

This manual does not cover products **RX-802AS/822AS/852AS**. These products have their own manuals.



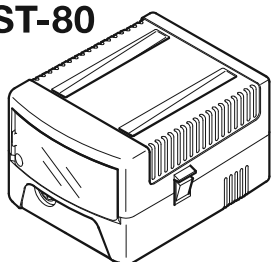
## FOR SAFE OPERATION

Before use, please read the **RX-802AS/822AS/852AS** operation manual carefully to make sure you fully understand the contents to ensure proper use.

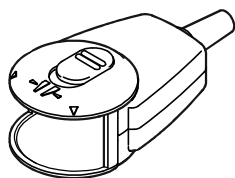
- Handle with care. Careless handling may result in fire or personal injury.
- We recommend using our **ST-28** soldering iron stand. Other soldering iron stands / holders may melt the grip of this unit.

## 1. PACKAGE CONTENTS/NAMES OF PARTS

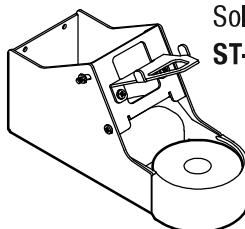
### XST-80



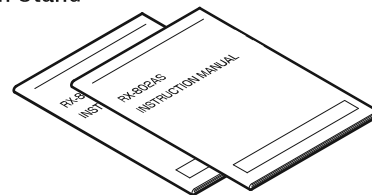
RX-802AS  
Station Unit



Tweezers Unit Grip  
**XST-80G** (Tip cartridge not included)



Soldering Iron Stand  
**ST-28**



Operation Manual for RX-802AS  
Operation Manual for XST-80/80G

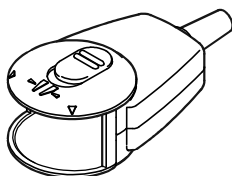


The **RX-80GAS** and **ST-21** (which normally come with the **RX-802AS**) are not included with this **XST-80**.

### **XST-80G** (When you purchase Tweezers Unit Grip only)

Please use with our soldering stations **RX-802AS**, **RX-822AS** or **RX-852AS**.

Tweezers Unit Grip  
**XST-80G**  
(Tip not included)



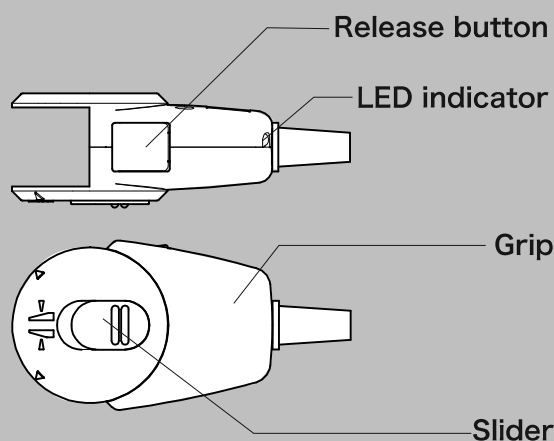
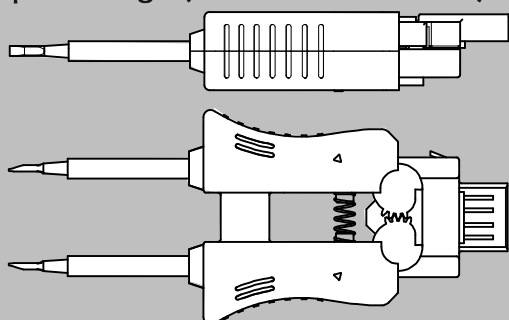
Operation Manual for XST-80/80G



When you use the soldering iron stand **ST-21** or **ST-27** with **XST-80G**, the front opening for the tip cartridge **ST-28MS** is required (sold separately).

## NAMES OF PARTS

Tip cartridge (This is not included.)



## 2. SETTING

For setting details of the control unit, please read the operation manual of **RX-802AS/822AS/852AS**.

1. Insert tip cartridge into grip until it clicks. (Screws should be down, gears should be up.) Please see diagram, right.
2. Put the grip into the soldering iron stand. Connect cord to control unit.
3. Turn the control unit power ON. The LED indicator will light up and the tips will start heating up.
4. Set the tip temperature.

For details, please refer to "Changing the Set Temperature" in the operation manual for **RX-802AS/822AS/852AS**.

When the LED indicator flashes, the tweezers are ready to use.



For longer tip life, always keep the tips wet with solder.  
(excluding the **XST-80HRT-0.5NW**)

5. Set the tip number.

For details, please refer to "Calibration of the Tip Temperature" in the operation manual for **RX-802AS/822AS/852AS**.

**NOTE:** Tip numbers are shown at the end of this manual.

## Distance between Tips

1. Push the tips together.
2. Slide the slider forward.
3. Release the tips. They are now set closer together. To restore wider setting, push back slider.

## 3. HOW TO USE

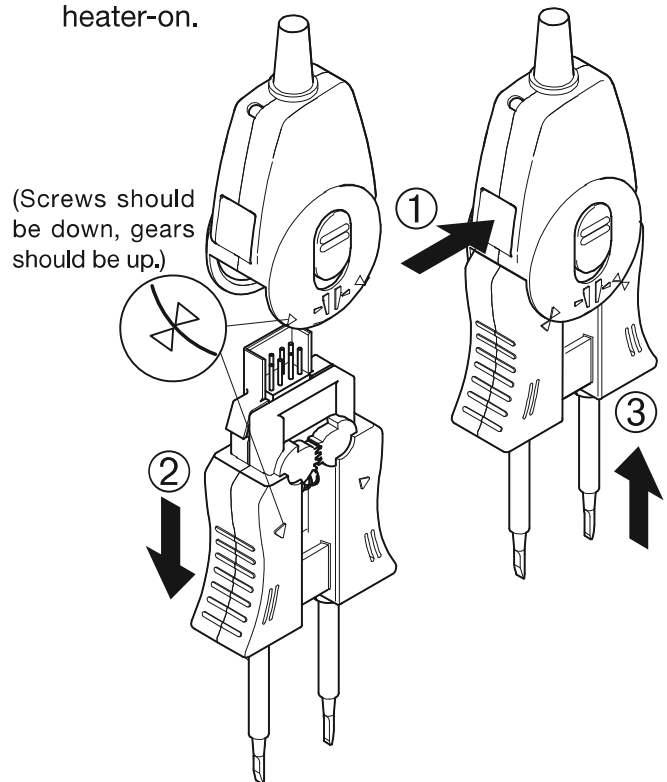
1. Position the tips and heat the soldered area around the component. Heat the PCB land as well. **NOTE:** If the land is not properly heated, solder may not melt completely.
2. Once the solder melts fully, you can tweezer out the discrete component.



## 4. MAINTENANCE

### Tip Cartridge Replacement

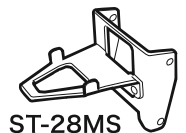
1. Press the release button at the side of the grip.
2. Pull out the tip cartridge.
3. Insert new cartridge until it clicks. Refer to the diagram below.
4. Press any button on the control panel to start heater-on.



## 5. REPLACEMENT PARTS

To order, contact your nearest distributor.  
Please refer to next page for tip details.

- Soldering Iron Stand **ST-28**
- Front Opening of the Tip Cartridge **ST-28MS\***
- ST-53 Sponge **ST-53SP**
- ST-40 Cleaner **ST-40BW**
- Tweezers Unit Grip **XST-80G**



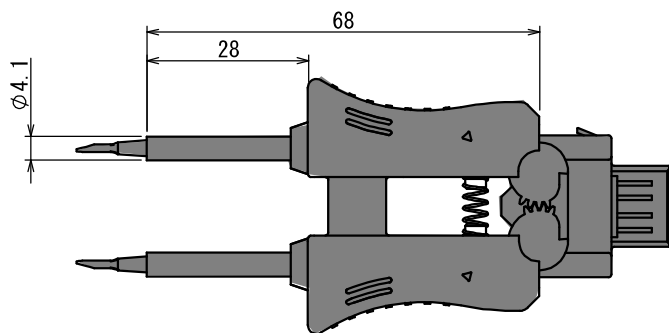
\* When you use the soldering iron stand **ST-21** or **ST-27** with **XST-80G**, the front opening for the tip cartridge **ST-28MS** is required (sold separately).

For how to attach, please refer to the last page of this manual.

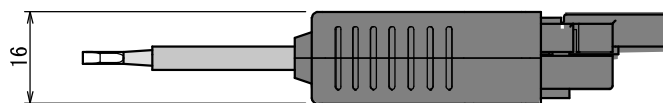
## 6. SPECIFICATIONS

Model No	XST-80G
Input Voltage / Power Consumption	24V AC/72W
Total Length	120mm (w/o cord bushing)
Weight	approx. 48g (w/o cord)
Leak Voltage	2mV or below
Earth Resistance	2Ω or below
Cord length	1.2m (between cord and control unit)

## 交換こて先 / 焊嘴号码 / AVAILABLE REPLACEMENT TIP CARTRIDGES

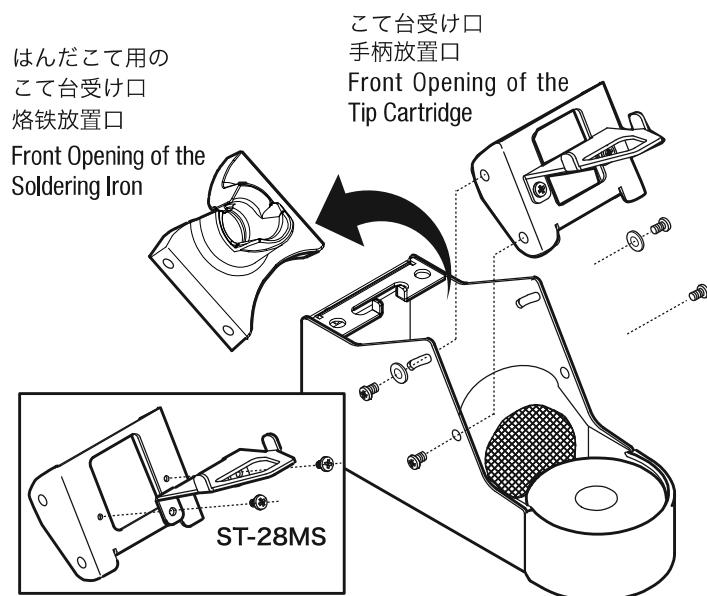


交換こて先のヒーター、こて先だけの交換はできません。因为是一体型的焊嘴，所以不能只更换焊嘴或者只更换发热芯。Tips/heaters not sold apart from cartridges.



XST-80HRT-0.5		XST-80HRT-0.5NW		XST-80HRT-2		XST-80HRT-1	
こて先番号 / 焊嘴号码 /Tip No. 1		こて先番号 / 焊嘴号码 /Tip No. 1		こて先番号 / 焊嘴号码 /Tip No. 1		こて先番号 / 焊嘴号码 /Tip No. 1	
		 Not solder-plated					
XST-80HRT-1C							
こて先番号 / 焊嘴号码 /Tip No. 1							

## ST-28MS こて台受け口交換方法 / ST-28MS 的安装更换方法 / HOW TO ATTACH THE ST-28MS



RX シリーズ付属のこて台 ST-21、ST-27 を XST-80G 用として使用される場合は、はんだこて用のこて台受け口を取り外し、別売のホットピンセット専用こて台受け口 ST-28MS に取り替えてください。

XST-80G 不能使用 RX 系列 ST-21 ST-27 的烙铁架。需要另购 ST-28MS。将烙铁放置口取下，更换手柄放置口 ST-28MS 即可。

When you use the soldering iron stand ST-21 or ST-27 with XST-80G, please remove its front opening, and replace with the front opening of the tip cartridge ST-28MS (sold separately).

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SOLDERING EQUIPMENT AND ACCESSORIES  
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