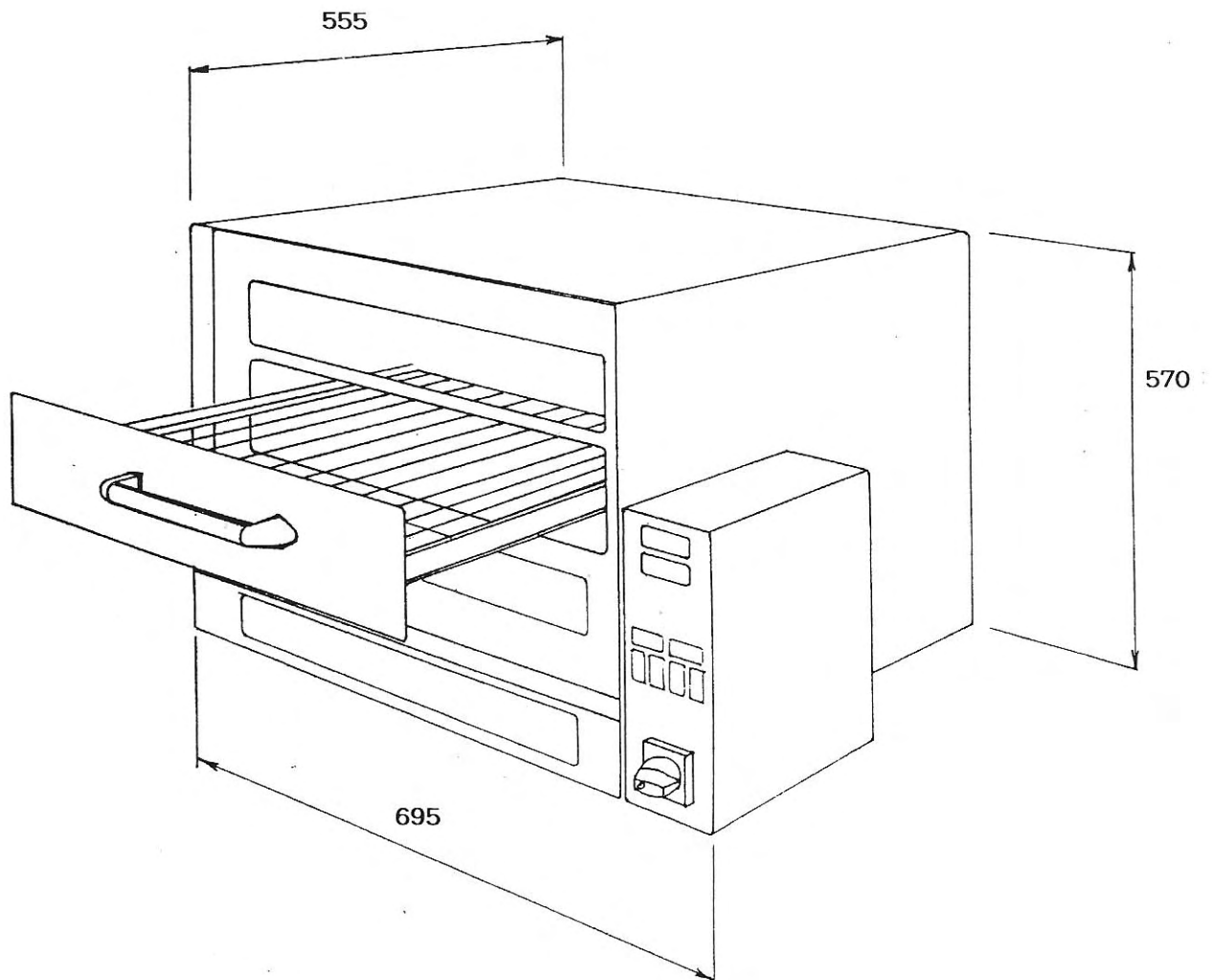


HA-08 REFLOW SOLDER OVEN



=====

1) CONNECTION AND POWER:

The oven is to be installed on a heat resistant floor/background. To power oven, fit main plug of minimum **16 Amp**. When power is switch on, (switch **A** on the front of the control panel) the oven will be start to preheat temperature.

The temperatures and times can be set with the switches G-H-I-J at the front panel, and the set basic time(t1) and temperature(°C1) can be read from the two displays time and temperature.

Basic temperature is selected on the basis of the solderpaste to be used, but will normally range from 140 to 180°C.

When the oven has completed the preheating phase, the preheat and reflow LED's (E-F) will light up in green, instead of red LED indication, accompanied by an acoustic signal.

2) THE SOLDERING CYCLE:

The cycle is started by opening the drawer and placing a pc-board in the drawer. This should preferable be done within two minutes. If the drawer is not closed within two minutes, the oven will switch off automatically! When this nevertheless happens, restore by pushing the reset button (K). If the soldering process is interrupted by opening the drawer, push the reset button (K) and cycle can be restarted from 2).

Time and temperature can be read from the displays. During the final stage of the preheating phase, the oven will maintain the basic set temperature, preheat LED (E) is flashing red/green. Upon completion of the preheating time, the reflow time will start, reflow LED (F) is flashing red/green. Temperature and time during the reflow period can be read from the displays. After completion of the reflow phase, the oven will emit an acoustic signal indicating that the drawer is to be opened and the pc-board removed. If the drawer is opened, the display will indicate that the drawer should remain open during the cooling period.

Only after temperatures have dropped to basic temperature, the displays indicate to close the drawer, accompanied by an acoustic signal.

The drawer must then be closed without pc-board and the cycle will restart from 2.

3) SETTINGS:

To change set times or temperatures, one should press the switches for time and temperature either positively + or negatively - .

The displays will show the previous value set for 1 second, after which this value will change positively or negatively. These set values will remain visible on the displays for two seconds (set value) to subsequently return to process value.

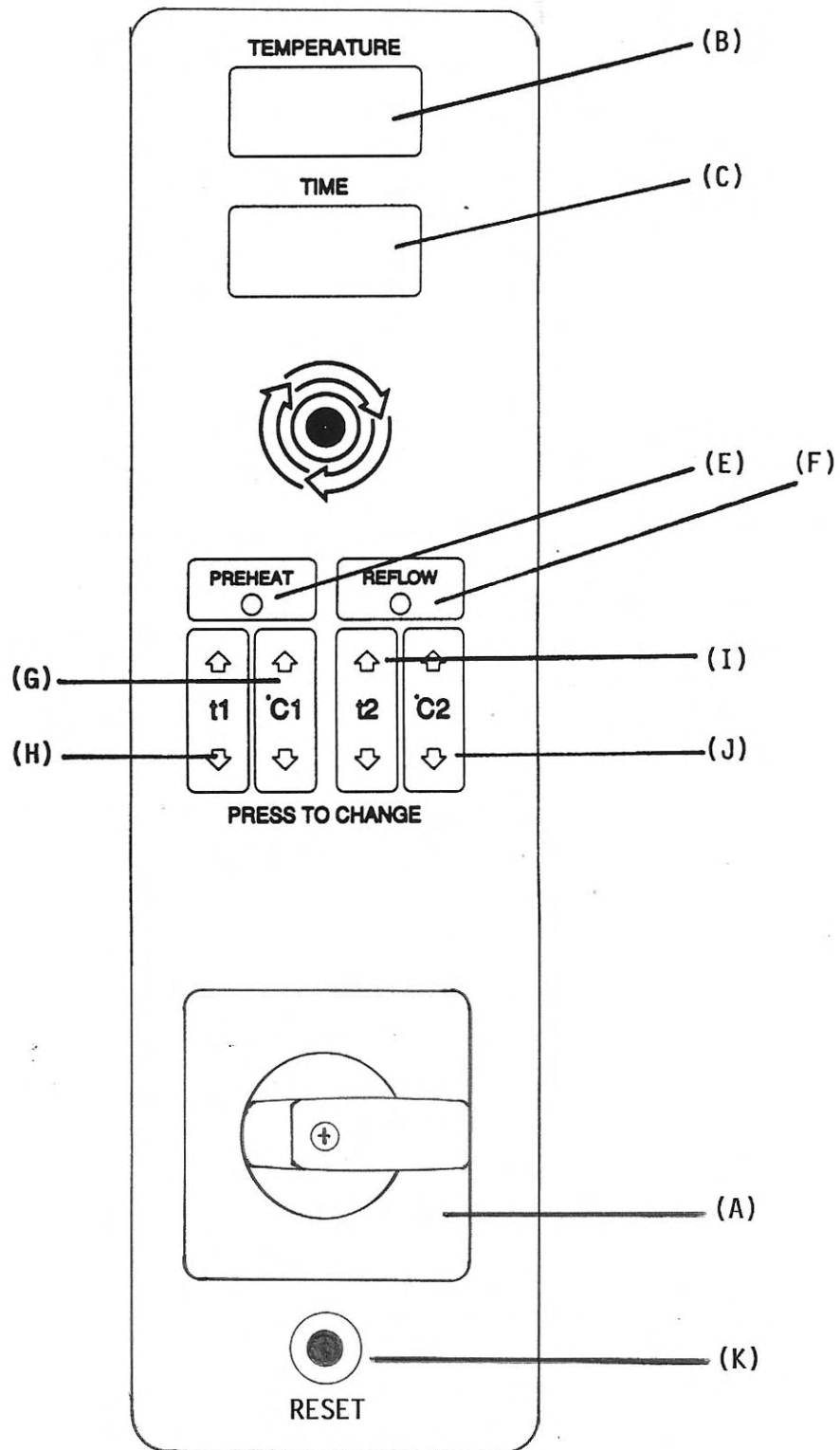
The time value for preheat (t1) and reflow (t2) can each be adjusted from 0 - 999 seconds.

The temperature setting for preheat temperature (°C1) is: 60 - 230 °C.

The temperature setting for reflow temperature (°C2) is: 90 - 290 °C.

Note well, that whatever the temperature setting is, there will always be a difference of 30°C. between preheat and reflow temperatures!

If the oven is not in use for 30 minutes, heating elements switching off automatically. By pressing the reset button (K) on the back side of the oven, the oven will start heating up to the set basic temperature.



TECHNO-HA/08 REFLOW OVEN WITH INERT GAS CONNECTION

When you want to run this oven with inert gas, be sure that you are working with non toxic or non explosive gas. (only N₂).
It will never be possible to work in a complete inert process chamber since there always will leak some air in to the process chamber. The inert gas only sees that you don't have so much oxidation as without inert gas connection.
The inert gas is heating before entering the process chamber, and cannot disturb your temperature profile.

TECHNICAL SPECIFICATION HA-08 REFLOW SOLDER OVEN

MAX. PCB dimensions: 265 x 440 mm. (10 x 17 Inches)
Power requirements: 208/240 VAC 50/60 Hz. single phase
Rated power max: 3950 watts
PREHEAT zone: 2400 watts forced air convection heat
REFLOW zone: 1500 watts quartz heaters

PREHEAT time: 1 - 999 sec.
REFLOW time: 1 - 999 sec.

PREHEAT temp.: 60 - 230°C.
REFLOW temp.: 90 - 290°C.

HEATUP time: approx. 8 - 12 minutes
WEIGHT: approx. 34 kg.
DIMENSIONS: 670 x 570 x 530 mm.

°°°000000000000000000000000°°°

TECHNO-HA/08 REFLOW OVEN WITH INERT GAS CONNECTION

When you want to run this oven with inert gas, be sure that you are working with non toxic or non explosive gas. (only N₂).

It will never be possible to work in a complete inert process chamber since there always will leak some air in to the process chamber. The inert gas only sees that you don't have so much oxidation as without inert gas connection.

The inert gas is heating before entering the process chamber, and cannot disturb your temperature profile.

TECHNICAL SPECIFICATION HA-08 REFLOW SOLDER OVEN

MAX. PCB dimensions: 265 x 440 mm. (10 x 17 Inches)

Power requirements: 208/240 VAC 50/60 Hz. single phase

Rated power max: 3950 watts

PREHEAT zone: 2400 watts forced air convection heat

REFLOW zone: 1500 watts quartz heaters

PREHEAT time: 1 - 999 sec.

REFLOW time: 1 - 999 sec.

PREHEAT temp.: 60 - 230°C.

REFLOW temp.: 90 - 290°C.

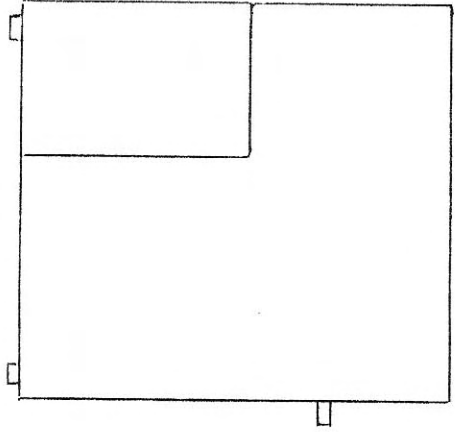
HEATUP time: approx. 8 - 12 minutes

WEIGHT: approx. 34 kg.

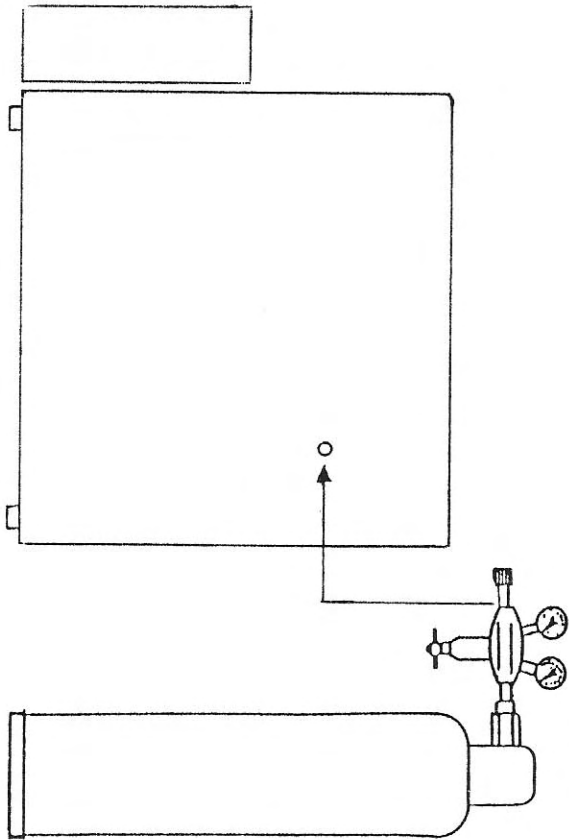
DIMENSIONS: 670 x 570 x 530 mm.

°°°00000000000000000000°°°

INERT GAS CONNECTION HA/08 REFLOW SOLDER OVEN



BACK SIDE OVEN HA/08



NITROGEN GAS