

# iroda®

Professional  
Quality

## MJ-950



## 750°C FLAMELESS HEAT

### ULTRA-THERM™ Flameless Heat Gun Piezo Electronic Automatic Ignition System

#### APPLICATIONS:

- General heating and drying applications
- Activate adhesives and potting compounds
- Bend and form plastics and plastic laminates
- PVC bending
- Preheat flux
- Remove windshield caulking
- Install heat shrinkable and solder-filled terminals
- Install thin wall, dual wall and adhesive lined heat shrink tubing and sleeves
- Shrink anti-static film tubes, molded parts and light gauge shrink packaging
- Stretch vinyls
- Repair vinyl
- Thaw frozen lock
- Heat test electronic components



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## iroda® ULTRA-THERM™ 750°C FLAMELESS HEAT

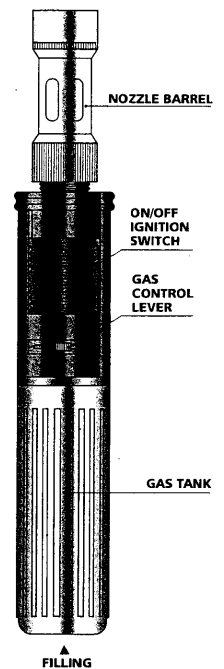
### Flameless Heat Gun Piezo Electronic Automatic Ignition System

#### SPECIFICATIONS

Length	190 mm (7.5 in)	
Weight (when gas-filled)	135 g	
Approximate temperature	750°C / 1400°F	
Nozzle Size	I.D.	14mm (0.55 in)
	O.D.	20mm (0.79 in)
Gas container capacity	20 ml	
Operating Time (one gas filling)	120 min at mid setting	

#### Warnings:

- When unit is fueled with flammable gas (Butane) under pressure, use with care.
  - DO NOT expose to heat above +50°C (+120°F) and avoid prolonged exposure to sun.
  - Excessive gas flow, flaming or catalyst pulsing red may occur when the regulator is incorrectly adjusted, i.e., set too high.
  - DO NOT refill, ignite or use near open flame, heater, furnace or combustible materials.
  - KEEP WORK AREA CLEAN. Cluttered areas and benches invite injuries.
  - KEEP AWAY FROM CHILDREN. Visitors should be kept away from work area.
  - STORE WHEN NOT IN USE. Store unit in dry, locked cabinet out of reach of children.
  - USE SAFETY GLASSES TO PROTECT YOUR EYES.
  - DO NOT OVERREACH. Keep proper footing and balance at all times.
  - STAY ALERT. Watch what you are doing. Use common sense. Do not operate unit when you are tired.
  - DO NOT leave unit unattended when it is operating or still hot.
  - ALWAYS BE SURE THE UNIT IS COOL BEFORE STORING.
  - Ensure Nozzle Barrel is cool before storing unit.
  - USE ONLY IN WELL VENTILATED AREA.
  - DO NOT ATTEMPT TO READJUST OR REPAIR. UNIT IS NOT USER SERVICEABLE.
- READ ENCLOSED INSTRUCTION MANUAL PRIOR TO USE.  
• BUTANE NOT INCLUDED.



Patents:  
 U.S. 5,490,496  
 5,810,579  
 R.O.C. 110483  
 133267  
 China ZL 95 2 09612.9  
 European Patent Pending

DESIGNED & MANUFACTURED  
 BY PRO-IRODA INDUSTRIES, INC.

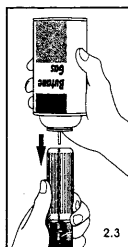


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## HOW TO USE ULTRA-THERM™

### REFUELING

- 2.1 Make sure ON / OFF switch is at "OFF" position before filling.
- 2.2 Adaptors are not normally required when refilling.
- 2.3 To refill hold refill can as pictured (fuel transfer is dependent upon gravity).
- 2.4 Stop filling when fuel sprays back indicating full tank.

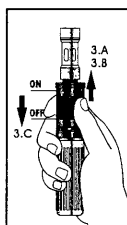
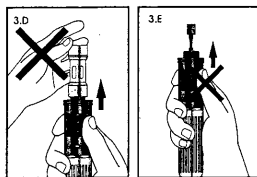


### IGNITION SEQUENCE-1

- 3.A Lift up ON / OFF IGNITION SWITCH to the "ON" position to start the flow of gas.
- 3.B Push the switch upward toward tip to the maximum point to ignite then release the switch back to "ON" position to stay on.
- 3.C To turn off, slide the ON / OFF ignition switch downward toward to the gas control lever.

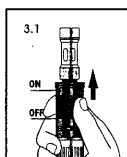
### IGNITION WARNINGS

- 3.D Do not touch Nozzle Barrel while igniting.
- 3.E Do not ignite the unit when "Nozzle Barrel" is not screwed on.



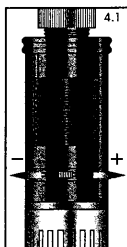
### HOW TO START

- 3.1.1 Set gas control level at **mid** position.
- 3.1.2 Push the ON / OFF ignition switch slowly upward toward tip to the max. point and release the switch. (same as 3A & 3B)
- 3.1.3 You may hear the sound of gas flowing and then the metal mesh at open end of Nozzle Barrel will glow orange after 1 or 2 seconds. If not, repeat #3.1.3
- 3.1.4 To turn off, Same as 3.C It is not necessary to move the gas control lever after the unit is turned off.



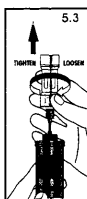
### ADJUSTMENT

- 4.1 The tip temperature can be adjusted by turning the GAS CONTROL LEVER observing the - + signs on the body.
- 4.2 Begin by setting the GAS CONTROL LEVER to **mid** position for most heating applications.
- 4.3 It is not necessary for the catalyst inside the nozzle to glow bright red to achieve satisfactory heating temperatures. Experience will dictate the adjuster setting required.



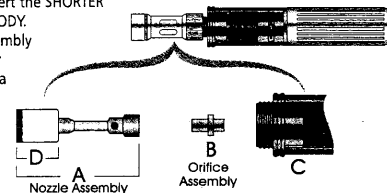
### CHANGING TIPS

- 5.1 Be sure the Nozzle Barrel has cooled before removal.
- 5.2 The catalyst seen through the open end of Nozzle Barrel is very delicate and will not sustain mechanical abuse without serious damage.
- 5.3 The Nozzle Barrel is easily removable allowing the installation of other style Nozzle Barrel or the replacement of a worn one. After the Nozzle Barrel is cool, simply unscrew it with a counterclockwise motion. Be careful not to overtighten as this could damage the inside parts and thread in the body.



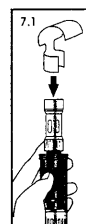
### CLEAN OR REPLACE ORIFICE ASSEMBLY

- 6.1 Remove Nozzle Barrel as shown in 5.3.
- 6.2 While holding the tool straight up in the vertical position, unscrew Nozzle Assembly (A) from the Torch Body (C). You may have to use a pliers or other tool to start unscrewing. Do not grasp and turn the Ceramic Head (D).
- 6.3 Carefully remove Orifice Assemble (B) by lifting out of torch body. NOTE THAT THE SHORTER SIDE OF ORIFICE ASSEMBLY FITS INTO TORCH BODY.
- 6.4 Soak Orifice Assembly in Naptha or other similar solvent for approximately 5 minutes.
- 6.5 Replace clean (or new) Orifice Assembly remembering to insert the SHORTER SIDE INTO TORCH BODY.
- 6.6 Replace Nozzle Assembly and hand tighten or tighten gently with a pliers grasping the shank of the Nozzle Assembly.



### DEFLECTOR

- 7.1 For best result, when shinking tubing use with deflector. (Please refer to diagram 7.1)



### CLEANING

- 8.1 Use only mild soap and a damp cloth to clean the housings of the tool. Many household cleaners contain chemicals which could seriously damage the plastic. Also do not use gasoline, turpentine, lacquer or paint thinner, dry cleaning fluids or similar products. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

### IMPORTANT NOTE:

THIS TOOL HAS BEEN ESPECIALLY DESIGNED FOR USE WITH 100% BUTANE GAS. ANY OTHER BUTANE-PROPANE MIX OR OTHER FUEL GASES COULD CREATE MUCH HIGHER TEMPERATURES.

### TROUBLESHOOTING

9. To reduce the risk of personal injury, property damage, or damage to your ULTRA-THERM™, do not attempt to repair the unit body.

PROBLEM	PROBABLE CAUSE	HOW TO CORRECT
9.1 Does not ignite	a. Empty tank b. Too high or low fuel pressure c. Clogged orifice assembly	a. Refill with butane fuel b. Adjust control lever to a higher or lower position. c. Clean or replace with new orifice assembly
9.2 Low gas pressure or low flame	a. Clogged orifice assembly b. Cold fuel c. Low fuel	a. Clean or replace with new one. b. Hold body in hands to allow unit to warm up. c. Refuel
9.3 Tip does not heat up	a. Used-up catalyst b. Insufficient fuel pressure c. Colgged orifice assembly	a. Replace with new tip. b. Adjust control lever to a higher position. c. Clean or replace with new one.