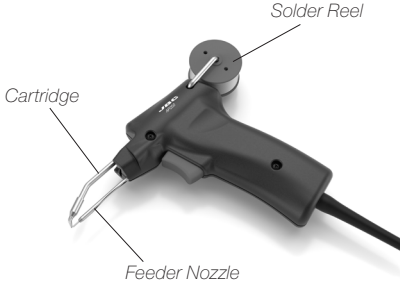# JBC

INSTRUCTION MANUAL

AP250

Manual-Feed Soldering Iron

This manual corresponds to the following references:

AP250-B

Packing List

The following items are included:

Manual-Feed Soldering Iron .... 1 unit
Already assembled in the soldering iron:
- Ref. 0019212   - ø1 mm Feeder Nozzle
- Ref. C250403   - Cartridge
- Ref. SN5450   - Solder Reel

ø1.5 mm Feeder Nozzle .... 1 unit
Ref. 0019211

Philips Screwdriver PH1x50 .... 1 unit
Ref. 0031586

Cartridge Extractor Pliers .... 1 unit
Ref. PLR195

Reel .... 1 unit

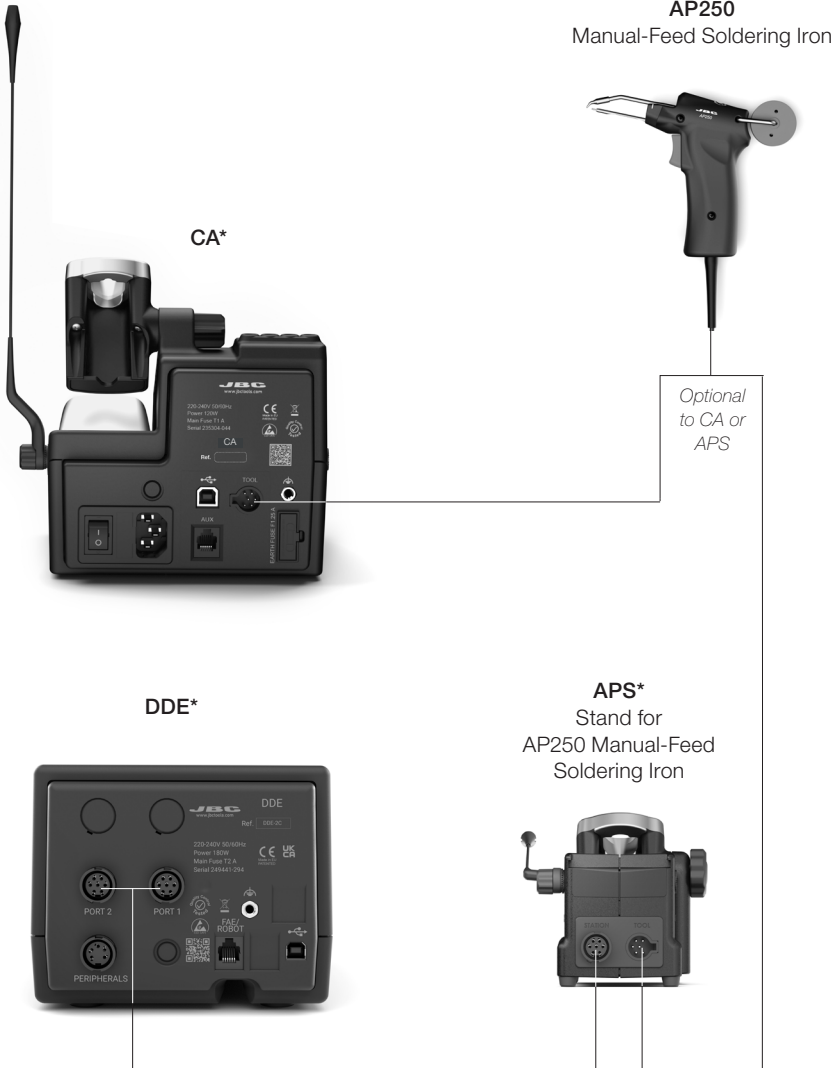**Manual** .... 1 unit
Ref. 0031412

Features and Connections

AP250 works with DI, DDE, DME Control Units by using APS Stand or optional with CA Manual-Feed Soldering Station.
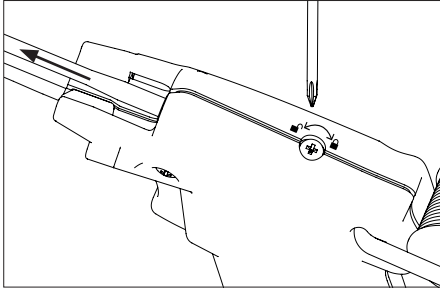
AP250
Manual-Feed Soldering Iron

CA*

Optional to CA or APS

DDE*

APS*
Stand for
AP250 Manual-Feed
Soldering Iron

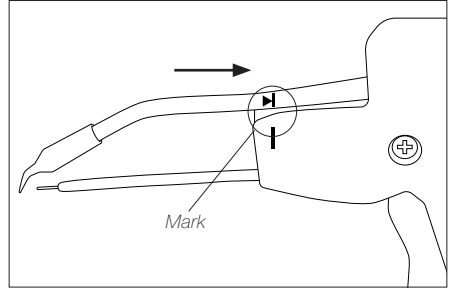** Not included, sold separately.*

Changing Cartridges

For a safe cartridge change, unplug the tool or turn the station off before following these guidelines:
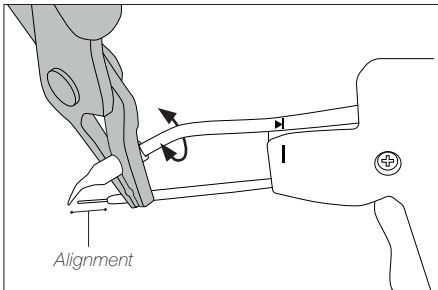
1. Removing

Loosen the screw and remove the cartridge. Use JBC's PLR195 cartridges extractor pliers to remove it if still hot.
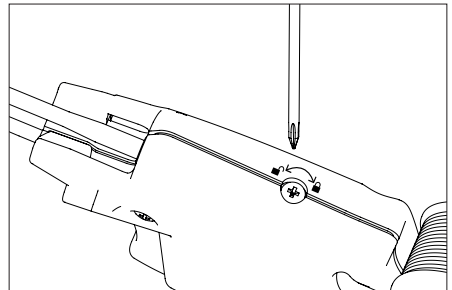
2. Inserting

Mark

Important: Insert the cartridge as far as the mark for a correct connection.

3. Aligning

Alignment

Align the tip of the cartridge with the feeder nozzle. Use JBC's PLR195 cartridge extractor pliers for a correct tip alignment.
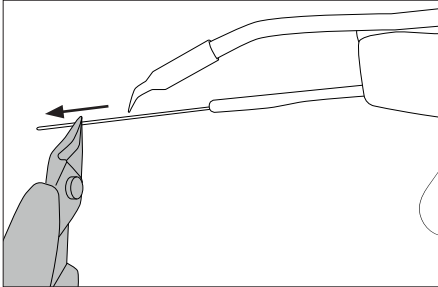
4. Fixing

Important: Tighten the screw again. This is necessary for the tool to function.
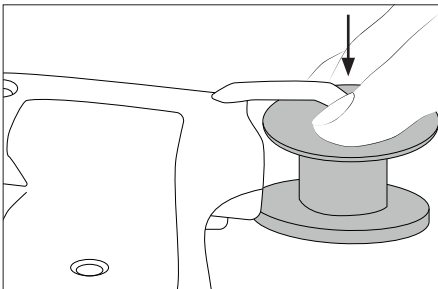
JBC

www.jbctools.com

Solder Wire Replacement

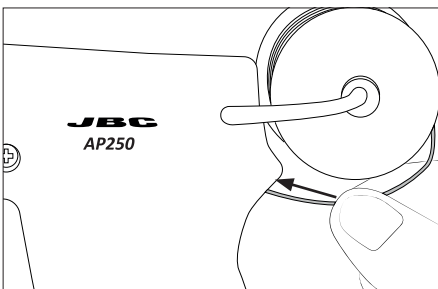## 1. Removing Remaining Solder Wire

Pull out the remaining solder wire from inside the feeder nozzle. Use a pliers if necessary.

2. Replacing Solder Reel

Remove the empty reel as shown and fit the new one in the same direction.
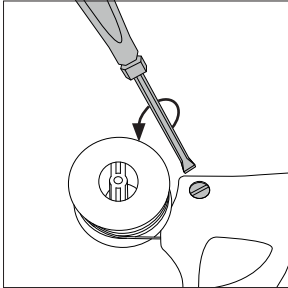
3. Inserting New Solder Wire

Insert the solder wire while pushing the trigger repeatedly until the solder wire appears at the nozzle.

Note: Use solder wire ø0.8 - 1.0 mm with Nozzle Ref. 0019212 and ø1.1 - 1.5 mm with Ref. 0019211

Changing the Feeder Nozzle

⚠ **Make sure the tool is unplugged.**
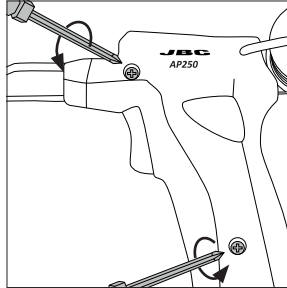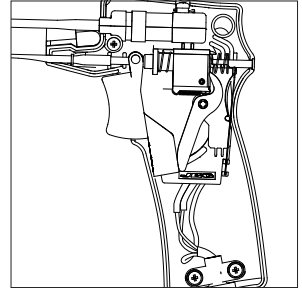
1. Remove the Reel

2. Remove the Cover

Open and take out the back side screw to remove the reel and to take out the solder wire from the nozzle.

Then remove the two front side screws and lift the cover off.

3. Remove the Nozzle

Feeder Nozzle

Trigger

Slider

Lever

① ②
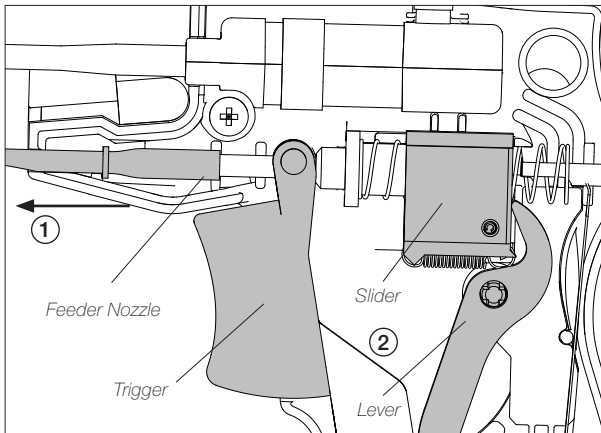
Take out the feeder nozzle and replace it with the new one (1) while holding the following three highlighted components in place (2): the trigger, the lever and the slider.

Reassemble the hand-piece and tighten the 3 screws.

Note: Do not disassemble these 3 components. It is imperative to hold them in its place (2).

Regulating the Feeder Nozzle

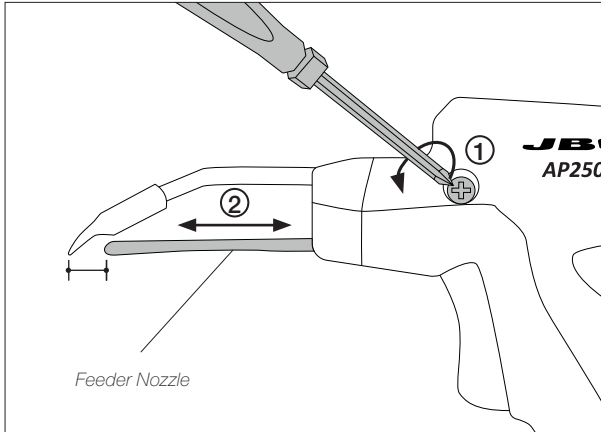Depending on the components that are being soldered or on the cartridge being used, the length of the feeder nozzle can be either shortened or lengthened (max 10 mm / 0.394 in).

Feeder Nozzle

Loosen the screw (1) to change the length of the feeder nozzle (2).
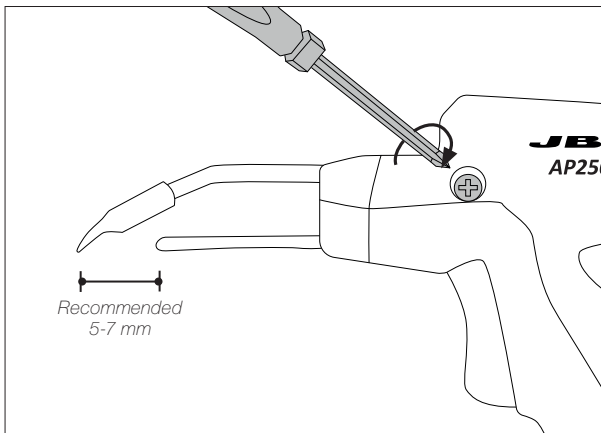
Recommended 5-7 mm

Adjust the feeder nozzle to the recommended length (5-7 mm / 0.19-0.27 in) and tighten the screw.

Compatible Cartridges*

AP250 Solder Feed works with C250 cartridges. Find the model that best suits your soldering needs in **www.jbctools.com**
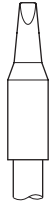
| Conical Bent | Chisel | Chisel Bent | Bevel |

Accessories

Solder Reel Stand*

For production line work, BES Solder Reel Stand is the ideal solution for easy solder wire supply. Suitable for Solder Reels up to 2.5 kg / 5.512 lb.

Wrap the solder wire twice around the empty reel as shown and then guide it into the AP250.

BES*
Solder Reel Stand

*Wrap solder wire **twice***

AP250
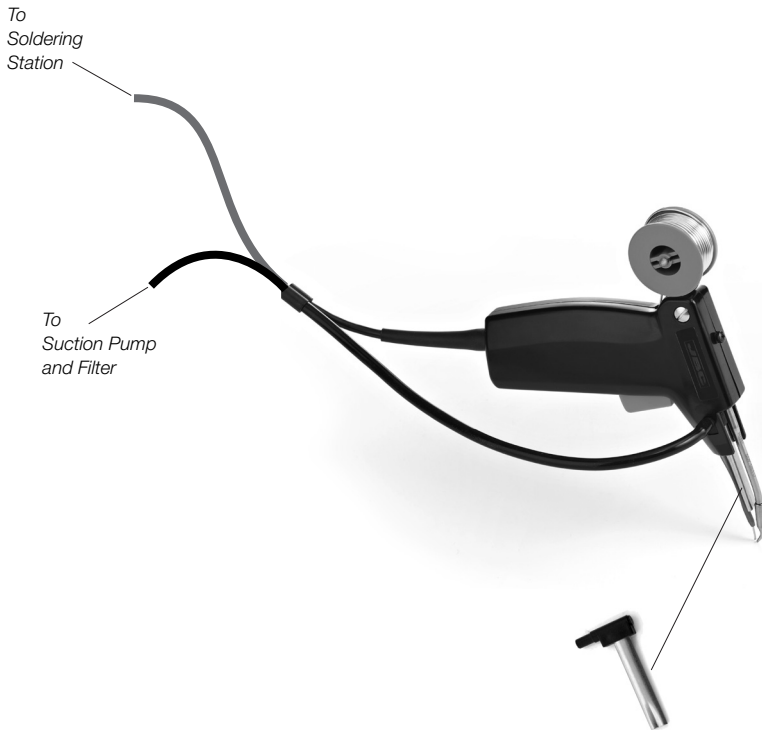Manual-Feed Soldering Iron

* Not included, sold separately.

Accessories

Fume Extractor Accessory*

The fume extractor accessory is an easy & safe solution for extracting the fume generated at the solder joint while soldering.

If you already have a high pressure suction system (filter required) on your workbench, you can connect it to the AP250 by means of the fume extractor accessory for occasional fume extraction.

To Soldering Station

To Suction Pump and Filter

F1204
Fume Extractor Accessory

* Not included, sold separately.

Notes

www.jbctools.com

Notes

Specifications

AP250
Manual-Feed Soldering Iron
Ref. **AP250-B**

- Solder Wire Diameter: Up to 1.5 mm / 0.06 in
- Total Net Weight: 232 g / 0.51 lb

- Package Dimensions / Weight: 245 x 185 x 45 mm / 367 g
  (L x W x H)   9.65 x 7.28 x 1.77 in / 0.81 lb

Complies with CE standards
ESD safe

JBC

Warranty

JBC's 2 year warranty covers this equipment against all manufacturing defects, including the replacement of defective parts and labor.
Warranty does not cover product wear or misuse.
In order for the warranty to be valid, equipment must be returned, postage paid, to the dealer where it was purchased.

This product should not be thrown in the garbage.
In accordance with the European directive 2012/19/EU, electronic equipment at the end of its life must be collected and returned to an authorized recycling facility.

CE EHL

www.jbctools.com