

# Operation Manual

## Copper Hatchet Tip Soldering Iron 62444

# wiltec



Illustration similar, may vary depending on model

Read and follow the operating instructions and safety information before using for the first time.

Technical changes reserved!

Due to further developments, illustrations, functioning steps, and technical data can differ insignificantly.

Updating the documentation

If you have suggestions for improvement or have found any irregularities, please contact us.



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Send an e-mail to:

[service@wiltec.info](mailto:service@wiltec.info)

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Our postal address is:

WilTec Wildanger Technik GmbH  
Königsbenden 12  
52249 Eschweiler  
Germany

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Returns Department  
WilTec Wildanger Technik GmbH  
Königsbenden 28  
52249 Eschweiler

E-mail: **service@wiltec.info**

Tel: +49 2403 55592-0

Fax: +49 2403 55592-15



## Introduction

Thank you for purchasing this quality product. **To minimise the risk of injury we urge that our clients take some basic safety precautions when using this device. Please read the operation instructions carefully and make sure you have understood its content.**

Keep these operation instructions safe.

## Safety and warnings

- Before connecting the gas cylinder, ensure that the seals between the device, pressure regulator, and gas cylinder are in place and in good condition.
- Do not use a device leaking, damaged, or malfunctioning.
- Do not use a device with damaged or worn seals.
- Keep the device and propane cylinder out of children's reach and do not allow children to use the device.
- The device should only be used outdoors and not below ground level.
- Observe the safety instructions on the propane cylinder.
- Ensure that the propane-cylinder valve and gas-regulating valve are completely closed when having finished working.
- Then disconnect the device from the propane cylinder by unscrewing the pressure regulator.
- The contents of the propane cylinder are flammable propane gas that must be kept out of the children' and unauthorised persons' reach.
- Repairs, including the replacement of nozzles, should only be carried out by a qualified specialist using original spare parts.
- Do not use the device in strong winds, rain, or high humidity.
- When not in use, the device should be stored away from dust and moisture.



### Warning!

#### Danger of explosion!

Pressurised gas cylinders can explode if knocked over or exposed to heat, causing serious damage to property and personal injury.

- Do not tamper with the propane cylinder and protect it from heating above 50 °C, e.g., by exposure to sunlight.
- The propane cylinder should be changed outdoors and away from all possible sources of ignition. This includes naked flames, pilot lights, electric cooking devices, etc.
- Smoking is strictly forbidden when changing the tank! There is a risk of explosion.
- If your device leaks gas (smell of gas), move it to a safe place immediately.
- Check your device for leaks only outdoors, in a place with good air circulation and no source of ignition, where the leak can be located and repaired. Never use a flame to locate a leak; use soapy water instead. Never carry out the test near flammable materials or other people.
- If the flame is blown out by a gust of wind, immediately close the gas-flap valve and gas-control valve to prevent further gas leakage.

**Warning!****Fire hazard!**

Flammable substances and hot surfaces can cause fires.

- Avoid using the device near combustible materials such as paper, wood, or other flammable substances.
- Do not put the ignited soldering iron down and do not leave the device running unattended, as this poses a fire hazard.
- Do not place the soldering iron on flammable materials, even after use, as this poses a fire hazard.
- The device should never be used in a barn, wooden arbour, or near a wooden fence.
- Do not store the device near heat sources such as heaters, electrical devices, ovens, or in places exposed to strong sunlight.

**Warning!****Risk of burns!**

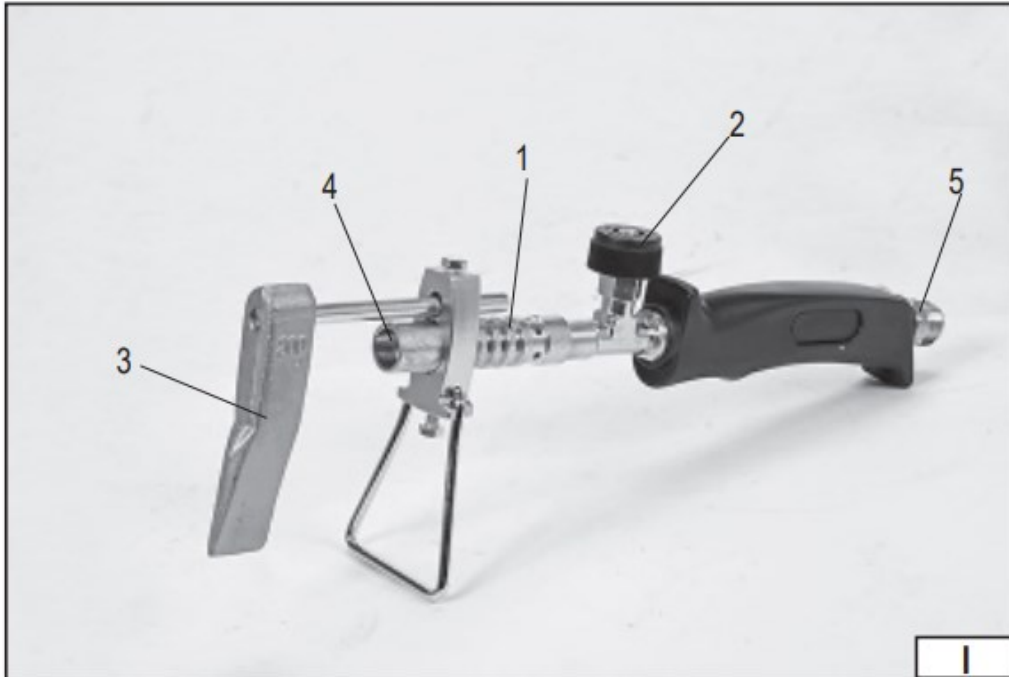
Touching hot surfaces can cause burns.

- The accessible parts can become very hot and cause injuries. Children should be kept away from the device.
- Do not touch the soldering iron while it is hot.

**Caution!**

A pressure reducer is always required for safe connection to a commercially available gas cylinder (not included in the scope of delivery). An adapter with the following dimensions is required to use the pressure reducer: 20 mm BSPP 1/2" external thread on the left, 13.16 mm BSPP 1/4"×19 internal thread on the left (not included in the scope of delivery).

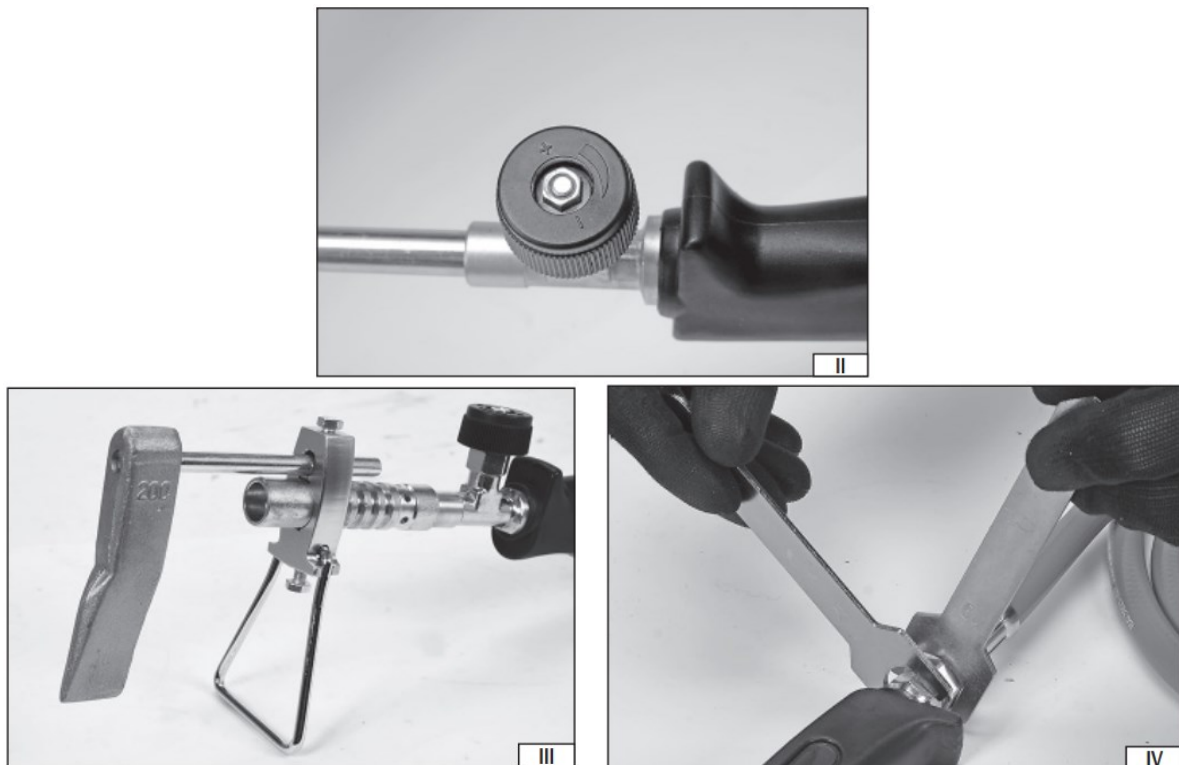
**Product overview**



No	Name
1	Gas burner
2	Gas regulating valve
3	Soldering tip
4	Flame nozzle
5	Gas connection

**Assembly**

- It is important that all threaded connections are only tightened with the force required for tightness to ensure that the tool poses no danger to the user. Overtightening can damage the seals.
- Ensure that the gas control valve (**Fig. 2**) on the handle is closed before assembly.
- Assemble the device by placing the soldering tip on the torch (**Fig. 3**). The soldering tip should be secured with two screws.
- The lower screw is used to attach the adapter to the flame nozzle, the upper screw to attach the soldering tip to the adapter. Only tighten the screws as much as is necessary to hold the elements in position. Overtightening the screws can damage the torch components.
- Attach the hose to the mounted tool (**Fig. 4**) and the other end to the gas cylinder.



### Leak test

1. Check that the gas-control valve on the handle is closed before liquid gas is introduced.
2. Ensure that all parts of the device are connected gas-tight, both after assembly and before each new use.
3. Ensure that connections and joints are correct and undamaged.
4. To check for leaks, use a gas-leak detector spray or apply a soapy solution (e.g., half a glass of water + 10 drops of detergent) to the gas-carrying parts at their connections. If bubbles appear at these points, the device is leaking.  
**Caution!** The test must never be carried out with an open flame.

### Operation

1. Unscrew the valve on the gas tank and then the valve on the tool. Unscrew just enough to allow the gas to escape.
2. Light the gas at the outlet of the cup. Use a special lighter for portable gas burners.
3. Adjust the height of the burner flame by turning the knob. The flame should only be directed at the soldering tip to heat it.
4. The temperature of the soldering tip can be adjusted by moving the soldering tip away from the nozzle or bringing it closer to the nozzle outlet. The greater the distance between the soldering tip and the nozzle, the lower the temperature of the soldering tip.  
**Attention!** The distance can only be adjusted when the tool is completely cooled down and disconnected from the gas tank.  
**Caution!** The tip of the soldering iron must not be too close to the nozzle! Leave a gap of at least 15 mm.
5. Place the tool on a non-flammable, heat-resistant, level, and flat surface and wait until the soldering tip has warmed up.
6. Place the tip on the soldering point. Make sure that the torch flame is only directed at the soldering tip.



7. Close the valve on the gas cylinder when having finished working, and place the torch on a non-flammable surface to have it cool down when the flame has gone out. Proceed with maintenance when the torch has cooled down.

## Replacing the propane tank

### Caution!

- The cylinder should only be replaced outdoors.
  - It is important to keep a sufficient distance from ignition sources, persons, and flammable materials. Before replacing the gas cylinder, make sure that gas remaining in the hose has been used up.
  - When changing the gas bottle, it is important to close the valve of the propane bottle tightly and to make sure that the burner is extinguished before loosening the gas bottle.
1. To change the propane-gas bottle, the pressure regulator of the propane-gas bottle must be unscrewed. All other parts of the device can remain connected.
  2. After each connection to the propane cylinder, the device must be checked again for leaks. In addition, the device, including the propane-gas hose, should be checked for operational safety before use.
  3. The hose should be replaced immediately if it is brittle, cracked, or damaged.

## Maintenance

- After dismantling, all parts should be checked carefully.
- The device can be cleaned with a dry cloth when the burner has cooled down. Do not use detergents, as they may block the burner holes and gas nozzle.
- When maintenance work has been completed, all parts of the device must be thoroughly dried. It is forbidden to use the burner with cleaning-agent residues.
- Check the permeability of the burner nozzle. If it is dirty, clean it carefully with a thin wire. Avoid enlarging or changing the shape of the nozzle opening.

## Storage and transport

- At the end of work and before storage and transport, disconnect the tool from the propane cylinder by unscrewing the pressure regulator.
- Ensure that the gas-regulating valve is closed and the device has cooled down completely before storing or transporting it in a safe and dry place.
- Secure the tool during transport.

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