

Products & Applications

Production Soldering System

The Production Solder Tip System is designed for production soldering applications where superior SmartHeat® Technology is needed to provide the performance for lead-free, but with a lower cost of ownership due to the innovative tip design. The two-piece, long life heater and cost effective tip design provide a viable production alternative for regular and lead-free soldering.

MFR-PST PRODUCTION SOLDERING SYSTEM	
Part No.	Description
MFR-PST	Production Soldering System
INCLUDES	
MFR-PS1K	Two Port Universal Voltage Power Supply
MFR-HPS	Production Soldering Hand-piece and Coil Assembly
MFR-WSSR	Soldering Workstand

Contents subject to change without notice"

Power Tips for Production Soldering

The Power Heater Tips offer a combination of performance and value. The replaceable tips are used on the MFR-HPS Production Soldering Hand-piece and deliver high power, economical soldering in high volume production applications. The tips come in a thermally optimized large diameter tip that includes additional iron plating for longer life.



Technical Specifications

MFR-PTZ, MFR-SRC, MFR-PST, MFR-STZ

Ambient Operating Temperature: 10- 40°C

Maximum Enclosure Temperature: 55°C

Input Line Voltage: 100- 240 VAC, grounded circuit

Input Line Frequency: 50/60 Hz

Power Consumption: 65 Watts max.

Output Power:

50 Watts max. at 22°C ambient temperature

Output Frequency: 450 KHz

Power Cord 3-Wire: 183cm (18/3") SJT

Power Supply Dimensions w x d x h:

122mm x 200mm x 152.5mm (4.8" x 8" x 6")

Agency Tested Per: IEC 61000-6-1, EC 61000-6-3 and

UL499, FCC CFR Part 15

Tip-to-Ground Potential: < 2mV

Tip-to-Ground Resistance: < 2 ohms

Idle Temperature Stability: ± 1.1°C in still air

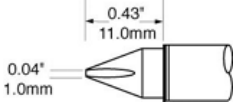
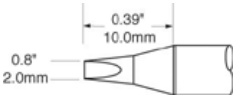
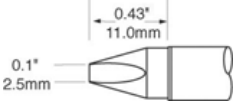
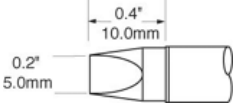
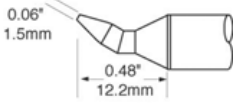
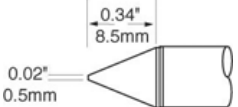
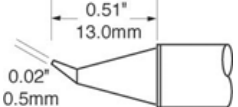
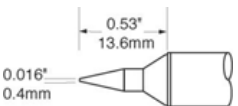
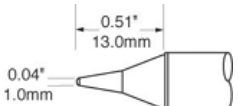
Hand-piece Cable Length:

L=71cm (48"), burn proof, ESD safe

Connector: 8-pin power connector

Workstand Dimensions w x d x h:

100 mm x 200 mm x 100 mm (4" x 8" x 4")

	SFV-lineart Chisel Solder Tip, 30° 1.0mm (.04")
	SFV-CH20 Chisel Solder Tip, 1.8mm (.07")
	SFV-CH25 Chisel Solder Tip, 2.5mm (.10")
	SFV-CH50 Extra Large Chisel Solder Tip, 5.0mm (.20")
	SFV-CHB15 Chisel Bent 30° Solder Tip, 1.5mm (.06")
	SFV-CN05 Conical Solder Tip, 0.5mm (.02")
	SFV-CNB05 Conical Bent Solder Tip, 0.5mm (.02")
	SFV-CNL04 Conical Long Solder Tip, 0.4mm (.016")
	SFV-CNL10 Conical Long Solder Tip, 1.0mm (.04")

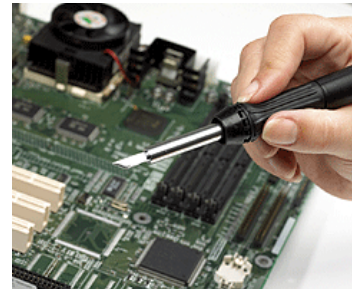
Soldering Tip Heater Options

With hand soldering, the task is to make a quality solder connection, without damaging the substrate and without negatively impacting throughput. All of the standard MFR Series power tips & rework cartridges are designed for use with glass fiber (FR4) PCB substrates. This is denoted by the second letter in the part number: "F". For example: **SFP-CH10**, **DFP-CN3**, and **SFV-CNL10**.

However, some specialist applications require working with thermally demanding or temperature sensitive substrates, such as ceramic hybrids or flexible circuits. OK International has developed specialty heaters that quickly deliver the necessary power, but operate at temperatures that minimize the risk of substrate damage. These are denoted by replacing the "F" in the part number with a "T" for temperature sensitive or a "C" for demanding loads. Please contact your local representative for information and availability of specialty tip heaters. For example: **STP-CH10** and **DCP-CN3**.

F = Standard FR4 Substrate
T = Temperature Sensitive
C = Ceramic or Heavy Load

	<p>SFV-CNL14 Conical Long Tip, 1.4mm (.055")</p>
	<p>SFV-DRH20 Conical Bevel Solder Tip, 1.8mm (.07")</p>
	<p>SFV-DRK50 Knife Solder Tip, 5.0mm (.20")</p>



Production Soldering in Action

New "Easy Access" Power Heater Tips for Production Soldering

Standard Power Heater Tips are designed for use with glass fiber (FR4) PCB substrates, denoted by the letter "F". To order specialty versions, replace the "F" in the part number with the appropriate letter designate for your application when ordering:
 T = Temperature Sensitive C = Ceramic or Heavy Load

	<p>SFV-CN05A Conical Solder Tip, 0.5mm (.02")</p>		<p>SFV-CH18A Fine Solder Tip, 1.8mm (.07")</p>
	<p>SFV-CNL10A Conical Long Solder Tip, 1.0mm (.04")</p>		<p>SFV-CH15A Chisel Solder Tip, 1.5mm (.06")</p>
	<p>SFV-CH50A Chisel Solder Tip, 5.0mm (.197")</p>		<p>SFV-CNL03A Conical Long Solder Tip, 0.3mm (.01")</p>
	<p>SFV-CH25A Chisel Solder Tip, 2.5mm (.10")</p>		<p>SFV-CN04A Conical Bent Solder Tip, 0.4mm (.016")</p>
	<p>SFV-DRH430A Drag Solder Tip, Hoof, 3.0mm (.12")</p>		

To order specialty versions of the Power Heater Tips replace the "F" in the part number with the appropriate letter designate for your application when ordering:

T = Temperature Sensitive C = Ceramic or Heavy Load

Dimensions and artwork listed are for indication/guidance only. Numbers have been rounded up.

Please contact your local technical support if you require specific technical information.



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