

**EN**

Original Instructions  
Version 3 – July 2025



# SOLDERING STATION

**61478**



Read this manual in full before using this product and retain it for future use. Always use the latest version of the manual. Please visit [drapertools.com/manuals](http://drapertools.com/manuals) for the latest version.

**Version 1:** February 2021

First release

**Version 2:** October 2022

**Version 3:** July 2025

## 1. Intended Use

This soldering iron uses heat generated by an electric filament to melt solder to carry out most soldering tasks. Any other application beyond the conditions established for use will be considered misuse. Draper Tools accepts no responsibility for improper use of this product.

## 2. Specification

|                      |             |
|----------------------|-------------|
| Stock No.            | 61478       |
| Part No.             | SI400       |
| Rated voltage        | 230V/50Hz   |
| Maximum rated input  | 40W         |
| Variable rated input | 5 - 40W     |
| Temperature range    | 150 - 420°C |
| Net weight           | 750g        |

## 3. Health and Safety Information

Important: Read all the Health and Safety instructions before attempting to operate, maintain or repair this product. Failure to follow these instructions may result in injury or damage to the user, the product or the workpiece.

### 3.1 General Health and Safety Precautions

- **DO NOT** use if the soldering gun is damaged or any parts are missing.
- **DO NOT** leave the soldering gun unattended and keep out of the reach of children.
- Unplug the soldering gun from the power supply when not in use. Allow to cool before changing the soldering tips.
- Wear appropriate protective clothing and safety eye protection.
- The soldering iron must be placed on its stand when not in use.
- **DO NOT** put the hot soldering gun down on any delicate or flammable surfaces.

- Ensure the work piece is adequately held before operating the soldering iron.
- **NEVER** use the soldering gun outside or in the rain.
- **NEVER** dismantle the soldering gun.
- **DO NOT** allow foreign objects to enter the soldering gun as they may cause internal damage.
- This product is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, lack of experience and knowledge, unless they have been given supervision or instructions concerning use of the product by a person responsible for their safety.
- Children should be supervised to ensure they do not play with the soldering iron.

### 3.2 Connection to the Power Supply



**CAUTION!** Risk of electric shock.  
**DO NOT** open.

This appliance is supplied with an approved rewireable plug and cord for your safety.

If the power supply cord is damaged, it must be replaced by Draper Tools, an authorised service agent or similarly qualified personnel in order to avoid a hazard. The damaged or incomplete plug, when cut from the cord, shall be disabled to prevent connection to a live electrical outlet.

This appliance is Class I† and is designed for connection to a power supply matching that detailed on the rating label and compatible with the plug fitted.

The value of the fuse fitted is marked on the pin face of the plug. Should the fuse need replacing, unscrew the face of the plug and remove the fuse. Ensure the substitute is of the correct rating, approved to BS 1362 and ASTA or BS Kite marked. This should only be performed by suitably qualified personnel.

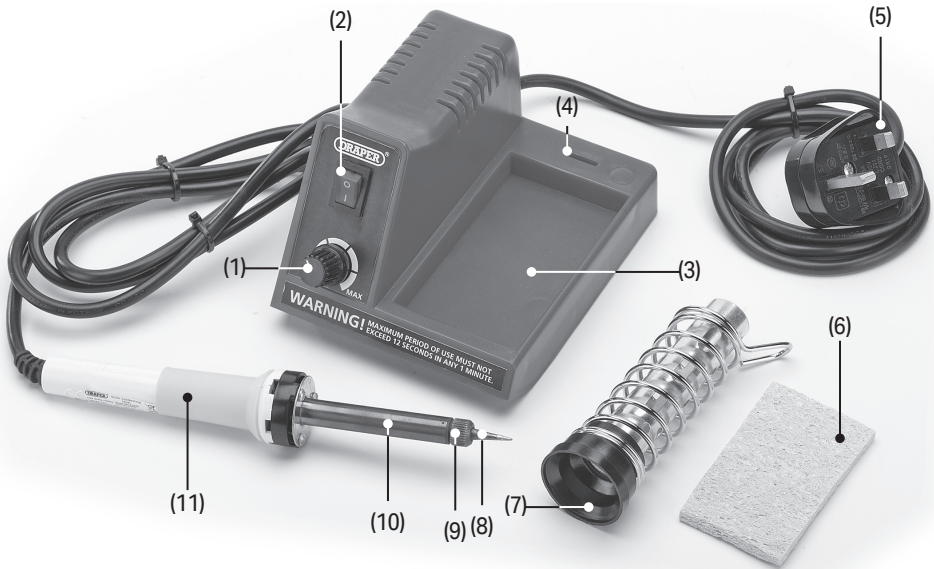
ASTA

BSI

†Earthed : This product requires an earth connection to protect against electric shock from accessible conductive parts in the event of a failure of the basic insulation.

## 4. Identification

Carefully remove the product from the packaging and examine it for any signs of damage that may have occurred during shipment. If any part is damaged or missing, do not attempt to use the product. Please contact the Draper Helpline; contact details can be found at the back of this manual.



- |                     |                                     |                         |                   |
|---------------------|-------------------------------------|-------------------------|-------------------|
| 1. Heat output dial | 4. Soldering iron stand insert slot | 6. Sponge               | 9. Collar         |
| 2. ON/OFF switch    | 5. Cord and plug                    | 7. Soldering iron stand | 10. Soldering gun |
| 3. Sponge tray      |                                     | 8. Tip                  | 11. Hand grip     |

Please visit [drapertools.com](http://drapertools.com) for our full range of accessories and consumables.

## 5. Assembly

**Important:** Before operating this product, read and understand all the safety instructions listed in this manual.

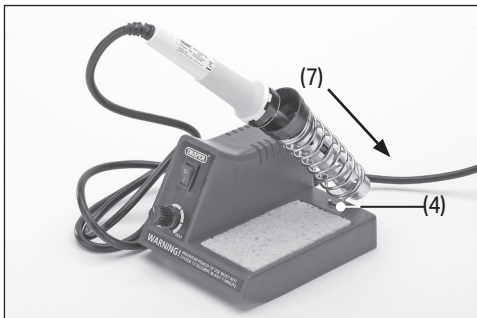


Fig. 1

- Before use insert the tab of the stand (7) into the slot (4) in the base unit

## 6. Instructions for Use

### Before soldering for the first time

- Before soldering for the first time the soldering tips should be tinned using solder and a separate flux until the tip is fully coated with solder.
- Ensure tips are tinned before soldering.
- Occasional re-tinning will ensure good solder connections.

### 6.1 Instruction for Use

- Ensure the objects to be soldered are clean.
  - Conductors should be cleaned with steel wool or fine sandpaper.
- Plug in and move the switch (2) to the **ON/I** position.
  - Adjust the heat dial (1) to achieve the required soldering tip temperature.
- Apply tip to the workpiece, then apply solder at the point of the tip contact.

- Remove the tip from the work piece.
  - Molten solder must cool undisturbed. Blowing on the solder will speed up setting.
  - **DO NOT** use more solder than required and just enough to make a good connection.
  - Use resin core solder for radio and electrical connections.
  - Use acid core solder only where flux residue has been removed. Use mainly for mechanical connections.
- After using with acid core, clean the soldering tip thoroughly.

## 7. Replacing the Soldering Tip

Note: Unplug from the power supply and allow to cool before replacing the soldering tip.

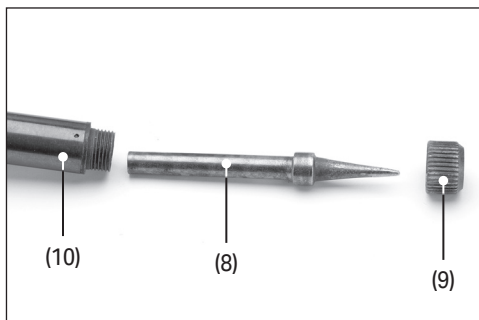


Fig. 2

- Loosen the collar (9) and remove from the soldering gun (10). Then pull out the tip (8).
- Fit the replacement tip into the gun. Tighten the collar securely.

## 8. Disposal

At the end of its working life, dispose of the product responsibly and in line with local regulations. Recycle where possible.

- **DO NOT** dispose of this product with domestic waste; most local authorities provide appropriate recycling facilities.



## 9. Warranty

12 months from date of purchase - Visit [drapertools.com/warranty](http://drapertools.com/warranty) for full details.

This warranty does not apply to any consumable parts or normal wear and tear, nor does it cover any damage caused by misuse, careless or unsafe handling, alterations, accidents, or repairs attempted or made by any personnel other than the authorised Draper Tools repair agent.

## 10. Symbols



Read the instruction manual



**Warning!**



WEEE –  
Waste Electrical & Electronic Equipment

Do not dispose of Waste Electrical & Electronic Equipment in with domestic rubbish



European conformity



UK Conformity Assessed

## Contact Details

### Draper Tools

Draper Tools Limited  
Hursley Road  
Chandler's Ford  
Eastleigh  
Hampshire  
SO53 1YF  
UK

### Delta International

Delta International BV  
Oude Graaf 8  
6002 NL  
Weert  
Netherlands

**Website:** [drapertools.com](http://drapertools.com)

**Email:** [sales@drapertools.com](mailto:sales@drapertools.com)

**Product Helpline:** +44 (0) 23 8049 4344

**Telephone Sales Desk:** +44 (0) 23 8049 4333

**General Enquiries:** +44 (0) 23 8026 6355

Please contact the Draper Tools Product Helpline for repair and servicing enquiries.