

HIGH CAPACITY SOLDERING

SURFACE-MOUNT



THRU-HOLE



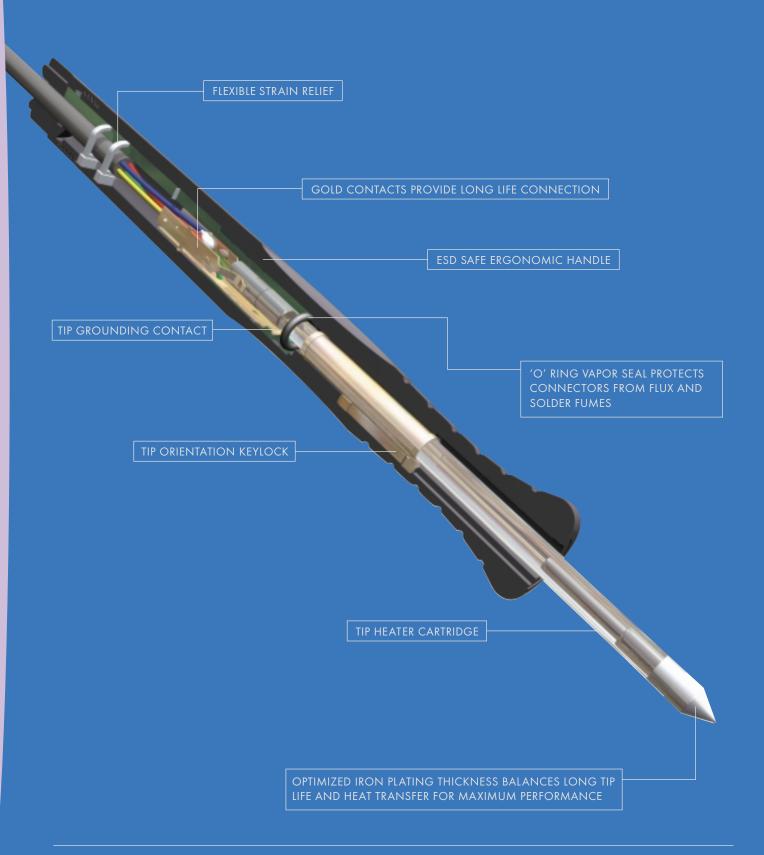
HW 100 HEATWISE™





SOLUTIONS FOR THE ELECTRONICS INTERCONNECTION PROCESS

PACE® ADVANCED HEATING TECHNOLOGY



QUALITY AND RELIABILITY

Your choice of system...

IMPROVE QUALITY AND PRODUCTIVITY

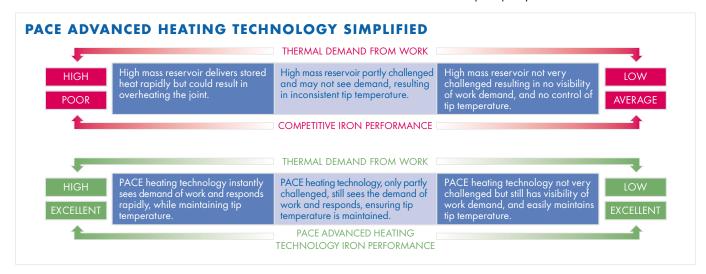
Using PACE's advanced electronics, the thermal demand from the solder joint is continuously monitored while supplying the precise amount of thermal energy required to reflow the solder joint. You can be sure the right amount of heat is always available with PACE's Advanced Heating Control.

The key advantage of PACE's Advanced Heating technology for production soldering is that it provides on-demand power to perfectly reflow joint after joint, even in the most demanding production soldering environments.

The direct power approach avoids the problem that competitive soldering irons often experience in demanding production soldering applications, where responsiveness of the iron suffers due to the larger thermal reservoir of a high mass heater and soldering performance can falter as the thermal reservoir becomes depleted.

This results in the system playing "catch-up", which causes two conditions:

- Inadequate heat delivery, negatively impacting operator productivity because the operator has to wait for the iron to catch up.
- 2. Inconsistent solder joint quality.



PACE ADVANCED PROCESS CONTROL FOR PRODUCTION SOLDERING



HW 100 HeatWise™ System

PACE is pleased to offer the latest advancement in technology and productivity enhancing solutions for hand soldering operations in over twenty years.

Both systems feature a handpiece possessing the latest in ergonomic design and operator comfort. The heart of both systems is our

integrated tip heater cartridge, the most responsive on the market today. Our systems deliver power directly to the work, on demand, resulting in high reliability soldering at safer, lower temperatures while maintaining one of the fastest recovery times available on the market today.

Finally, the freedom to choose how you want to control your process!



TW 100 TempWise™ System

The consistency of PACE's Advanced Soldering systems increases quality at every bench. Our systems continuously monitor the thermal demand of the work and respond immediately by delivering the exact amount of power required to the reflow the joint, at safe, low temperatures.

Space has never been more valuable than on today's workbench and operators' desire to have modern looking equipment has never been higher. PACE's Advanced power supplies and iron stands have been designed with smaller footprints than most other systems. Power supplies can also be mounted under a shelf or bench to preserve precious bench-top space. PACE has also changed the look of soldering systems forever with a unique, pleasing, modern appearance and workspace enhancing colors. We invite you to read on about our systems, we know you'll be impressed.



HEATWISE™ WITH POWER MODULES

High Reliability Soldering for Thru-Hole, SMT, Hybrid and other soldering applications.

HW 100 HEATWISE™ VISIBLE HEAT LEVEL CONTROL



HeatWise[™] senses the thermal demand of the work and responds immediately by delivering the exact amount of power required to reflow the joint, at safer, lower temperatures. And, because HeatWise[™] responds with high power you won't run out of heat before the job is complete.

Making high quality solder joints is easier than ever before, even for your less experienced operators!

Working with lead free solder? Not a problem for HeatWise™ technology! Making high quality lead free solder joints is just as easy, even with these more challenging alloys.

POWER MODULES BRING PROCESS CONTROL OUT IN THE OPEN

With PACE's Advanced HeatWise™ Soldering system (HW 100), you always know the Heat Level your operators are using with just a glance. You select the Heat Level you want with the appropriate Color-Coded Power Modules, which installs right into the PowerPort™ on the front of the station.

Competitive systems use the tip to determine operating levels and it is virtually impossible to tell which tip is installed in the handpiece! How do you really know your process is intact?

Level 5, 6 and 7 Power Modules come standard with the HeatWise™ system. If the Power Module is removed, the system immediately powers off preventing any noncompliant soldering from taking place. Changing Heat Levels takes just seconds without having to change tips.



PowerPort™

By specifying which Power Module to use on a job, you've specified your process. Simply plug into the PowerPortTM and turn the system on. Gone are the days of dials, read-outs buttons, calibration tools, procedures, and certificates. Compliance with ISO 9000 and internal quality specifications has never been easier. A "Calibration Not Required"



Power Modules

statement is available, by request, from PACE.

HeatWise™ systems feature Auto Set Back & Auto Off options to maximize tip and heater life and save energy. Simply touch the tip to the sponge or cycle the power and you're soldering again in seconds!

Power Modules are available to suit your particular requirements

PRESERVE PRECIOUS BENCHTOP SPACE WITH THE HW100 / TW100 MOUNTING KIT

Using the optional power source mounting bracket kit (P/N 1257-0288-P1), you can preserve precious benchtop space in a variety of ways.



1. System mounted under work shelf.



2. System mounted under work table.



3. System mounted under conveyor.

4

TEMPWISE™ DIGITAL WITH INSTACAL™

Unsurpassed Temperature Accuracy, Specification Conformance and Verification.

FOR THE MOST DEMANDING TEMPERATURE ACCURACY AND CONFORMANCE REQUIREMENTS:



TEMPWISE™ CONTROL DIGITAL SYSTEM

PACE's TempWiseTM TW 100 with InstaCalTM offers you the option of Unsurpassed Temperature Accuracy, Specification Conformance and Verification. Now you and your operators can enjoy the comfort, convenience and performance of a Tip Cartridge System with the legendary accuracy and repeatability that you expect from PACE.

Simply insert the desired tip geometry into the handle, select your temperature and touch the tip to the InstaCalTM Sensor which plugs right into the power source. In just seconds, the system is calibrated to operate within +/- 15 °C (27 °F). Even if you change temperatures, the system and tip stay in calibration. When changing tips, the system will prompt the user to calibrate so you can always be sure your operating temperature meets your process specification, unlike other systems.



InstaCalTM gives you an accurate, truly independent at the tip calibration any time and as often (or as little) as your specifications require. InstaCalTM features a laser trimmed, platinum RTD sensor that's 5 times more accurate than conventional contact thermocouple calibration systems.

SAVE TIME AND MONEY!

The operator can verify specification compliance in just seconds right on the unit itself. There's never a need to take a system off the line or to stretch limited budgets buying expensive calibration equipment, maintaining additional units to keep the line working, or conducting lengthy calibration procedures.

The TW 100 TempWise™ comes standard with the following unique programming options:

- 1. PASSWORD PROTECTION: When activated, the password feature will prevent unauthorized changes to stored system temperature parameters and feature settings.
- TEMPERATURE SETBACK: To maximize tip and heater life, the system can be programmed to automatically reduce the power supplied to the heater after a user-defined time period of inactivity.
- 3. AUTO OFF: A safety feature that turns the power off after the system has entered Temperature Setback.
- 4. USER DEFINABLE OPERATING TEMPERATURE RANGE: This is a unique PACE feature that allows an operating temperature range to be defined using a temperature minimum and maximum. The operator can freely adjust the operating temperature between the minimum and maximum limits which gives you more control and the operator the flexibility to adjust temperatures depending on the work.
- INSTACALTM ENABLE/DISABLE: Turns the InstaCalTM feature on or off.

Making high quality solder joints is easier than ever before, even for your less experienced operators!

Working with lead free solder? Not a problem, making high quality solder joints is just as easy, even with these more challenging alloys.



InstaCal™ self calibration



ECONOMIC BENEFITS

In test after test, PACE's Advanced Technology systems have out performed the competition.

THE CHALLENGE

Efficiency of thru-hole solder joints soldered per hour with same tip geometry and tip temperature.



What does this mean to you? Substantial productivity savings by maximizing efficiency and thru-put.

PACE ADVANCED TECHNOLOGY SYSTEMS SAVE YOU TIME AND MONEY

annual hours saved		annual savings (us \$)*
BRAND M	58 HOURS	\$1,160
CONVENTIONAL IRON BRAND P	164 HOURS	\$3,280
BRAND H	176 HOURS	\$3,520
CONVENTIONAL IRON BRAND H	553 HOURS	\$11,060
CONVENTIONAL IRON BRAND W	768 HOURS	\$15,360

^{*} Assuming a fully burdened labor rate of \$20 USD per hour

ONE TIP - SELECT THE TEMPERATURE YOU WANT

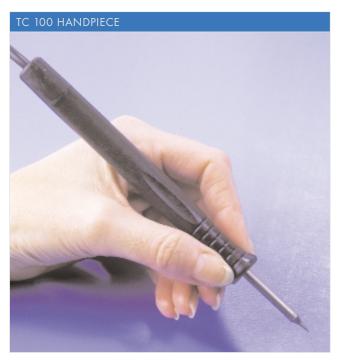
With PACE's Advanced Technology soldering systems, you begin to save money from day one! Unlike the competition, you only need to inventory one tip, not multiple tips with different temperature ratings. Install the tip geometry you want. Then, change Heat Levels, at will, without changing tips. Most importantly PACE Tip Cartridges are much more cost effective than the competition. Watch your inventory costs shrink as productivity soars!



ERGONOMIC HANDPIECE

Unsurpassed thermal performance and productivity.

ADVANCED ERGONOMIC HANDPIECE



Crafted by a team of highly trained engineers in the surgical instrument field, the handpiece is uniquely designed to virtually eliminate operator fatigue, improve control and enhance productivity in the most demanding production soldering environments!

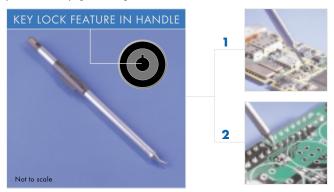
The heater and sensor are right at the tip, away from the handle keeping it cool and comfortable. After extensive operator surveys, the "Tip to Grip" length has been optimized for the perfect balance between reach, access and visibility of the work.

Operators love it! "It just feels great!"

PACE'S TIP/HEATER CARTRIDGE: THE KEY TO YOUR SUCCESS!

PACE's Tip Cartridge employs a unique key lock feature which ensures proper tip orientation, durability and stability, even in the rough and tumble of demanding production soldering operations.

The key lock feature transfers all the forces on the tip to the super strong handle, protecting the electrical connection, unlike the competition. A replaceable seal at the front of the connector seals out flux fumes and other contaminants ensuring reliable power and tip grounding.



1. TC 100 with SMT soldering application.



2. TC 100 with Thru-hole soldering application.

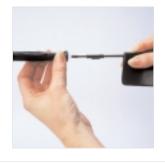


The PACE tip end starts with a special copper alloy with superior heat transfer capacity followed by a thick layer of hard wearing iron for long life and excellent solderability. No other tip cartridge lasts longer! For extreme applications long life tips are also available.

* This is depending on customer applications.

INSTANT TIP CHANGES

To change a tip geometry, simply grasp the tip cartridge with the supplied heat pad and pull the cartridge out and place it in the tool stand. Simply push in the new tip and your ready to go. There is no need to turn off the power source, and no potential risk of exposure to dangerous RF!









PACE ADVANCED HEATING SYSTEMS

PACE Tips Deliver More Heat at Safe, Low Temperatures.

PACE's Advanced Systems offer the durability, reliability and power needed with all the comfort and performance you expect from a Tip Cartridge System.

For maximum flexibility, PACE offers one of the widest variety of tips available on the market today. From single point soldering tips to precision engineered SMT tips like PACE's patented Mini-Wave® tip that makes installing non-thru-hole components easier than you have ever imagined.

PACE strongly recommends using the lowest possible Heat Level or temperature for the job to maximize tip life and to minimize thermal stress to components and PCBs.

Because PACE's Advanced Technology systems use an integrated tip/heater cartridge designed for high power delivery, you can often melt solder and form a quality joint using a Heat Level or temperature up to 38 °C (100 °F) or more lower than a conventional soldering iron.

HEATWISETM

POWER MODULE	PART NUMBER	COLOR
HEAT LEVEL 5	1207-0362-01-P1	Green
HEAT LEVEL 5.5	1207-0362-02-P1	Blue
HEAT LEVEL 6	1207-0362-03-P1	Orange
HEAT LEVEL 6.5	1207-0362-04-P1	Gold
HEAT LEVEL 7	1207-0362-05-P1	Red
HEAT LEVEL 7.5	1207-0362-06-P1	Purple
HEAT LEVEL 8	1207-0362-07-P1	Black



Power Modules

TEMPWISETM

DESCRIPTION	PART NUMBER
INSTACAL TM MODULE	1207-0364-P1

TC 100

DESCRIPTION	PART NUMBER
FUME EXTRACTION COLLECTION TUBE KIT	8887-0100



InstaCal™ Module

TIP & TOOL STAND

The Tip and Tool Stand for TC 100 handpiece is truly unique among iron stands and has the smallest footprint available. The angle of the handpiece cubby is adjustable for maximum ease of use. The stand features a sponge and stay-moist reservoir for cleaning the iron tip. Five cartridges can be stored on the stand and an optional tip cartridge stand can hold 10 more tip cartridges. To store and protect additional tip cartridges, a tip case is also available.

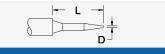
DESCRIPTION	PART NUMBER
TIP & TOOL STAND	1257-0258-P1
TIP & TOOL STAND INTERLOCK	1335-0251-P1
TIP CARTRIDGE STANDS	1321-0639-P1
TIP CASE	1310-0034-P1

HANDPIECE CUBBY



PACE TIP CARTRIDGES

Advanced Technology Series Tips Deliver More Heat at Safer, Lower Temperatures.



D				
TIPS	DESCRIPTION	SIZE - L	SIZE - D	PART NUMBER
+	1/32" Conical Sharp Extended	13.4mm (0.530")	0.80mm (0.031")	1124-0001-P1
+	1/64" Conical Sharp	8.3mm (0.330")	0.40mm (0.016")	1124-0002-P1
6 ×	1/64" Conical Sharp Bent 30 Degrees	7.8mm (0.310")	0.40mm (0.016")	1124-0003-P1
+	1/64" Conical Sharp Extended	13.5mm (0.535")	0.40mm (0.016")	1124-0004-P1
€ †	1/32" Conical	4.7mm (0.188")	0.80mm (0.031")	1124-0005-P1
\longrightarrow	3/128" Conical	4.6mm (0.184")	0.60mm (0.023")	1124-0006-P1
₹	1/16" 90 Degree Chisel	10.9mm (0.430")	1.60mm (0.063")	1124-0007-P1
	3/64" 30 Degree Chisel	9.9mm (0.390")	1.20mm (0.047")	1124-0008-P1
€D>±+	3/64" 30 Degree Bevel	4.3mm (0.170")	1.20mm (0.047")	1124-0009-P1
	13/64" Chisel	7.62mm (0.300")	5.15mm (0.203")	1124-0010-P1
1	1/64" 60 Degree Bevel	14.7mm (0.580")	0.40mm (0.016")	1124-0011-P1
=	1/32" 30 Degree Chisel	9.1mm (0.360")	0.80mm (0.031")	1124-0012-P1
	3/32" 30 Degree Chisel	9.9mm (0.390")	2.40mm (0.094")	1124-0013-P1
	5/64" 60 Degree Chisel	4.7mm (0.185")	2.00mm (0.078")	1124-0014-P1
	1/64" Conical, Sharp, Bent 30	15.8mm (0.625")	0.40mm (0.016")	1124-0015-P1
	Degrees, Extended			
+	3/64" Chisel Bent 30 Degrees	10.7mm (0.425")	1.20mm (0.047")	1124-0016-P1
1	1/16" 60 Degree Chisel	15.8mm (0.425")	1.60mm (0.063")	1124-0017-P1
1	1/32" Conical Sharp Extended	16.7mm (0.660")	0.80mm (0.031")	1124-0018-P1
	1/16" 30 Degree Chisel	9.9mm (0.390")	1.60mm (0.063")	1124-0019-P1
E TO+	1/8" 90 Degree Chisel	4.8mm (0.190")	3.20mm (0.125")	1124-0020-P1
	3/128" Conical Sharp Bent 30 Degrees	14.4mm (0.570")	0.60mm (0.023")	1124-0021-P1
	1/16" Conical Sharp	9.9mm (0.390")	1.60mm (0.063")	1124-0022-P1
8 T 0 +	1/8" 90 Degree Chisel Extended	8.6mm (0.340")	3.20mm (0.125")	1124-0023-P1
	1/16" 30 Degree Bevel	9.9mm (0.390")	1.60mm (0.063")	1124-0024-P1
	1/16" Conical Sharp Extended	12.1mm (0.478")	1.60mm (0.063")	1124-0025-P1
	1/16" Chisel Bent 30 Degrees	9.7mm (0.385")	1.60mm (0.063")	1124-0026-P1
5	3/128" Conical Sharp	15.2mm (0.600")	0.60mm (0.023")	1124-0027-P1
	3/64" Chisel, Bent 30 Degrees, Extended	21.8mm (0.860")	1.20mm (0.047")	1124-0028-P1
	1/32" 30 Degree Bevel	9.1mm (0.360")	0.80mm (0.031")	1124-0029-P1
	1/32" Conical Sharp	9.9mm (0.390")	0.80mm (0.031")	1124-0030-P1
'	Heat Staking	N/A	4.00mm (0.156")	1124-0031-P1
	MiniWave	N/A	6.35mm (0.25")	1124-0032-P1
" " " " " " " " " " " " " " " " " " "	Angled MiniWave, 3.3 mm	N/A	6.35mm (0.25")	1124-0033-P1
	Single Sided Chisel	N/A	6.35mm (0.25")	1124-0034-P1
	Angled MiniWave, 2.4mm	N/A	3.04mm (0.12)	1124-0035-P1
-	1/128" Conical	N/A	0.19mm (0.007)	1124-0036-P1
	1/4 Flat Blade	N/A	6.35mm (0.25")	1124-0037-P1
At a 1 and 1				

Not drawn to scale.



SYSTEM FEATURES AND SPECIFICATIONS

FEATURES	HW 100 HEATWISE™ SYSTEM	TW 100 TEMPWISE™ SYSTEM
CALIBRATION REQUIREMENT	None	Self Calibrating with InstaCal Module
THERMAL MANAGEMENT SYSTEM	Microprocessor control with Fixed performance level selected by Power Module.	Microprocessor control with Digital user interface.
C/F DISPLAY OPTION	Not Applicable	Yes
TEMPERATURE LOCKOUT	Yes, using Power Modules. Operator access to Power Modules can be easily restricted.	Yes, using Password.
TEMPERATURE SETBACK	Yes, Fixed at 30 minutes (can be disabled)	Yes, User selected up to 90 minutes
AUTO OFF	Yes, Fixed at 30 minutes (can be disabled)	Yes, User selected up to 90 minutes
USER DEFINED OPERATING TEMPERATURE RANGE	No	Yes
HEAT LEVEL / TEMPERATURE SELECTION	Power Module	LED Display and Keypad
OPERATING HEAT LEVEL / TEMPERATURE VISIBLE	Yes, color coded Power Modules (5, 6 and 7 Power Modules supplied as standard)	Yes, LED Display
HANDPIECE	TC 100	TC 100
ESD SAFE HOUSING	Yes	Yes
CAN BE MOUNTED UNDER A SHELF OR WORKBENCH	Yes, with optional mounting bracket	Yes, with optional mounting bracket

SPECIFICATIONS	HW 100 HEATWISE™ SYSTEM	TW 100 TEMPWISE™ SYSTEM
POWER REQUIREMENTS	97-127 VAC 50/60 Hz, 80 Watts maximum 197-253 VAC 50/60 Hz, 80 Watts maximum	97-127 VAC 50/60 Hz, 80 Watts maximum 197-253 VAC 50/60 Hz, 80 Watts maximum
DIMENSIONS	184mm H x 107mm W x 122mm D (7.25" H x 4.2" W x 4.8" D)	184mm H x 107mm W x 122mm D (7.25" H x 4.2" W x 4.8" D)
TIP & TOOL STAND DIMENSIONS	71mm H x 88mm W x 195mm D (2.8" H x 3.5" W x 7.7" D)	71 mm H x 88mm W x 195mm D (2.8" H x 3.5" W x 7.7" D)
WEIGHT	1.6 Kgs (3.5 lbs)	1.6 Kgs (3.5 lbs)
TC 100 HANDPIECE WEIGHT	88.2g (3.1oz)	88.2g (3.1oz)
TIP TO GROUND RESISTANCE	<2 Ohms	<2 Ohms
TEMPERATURE STABILITY	Within +/- 5 °C (9 °F), idle tip temperature	Within +/- 5 °C (9 °F), idle tip temperature
ABSOLUTE TEMPERATURE ACCURACY	N/A	Within +/- 15 °C (27 °F)
HEAT LEVEL / TEMPERATURE RANGE	260 °C - 425 °C (500 °F – 800 °F) Power Modules are available in the following Heat Levels: 5, 5.5, 6, 6.5, 7, 7.5, 8.	260°C - 425°C (500°F - 800°F)

PART NUMBERS	HW100 HEATWISE™ SYSTEM	TW 100 TEMPWISE™ SYSTEM
120 VAC UNIT	8007-0387	8007-0389
230 VAC UNIT	8007-0388	8007-0390
TC100 HANDPIECE	6010-0132-P1	6010-0132-P1
TC 100 HANDPIECE CORD ASSEMBLY	3008-0131-P1	3008-0131-P1

PACE® soldering systems meet or exceed the following standards/agency requirements - ANSI-J-STD-001, MIL-STD 2000, UL, CSA and CE.

PRODUCT PAGE

For a complete product listing contact PACE or visit www.paceworldwide.com

PACE provides innovative solutions, products and training for the assembly, rework, repair and testing of printed circuit boards. PACE's unique capabilities and evolving vision have provided universal solutions to thru-hole and surface-mount assembly and rework problems for the most advanced electronics. Our strong commitment

and history of achievement has resulted in an unparalleled range of Assembly, Repair and Fume Extraction systems to meet your company's needs whether working to ISO-9000, industrial, military or your own internal specifications. Whatever the challenge, PACE stands ready to provide the best, cost-effective solution for you.

ST SYSTEMS

This product line offers three basic configurations: production soldering, shop air desoldering and fully selfcontained desoldering. Each of these basic configurations are available in either analog or digital versions.





ST 85



ST 75



ST 115



MBT/PRC SYSTEMS

PACE offers a broad range of rework and repair products to meet all your repair needs. Whether you are replacing a surface mount component, repairing a multi-layer printed circuit board, or making a plated thru-hole repair.





PRC 2000



THERMOFLO SYSTEMS

The PACE family of ThermoFlo hot air systems offers a complete solution for virtually all surface mount, BGA and CSP applications. From handheld rework and repair to the production line.

TF 200



TF 2000



XR 2000



FUME EXTRACTION

PACE offers Fume Extraction Systems that feature the latest advancements in filter condition monitoring and process control as well as cost effective solutions. A variety of collection accessories are available.

ARM-EVAC 105



ARM-EVAC 50



FUMEFLO WORKTABLE



LAB-EVAC 150



SUPPORT SYSTEMS

The Technical, Applications Support and Training Group provides PACE customers with a full spectrum of support services and products.



TRAINING



THERMOBOND CIR-KIT



HS 200



BGA REBALLING KIT





A WORLDWIDE COMMITMENT

With offices worldwide, PACE is a recognized world leader in the development of solutions for the assembly and repair of highly advanced electronics. Our expertise extends back to the dawn of the modern electronics industry. In 1958, PACE introduced training programs for the repair of printed wire assemblies, and soon after, revolutionized the industry by creating the first self-contained vacuum desoldering system.

Today, PACE continues to provide innovative solutions, products and training for the rework, repair and testing of printed circuit assemblies. Our unique capabilities and evolving vision have provided universal solutions for thru-hole and surface mount assembly and rework problems in the most advanced electronics.

Additionally, PACE manufactures Fume Extraction Systems to reduce exposure to harmful particulates and gases created from hand soldering operations. PACE Fume Extraction Systems effectively remove these contaminants from the worker's breathing zone thereby reducing or eliminating health risks and improving productivity.

Our strong commitment and history of achievement has resulted in an unparalleled range of Assembly, Repair and Fume Extraction solutions to meet your needs whether working to ISO-9000, industrial, military or your own internal specifications. Whatever the challenge, PACE stands ready to help you set a new standard.



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INTERNET

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A CUSTOMER COMMITMENT

In 2001 the distinguished Frost & Sullivan Award for the World Surface Mount Technology Rework and Repair Equipment Industry was bestowed upon PACE.

The Frost & Sullivan Market Engineering Customer Service Leadership Award is presented to companies that have demonstrated superior responsiveness to customer needs and value-added support in technology and services.

PACE was selected based upon independent research with customers, key market participants and even our competition. This award reiterates PACE's commitment to excellence from product concept to customer service in the field. Frost & Sullivan's research recognizes that the key to PACE's success in the industry is our interactive approach with customers to provide solutions and respond to end-user feedback when developing products.

SOLUTIONS FOR THE ELECTRONICS INTERCONNECTION PROCESS

The following are trademarks and/or service marks of PACE, Incorporated, Laurel, Md USA: INSTACALTM, FUMEFLOTM, HEATWISETM, PACEWORLDWIDETM, PERMAGROUNDTM, POWERPORTTM and TEMPWISETM.

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications, including MIL-STD-2000, ANSI/J-STD-001, IPC 7711, IPC 7721 and IPC-A-610.

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