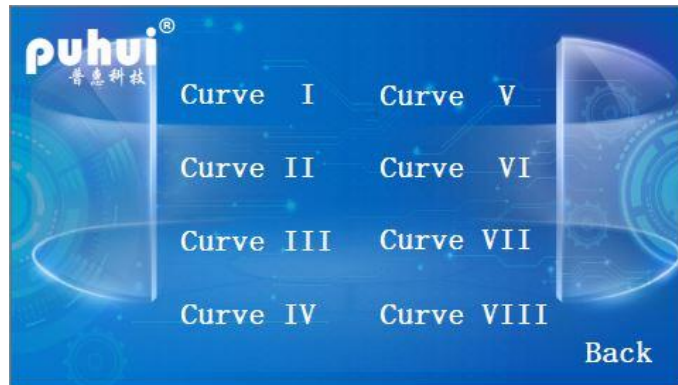
5.Software Interface

- 1) Panel Function



Language switch option

- 2) Press "Select Curve", enter into the curves interface, where users can choose suitable curve from them.
(Any curves built-in cannot be edited).



This machine is equipped with 8 preset curves:

Curve 1, available for: Sn99Ag0.3Cu0.7/SAG305;

Curve 2, available for: Sn/Ag3.5; Sn/Cu.75 Sn/Ag4.0/Cu.5;

Curve 3, available for: 85Sn/15Pb 70Sn/30Pb;

Curve 4, available for: 63Sn/37Pb 60Sn/40Pb;

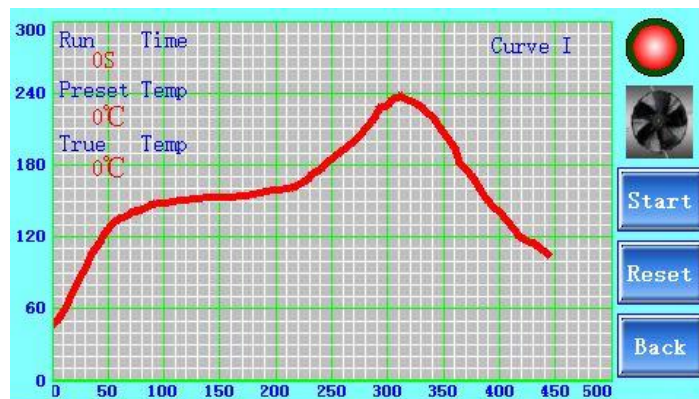
Curve 5, available for: Sn/Ag3/Cu.5 ;

Curve 6, available for: Standard curing of red glue, Heraeus PD955M ;

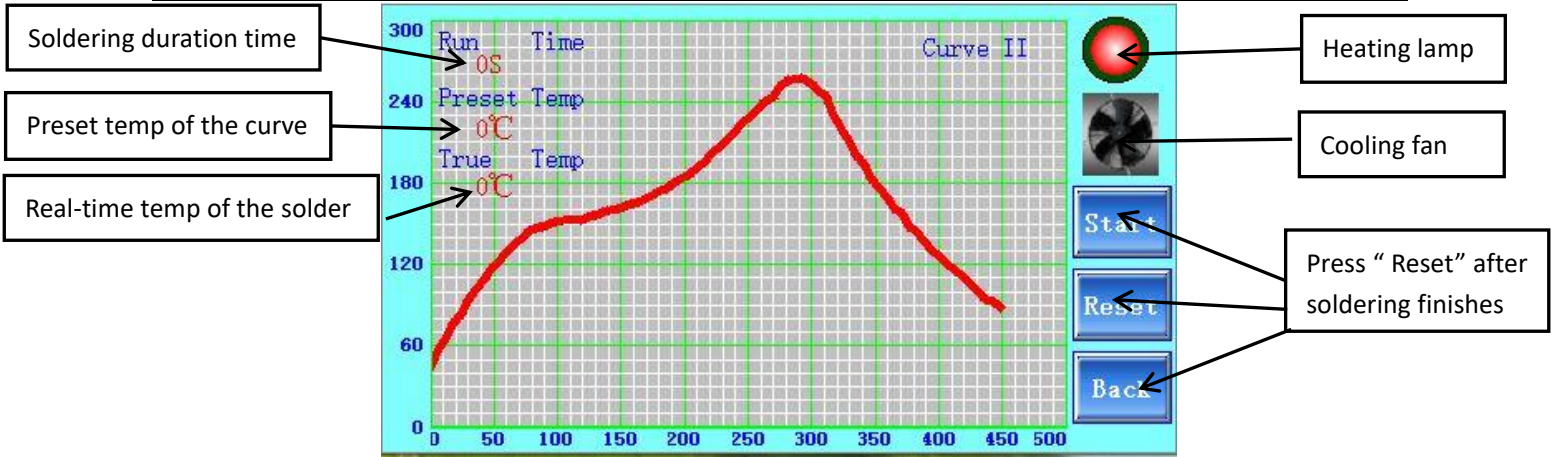
Curve 7, available for: PCB repair work etc.;

Curve 8, available for: Sn/Ag3.5 Sn/Ag3.0/Cu.8 Sn/Sb.5; Sn/Bi3.0/Ag3.0 .

- 3) Choose suitable curve, enter into the soldering interface.



Press "start", the reflow oven begins to work. When the "True Temp" is between 45°C and 60°C, the value of the "Run Time" starts to change and the heating curve begins to draw. When the "Preset Temp" is higher than the "True Temp", the indicator light color is green, the infrared tubes heating, the fan stops; When the "Preset Temp" is lower than the "True Temp", the indicator color will be red, the infrared tubes stop heating and the fan starts.



4) Press "Room Temp" into interface below:



Need to calibrate the room temperature before using for the first time.


Press "OK" button---

a. If the room temperature is higher than 40°C, the password box will pop up, users need to enter the



correct password, click the "ok" button --- click the "Display" button, -click [home button icon]. Then turn on the machine again. Enter room temp interface, it will show the correct room temperature, just quit the interface to other functions.



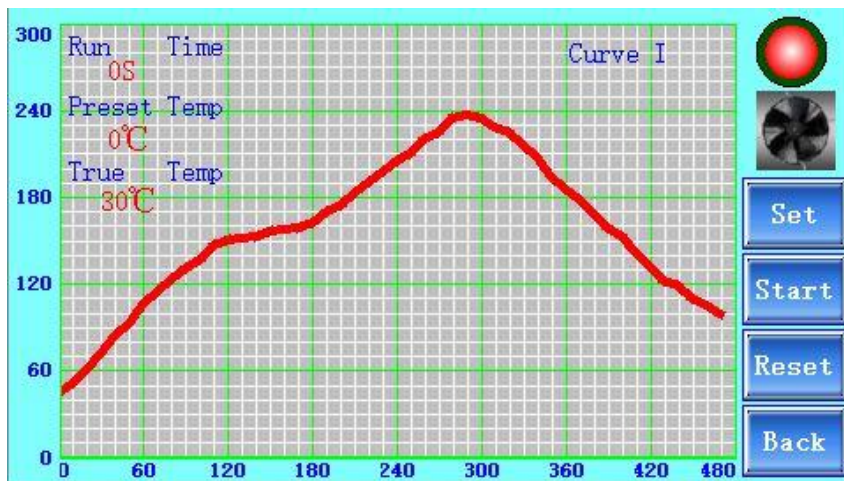
b. If the room temperature is lower than 40°C, click the "Display" button, click . Then turn on the machine again. Enter room temp interface, it will show the correct room temperature, just quit the interface to other functions.

Special note: The machine is strictly prohibited calibrating room temp in the high temperature after heating !!

5) Press "Design Curve" into interface below:

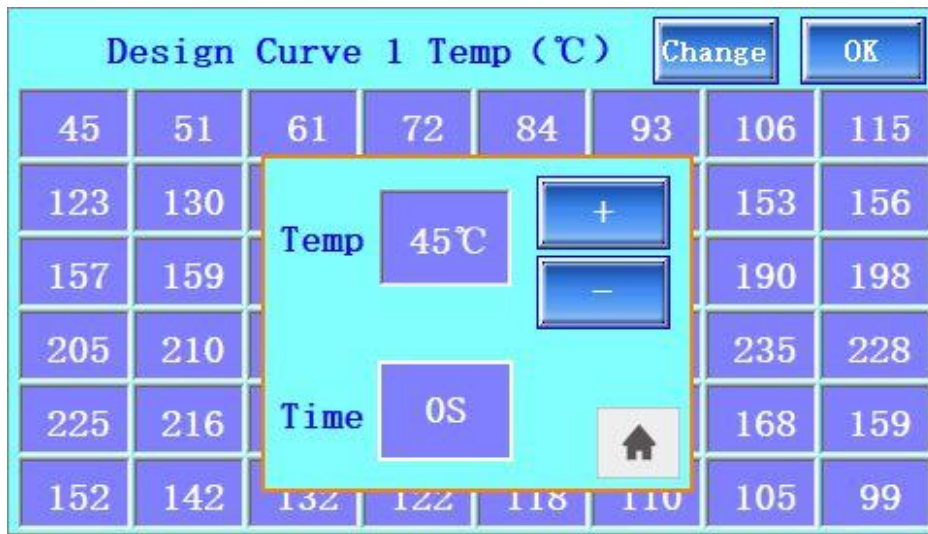


Press the "Design Curve I "



Press "set" button,

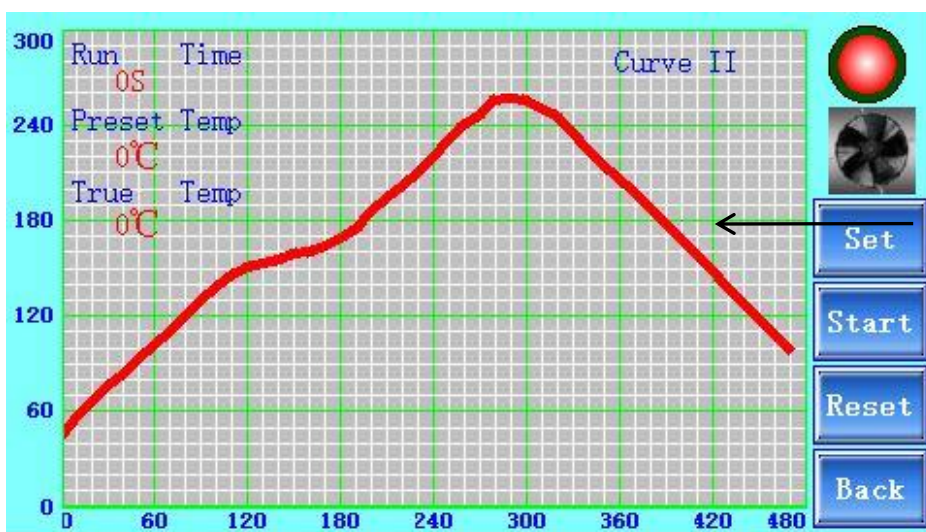
Set the peak temp value in different time, (the total welding time is 470s, a fixed value), as below pic:



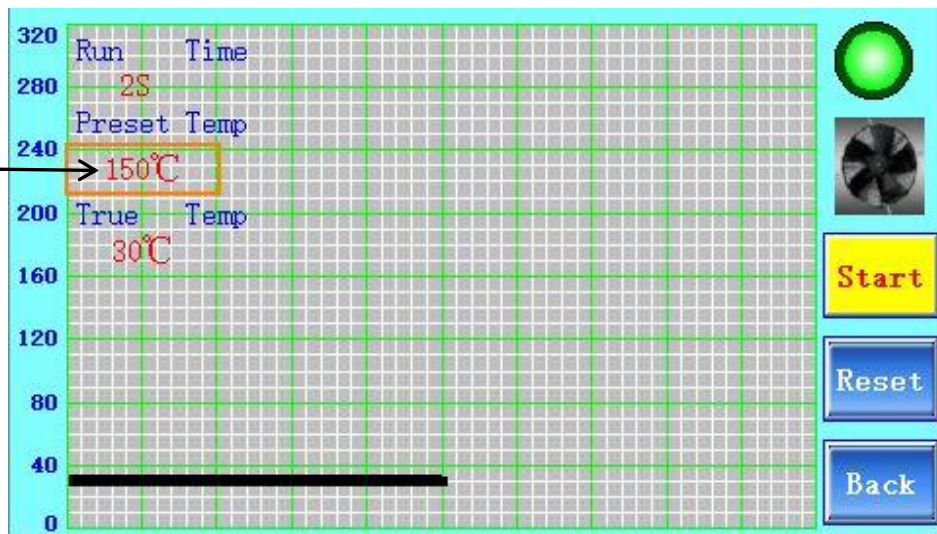
The temperature value of the 1st row from left to right corresponds to the time value 0→70s;
 The temperature values in the 2nd row from left to right correspond to the time values 80→150s
 In the 3rd row, the temperature value from left to right corresponds to the time value 160→230s;
 The temperature values in the 4th row from left to right correspond to the time values 240→310s
 In the 5th row, the temperature value from left to right corresponds to the time value 320→390s;
 In the 6th row, the temperature value from left to right corresponds to the time value 400→470s;

- a. Users can directly click the temperature value to change the temp value in the selection;
- b. or can also click on "Change" Button, and a small window will pop up. Click the "+" and "-" buttons on the interface to conveniently change the temperature value at a specified point in time.

The time value is fixed and cannot be changed. Click "OK" button to return to the heating interface of self-set curve and a new curve has been drawn.



- 6) Press "Constant Temp Timing", enter into below interface. That's function is for setting Constant Temp state.



- 7) The buzzer will ring when the soldering finishes.

Special note: In the cooling stage of reflow welding process, if the actual temperature is higher than the preset temperature of 15°C, the motherboard will send out a beeping prompt, which is a normal phenomenon.

- 8) The system version is subject to change without prior notice.

6.Attention

- 1) Ensure the machine is grounded reliably.
- 2) Please connect the exhaust pipe to the outdoor ventilation place or recovery device to avoid indoor pollution.
- 3) The thermal insulation material of the machine has been strictly protected, it is not allowed to disassemble the machine without protection.
- 4) You should reserve more than 10s time interval between last turning off and next turning on, It cannot be turned on / off continuously.

7.Warranty

The whole machine's warranty is one year, with lifelong maintenance, long-term Ex-factory price supply accessories, we provide instant online Q & A , technical consulting services.

Declaration

If there is any inconsistency between user manual and actual product, the actual product shall prevail.