

TECHNO- HA-06

OPERATION INSTRUCTIONS FORCED AIR CONVECTION OVEN TECHNO-HA/06

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1) CONNECTION AND POWER:

The oven is to be installed on a heat resistant floor/background. To power oven, fit main plug of minimum 10 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 - 260 °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 front side of the oven, the oven will start heating up to the set basic temperature.

REFLOW SOLDER OVEN TECHNO-HA/06 WITH INERT GAS CONNECTION

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When you want to run the solderoven HA-06 with inert gas, be sure that you are working with non toxic or non explosive gas!

The flowmeter on the solder oven has a scale for air/nitrogen, working with other gases will only indicate a flow but not read out accurate data.

It will never be possible to work in a complete inert process chamber since there allways will leak some air in to this process chamber.

The inert gas only sees that you do not have so much oxidation as without inert gas!

You have to adjust the gas flow to approximately 100-400 L/hour, (flowmeter max. 500 L/hour) with a pressure between 2 and 4 bar.

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

TECHNICAL SPECIFICATIONS HA-06 SOLDER OVEN:

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Power requirements: 208 - 240 VAC. 50/60 Hz.

Rated power: 3950 Watts

Preheat zone: 2500 Watts

Reflow zone: 1400 Watts

Max. substrate surface PCB: 300 x 370 MM.

Two heating zones, microprocessor controled.

Preheat time: 1 - 999 sec.

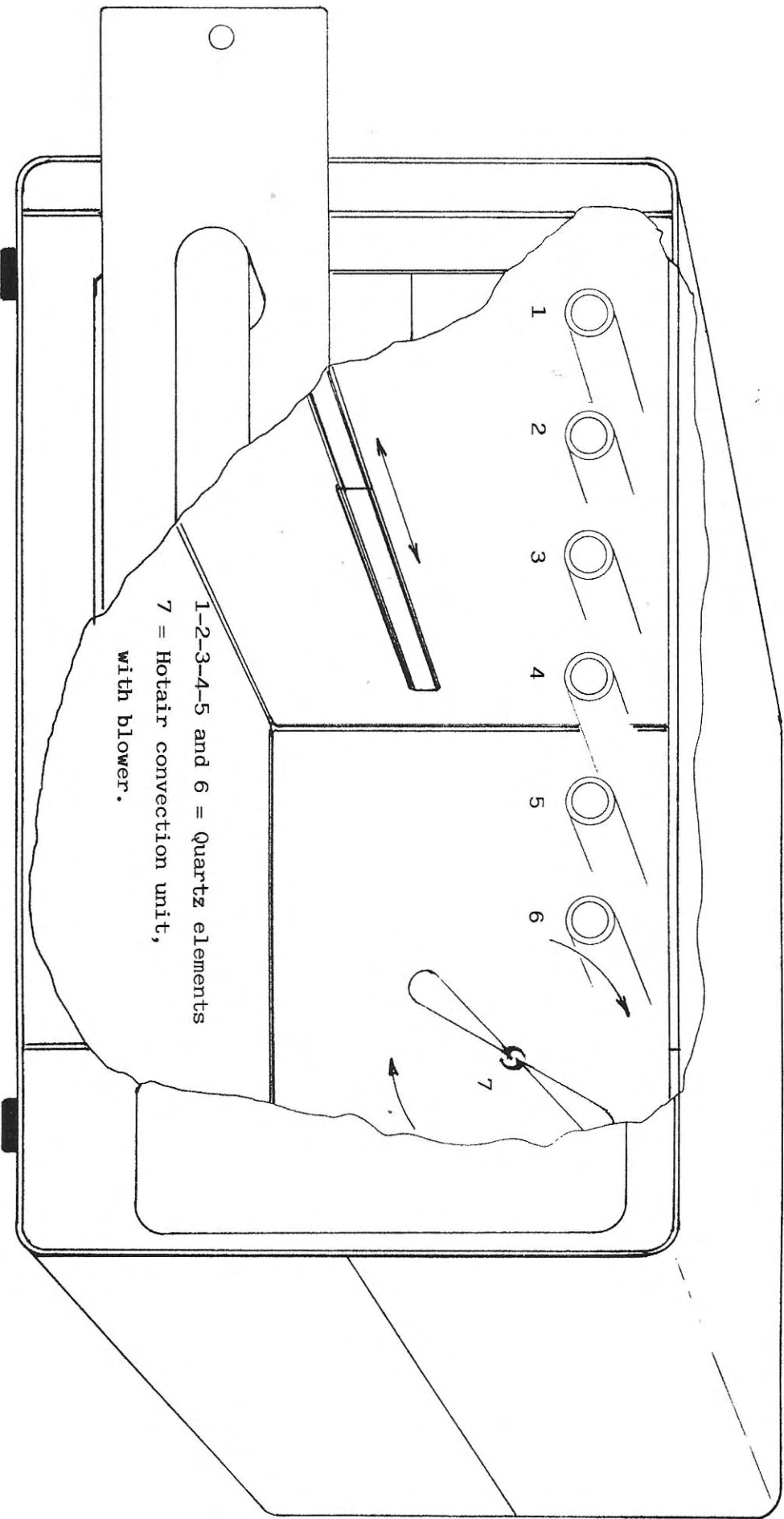
Reflow time: 1 - 999 sec.

Preheat temp.: 60 - 260 °C.

Reflow temp.: 90 - 290°C.

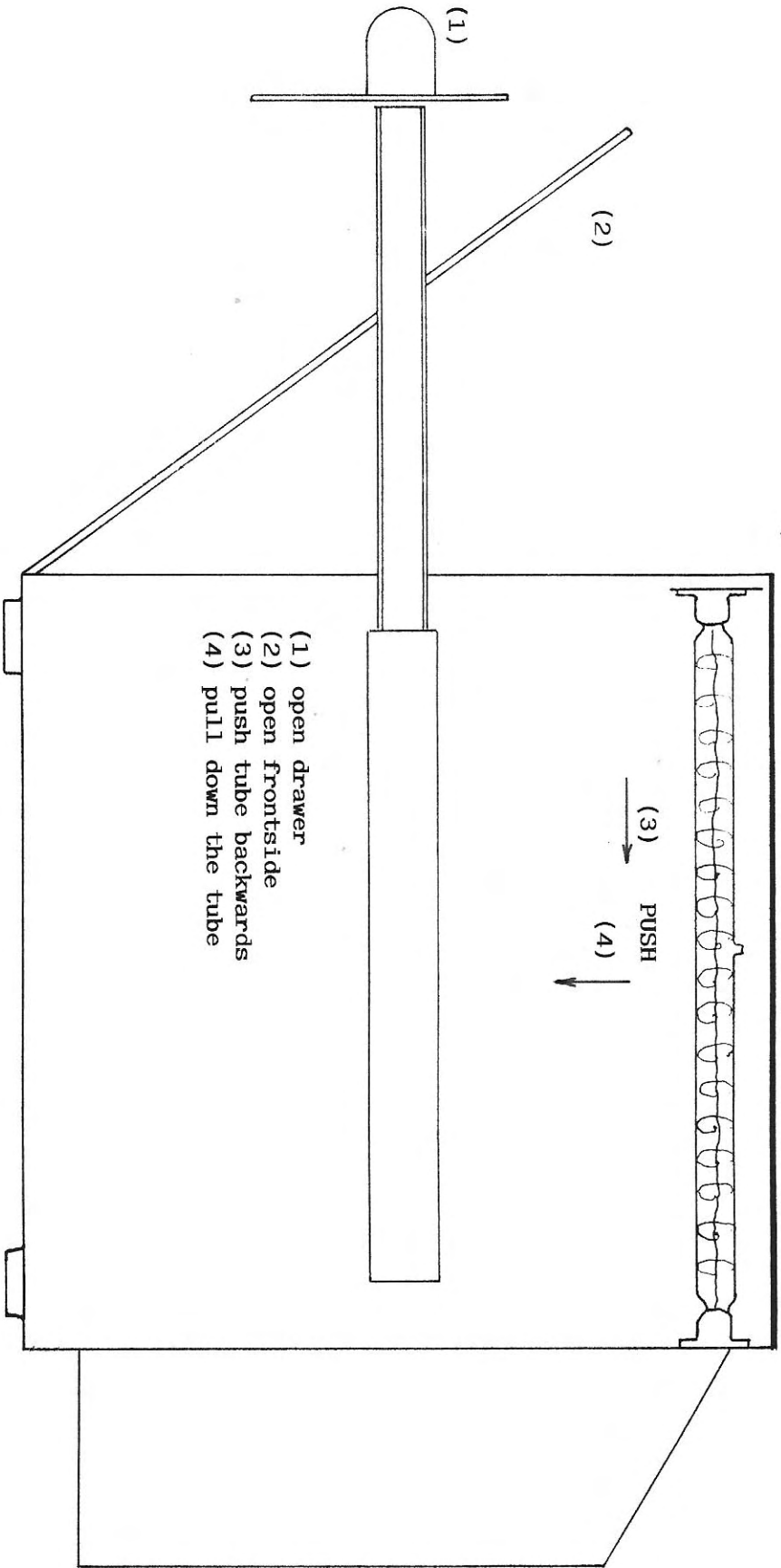
Heat-up time: approx. 8 min.

Net weight : 18 kg.



HOTAIR/QUARTZ REFLOW OVEN TECHNO- HA/06

How to change a quartstube :



SPARE PARTS LIST HA/06 HOTAIR/QUARTZ REFLOW OVEN

PART NUMBER:	DISCRIPTION	USAGE
06-R7S/1500	QUARTZ HEATER ELEMENT	TOP HEATER
06-DGH	OVEN DOOR GLASS	FRONT
06-D/GRIP	DRAWER GRIP	FRONT
06-FPCB	PC-BOARD, FRONT	FRONT PANEL
06-MPCB	PC-BOARD, MAIN	MICROPROCESSOR BOARD
06-THK	THERMOCOUPLE WIRE	OVEN TEMP.CONTROL
06-RB	RESET SWITCH	START OVEN
06-BU	BUZZER	ALARM
06-DRR	DRAWER GUIDE L/R	DRAWER
06-DFR	DRAWER FRONT	DRAWER
06-MSH	DRAWER MICROSWITCH	START OVEN
06-GRID	OVEN GRID	DRAWER
06-15/220	OVEN LAMP	LIGHTING
06-		
06-		
06-		
06-		