

## 3-in1 SMD/Thru-Hole Rework Package Model ST115E+ST325+ST50

All requisite tools for SMD/PTH Rework in the standard package

**SONA**  
**Technologies**  
reliable performance, dependable service

**PAGE**<sup>®</sup>  
worldwide



- All inclusive package, no hassles for customer
- Developed from best of breed tools & accessories
- Covers SMD/PTH soldering & desoldering
- Ideal for service centers, Labs

**Ready-to-use package - all you need is mains input power**

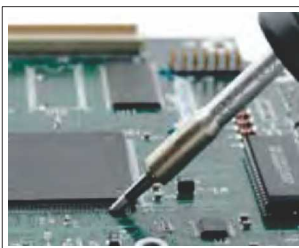
**powerful** & programmable Hot Air Reflow Station  
Temperature Controlled SMD/PTH Soldering Station  
Temperature Controlled PTH Desoldering Station

This package is a multi-function SMD & PTH Workstation that combines powerful Hot Air Pencil, Desoldering Gun and Soldering Pencil for all of your SMD and PTH soldering and desoldering needs. Various parameters like tool temperatures, airflow etc. are controlled digitally by the micro-controller based control units. Digital display shows set and actual temperatures.

### Scope of Supply:

- ST-325 Programmable Hot Air System
- ST-50 Main Power & Control Unit
- PS-90 Universal Soldering Pencil
- Stand for PS-90 with Cleaning Sponge & Dry Cleaner
- ST-115E Desoldering System includes:
  - ST-115 Control Unit
  - SX-100 Desoldering Tool
  - Stand for SX-100 with Cleaning Sponger

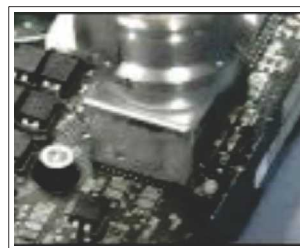
### SMD/Thru-Hole Rework Package Cover:



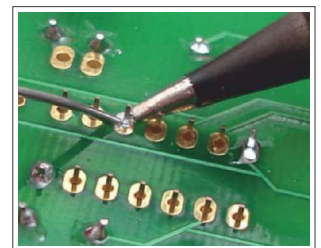
SMD ICs soldering



Thru-Hole desoldering



Large SMD Desoldering



Leadree & PTH soldering

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### PACE USA make SMD Hot Air System Model ST-325

#### Patented, Adjustable, Spring Loaded Vacuum Pik

The handpiece is fitted with an adjustable, spring loaded vacuum pik to lift components from the PCB and to hold the component in the nozzle during alignment.

The “give” in the spring loading is set, but the absolute position of the vacuum pik is adjustable over a 1.5" length.

The ST 325 is a digital, self-contained system that is fully programmable and can be used to remove or install surface mount components when individual or multiple operations are to be run. From the front panel, the system can be used in either manual or “timed” modes. Manual mode means that the system generates heated airflow when the cycle button is pressed; when it is pressed a second time the system shuts off. “Timed” modes allow the operator to create up to 20 “Profiles” that consist of time and temperatures parameters to ensure process control and repeatability. Both cycle start and vacuum functions are activated with conveniently located switches on the handpiece.

The ST 325 comes standard with one K-type thermocouple input that can be used to monitor the thermal environment at the work site with optional software. The system also comes with the Lo-Flo pump and the vacuum wand (PV-65) for manipulating components manually. The heavy-duty, durable metal housing ensures years of service & the sloped face of the front panel is a standard feature for ease of use. Other ST systems can be stacked on to the ST 325 to preserve bench space. The capabilities of the ST 325 can be used to rework just about any type of standard pitch SMD component when coupled with ST 500, ST 525, or ST 550.

When additional programming capability is required, such as 4 zone profile creation, an optional software package is available that can be used with a PC or laptop (1199-0019-P1). The optional software package further allows the ST 325 to control the ST 450 Preheater when bottom side heating of the PCB is required. Once the 4 zone profiles have been created with the software, they can be downloaded to the ST 325 and can be run WITHOUT the PC or laptop being connected!

The system can install standard BGA packages when fitted with the ST 500, ST 525 or ST 550, ST 450 or ST 400, and the optional PC or laptop software. Course pitch area array components are aligned using a proven, reliable template method that is easy to use



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#### ST 325



#### Features

- Multi-level password lock-out prevents unauthorized changes.
- User definable temperature zone.
- Audible countdown timer for end of cycle indication in the Timed and Program modes.
- On-screen display of parameters (temperature, time) during operation.
- Store and recall up to 20 profiles (40 with optional software).
- Quiet-Flo turbine blower offers nearly silent operation.
- Hi-Flo Vacuum Pump for holding component securely.
- Lo-Flo Vacuum Pump for component wand.

#### Technical Specifications

Specifications	ST 325
Part Number	8007-0432 ST 325E
Dimensions	134mm x 245mm x 254mm
Weight	4.5kgs (9.9lbs)
Input Supply	197-253 VAC, 50/60 Hz,
Power Consumption	575 Watts max.
Temperature Control	Closed loop,
Temperature Stability	± 9°C (±15°F) at idle tip temp.
Temperature Range	149° to 482°C nominal
Airflow Range	5-22 slpm

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**PACE USA make Digital Soldering Station Model ST-50**

Digital Display for set & actual temperatures

Tool Stand for Soldering Iron



**Features:**

- IntelliHeat® Control Technology
- Digital Display & Keypad
- °C/°F display options
- Password lockout
- Temperature SetBack
- Auto-Off
- Definable operating temperature range
- ESD grounding jack
- ESD Safe metal housing
- Stackable
- Can be mounted under workbench or shelf with optional bracket (1321-0609-P1)

The ST 50 is a single channel, digital power supply that is available with the TD-100 ThermoDrive Soldering Iron or PS-90 SensaTemp® Soldering Iron. The ST 50 can also be purchased as a Power Source only and combined with any of 4 optional handpieces. The programmable features of the ST 50 cannot be found anywhere on similarly priced systems! The ST 50 improves quality, reduces costs and eliminates the maintenance and calibration hassles associated with other systems. The ST 50 features IntelliHeat® Control Technology. The heavy-duty, durable metal housing ensures years of service and the sloped face of the front panel is a standard feature for ease of use. An optional mounting bracket (P/N 1321-0609-P1) is available to mount the system under a work-bench or shelf, preserving precious bench top space. The optional Instant-SetBack Cubby is available for the TD-100 ThermoDrive Soldering Iron to extend tip life, especially beneficial when Lead Free solders are used.

**Scope of Supply**

- ST-50 Main Power & Control Unit
- PS-90 Universal Soldering Pencil
- Stand for Soldering Pencil
- Cleaning Sponge & Dry Cleaner

**Technical Specifications**

Specifications	Model ST-50
System 230v	8007-0533 (ST-50 + PS-90)
Power Requirements	197-253 VAC, 50/60 Hz, 90 Watts max.
Dimensions	104mm (4.1") H x 130mm (5.1") W x 152mm (6.0") D
Weight	5 Kg (11 lbs.)
Control	LED Display
Control Technology	IntelliHeat
Tip to Ground Resistance	2 ohms or less
Temperature Accuracy	Meets or exceeds ANSI-J-STD 001
Absolute Temperature Stability	± 1.1°C (± 2 °F) at idle tip temp.
Temperature Range	Tip Heater Cartridge Technology = 205°C to 454°C (400°F to 850°F) SensaTemp® Digital Control 37°C to 482°C (100°F to 900°F)
System Can Be Calibrated	Yes

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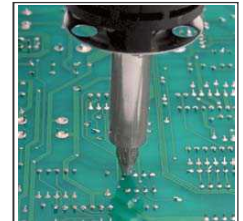
All requisite tools for SMD/PTH Rework in the standard package

### PACE USA make Desoldering System Model ST-115E

Digital Display for set & actual temperatures



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Reliable Thru-hole Desoldering



SX-100 Soldr-X-Tractor Desoldering Tool

#### Scope of Supply

- ST-115 Control Unit
- SX-100 Desoldering Tool
- Stand for SX-100 with Cleaning Sponge and Dry Cleaner

A single channel, digital display, fully programmable power supply, the ST-115 is compatible with all IntelliHeat® handpieces, comes as a system with the new SX-100 or as a Power Source only. The programmable features of the ST-115 cannot be found anywhere on similarly priced systems! The ST-115 improves quality, reduces costs and eliminates the maintenance and calibration hassles associated with other systems. The heavy-duty, durable metal housing ensures years of service and the sloped face of the front panel is a standard feature for ease of use.

#### Technical Specifications

Specifications	Model ST-115E
System 230v	8007-0522
Power Source Only 230V	8007-0523
Power Requirements	197-253 VAC, 50/60 Hz, 120 Watts max.
Dimensions	88mm (3.5") H x 171mm (6.75") W x 254mm (10") D
Weight	4 Kg (9 lbs.)
Control	LED Display & Keypad
Control Technology	IntelliHeat
Tip to Ground Resistance	2 ohms or less
Temperature Accuracy	Meets or exceeds ANSI-J-STD
Absolute Temperature Stability	± 1.1°C (± 2°F) at idle tip temp
Temperature Range	Tip Heater Cartridge = 205~454°C; SensaTemp® 37~482°C
System Can Be Calibrated	Yes
Vacuum/Pressure Source Type	Self Contained Pump
Vacuum Rise Time	150 ms Average
Vacuum (Nominal)	20 in Hg max
Flow Control Valve	High Precision Needle Valve
Pressure (Nominal)	18 p.s.i. max
Air Flow (Nominal)	8 slpm max

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## Standard Tips for PS-90


	Description	Tip Size	Part Number
	1/32" Conical Sharp Extended	0.80mm (0.031")	1121-0359-P5
	1/64" Conical Sharp	0.40mm (0.016")	1121-0357-P5
	1/32" Chisel	0.80mm (0.031")	1121-0359-P5
	1/16" Chisel	1.60mm (0.063")	1121-0533-P5
	3/32" Chisel	2.40mm (0.094")	1121-0360-P
	1/8" Chisel	3.20mm (0.125")	1121-0337-P5
	3/16" Chisel	4.80mm (0.188")	1121-0358-P5
	Mini Wave	3.30mm (0.13")	1121-0490-P5
	Flat Blade	6.60 (0.25")	1121-0402-P1

## Standard Desoldering Nozzles for SX-100




Description	Internal Dia (ID)	Outer Dia (OD)	Part Number
Thermo-Drive	0.76mm (0.030")	2.03mm (0.080")	1121-0930-P5
Thermo-Drive	1.02mm (0.040")	2.29mm (0.090")	1121-0931-P5
Thermo-Drive	1.52mm (0.060")	3.05mm (0.120")	1121-0932-P5
Thermo-Drive	2.29mm (0.090")	5.1mm (0.200")	1121-0933-P5
Thermo-Drive	4mm (0.16")	5.1mm (0.200")	1121-0951-P5

## 6 Pcs Hot Air Nozzle Set Model SON-PNS0309 for different applications

Hot Air Nozzles	Component type	Dimensions	Part Number
	SO8	5.0mm Diameter	4028-1012-P1
	PLCC28	12.5mm x 12.5mm	4028-2003
	QFP80, 100	17.5mm x 23.0mm	4028-2501-NB
	PLCC52	20.0mm x 20.0mm	4028-2006- NB
	QFP132	25.5mm x 25.5mm	4028-2503-NB
	QFP160	31.5mm x 31.5mm	4028-2504-NB

## 6 Pcs Hot Air Nozzle Set Model SON-PNS6 for different applications

Hot Air Nozzles	Component type	Dimensions	Part Number
	PLCC28	12.5mm x 12.5mm	4028-2003
	TQFP120	15.5mm x 15.5mm	4028-3004
	PLCC52	20.0mm x 20.0mm	4028-2006-NB
	PLCC68	24.0mm x 24.0mm	4028-2007-NB
	QFP132	27.0mm x 27.0mm	4028-2503-NB
	QFP240	33.0mm x 33.0mm	4028-2506-NB

Note: For other types and sizes of Hot Air Nozzles please refer the data sheet of ST-325 Hot Air System

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