

## SX-80 Glass Flux/Solder Trap Installation & Maintenance Instructions

### 1. Packing Contents

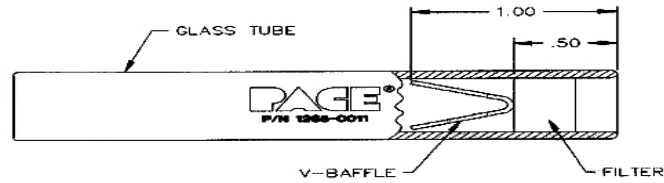


Figure 1:  
Glass Tube Assembly

Part Number	Part Description	Quantity
1125-0011-P1	Glass Chamber, SX 80	2
1213-0087-P1	Front Seal	2
4010-0110-P2	V Baffle, Glass Chamber	2
1309-0018-P10/P100	Filter, Felt	4
1100-0307-P1	Hot Grip Removal Pad	1

**WARNING:** THE GLASS CHAMBER WILL BE HOT AFTER USE. USE THE RUBBER REMOVAL PAD TO HANDLE THE CHAMBER AT ALL TIMES AND ALLOW THE CHAMBER TO COOL BEFORE CLEANING. FAILURE TO DO SO MAY RESULT IN BURNS.

### 2. Installation

- a. While holding the SX-80 handpiece straight up with tip pointing up, pull plunger lock back until you can turn counterclockwise to loosen, release.
- b. Using recessed finger grips next to the PACE logo, pull flux/solder trap door up and out.
- c. Remove cardboard disposable flux/solder trap from holder.
- d. Insert the v-baffle followed by the felt filter into the glass chamber (align the felt filter to the blue marking; refer to assembly diagram in table above.). Make sure the filter and the v-baffle have a small space between them.
- e. Check the front seal inside handpiece at the heater assembly for damage or if it the seal is slotted (figure 2). If either condition applies replace front seal.
- f. Insert glass flux/solder trap into holder. Felt filter end is in the opposite direction of the arrows. Make sure end with filter is flush with the flux/solder trap holder.
- g. Insert flux/solder trap holder back into the SX-80
- h. Turn plunger lock clockwise and lock into place.



Figure 2: Front Seal with slots

### 3. Maintenance

Maintenance should only be completed by qualified personnel designated by your company. Clean glass flux/solder trap when it becomes filled with solder or you lose suction

- a. While holding the SX-80 handpiece straight up with tip pointing up, pull plunger lock back until you can turn counterclockwise to loosen, release.
- b. Using recessed finger grips next to the PACE logo, pull flux/solder trap door up and out.
- c. Using new glass tube, push the used glass tube out of the flux/solder trap from holder onto a heat protected surface. Always use the rubber removal pad to pick up the hot glass tube to prevent burns.
- d. Allow glass tube to cool before cleaning.
- e. When chamber is cool push the v-baffle and filter out with a nylon bristle brush. DO not do this when hot, the nylon brush bristles will melt.
- f. Clean the chamber with the nylon bristle brush wetted with an approved solvent. Run the brush through the chamber several times till all solder and flux residue is completely removed. Coat the glass chamber and v-baffle with a small amount of mineral oil.
- g. Reassemble the collection chamber and by reinserting the v-baffle and a new felt filter.
- h. Inspect the front and rear seal for damage before reassembly.

### 4. Service

Please contact PACE or your local distributor for service or repair.



**PACE USA**  
9030 Junction Drive  
Annapolis Junction, MD 20701  
USA

Tel: (301) 490-9860  
Fax: (301) 498-3252

**PACE Europe**  
Sherbourne House  
Sherbourne Drive  
Tilbrook, Milton Keynes MK7 8HX  
United Kingdom  
(44) 1908-277666  
(44) 1908-277777