

Thank you for placing your trust in our company by purchasing this Weller soldering tool. Production was based on stringent quality requirements which guarantee the perfect operation of the device over a long period.

## 1. Description SP 15, SP 25, SP 40 and SP 80

We have produced the Weller SP soldering iron for the ambitious DIY electronic technician. Just the right soldering tool for professional soldering work. Robust, economic and multifunctional use for soldering tasks. These soldering irons are perfectly suited to electric and electronic repair work. The soldering irons in the SP series are connected to the mains/line voltage and are characterised by a solid heating element structure and have a wide range of soldering tips. With their various power groups 15, 25, 40 and 80 Watts, they can perform a wide range of soldering tasks. The soldering tips are provided with an electro-plated protective layer, which considerably increases the lifetime of the soldering tip. It must never be destroyed through mechanical adaptation (e.g. filing, scratching).

### Technical data

Voltage	Power		Protection class
	230 V AC	15 W	
SP 15	230 V AC	15 W	I
SP 25	230 V AC	25 W	I
SP 40	230 V AC	40 W	I
SP 80	230 V AC	80 W	I

## 2. Commissioning

Bend open the soldering iron support as shown in the bending instructions. Place the soldering iron in the soldering iron support. Ensure that there are no combustible materials near the soldering iron. Check that the mains voltage is compatible with the connected load of the soldering iron. Insert the mains connector of the soldering iron in the mains socket-outlet. The lighting in the grip indicates operation of the soldering iron. When the required heating-up time has passed, coat the soldering tip with a small amount of solder. Now the soldering work can begin.

## 3. Operating guidelines

- The soldering tips are provided with an electro-plated protective layer. The protective layer considerably lengthens the lifetime of the soldering tip and must never be destroyed through mechanical adaptation (e.g. filing, scratching).
- Prevent the soldering tip from becoming seized. A thin graphite layer applied to the thin end of the soldering tip, plus frequent withdrawal of the soldering tip, prevents unpleasant seizure.
- The soldering tip should be cleaned with a sponge soaked in water.
- Always place the soldering iron in the original support. During soldering breaks, always ensure that the soldering tip is well tin-coated.
- Before starting soldering, all metallic parts must be well cleaned.
- Always use the correct soldering tin. For normal electrical connections, use a solder with as low an acid content as possible together with a mild fluxing agent.
- When working with the soldering tip, ensure that as large an area as possible is used for transfer of heat onto the workpiece.



## 4. Caution!

Please read these Operating Instructions and the attached safety information carefully prior to initial operation of the soldering iron. Failure to observe the safety regulations results in a risk to life and limb.

The manufacturer shall not be liable for damage resulting from misuse of the machine or unauthorised alterations.

The Weller SP soldering iron series corresponds to the EC Declaration of Conformity in accordance with the basic safety requirements of Directives 89/336/EEC and 73/23EEC.

## 5. Scope of delivery

Soldering iron with soldering tip  
Support  
Operating Instructions  
Safety information

## 6. Soldering tip range

Type	Order no.	Tip width	mm	Packaging
SP 15	0054313299	S6, soldering tip nickel-plated, straight	1.2	3 units on cardboard
	0054313199	S5, soldering tip nickel-plated, straight	2.0	3 units on cardboard
	0054003499	S3, soldering tip nickel-plated, straight	3.5	3 units on cardboard
	0054321099	S31, soldering tip "Longlife", straight	0.4	1 unit on cardboard
	0054321199	S32, soldering tip "Longlife", straight	2.0	1 unit on cardboard
SP 25	0054313399	S10, soldering tip nickel-plated, straight	2.0	3 units on cardboard
	0054003099	S1, soldering tip nickel-plated, straight	4.5	3 units on cardboard
	0054003199	S2, soldering tip nickel-plated, bent	4.5	3 units on cardboard
	0054320099	S33, soldering tip "Longlife", straight	2.0	1 unit on cardboard
	0054320299	S35, soldering tip "Longlife", straight	5.0	1 unit on cardboard
SP 40	0054313499	S12, soldering tip nickel-plated, straight	3.0	3 units on cardboard
	0054003299	S4, soldering tip nickel-plated, bent	6.3	3 units on cardboard
	0054313599	S13, soldering tip nickel-plated, straight	6.3	3 units on cardboard
	0054322099	S36, soldering tip "Longlife", straight	5.0	1 unit on cardboard
	0054322299	S37, soldering tip "Longlife", bent	5.0	1 unit on cardboard
SP 80	0054313699	S14, soldering tip nickel-plated, bent	5.0	2 units on cardboard
	0054003399	S8, soldering tip nickel-plated, bent	9.5	2 units on cardboard
	0054310629	MT20 (43106), soldering tip nickel-plated, straight	9.5	1 unit in polythene bag
	0054323099	S38, soldering tip "Longlife", straight	7.0	1 unit on cardboard
	0054323299	S39, soldering tip "Longlife", bent	7.0	1 unit on cardboard

## Soldering iron support - bending instructions

Bend up inside element of soldering iron support approx. 45°

