

APR

Scorpion Rework System ***User Guide***

Contents

Safety and Regulatory Information	3
Description	5
Packaging	6
Scorpion System Components	9
Set-up	11
System Operation	14
Reflow Head and Precision Placement Head Operation	14
Board Holder	15
SmartPlace Camera Remote Operation	15
System Icons and Descriptions	17
Profile Window	20
Removal Sequence, Reflow Head	24
Place Sequence, Reflow Head	26
Place Sequence, Reflow Head and Precision Placement Head	27
Calibration and Adjustment	41
Specifications	72
Nozzles and Accessories	76
Replacement Parts	76
Customer Service and Warranty	76

Safety and Regulatory Information

WARNING

- TO PREVENT FIRE OR SHOCK HAZARD, DO NOT EXPOSE SYSTEM TO MOISTURE.
- TO PREVENT FIRE OR SHOCK HAZARD, DO NOT USE FLAMMABLE SOLVENTS NEAR OR ON THE SYSTEM WHILE CONNECTED TO A POWER SOURCE.
- TO PREVENT POSSIBILITY OF INJURY OR DAMAGE TO THE SYSTEM, DO NOT OPERATE WITH ANY COVERS OR PANELS REMOVED.
- **CHANGES OR MODIFICATIONS MADE TO THIS PRODUCT WITHOUT EXPRESS APPROVAL FROM APR COULD VOID THE USERS AUTHORITY TO OPERATE THE EQUIPMENT.**

CAUTION

- Read and understand the entire Operator's Manual before installation or operation of the Scorpion Rework System. Heed all warnings on the system and in the operating instructions.
- Use of the Scorpion Rework System is intended only for the removal and placement of electronic components on to printed circuit boards by properly trained personnel. If you are not familiar with the proper and safe operation of the unit, do not operate it until proper training has been obtained.
- The unit should be operated only from the type of power source indicated on the serial number label.
- Use only the supplied power cord. Avoid damage to the power cord. If damage should occur, replace it with the approved APR replacement power cord.



- This CAUTION symbol on the equipment refers the user to the user guide for additional information. This symbol appears next to the relevant information in the manual.



- This HOT symbol on the equipment warns the user of a hot surface and potential injury if touched. Please refer to the Operator's Manual for additional information. This symbol appears next to the relevant information in the manual.



- This HEAVY LIFTING symbol on the packaging warns the user to team lift the Scorpion Rework System during removal from packaging and installation on the workbench. Please refer to the user guide for additional information. This symbol appears next to the relevant information in the manual.



- This PINCH POINT symbol on the equipment warns the user of a potential injury. This symbol appears next to the relevant information in the manual.



When operating this equipment, please exercise caution. If this unit is used in a manner which it is not intended for, serious personal injury may occur. Please read this user guide thoroughly prior to use.



- **The main power cord is a means for disconnecting the equipment from an operating energy source. Equipment must not be positioned in a way that impedes the disconnection of the main power cord in case of an emergency.**
- **Mandatory use of a grounding strap is required when operating the equipment.**

Other Safety Tips

- Unplug the unit before cleaning. Clean the exterior of the system with a damp cloth. Do not use solvent-based cleaners.
- Slots and openings in the system are provided for ventilation and to ensure reliable operation and protection from overheating. The openings should never be blocked or covered.
- Do not overload power outlets and extension cords. This can result in fire or electric shock.

Description

Thank you for your purchase of a Scorpion Rework System. Each unit has been inspected thoroughly by APR prior to shipment, and with proper maintenance will give you years of reliable performance.

This user guide is a valuable resource. It explains the systems options, features, specifications and the correct operation of your Scorpion Rework System. If any problems should occur during setup or operation of your system, contact [APR Customer Service](#).

The Scorpion Rework System provides both accurate component placement and specifically tailored reflow profiles in one user friendly, single platform rework system.

The challenges of array package rework, and the inability to easily inspect placement accuracy (with BGAs in particular), call for a solution that allows for simultaneous viewing of PC board pads and component pads or balls for accurate placement. The Scorpion Rework System fills this need with quick, accurate placement through the use of the SmartPlace Technology vision system employing dual image overlay technology. The image of the BGA solder balls is overlaid with that of the PC board pattern with magnification from 20X to 50X. The image is viewed on the computer monitor and fine adjusted with micrometers on the board holder. Finally, the part is placed and the vacuum is released.

After accurate component placement is achieved, the vacuum pickup tube is retracted and the reflow nozzle is lowered into place. At this point, the component is subjected to a user-customizable multi-zone, full convection reflow profile, specifically tailored to the requirements of that particular PCB, device and solder paste. Accurate duplication of original oven reflow parameters is achieved.

During the course of the reflow profile, source temperatures and time intervals can be modified “On the Fly”, eliminating the need to wait for the current profile to terminate before modifications can be made. Precise solder joint temperatures are measured and displayed on a real time graphical display, thus providing the necessary data to accurately and easily establish the optimum reflow profile for each particular application within minutes.

The Scorpion Rework System is available in the following item numbers:

Item	Description
APR-1200-SRS	Scorpion Rework System, with Manual Placement Head
APR-1200A-SRS	Scorpion Rework System, with Motorized Placement Head
APR-1200-SRS-MOB	Scorpion Rework System, with Manual Placement Head, for High Density Boards
APR-1200A-SRS-MOB	Scorpion Rework System, with Motorized Placement Head, for High Density Boards
670050	Scorpion XL Rework System, with Manual Placement Head
670051	Scorpion XL Rework System, with Motorized Placement Head

Packaging

APR-1200-SRS

Qty	Item	Description
1	-	Scorpion Rework System
1	-	Scorpion Power Cord (male plug not included)
1	SPT-RC	Remote Control with DB9 Cable, for Scorpion with Manual Placement Head
1	-	19" LCD Monitor with HDMI Cable and U.S. Power Cord
1	-	Optical Mouse
1	FSL-SRS-3	PCB Spring Finger, Long (3 pack)
1	FSS-SRS-3	PCB Spring Finger, Short (3 pack)
1	UBS-SRS	Underboard Support
3	-	Thermocouple, 40 Gauge, 36"
1	VNZ-ORINGK	O-Ring Kit (assortment, qty 5 for each of the 4 sizes)
1	VNZ-12	Vacuum Nozzle, 11.5 mm O.D.
1	VNZ-08	Vacuum Nozzle, 8.0 mm O.D.
1	VNZ-05	Vacuum Nozzle, 5.5 mm O.D.
1	VNZ-01	Vacuum Nozzle, 1.5 mm O.D.
1	AC-RP	Nozzle Removal Pad
1	APR-20987	Adjustable Component Nest, CSP
1	APR-19782	Adjustable Component Nest, BGA
1	KAP-100	Pre-cut Kapton Tape (100 pack)
1	SRS-OVK	Optical Verification Kit
1	PNZ-07	Placement Nozzle, 1.0 mm O.D.
1	PNZ-24	Placement Nozzle, 4.0 mm O.D.
1	PNZ-60	Placement Nozzle, 12.5 mm O.D.
1	PNZ-AD	Placement Nozzle Adapter

APR-1200-SRS-MOB

Qty	Item	Description
1	-	Scorpion Rework System
1	-	Scorpion Power Cord (male plug not included)
1	SPT-RC	Remote Control with DB9 Cable, for Scorpion with Manual Placement Head
1	-	22" LCD Monitor with HDMI Cable and U.S. Power Cord
1	-	Optical Mouse
1	FSL-SRS-3	PCB Spring Finger, Long (3 pack)
1	FSS-SRS-3	PCB Spring Finger, Short (3 pack)
1	UBS-SRS	Underboard Support
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1	PNZ-AD	Placement Nozzle Adapter

APR-1200A-SRS

Qty	Item	Description
1	-	Scorpion Rework System
1	-	Scorpion Power Cord (male plug not included)
1	SPT-RCA	Remote Control with DB9 Cable, for Scorpion with Motorized Placement Head
1	-	19" LCD Monitor with HDMI Cable and U.S. Power Cord
1	-	Optical Mouse
1	FSL-SRS-3	PCB Spring Finger, Long (3 pack)
1	FSS-SRS-3	PCB Spring Finger, Short (3 pack)
1	UBS-SRS	Underboard Support
3	-	Thermocouple, 40 Gauge, 36"
1	VNZ-ORINGK	O-Ring Kit (assortment, qty 5 for each of the 4 sizes)
1	VNZ-12	Vacuum Nozzle, 11.5 mm O.D.
1	VNZ-08	Vacuum Nozzle, 8.0 mm O.D.
1	VNZ-05	Vacuum Nozzle, 5.5 mm O.D.
1	VNZ-01	Vacuum Nozzle, 1.5 mm O.D.
1	AC-RP	Nozzle Removal Pad
1	APR-20987	Adjustable Component Nest, CSP
1	APR-19782	Adjustable Component Nest, BGA
1	KAP-100	Pre-cut Kapton Tape (100 pack)
1	SRS-OVK	Optical Verification Kit
1	PNZ-07	Placement Nozzle, 1.0 mm O.D.
1	PNZ-24	Placement Nozzle, 4.0 mm O.D.
1	PNZ-60	Placement Nozzle, 12.5 mm O.D.

APR-1200A-SRS-MOB

Qty	Item	Description
1	-	Scorpion Rework System
1	-	Scorpion Power Cord (male plug not included)
1	SPT-RCA	Remote Control with DB9 Cable, for Scorpion with Motorized Placement Head
1	-	22" LCD Monitor with HDMI Cable and U.S. Power Cord
1	-	Optical Mouse
1	FSL-SRS-3	PCB Spring Finger, Long (3 pack)
1	FSS-SRS-3	PCB Spring Finger, Short (3 pack)
1	UBS-SRS	Underboard Support
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1	SRS-OVK	Optical Verification Kit
1	PNZ-07	Placement Nozzle, 1.0 mm O.D.
1	PNZ-24	Placement Nozzle, 4.0 mm O.D.
1	PNZ-60	Placement Nozzle, 12.5 mm O.D.

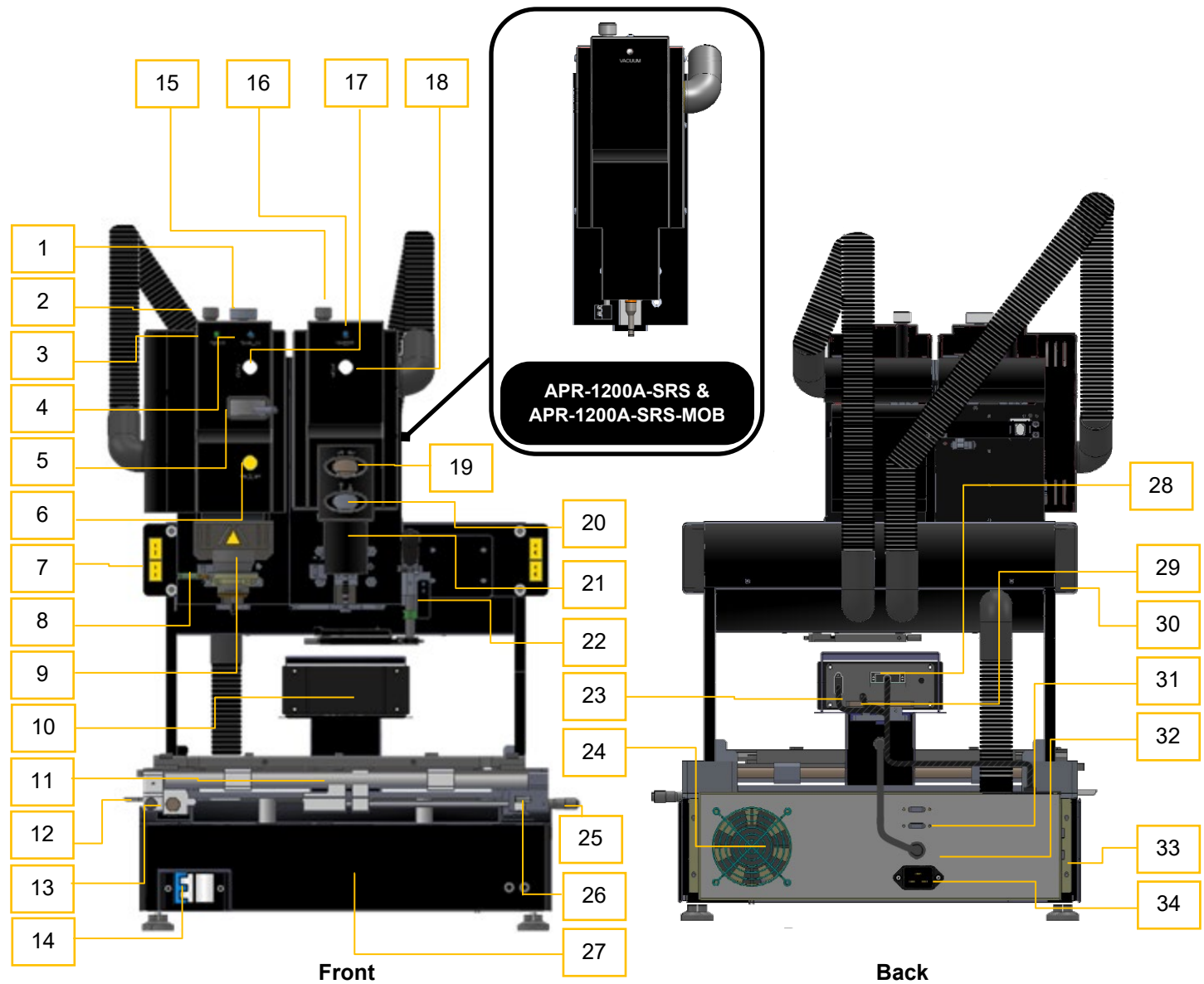
670050

Qty	Item	Description
1	-	Scorpion XL Rework System
1	-	Scorpion Power Cord (male plug not included)
1	SPT-RC	Remote Control with DB9 Cable, for Scorpion with Manual Placement Head
1	-	19" LCD Monitor with HDMI Cable and U.S. Power Cord
1	-	Optical Mouse
1	FSL-SRS-3	PCB Spring Finger, Long (3 pack)
1	FSS-SRS-3	PCB Spring Finger, Short (3 pack)
2	UBS-SRS	Underboard Support
3	-	Thermocouple, 40 Gauge, 36"
1	VNZ-ORINGK	O-Ring Kit (assortment, qty 5 for each of the 4 sizes)
1	VNZ-12	Vacuum Nozzle, 11.5 mm O.D.
1	VNZ-08	Vacuum Nozzle, 8.0 mm O.D.
1	VNZ-05	Vacuum Nozzle, 5.5 mm O.D.
1	VNZ-01	Vacuum Nozzle, 1.5 mm O.D.
1	AC-RP	Nozzle Removal Pad
1	APR-20987	Adjustable Component Nest, CSP
1	APR-19782	Adjustable Component Nest, BGA
1	KAP-100	Pre-cut Kapton Tape (100 pack)
1	SRS-OVK	Optical Verification Kit
1	PNZ-07	Placement Nozzle, 1.0 mm O.D.
1	PNZ-24	Placement Nozzle, 4.0 mm O.D.
1	PNZ-60	Placement Nozzle, 12.5 mm O.D.
1	PNZ-AD	Placement Nozzle Adapter

670051

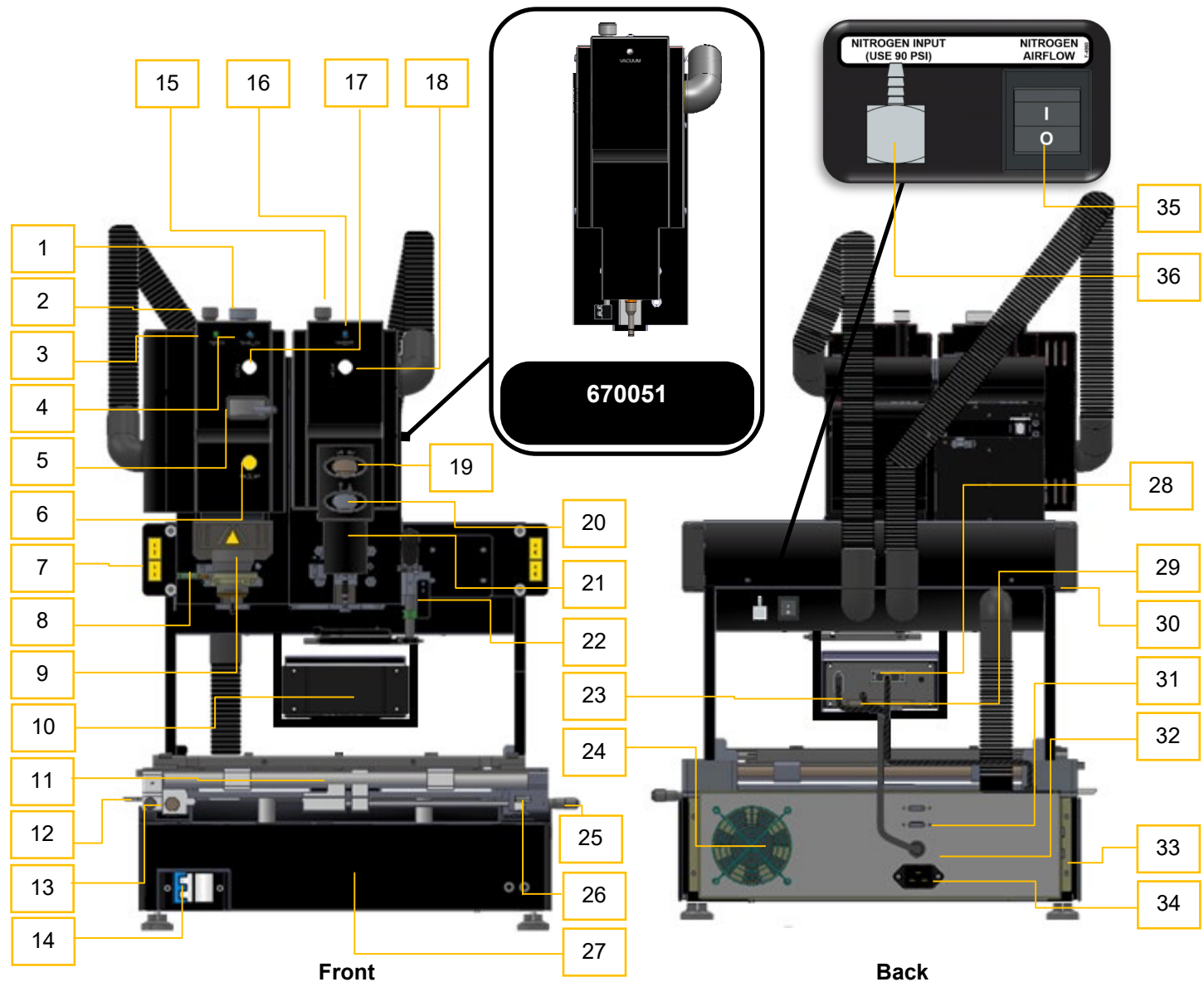
Qty	Item	Description
1	-	Scorpion Rework System
1	-	Scorpion Power Cord (male plug not included)
1	SPT-RCA	Remote Control with DB9 Cable, for Scorpion with Motorized Placement Head
1	-	19" LCD Monitor with HDMI Cable and U.S. Power Cord
1	-	Optical Mouse
1	FSL-SRS-3	PCB Spring Finger, Long (3 pack)
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1	PNZ-60	Placement Nozzle, 12.5 mm O.D.

Scorpion System Components - APR-1200-SRS



1	Fine "Z" axis adjustment	19	Theta adjustment
2	Travel adjustment	20	Fine "Z" axis adjustment
3	Power "On" LED	21	Precision Placement Head
4	Vacuum Seal indicator	22	Component placement assembly
5	Component Theta control	23	Remote control connector
6	"X" axis release button	24	Chassis Fan
7	External Type K thermocouple	25	"X" Axis micrometer
8	Travel dampener	26	"X" Axis lock
9	Reflow head	27	Preheater Chassis assembly
10	SmartPlace Technology Vision System	28	Camera DVI connector
11	Board holder assembly	29	Camera power connection
12	"Y" lock	30	Gantry assembly
13	"Y" Axis micrometer	31	USB connectors
14	Circuit breaker	32	SmartPlace power cable
15	Travel Adjustment	33	HDMI monitor connector
16	Vacuum Seal Indicator	34	Power cable
17	"Z" Axis release		
18	"Z" Axis release		

Scorpion XL System Components - 670050



1	Fine "Z" axis adjustment	19	Theta adjustment
2	Travel adjustment	20	Fine "Z" axis adjustment
3	Power "On" LED	21	Precision Placement Head
4	Vacuum Seal indicator	22	Component placement assembly
5	Component Theta control	23	Remote control connector
6	"X" axis release button	24	Chassis Fan
7	External Type K thermocouple	25	"X" Axis micrometer
8	Travel dampener	26	"X" Axis lock
9	Reflow head	27	Preheater Chassis assembly
10	SmartPlace Technology Vision System	28	Camera DVI connector
11	Board holder assembly	29	Camera power connection
12	"Y" lock	30	Gantry assembly
13	"Y" Axis micrometer	31	USB connectors
14	Circuit breaker	32	SmartPlace power cable
15	Travel Adjustment	33	HDMI monitor connector
16	Vacuum Seal Indicator	34	Power cable
17	"Z" Axis release	35	Nitrogen controller switch
18	"Z" Axis release	36	Nitrogen input hose barb

Set-up



The main unit is very heavy. Please uncrate the unit with 2 people.



DO NOT LIFT THE MAIN UNIT BY THE PCBA BOARD HOLDER. LIFTING BY THE BOARD HOLDER WILL DAMAGE THE ASSEMBLY!



Before setting up your equipment

- Ensure your Scorpion Rework System has arrived complete
- Provide a location that allows the user to operate this machine in a comfortable, well-spaced environment



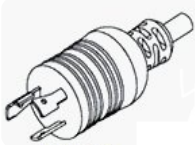
Every Scorpion Rework System has been factory assembled and calibrated.

- Recalibration is not necessary after initial setup.
- Verifying calibration and product functionality is strongly recommended prior to initial use

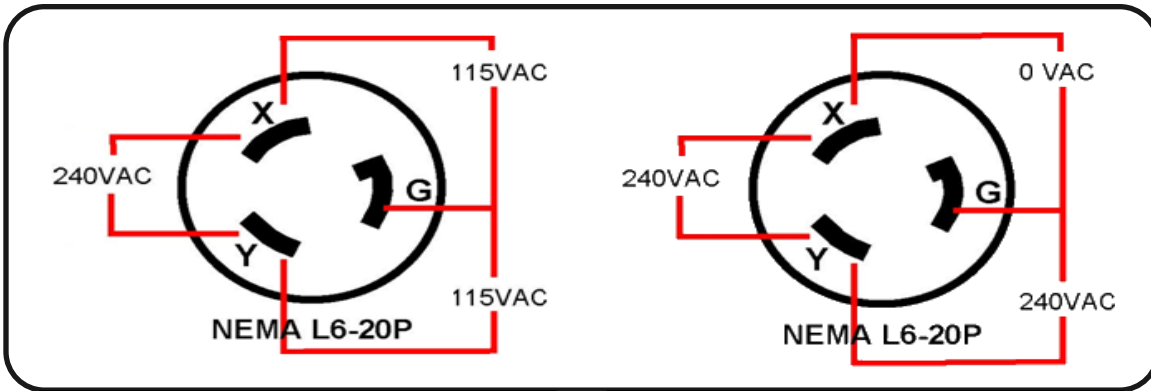


Power-up Sequence

- Attach an appropriate power plug to the stripped end of the power cord. Use recommended power plugs:
 - Nema 6-20
 - Nema L6-20
 - IEC 60309



Use the following diagrams together with the manufacturer's recommended procedure for hooking up wires to a power plug



Configuration 1

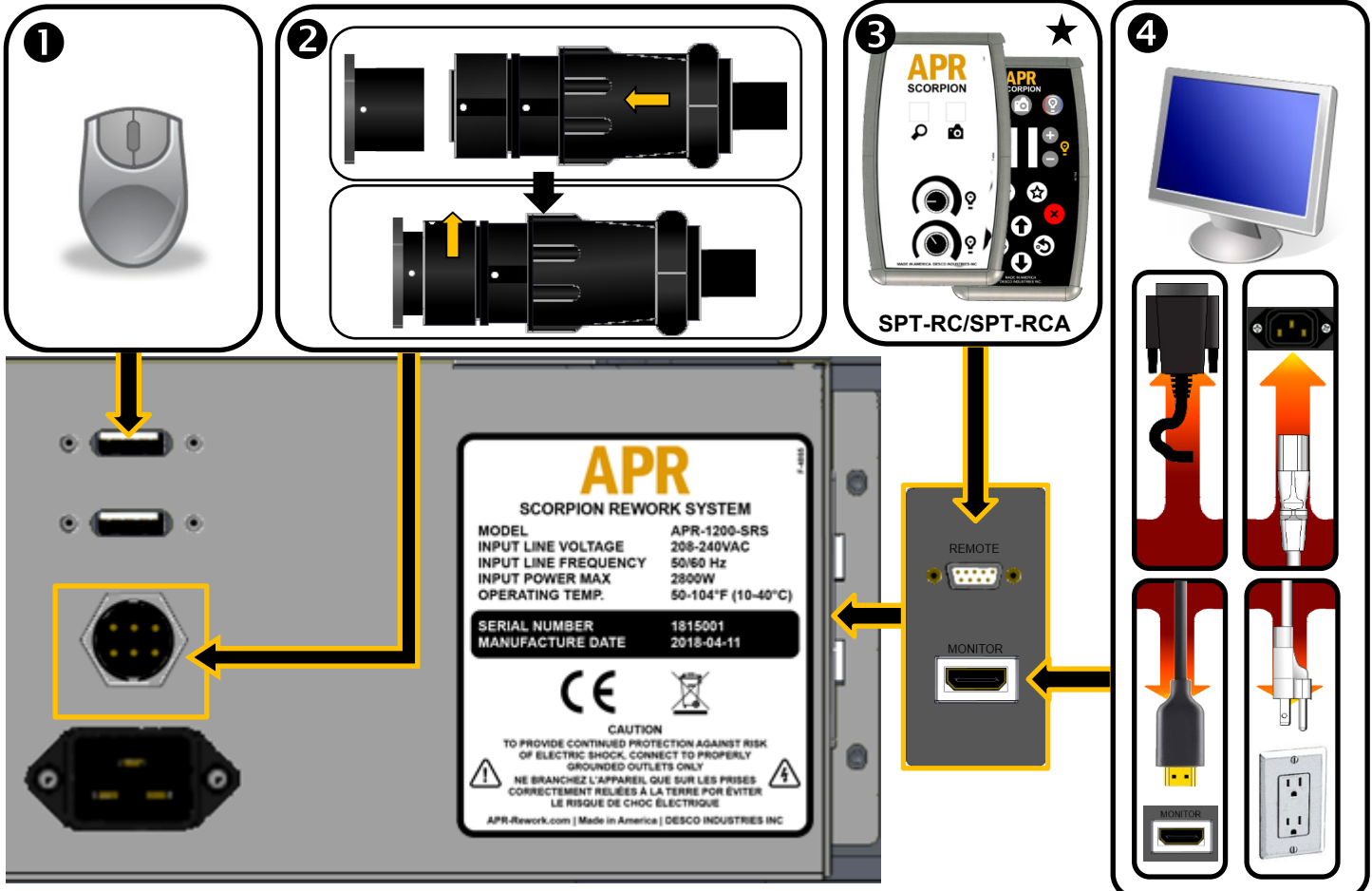
- Measure from **X** to **Y**. This measurement should always be 200VAC to 240VAC
- Measure from **G** to **X**. This measurement will be 110VAC-125VAC
- Measure from **G** to **Y**. This measurement will be 110VAC-125VAC

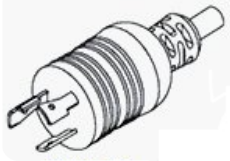
Configuration 2

- Measure from **X** to **Y**. This measurement should always be 200VAC to 240VAC
- Measure from **G** to **X**. This measurement will be 0 VAC
- Measure from **G** to **Y**. This measurement will be 200VAC-240VAC

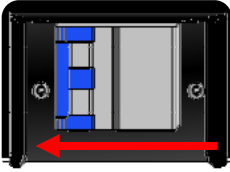
Cable Connections

★ SPT-RCA --- APR-1200A-SRS & APR-1200A-SRS-MOB





Insert the power cord plug into a receptacle



Set the circuit breaker switch to the "on" position



When the title screen, appears your Scorpion Rework System is ready for operation!



Click the log-in icon.

- The system has three levels of permissions; operator, engineer, and administration modes.
- Enter the appropriate password for the user level with the onscreen keyboard.
- Default Operator password=operator
- Default Engineer password=engineer
- Default Administration password=guru



Navigation



The Scorpion user interface offers two options for navigation.

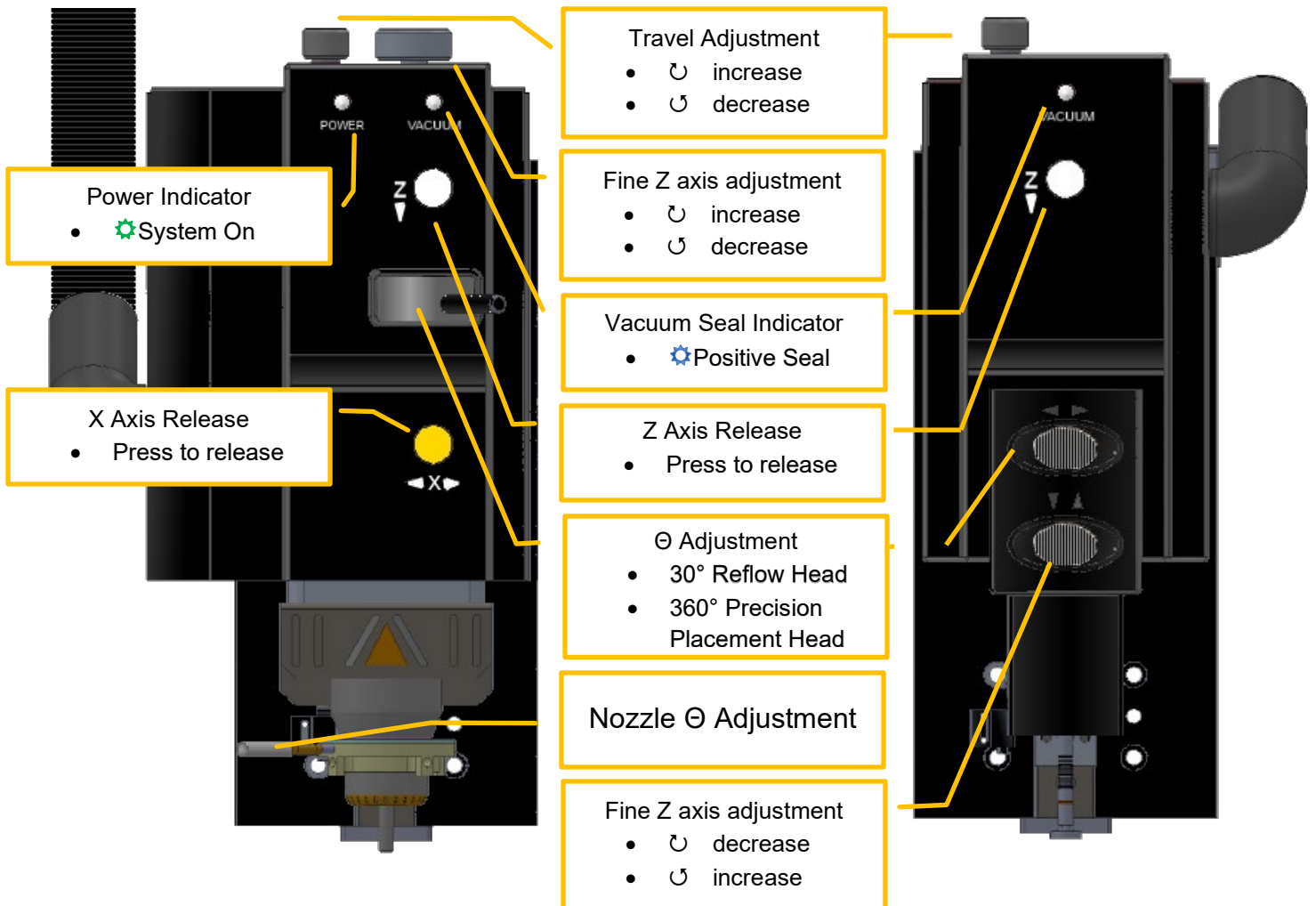


- Each dot corresponds to a different screen. Select a screen by left-clicking on the appropriate dot.
- The first dot is the title screen, the second dot is the profile window, the third dot is system configuration window, and the fourth dot is the factory administration window.

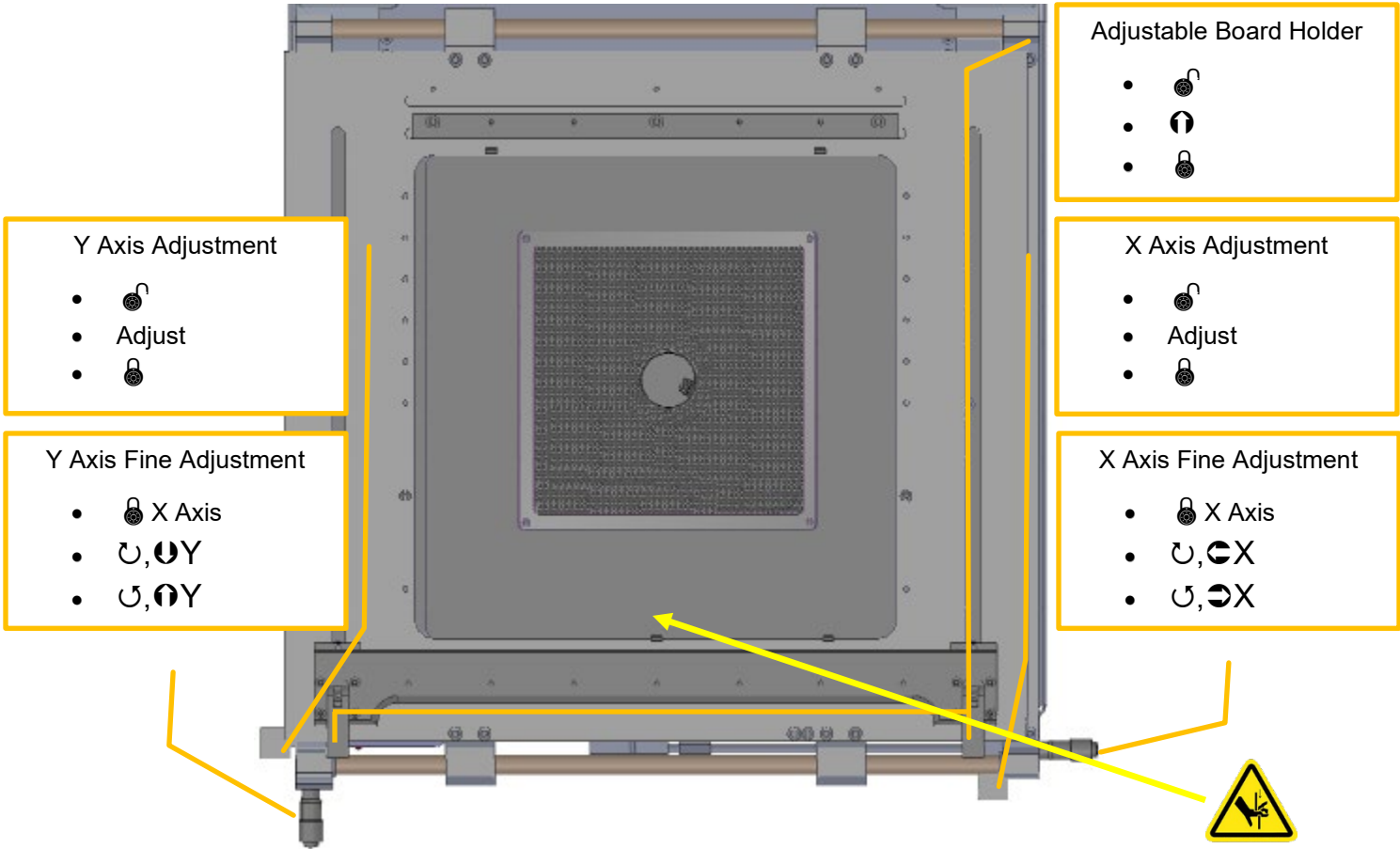
System Operation

Reflow Head:

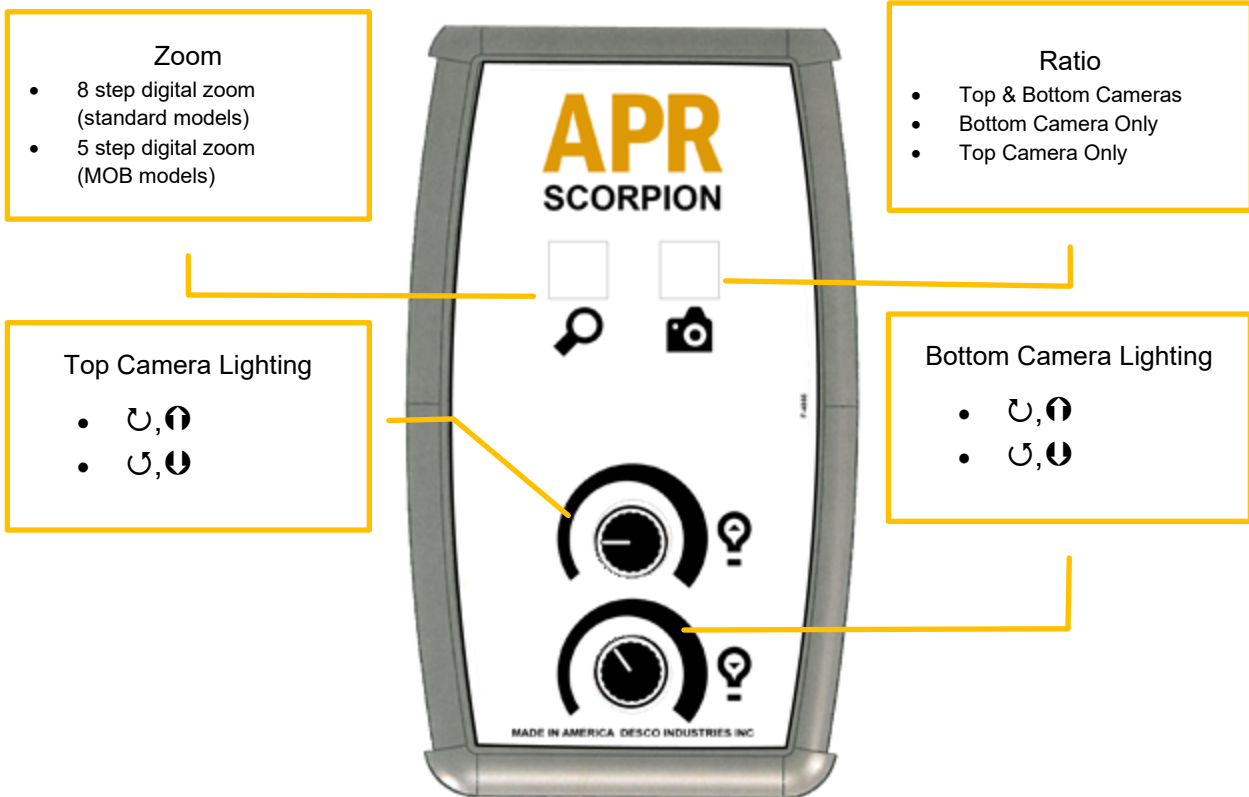
Precision Placement Head Operation: APR-1200-SRS & 670050

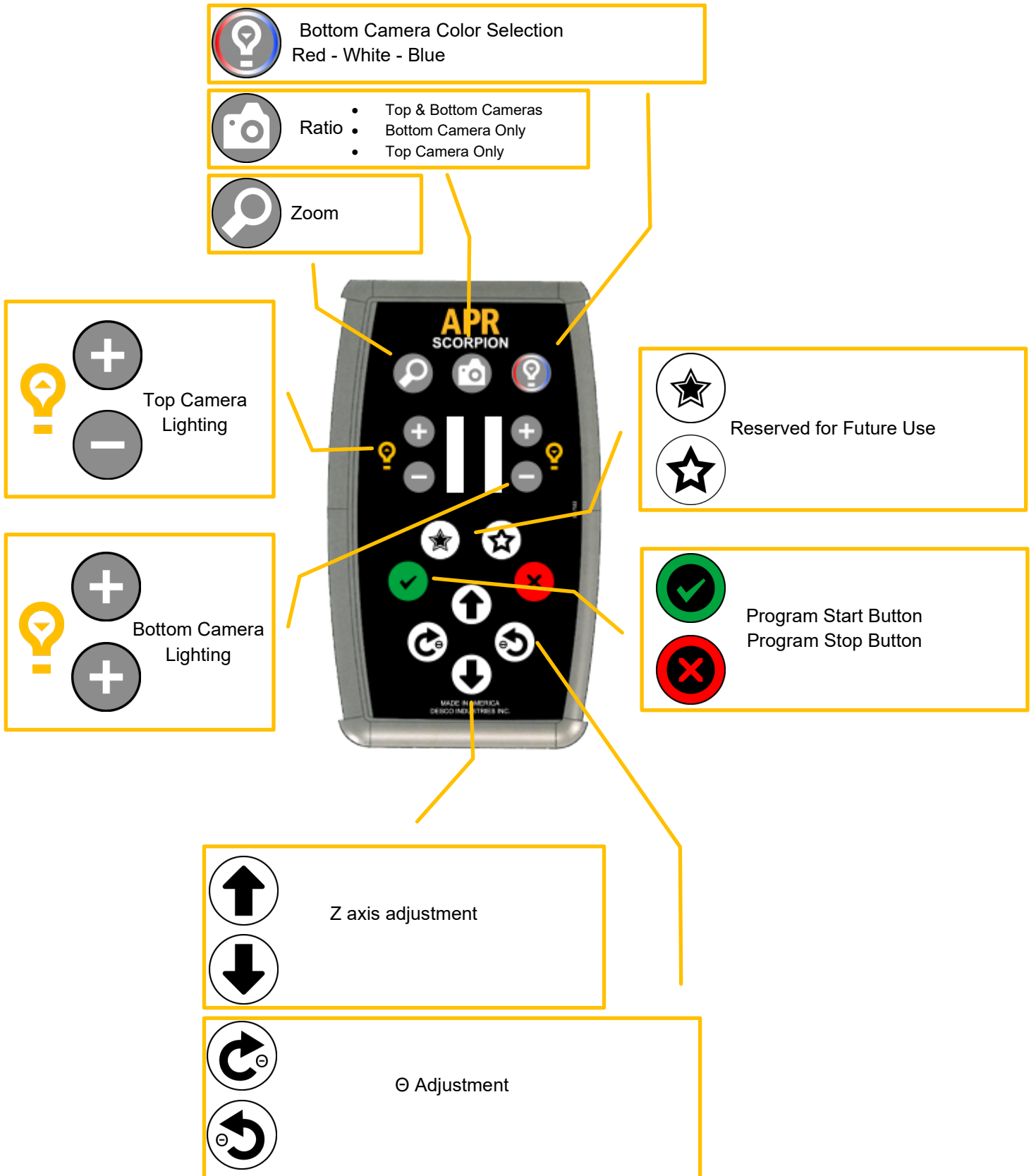


Board Holder Operation



SmartPlace Camera Remote Operation: APR-1200-SRS, APR-1200-SRS-MOB, 670050





System Icons and Descriptions

	Login	 	Locked Unlocked
	New Removal Profile	 	Vacuum Shaft Retract, Reflow Head
	New Placement Profile	 	Vacuum Shaft Retract, Precision Placement Head
	Open/Import Profile	 	Vacuum On-Off
	Save/Export File	 	Puff-Off
	Start Profile		Reflow Blower
	Auto Profile		Focus Blower
	Cycle Advance		Surround Blower
	Add Zone	 	Reflow Heater Calibration Calibration in Progress
	Screen Capture		Focus Heater Calibration
 	Open Screen Shot Close Screen Shot		Surround Heater Calibration
	Language Select	 	Preheater Preset Off Preheater Preset On
	Back-up & Restore		Thermocouple Calibration
	Restore Factory Settings		Unmount USB Drive
	User Guide	 	Side-view Camera On/Off
	Software Shutdown		



User Guide



- Hover the cursor over the user guide icon



- Left click the icon to activate
- Left click again to deactivate



Software Shutdown



- Metcal recommends shutting down the software prior to removing power to the unit. This will minimize the risk of file corruption to the computer's memory card.



- Hover the cursor over the software shutdown icon



- Left click the icon to activate.



Tool Tip language select.



- Hover the cursor over the tool tip language select icon.



- Right click on the mouse button to access the language options box.



- The language option box displays showing the current language setting.



- Use the scroll wheel to the language.

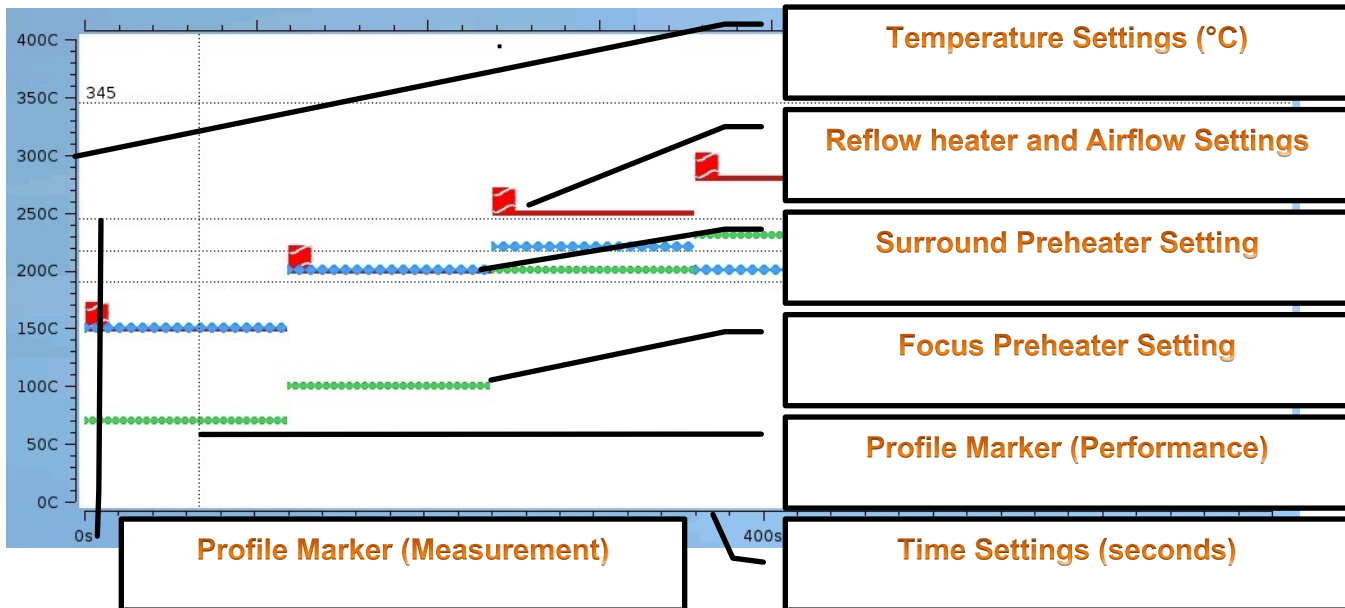


- Right click the mouse button to save changes.



- Left click the icon to activate
- Left click again to deactivate

Active Profile Area



Changing Profile Values



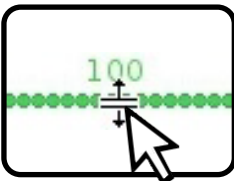
Changing airflow

- Left click on the box area to change airflow.
- 3 available settings, low (1 bar), medium (2 bars), and high (3 bars).



Changing temperature

- Each line corresponds to a different heater
- Temperature can be changed in two ways.



Changing temperature - Method 1

- Left click the desired heater. The cursor will change to double arrows. Drag & drop to the desired temperature.



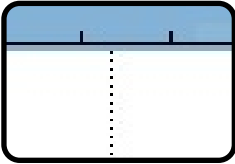
Changing temperature - Method 2

- Right click the desired heater. The temperature adjust dialog box will appear. Use the up and down arrows to select the desired temperature. Click "ok" to enter the desired temperature.



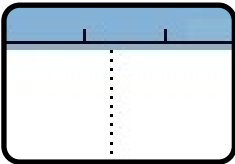
Changing Time Zones

- The default configuration is 4 heating zones and 1 for cooling. An additional 4 zones of heating and 1 of cooling can be added.
- The duration of each zone can be changed in two ways.



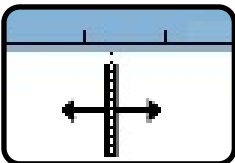
Adding additional time zones

- Hover the cursor over the time zone bar area located at the top of the graph. The cursor will change to the "zone" icon. Left click to add an additional zone.



Removing time zones

- Hover the cursor over the time zone bar area located at the top of the graph. The cursor will change to the "zone" icon. Right click to remove a zone.



Changing time zone duration - Method 1

- Left click the desired zone. The cursor will change to double arrows. Drag & drop to the desired time.



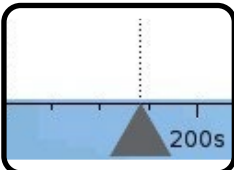
Changing time zone duration - Method 2

- Right click the desired zone. The time adjust dialog box will appear. Use the up and down arrows to select the desired time. Click "ok" to enter the desired time.



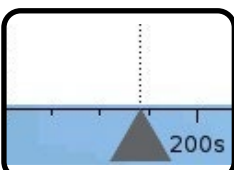
Profile Markers (Performance)

- 8 markers are available
- Markers provide time, temperature, and ramp rate information at user defined intervals



Adding Profile Markers

- Hover the cursor over the time zone bar area located at the bottom of the graph. The cursor will change to the "marker" icon. Left click to add a marker. Markers are color-coordinated with the clocks displayed in the time and temperature table.



Removing Profile Markers

- Hover the cursor over the time zone bar area located at the bottom of the graph. The cursor will change to the "marker" icon. Right click to remove a marker.



Profile Data Table

- 1 System Performance information
- Displays 8 user-defined profile markers (performance)
- Provides temperature and ramp rate data

System Performance information

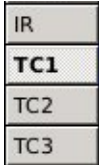
Time	129	138	142	142					
Reflow	0	-	0	-					
Small	-	0	-	0	-				
Large	-	0	-	0	-				
IR	-	0	-	0	-				
TC1	-	0	-	0	-				
TC2	-	0	-	0	-				
TC3	-		-		-				

Internal Thermocouple;
Reflow, Focus, & Surround

Profile Marker time (seconds)

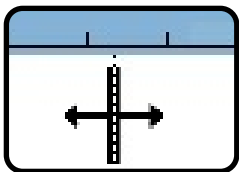
Profile Marker temperature data (°C)

Profile Marker ramp rate data



Repeatability verification:

- If external thermocouple plots were saved as part of a previous run.
- Left click "Real Time" data box on the appropriate external TC1,2,3 to enable / disable a comparison plot for the next run.



Changing Profile Marker location - Method 1

- Left click the desired profile marker. The cursor will change to double arrows. Drag & drop to the desired time.

Changing Profile Marker location - Method 2

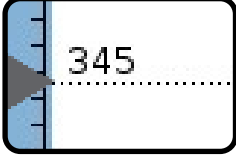


- Right click the profile marker. The time adjust dialog box will appear. Use the up and down arrows to select the desired time. Click "ok" to enter the desired time.



Profile Markers (Measurement)

- Markers provide a reference line during profile operation



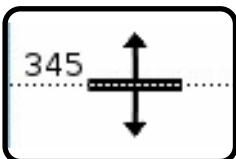
Adding Profile Markers

- Hover the cursor over the temperature zone bar area located on the left of the graph. The cursor will change to the "marker" icon. Left click to add a marker.



Removing Profile Markers

- Hover the cursor over the temperature zone bar area located on the left of the graph. The cursor will change to the "marker" icon. Right click to remove a marker.



Changing Profile Marker location - Method 1

- Left click the desired profile marker. The cursor will change to double arrows. Drag & drop to the desired time.



Changing Profile Marker location - Method 2

- Right click the profile marker. The time adjust dialog box will appear. Use the up and down arrows to select the desired time. Click "ok" to enter the desired time.

Profile Information Area

Profile mode: remove

Name: /default

Total Cycle Count: 14

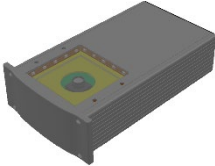
Total Cycle Run Time: 2:17 (hr:min)

Displays the current mode(remove, place, or calibration), profile name, and system cycle count and run time.



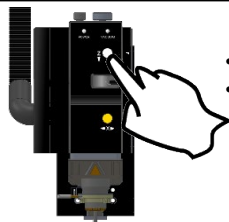
Removal Sequence, Reflow Head

- Position the reflow head over the preheater in the up position.
- Fit the appropriate vacuum cup and nozzle



When equipped with the SmartPlace Technology Vision System

- Pull out the camera
- Adjust the fine "Z" axis until the edge of the vacuum cup or reflow head is in focus.
- Using the camera, to view the nozzle or vacuum cup ensures alignment over the part under rework
- Return camera to the home position



- Press the reflow head release button
- Using the fine "Z" axis adjustment knob, adjust the head to be within 2mm of the PCB surface. For applications that require the protection of adjacent, sensitive components, lower the nozzle to board level.



Start the reflow profile by presing the start icon

- Vacuum is activated through the profile. The vacuum indicator lights when a vacuum seal is obtained.
- The vacuum shaft will automatically retract in the last zone of the reflow profile.



At the end of the profile...

- raise and lock the head in the up position
- automatic puff-off of the part will occur 30 seconds after the end of the profile
- manual puff-off is now available

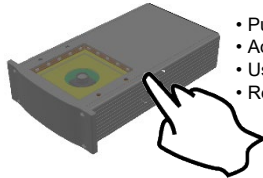


Place Sequence, Reflow Head

- Position the reflow head over the preheater in the up position
- Fit the appropriate vacuum cup and nozzle



- Place the component into the component tray.
- Place the component tray onto the placement arm.
- Turn on the vacuum and place the component on the vacuum cup.
- Rotate the placement arm counterclockwise, positioning the component under the vacuum nozzle.
- Pull down on the placement arm to raise the component into position
- The vacuum indicator will LED will light with a positive seal.



When equipped with the SmartPlace Technology Vision System

- Pull out the camera
- Adjust the fine "Z" axis until the component is in focus
- Use the "X" and "Y" board holder adjustments to center the part to the pads.
- Return camera to the home position



- Press the reflow head release button
- Lower the head to the PCB using the fine "Z" axis adjustment.



- Click on the puff-off icon to place the component to the board



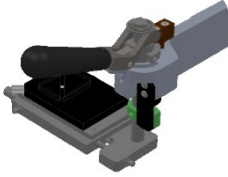
Start the profile...

- At the end of the profile, raise the head to the up position.

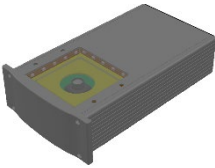


Place Sequence, Reflow Head and Precision Placement Head

- Position the **placement** head over the preheater in the up position
- Fit the appropriate nozzle into the reflow head
- Fit the appropriate vacuum nozzle into the Precisions Placement Head

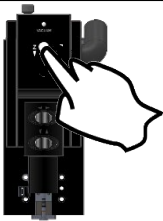


- Place the component into the component tray.
- Place the component tray onto the placement arm.
- Turn on the vacuum and place the component on the vacuum cup.
- Rotate the placement arm counterclockwise, positioning the component under the vacuum nozzle.
- Pull down on the placement arm to raise the component into position
- The vacuum indicator will LED will light with a positive seal.



When equipped with the SmartPlace Advantage Vision System

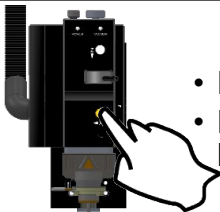
- Pull out the camera
- Adjust the fine "Z" axis until the component is in focus
- Use the "X" & "Y" board holder adjustments and the Theta head adjustment to center the part to the pads.
- Return camera to the home position



- Press the Precision Placement Head release button
- Lower the part to the PCB using the fine "Z" axis adjustment.



- Click on the puff-off icon to place the component to the board which also retracts the vacuum nozzle



- Raise the Precision Placement head into the up position.
- Press the "X" axis release button and center the reflow head.

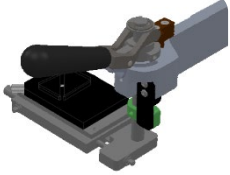


Follow the Place Sequence, Reflow Head instructions.

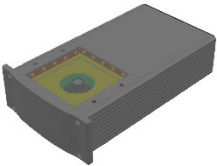


Place Sequence, Automatic Placement Head

- Position the placement head over the preheater in the up position
- Fit the appropriate nozzle into the reflow head
- Fit the appropriate vacuum nozzle into the Automatic Placement Head

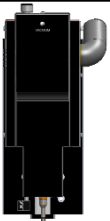


- Place the component into the component tray.
- Place the component tray onto the placement arm.
- Rotate the placement arm clockwise, positioning the component under the vacuum nozzle.
- Press the icon.
- Press the button on the remote control. The vacuum nozzle will make contact with the part and a light will indicate a positive vacuum seal.
- Press the button to retract the vacuum nozzle.



With the SmartPlace Advantage Vision System

- Pull out the camera
- Adjust the fine "Z" axis using the & icons until the component is in focus
- Use the "X" & "Y" board holder adjustments and the & icons to center the part to the pads.
- Return camera to the home position



- Press the reflow head release button to lower the automatic placement head
- Press the button on the remote control to lower the vacuum nozzle & component into contact with the board.
- Press the icon to activate the puff-off function.
- Press the button to retract the vacuum nozzle to the start position.



- Raise the Precision Placement head into the up position.
- Press the "X" axis release button and center the reflow head.



Follow the Place Sequence, Reflow Head instructions.

System Operations



Open/Import Profile



- Hover the cursor over the open/import icon



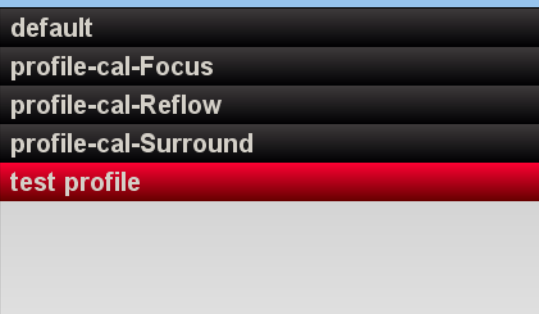
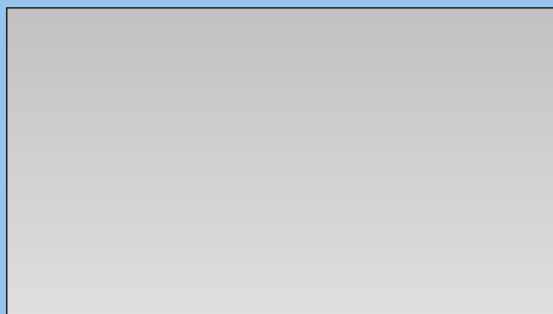
- Left click the mouse button to open a remove profile
- Right click the mouse button to open a place profile



- Select the file from the subdirectory box.

Subdirectory:

Select Profile



OK

Cancel



- Select and highlight the desired profile then press the OK button.
- Press the Cancel button to return to the profile page.



Saving/Exporting a New Profile



- Hover the cursor over the save icon



- Left click the mouse button & the profile naming dialog box displays.

Subdirectory:

Enter Profile Name



OK

Cancel

Create Dir



- Enter the desired profile name, select the save location from the subdirectory box, & press the OK button.
- To create a new directory enter the name and left click the Create Dir button.
- Press the Cancel button to return to the profile page.



Creating/Deleting a New Folder



- Hover the cursor over the save icon



- Left click the mouse button & the profile naming dialog box displays.

Subdirectory:

Enter Profile Name



OK Cancel Create Dir

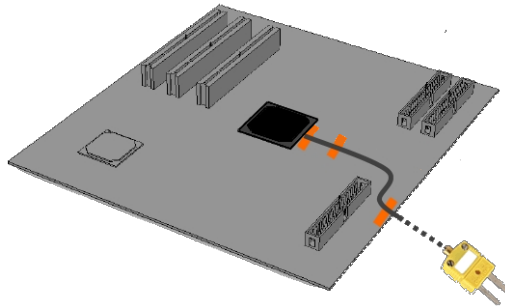


- To create a new directory enter the name and left click the Create Dir button.
- To delete a directory, select the directory, & press the Delete button.
- Press the Cancel button to return to the profile page.



Auto-profile

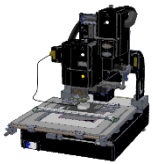
- A tool used to assist in the creation of thermal profiles.
- A thermocouple trigger is used to control the actions of the Scorpion.



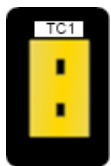
Example PCBA



- Place a K type thermocouple (TC) under the component part.
- 36 gauge TC with component stand-off heights $> .5\text{mm}$
- 40 gauge TC with component stand-off height of $< .5\text{mm}$



- Place the board into the board holder.
- Lower the reflow head into position over the component



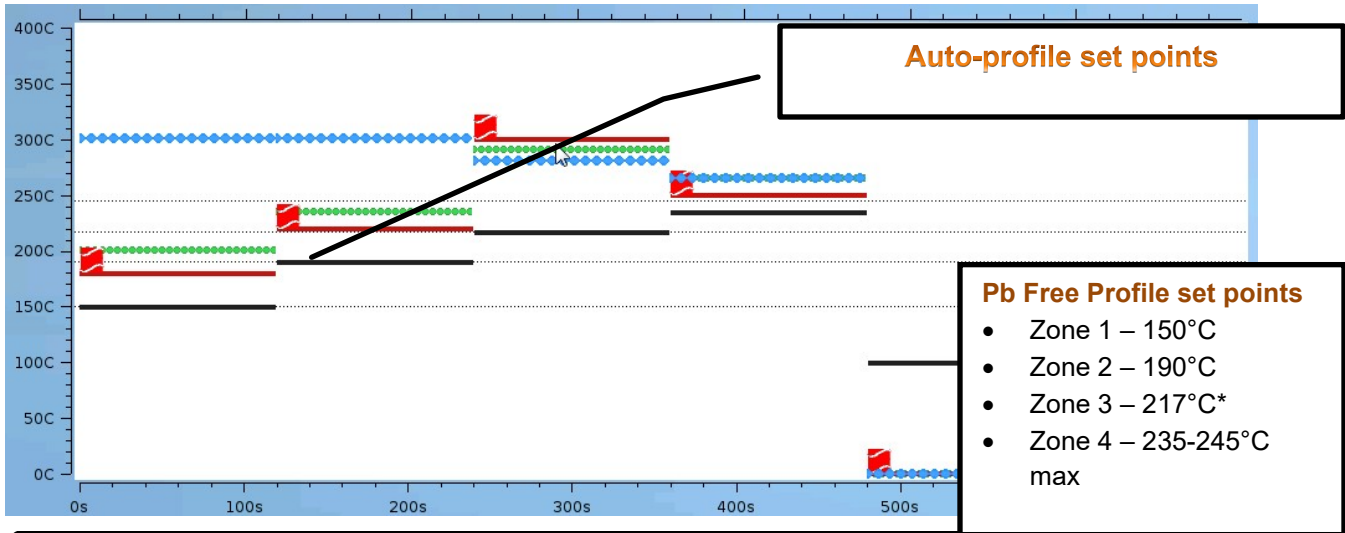
- Connect the K type thermocouple to TC1.



- Hover the cursor over the Auto-profile icon.

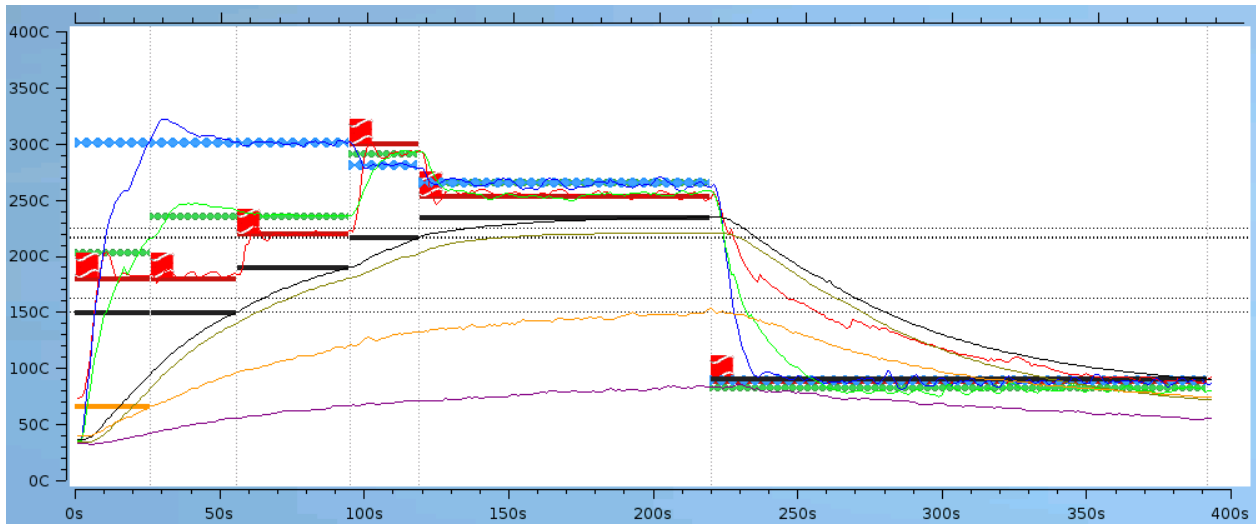


- Left click once for a lead-free Auto-profile .
- Left click twice for a lead Auto-profile.
- Left click three times to turn off Auto-profile.



- Hover the cursor over the Scorpion start profile icon.

- Left click the Scorpion icon to run the profile.



Lead-free Auto-profile Desktop PCBA



Puff-Off Time Adjustment



- Hover the cursor over the puff-off icon.



- Right click on the mouse button to access the puff-off time adjustment box.

Enter Value: 250

- The puff-off time adjustment box displays showing the current puff-off setting in milliseconds.



- Use the scroll wheel to adjust the puff-off time to the desired level.



- Right click the mouse button to save changes.

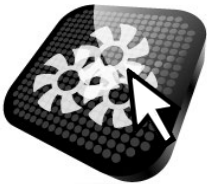


Activating the Preheater Preset.

- The preheater preset requires the use of the optional IR thermocouple kit, APR-SRS-UK2.



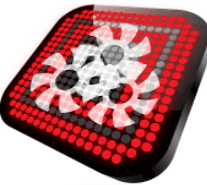
- Attach the optional IR thermocouple to the IR thermocouple connector .



- Hover the cursor over the preheat temperature icon.



- Left click the preheat temperature icon.



- The preheat temperature function is now active.
- This feature only works when used with the optional IR thermocouple.
- Left click the icon to disable.



Changing the Preheater Preset.



- Hover the cursor over the preheater preset icon.



- Right click on the mouse button to access the preheat temperature adjustment box.

Current Setting: 50

- The preheat temperature adjustment box displays the current airflow setting.



- Use the scroll wheel to adjust the preheat temperature to the desired level.



- Right click the mouse button to save changes.



Data Backup



- Insert a USB flash drive with a 2GB or greater capacity into the USB connector.



- Hover the cursor over the data backup icon.



- Left click the data backup icon.

Backup data to USB drive?

Yes

No

Backup in process, please wait.

Backup success

OK



Data Restore



- Insert a USB flash drive with a 2GB or greater capacity into the USB connector.
- The flash drive must contain files from a previous backup.



- Hover the cursor over the data backup icon.



- Right click the data backup icon.

Restore data from USB drive?

Yes

No

Are you sure? This may overwrite profiles currently on the machine.

Yes

No

Restore in process, please wait.

Restore success

OK



Capture Screen Shot

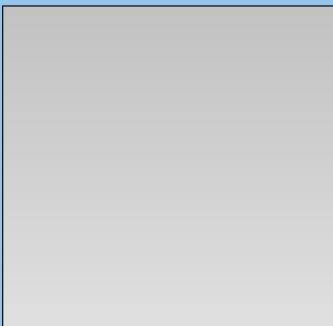


- Hover the cursor over the screen capture icon

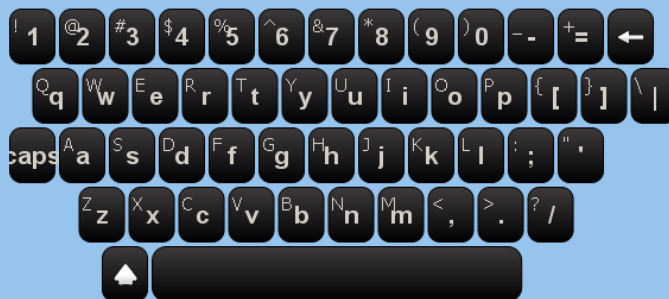


- Left click the mouse button & the naming dialog box displays.

Subdirectory:



Enter Name



OK

Cancel

Create Dir



- Enter the desired name, select the save location from the subdirectory box, & press the OK button
- To create a new directory enter the name and left click the Create Dir button.
- To delete a directory, select the directory, & press the Delete button.
- Press the Cancel button to return to the profile page.



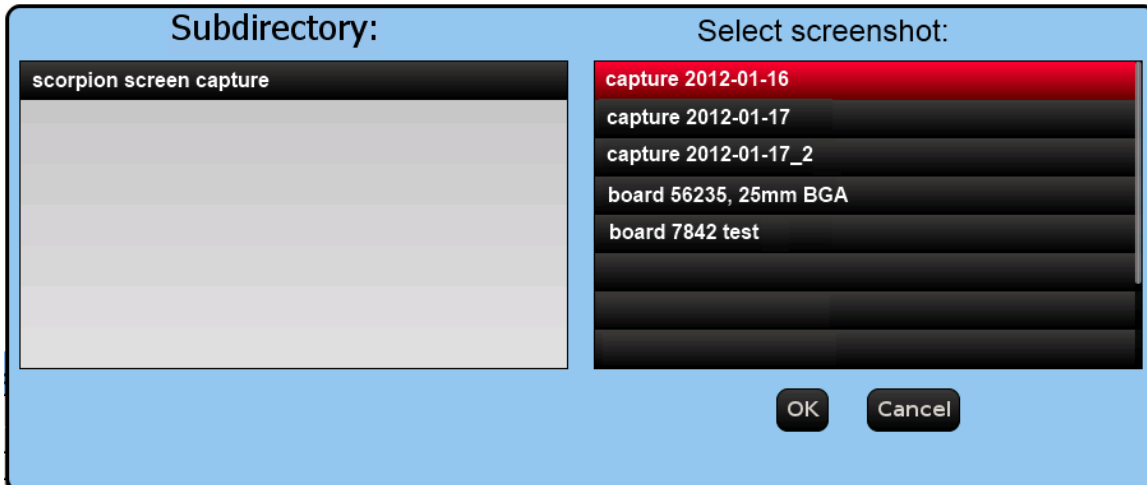
Display Screen Shot



- Hover the cursor over the screen capture icon



- Left click the mouse button & the select dialog box displays.

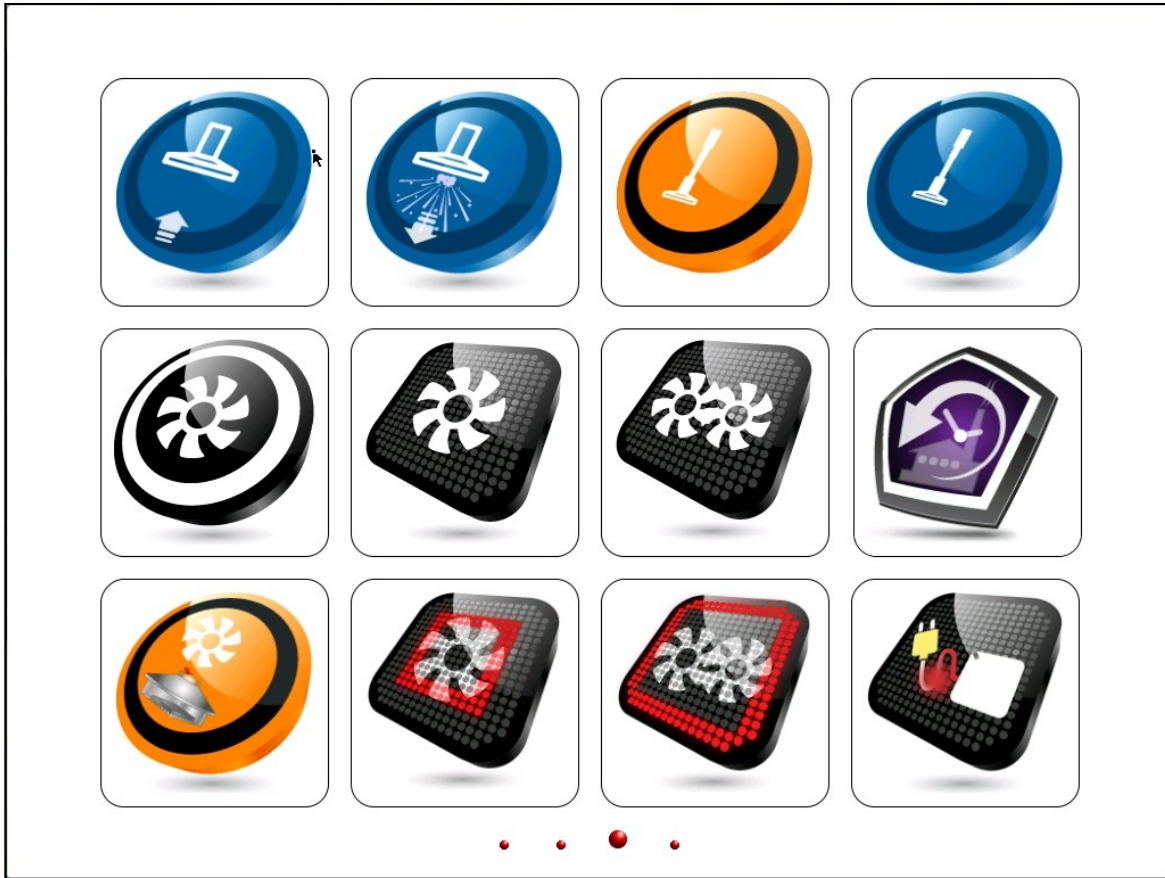


- Select the desired screen shot, the name of the screen shot highlights in red. Press OK.



- Left click the close screen capture icon to return to the profile screen.

Calibration and Adjustment



External Thermocouple Calibration	42
Reflow Blower Calibration	43
Focus Blower Calibration	45
Surround Blower Calibration	48
Reflow Heater Calibration	49
Focus Heater Calibration	51
Surround Heater Calibration	52
Display Calibration Settings	53
Elevator Torsion Spring Adjustment	54
Scorpion Head(s) Pitch Adjustment	55
Reflow Head Yaw Adjustment	58
Precision Placement Head Yaw Adjustment	61
SmartPlace Camera Mount Adjustment	64
SmartPlace Camera Sensor to Optical path alignment	66
Component Arm Adjustment	68
Vacuum Filter Replacement	69
Scorpion Software Installation	70
Factory Restore and Save	71

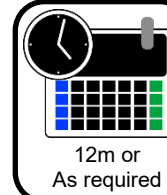
Maintenance Schedule





External Thermocouple Calibration

- Required:
- K type thermocouple simulator



K type thermocouple tester



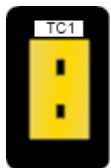
Set knob to 250°C



- Left click the thermocouple calibration icon



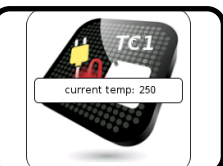
- The current temperature will be displayed



- Plug the K type thermocouple tester into the matching external thermocouple connector



- Right click the thermocouple to calibrate calibration



- The current temperature will be displayed
- Repeat until each thermocouple has been calibrated.

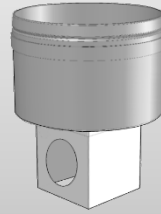


Reflow Blower Setup

- Required:
- Heater Calibration Kit; SRS-CALKIT

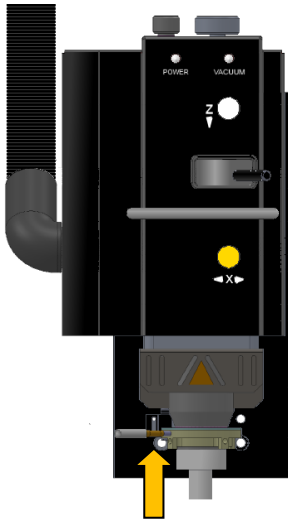


5400-0020

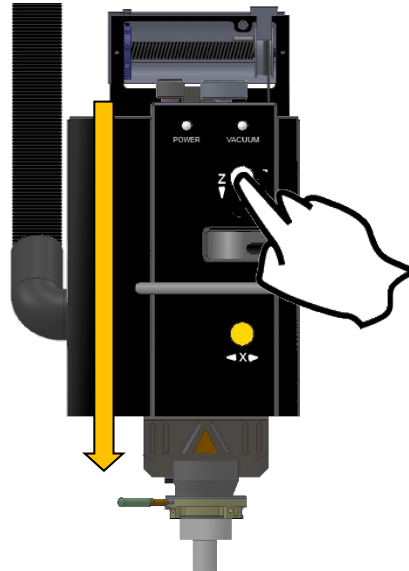


NZA-SRS-CAL

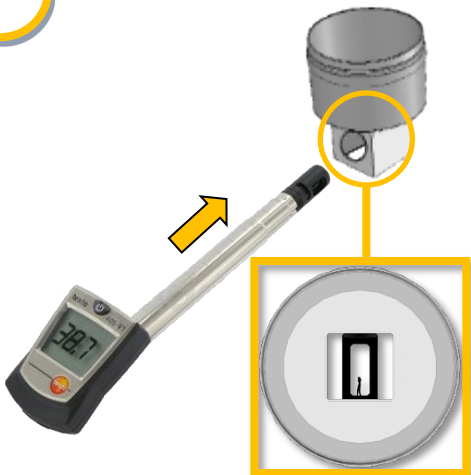
1



2



3





Reflow Blower Setup, continued

- The reflow blower has four settings: low, medium, high, and cool.



- Hover the cursor over the reflow blower calibration icon.



- Left click the mouse button to select the desired setting. The appearance of the icon will change based on the setting.



- Right click on the mouse button to access the airflow adjustment box.

Low Setting: X.X

- The airflow adjustment box displays showing the current airflow setting.



- Use the scroll wheel to adjust the airflow to the desired level. Low = 3 m/s, Medium= 4 m/s, High= 5 m/s, Cool=5.5 m/s; ± 0.2 .



- Right click the mouse button to save changes.

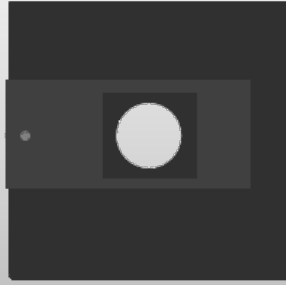


Focus Blower Setup

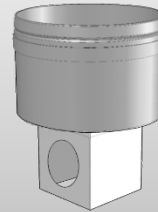
- Required:
 - Heater Calibration Kit; SRS-CALKIT



5400-0020

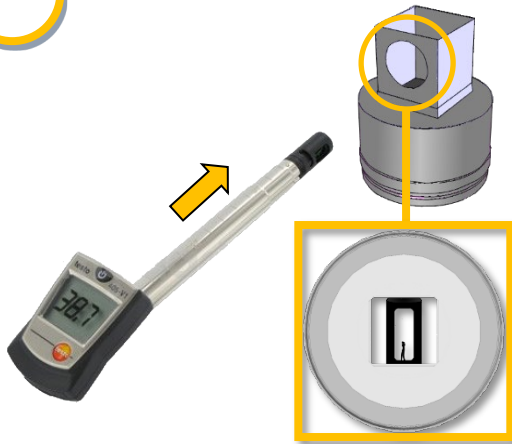


9025-9000

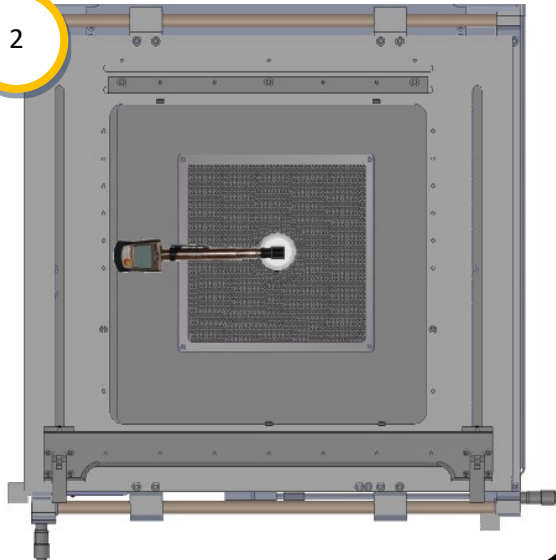


NZA-SRS-CAL

1



2





Focus Blower Setup

- The focus blower has a single setting.



- Hover the cursor over the focus blower calibration icon.



- Right click on the mouse button to access the airflow adjustment box.

Setting: 2.7

- The airflow adjustment box displays showing the current airflow setting.



- Use the scroll wheel to adjust the airflow to the desired level. Adjust the airflow setting until the meter reads 6.0 m/s +/- 0.1.



- Right click the mouse button to save changes.

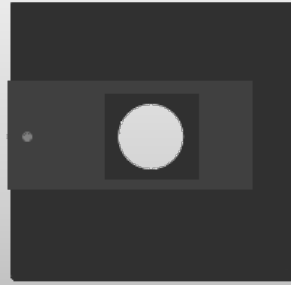


Surround Blower Setup

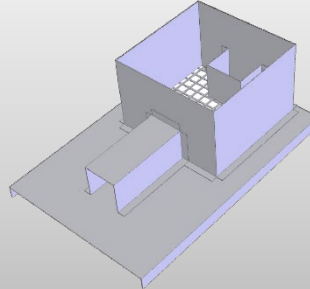
- Required:
- Heater Calibration Kit; SRS-CALKIT



5400-0020

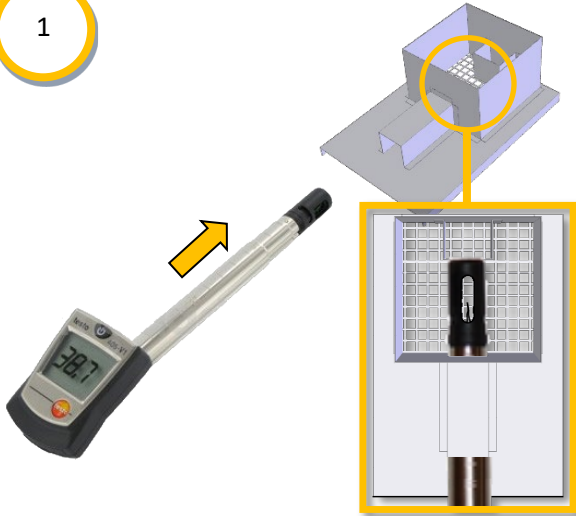


9025-9000

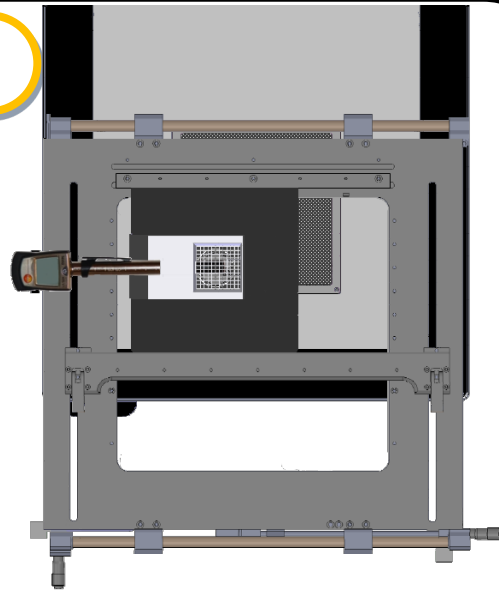


7050-2262

1



2





Surround Blower Setup

- The surround blower has a single setting.



- Hover the cursor over the surround blower calibration icon.



- Right click on the mouse button to access the airflow adjustment box.

Setting: 3.0

- The airflow adjustment box displays showing the current airflow setting.



- Use the scroll wheel to adjust the airflow to the desired level. Adjust the airflow setting until the meter reads 2.0 m/s +/- 0.1.

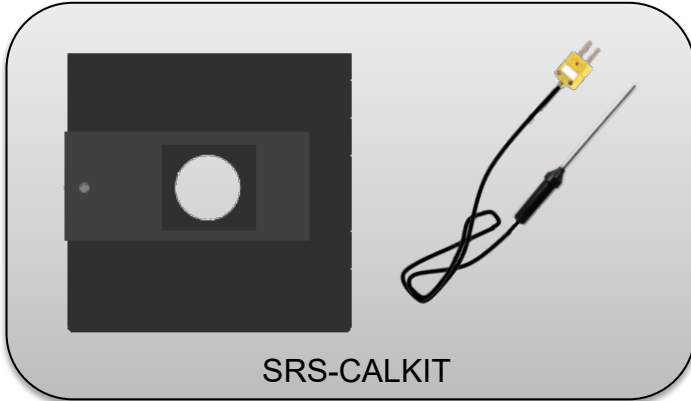
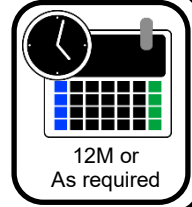


- Right click the mouse button to save changes.

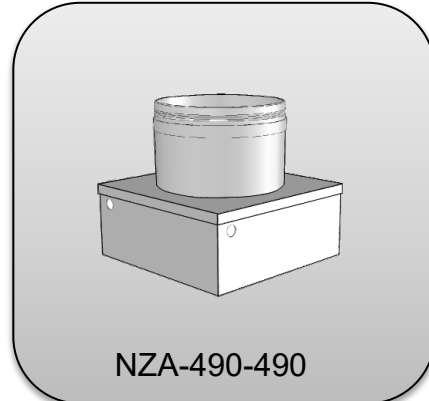


Reflow Heater Calibration

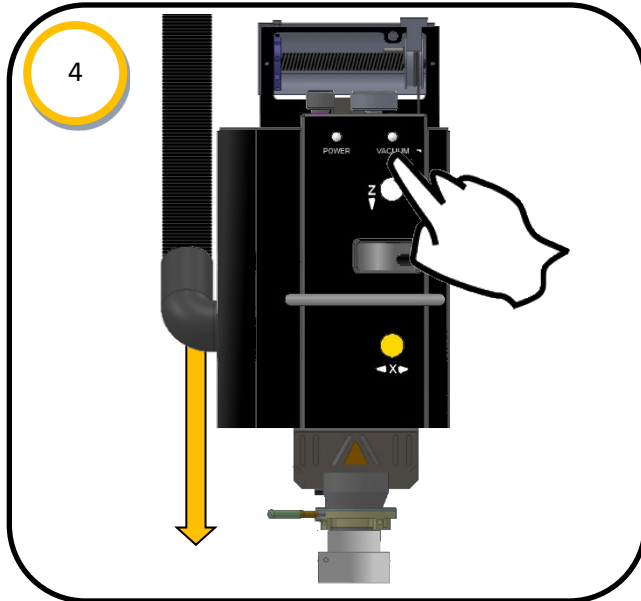
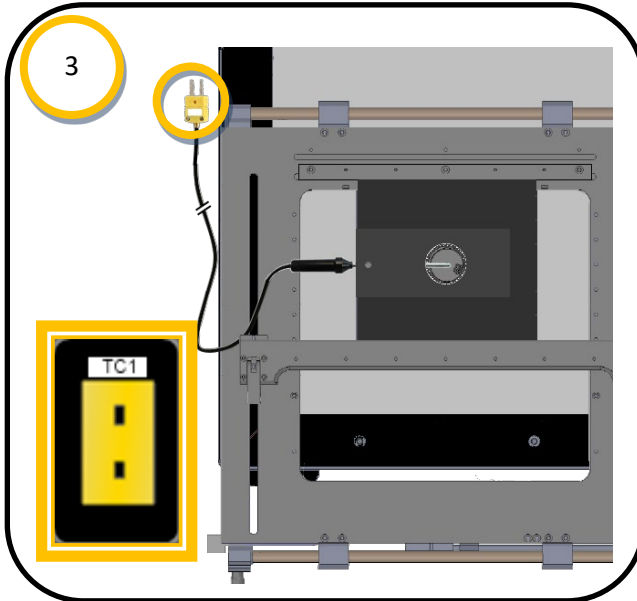
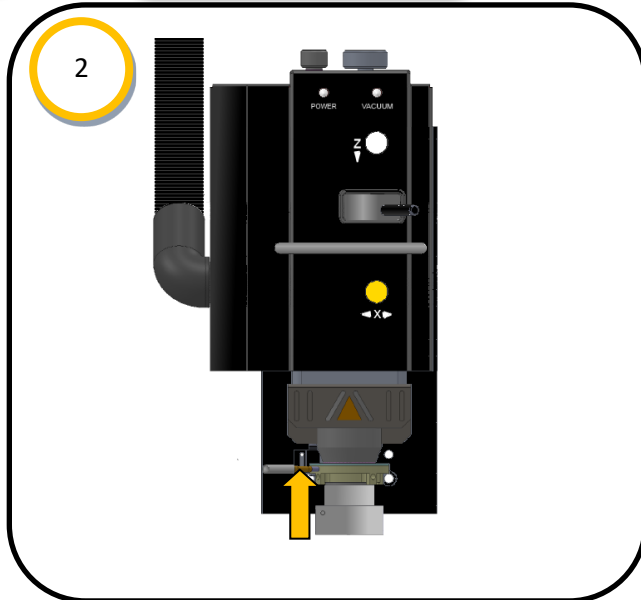
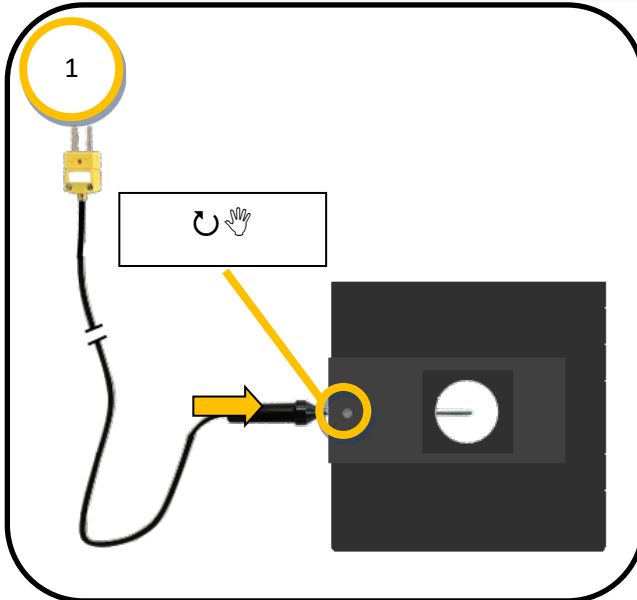
- Required:
- Heater Calibration Kit; SRS-CALKIT
- Nozzle NZA-490-490

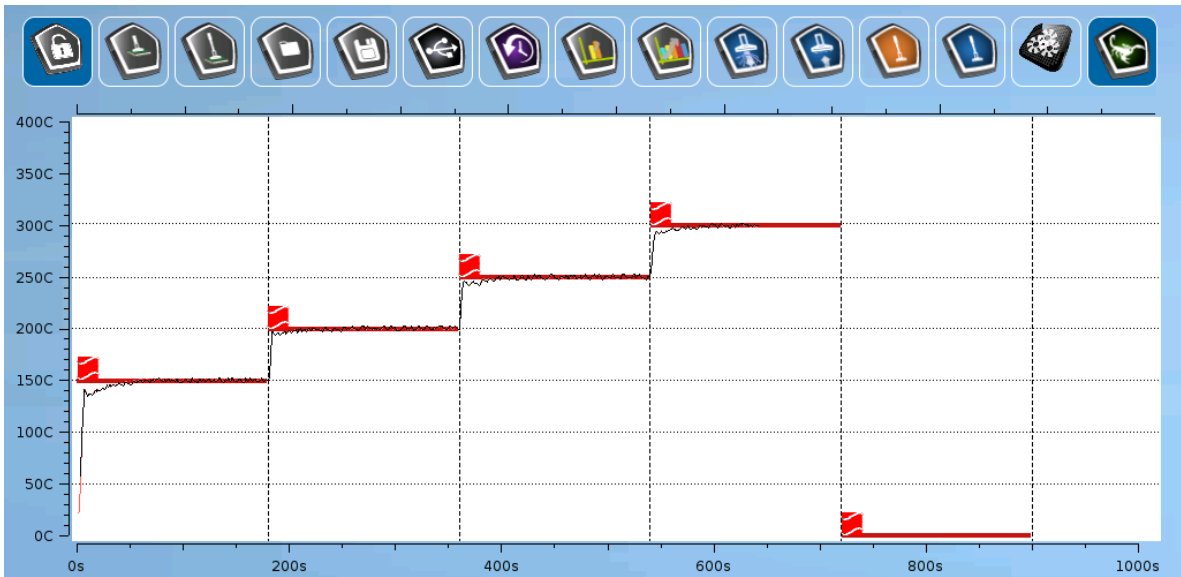
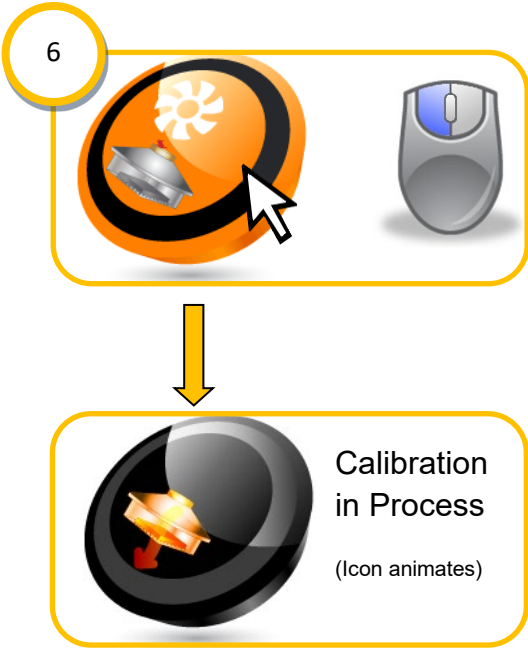
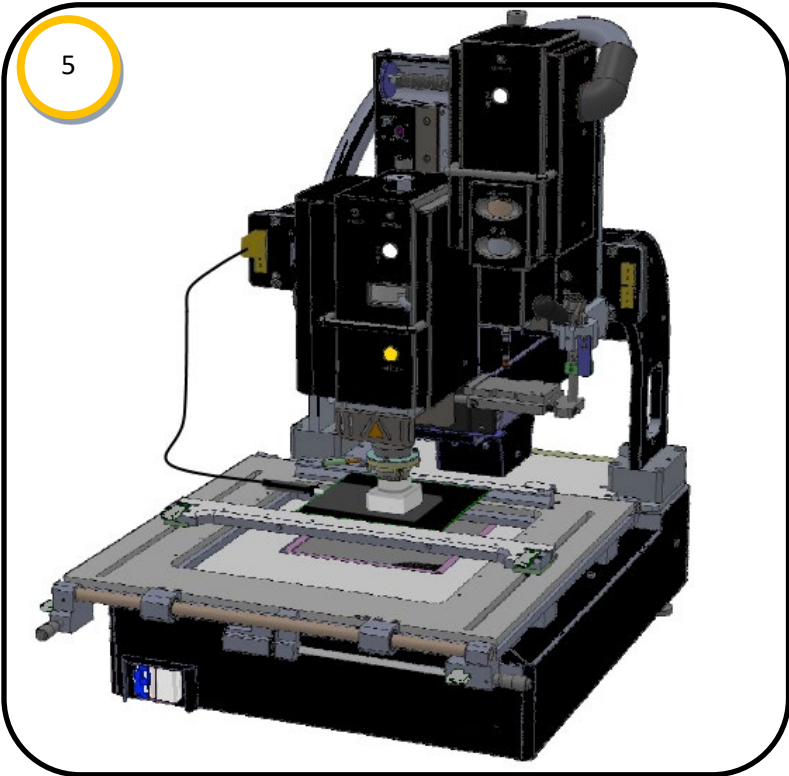


SRS-CALKIT



NZA-490-490



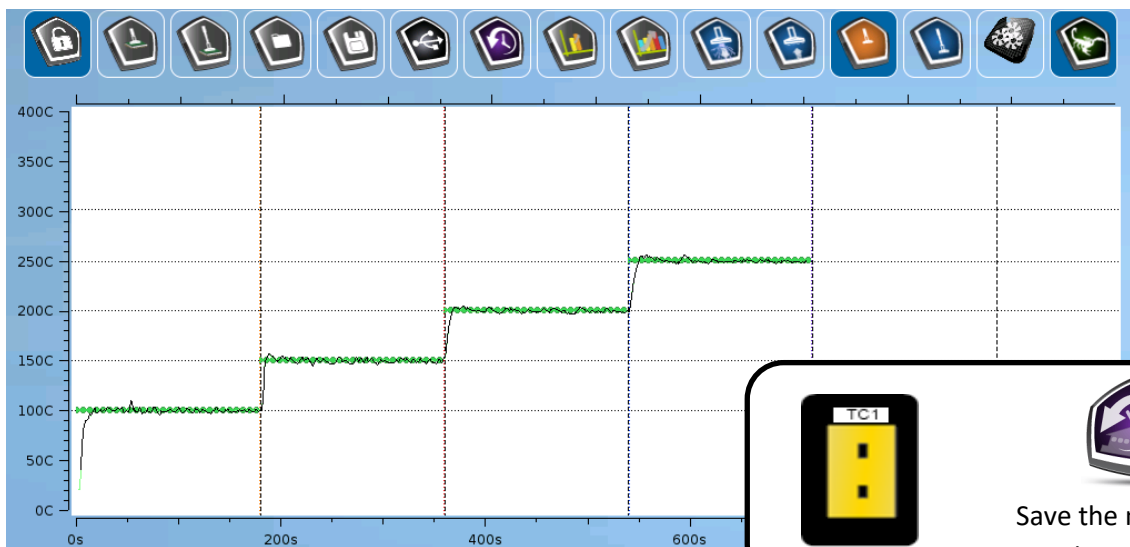
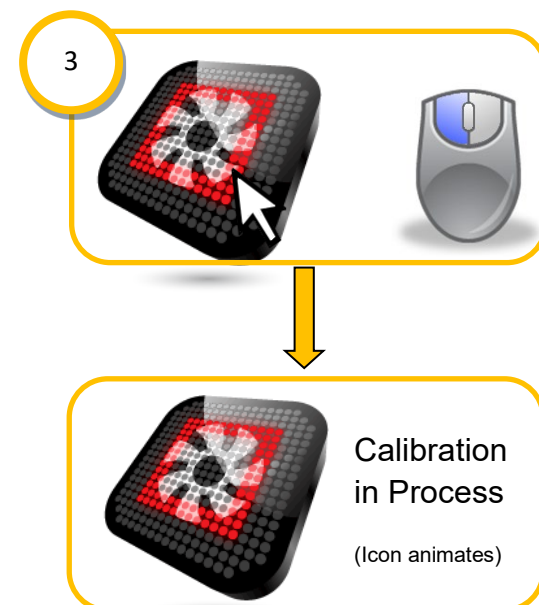
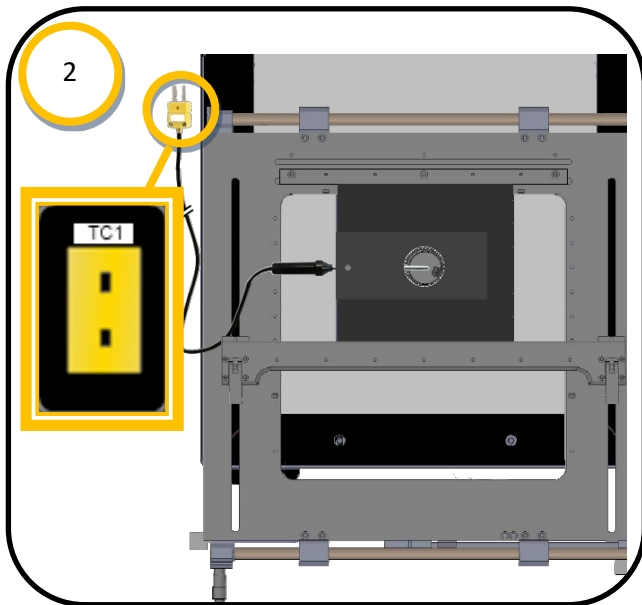
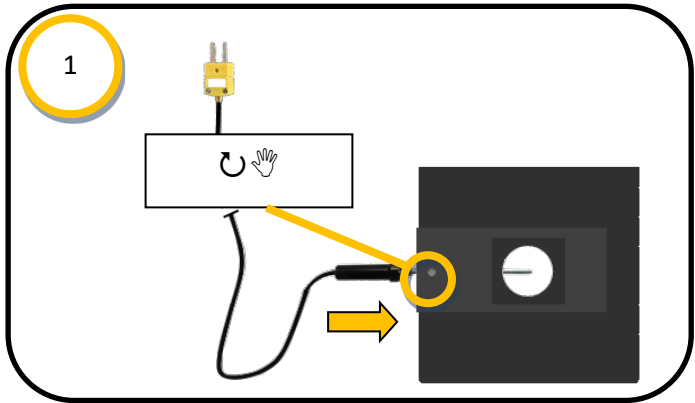
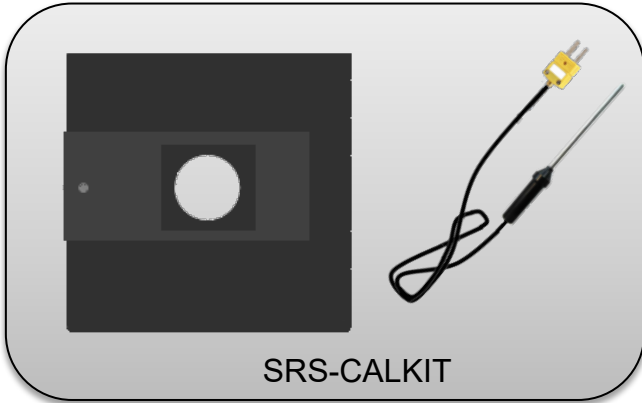
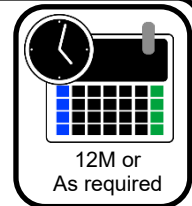


Example - Reflow Heater Calibration Profile Plot



Focus Heater Calibration

- Required:
- Heater Calibration Kit; SRS-CALKIT



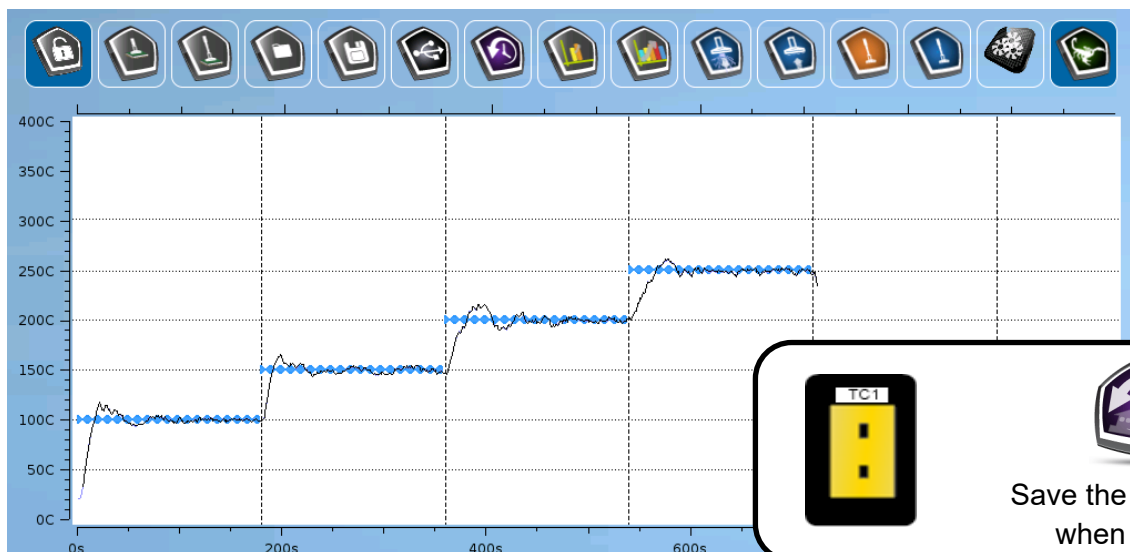
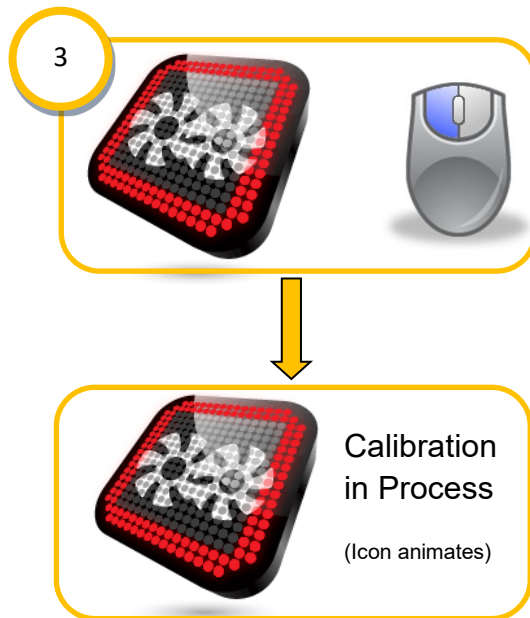
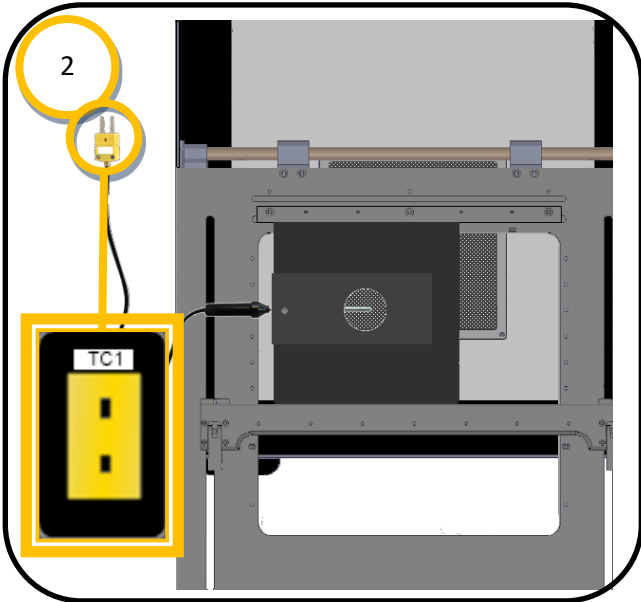
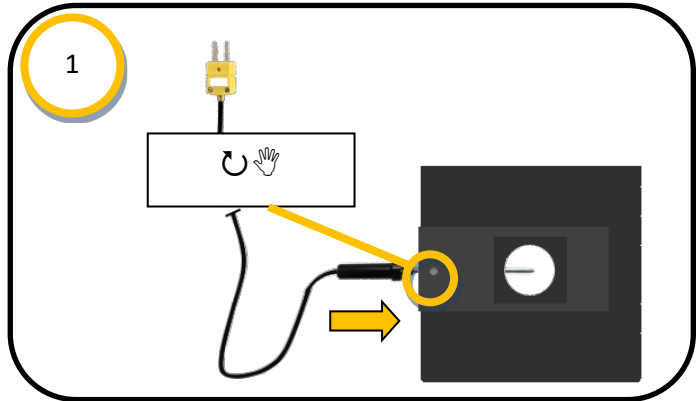
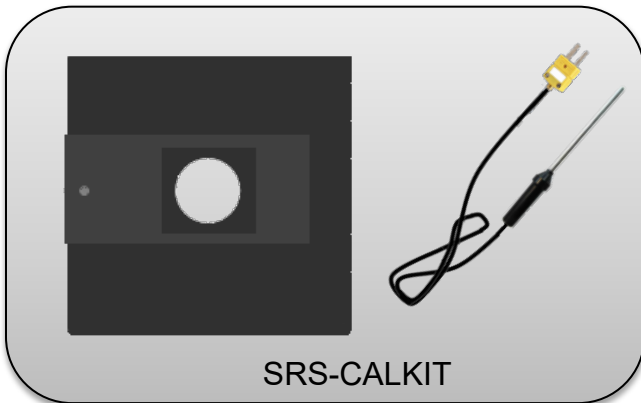
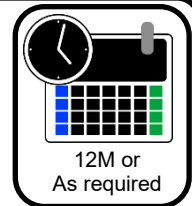
Example –Focus Preheater Calibration Profile Plot





Surround Heater Calibration

- Required:
- Heater Calibration Kit; SRS-CALKIT



Example – Surround Preheater Calibration Profile Plot



Display Calibration Settings

- Reflow, Focus, and Surround heaters.



- Hover the cursor over a calibration icon.



- Right click to display the heater calibration offsets.

Reflow heater calibration offsets:

(cal temp -> offset)

150 -> -11.08

200 -> -17.32

250 -> -24.61

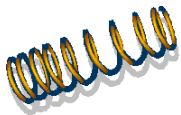
300 -> -32.59

OK

Example



- Left click the OK button to close the heater calibration offset dialog box.

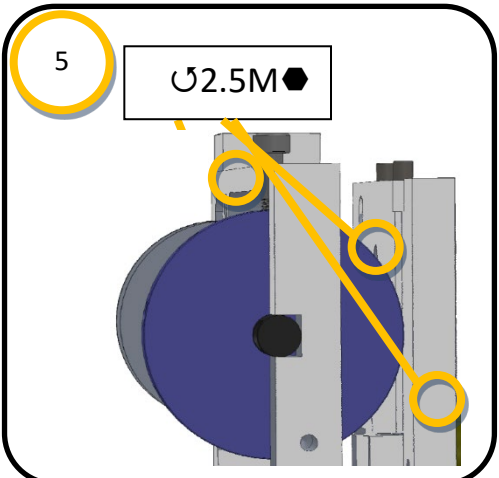
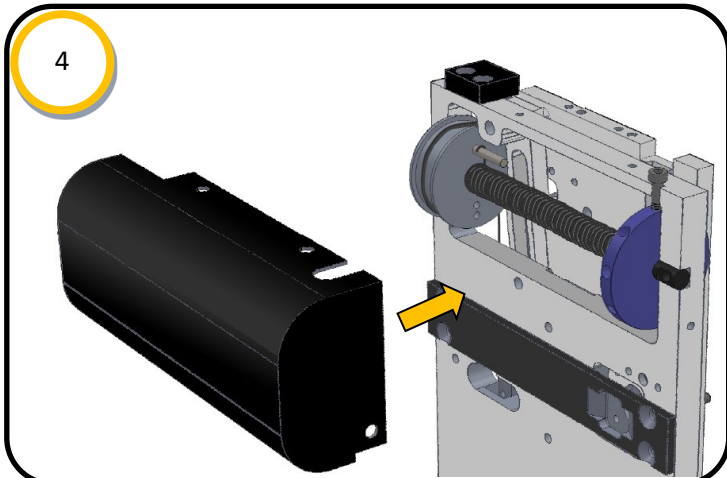
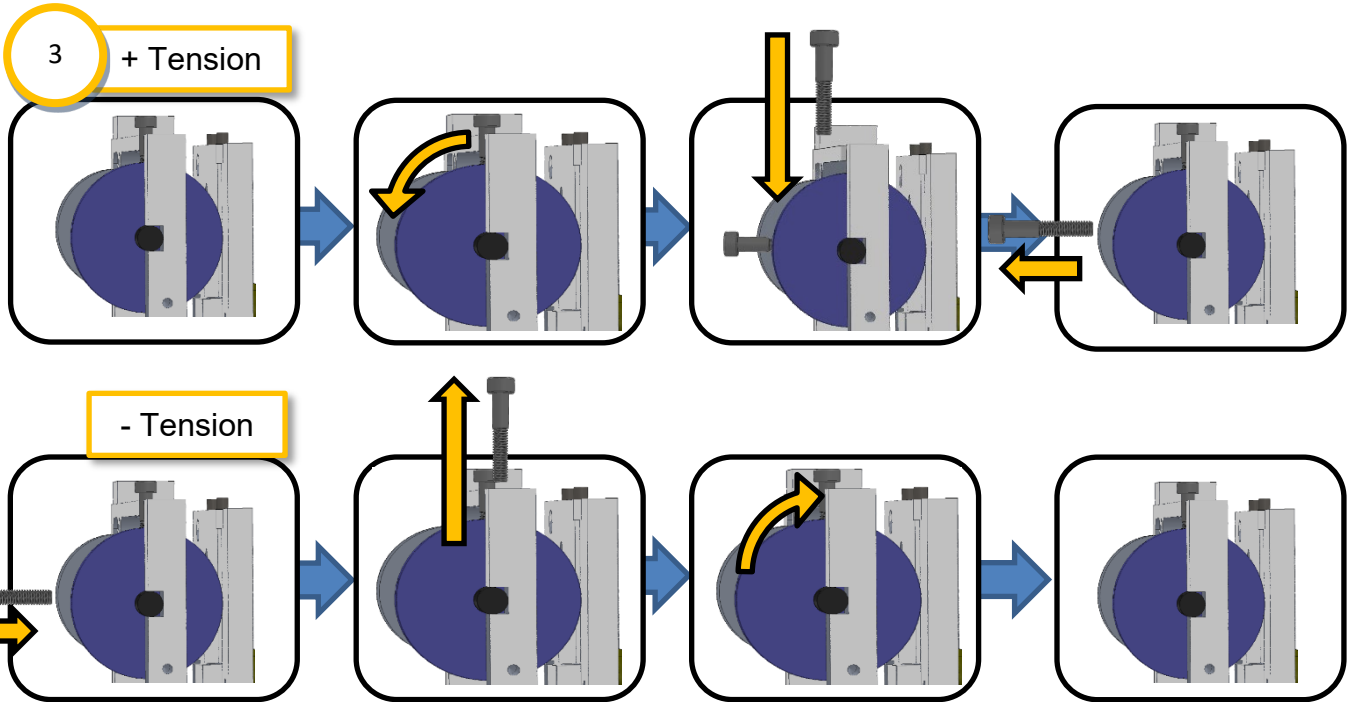
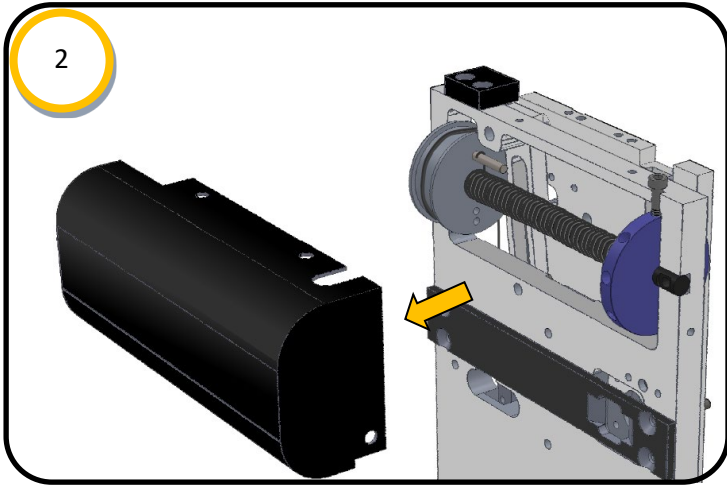
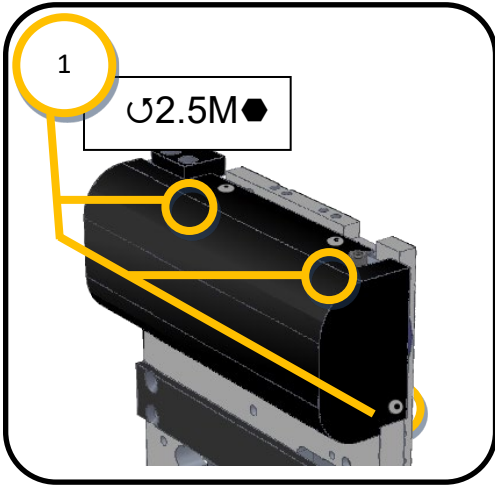


Elevator Torsion Spring Adjustment

• Adjusts the rate of travel of the head assembly



6M or
As required





Scorpion Head Pitch Adjustment

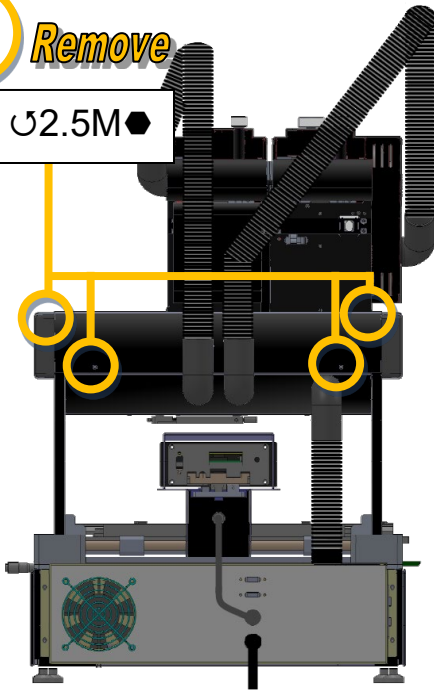


12M or
As required

1

Remove

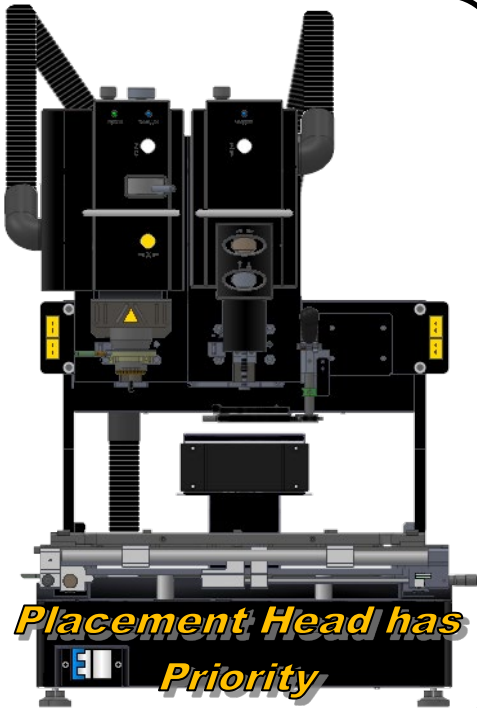
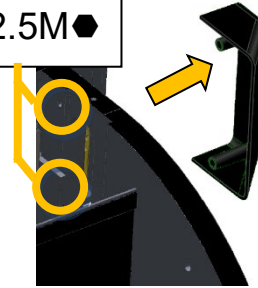
⌀2.5M



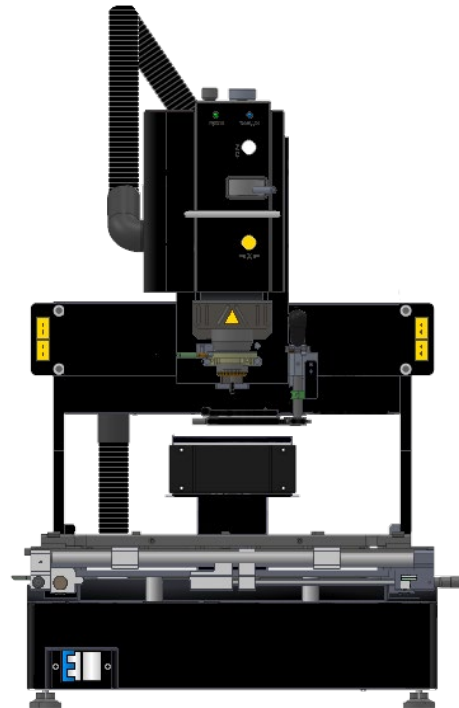
2

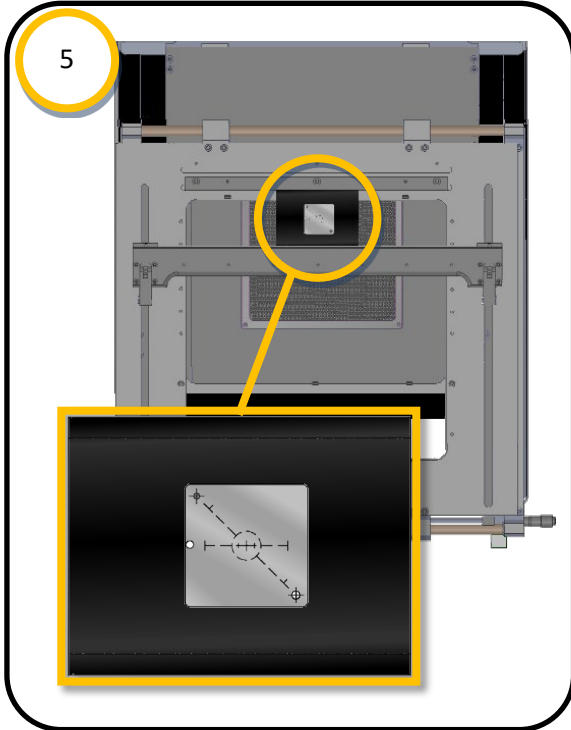
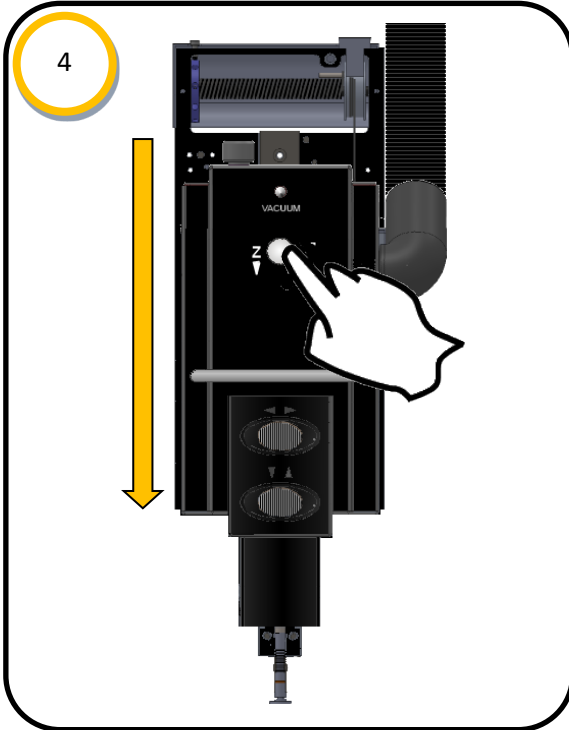
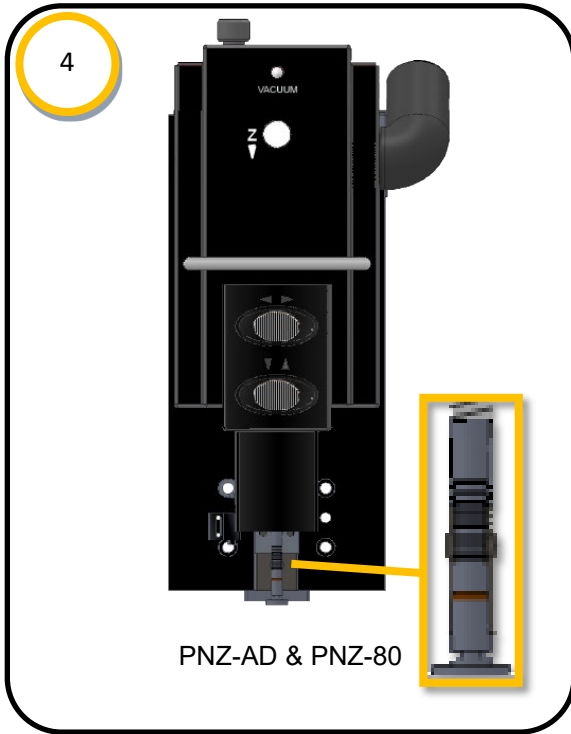
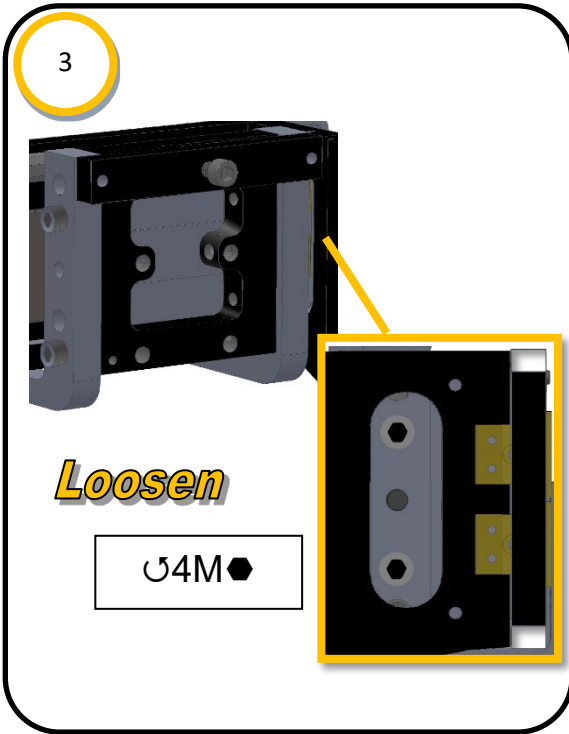
Remove

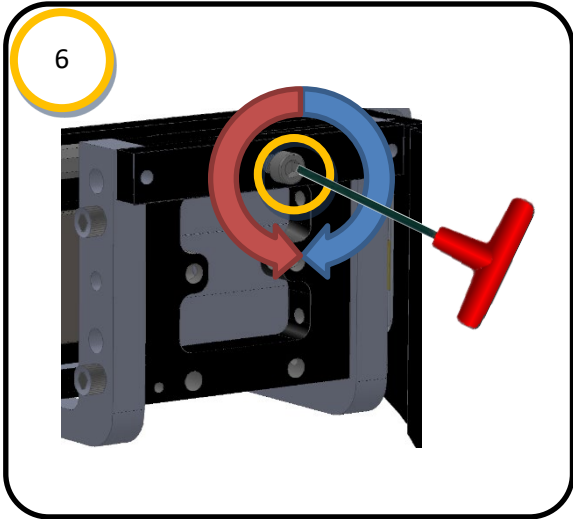
⌀2.5M



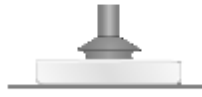
**Placement Head has
Priority**







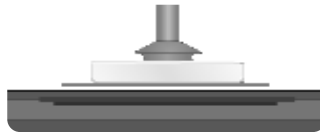
Activate the vacuum pump



Pick up the alignment plate with the vacuum nozzle



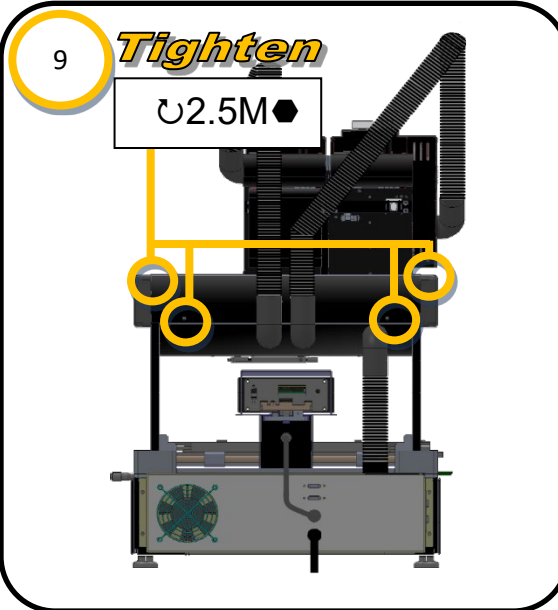
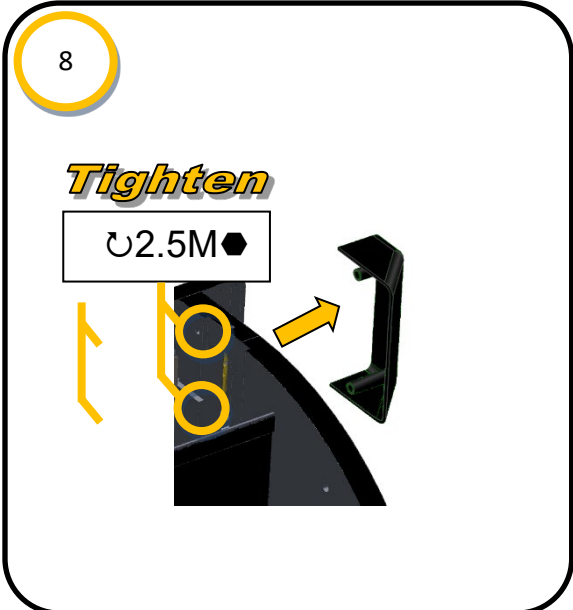
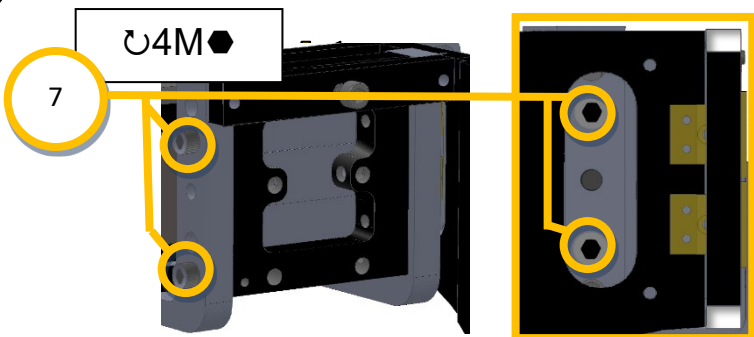
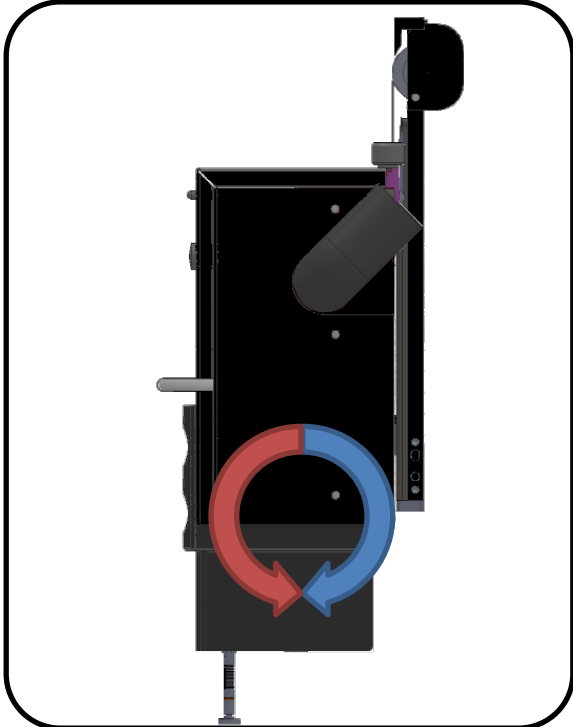
Insert M3



Raise the alignment head 2-3mm from the nest

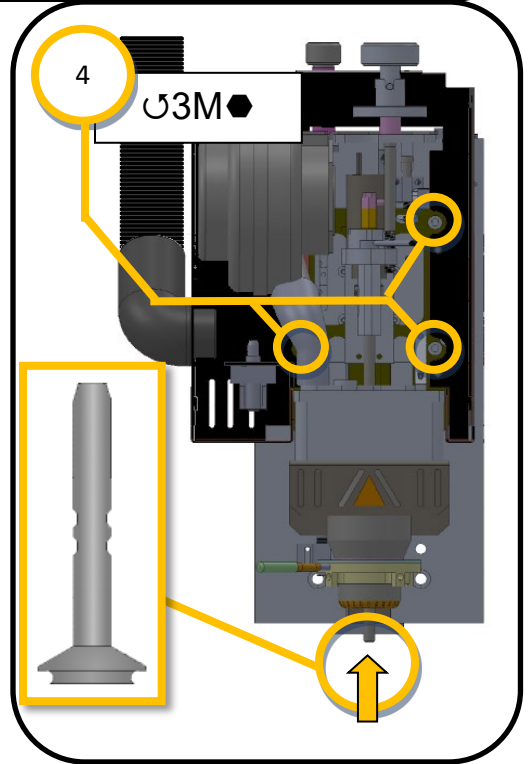
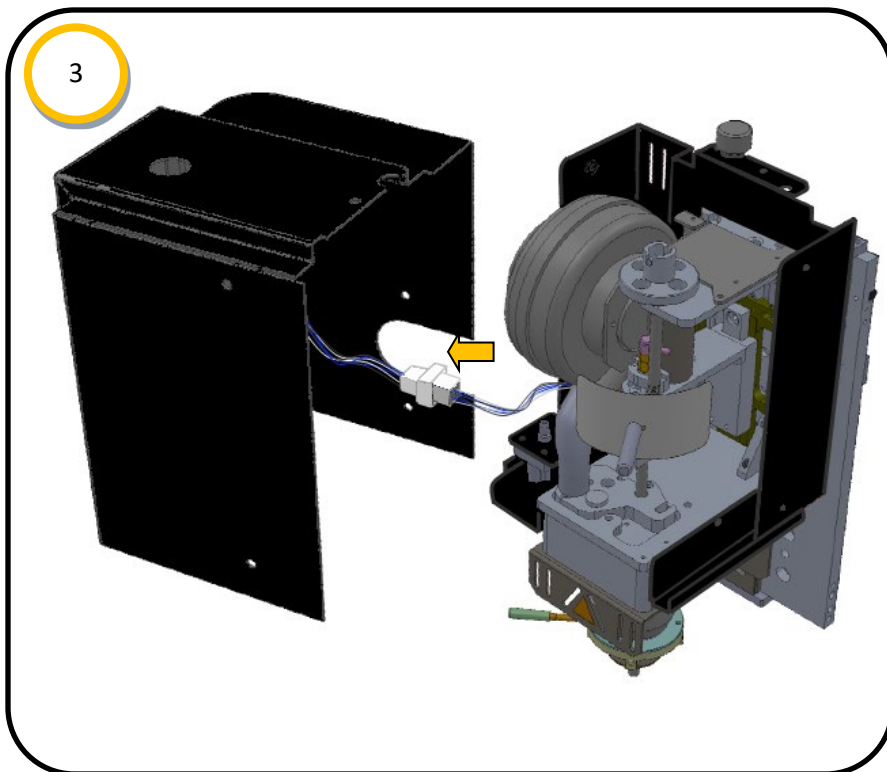
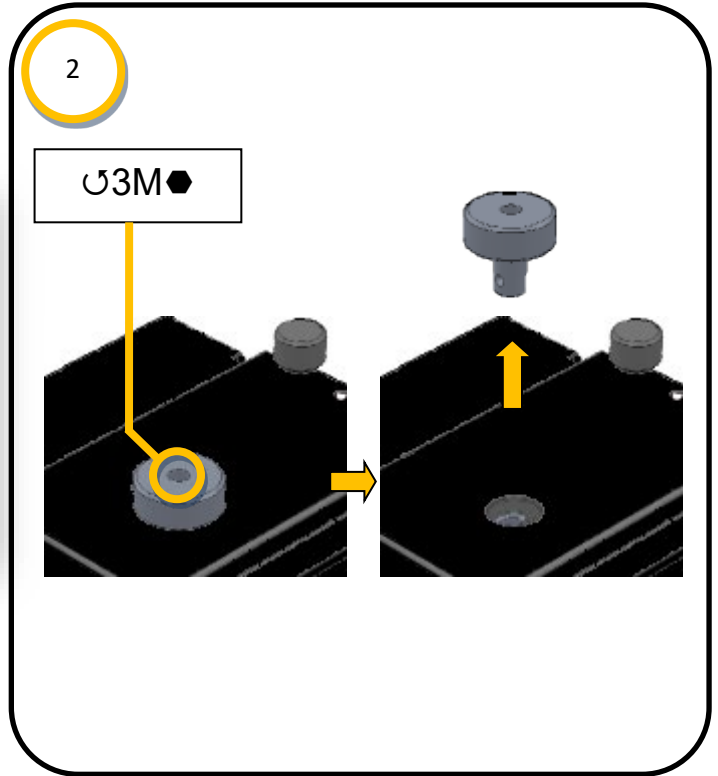
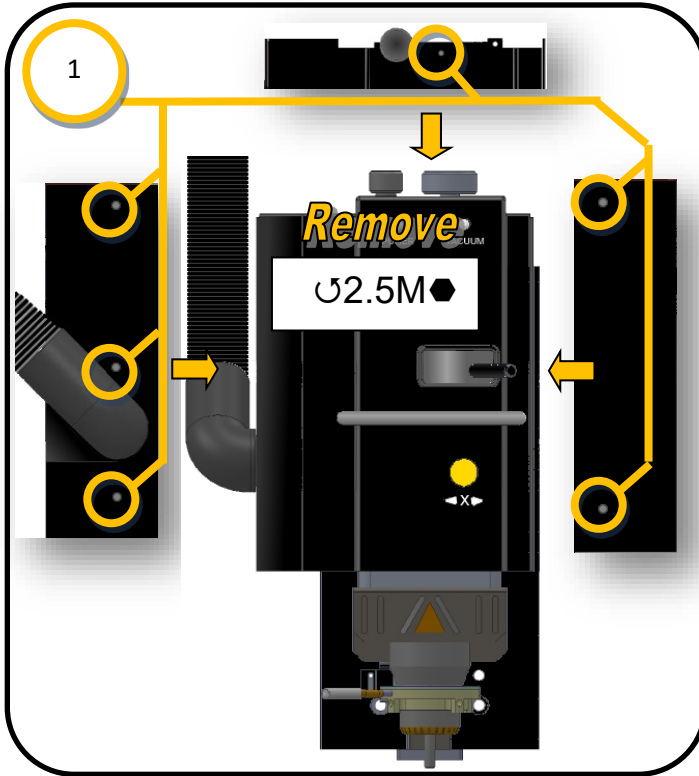


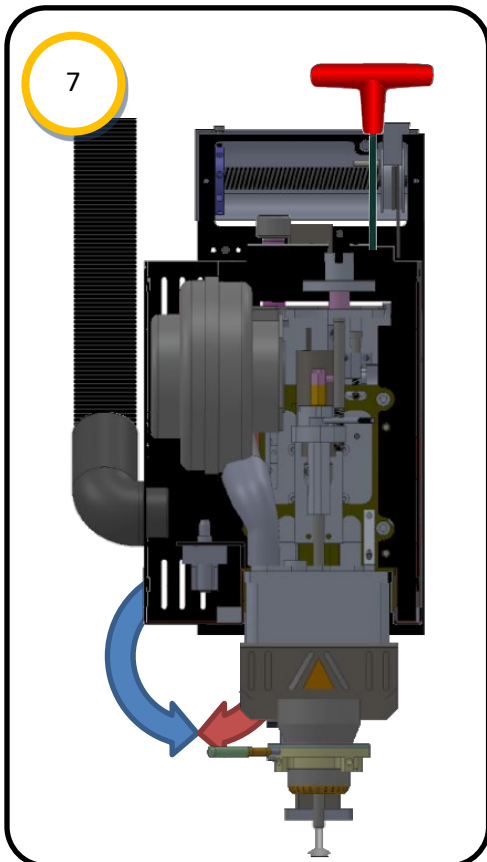
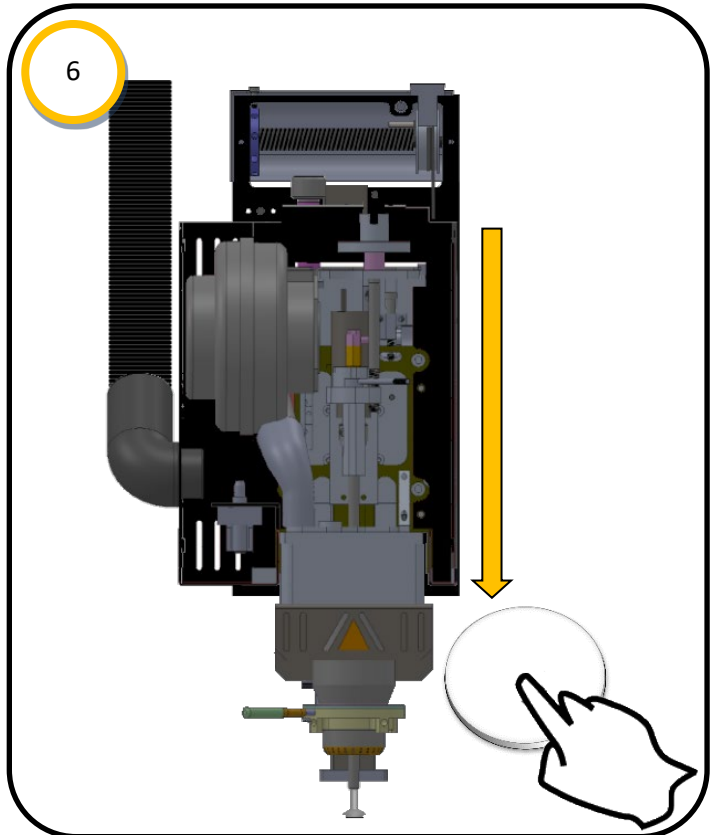
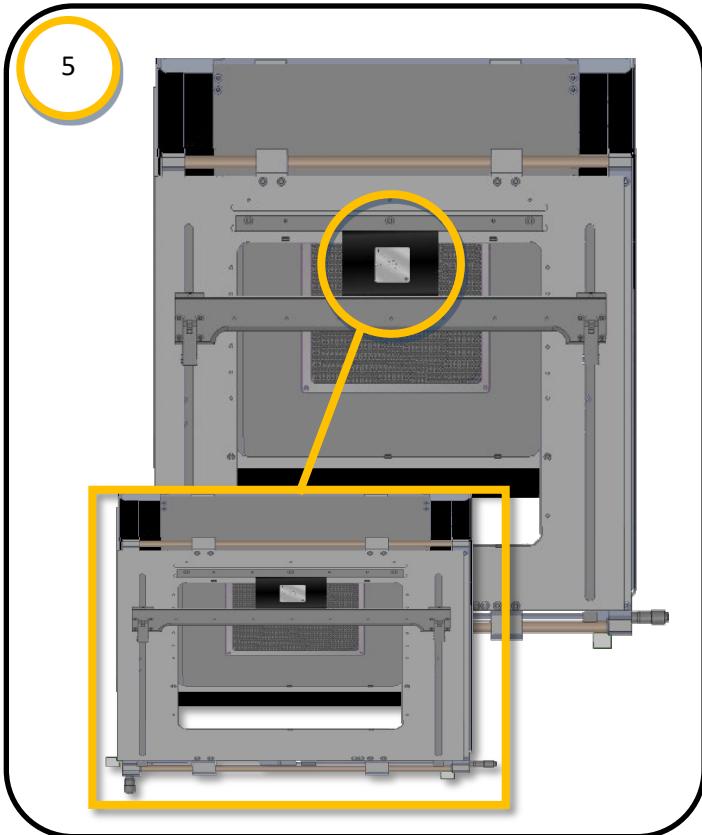
Adjust the alignment plate until it is parallel with the nest



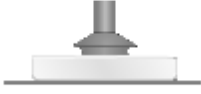




Reflow Head Yaw Adjustment

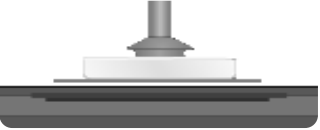





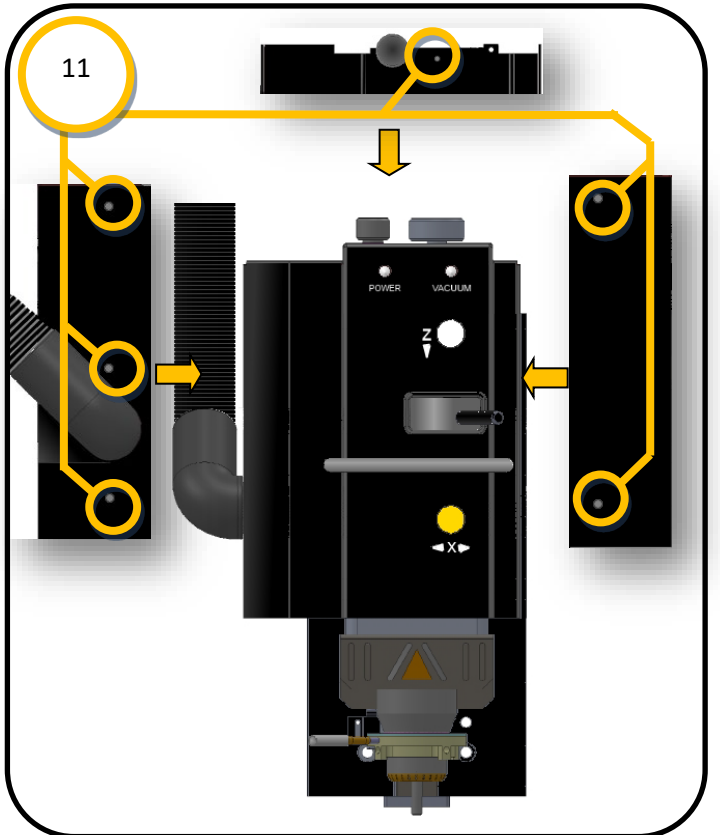
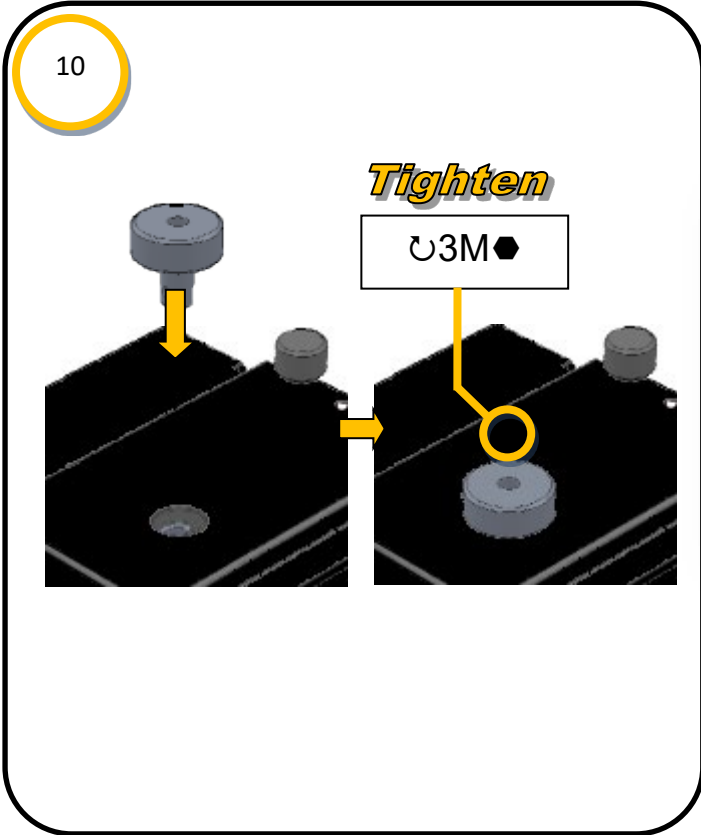
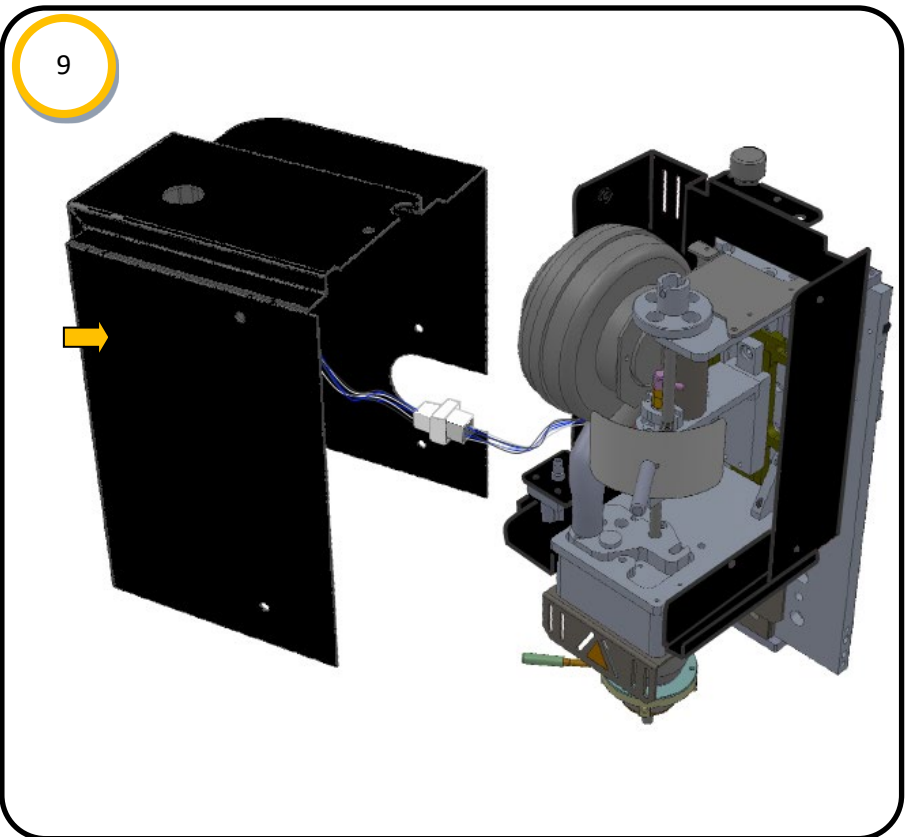
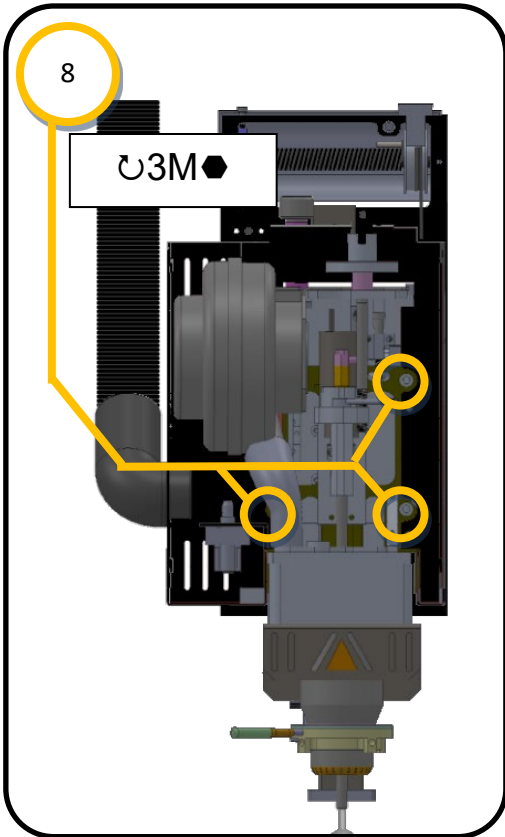
 Activate the vacuum pump

 Pick up the alignment plate with the vacuum nozzle

 Insert M3 

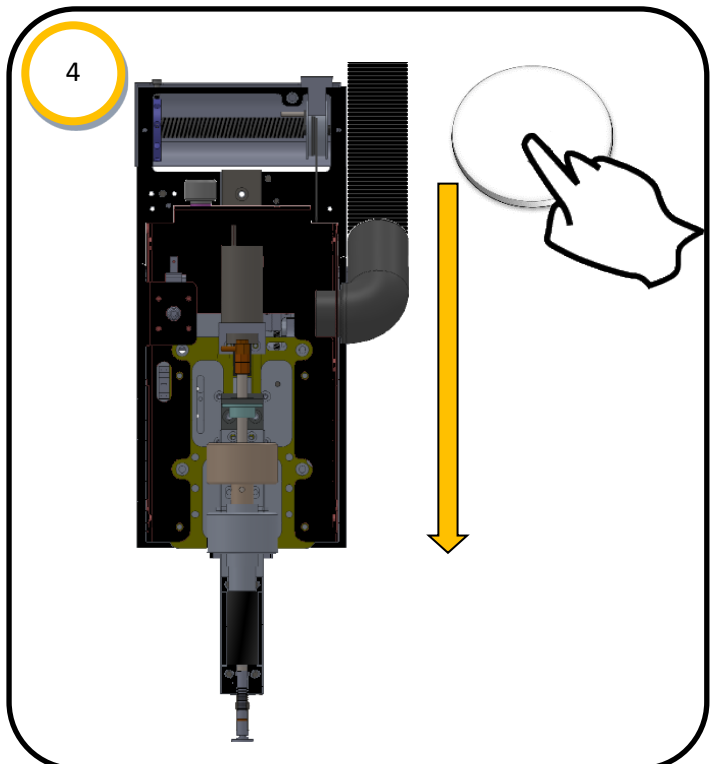
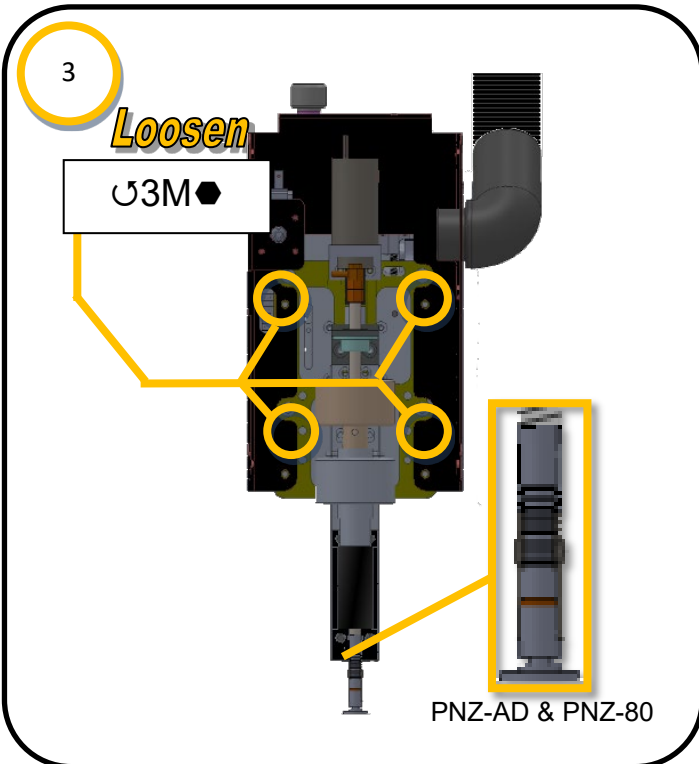
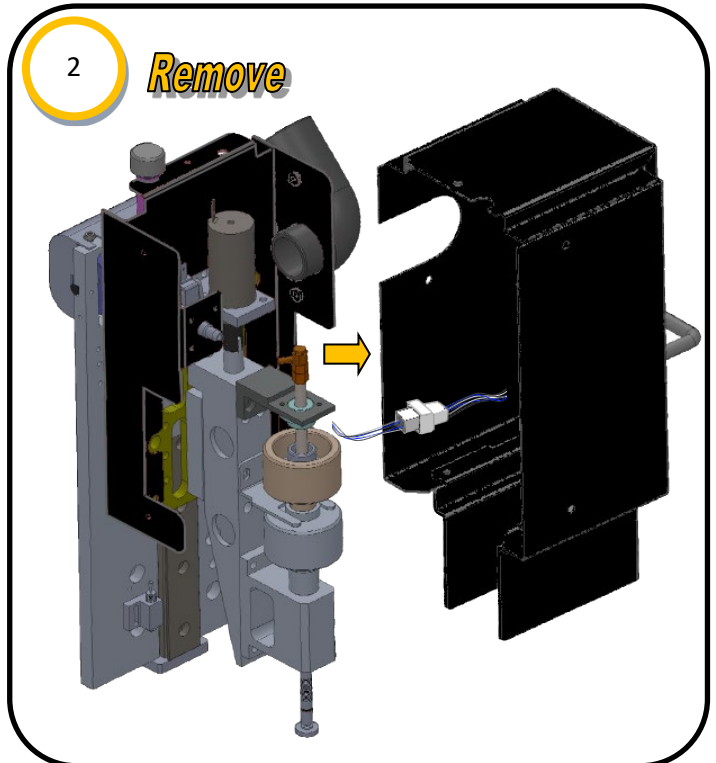
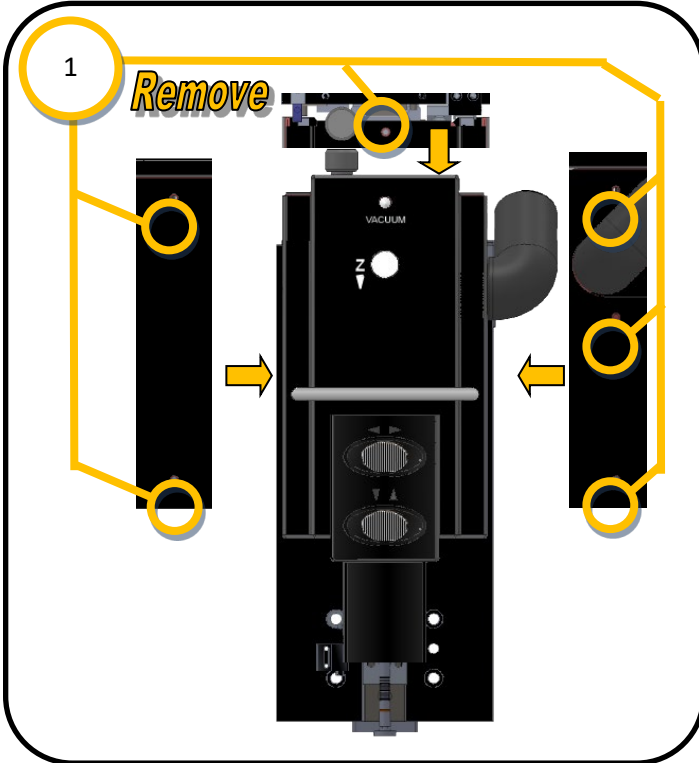
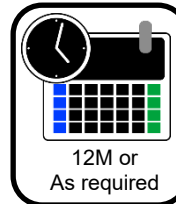
 Raise the alignment 2-3mm from the nest

 Adjust the alignment plate until it is parallel with the nest

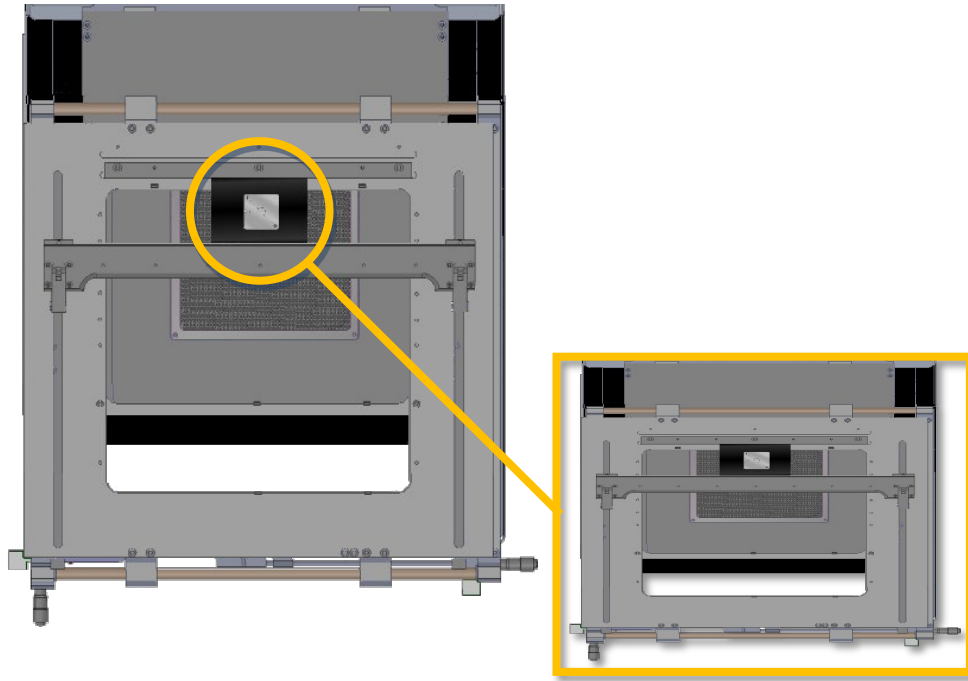




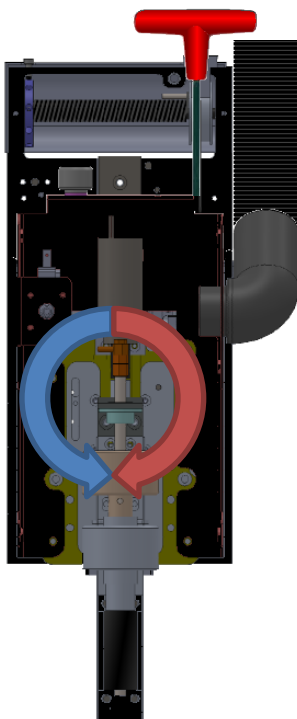
Precision Placement Head Yaw Adjustment



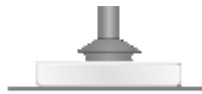
5



6



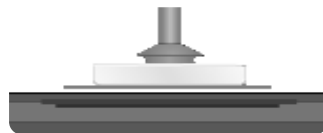
Activate the vacuum pump



Pick up the alignment plate with the vacuum nozzle



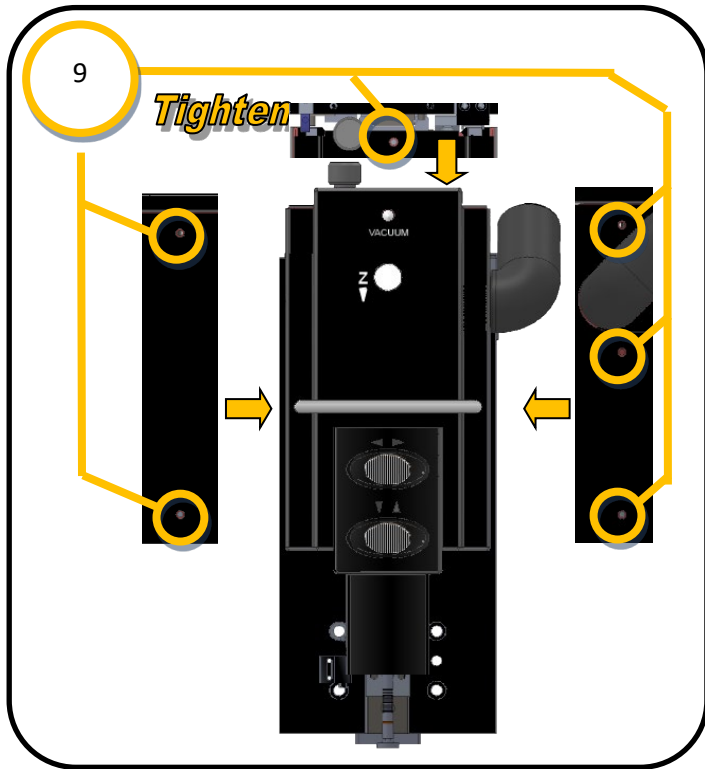
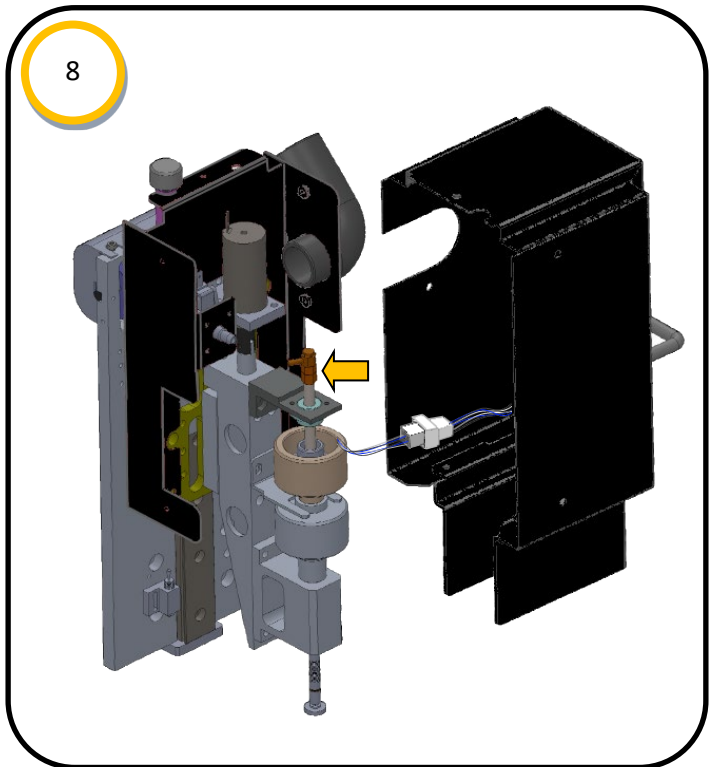
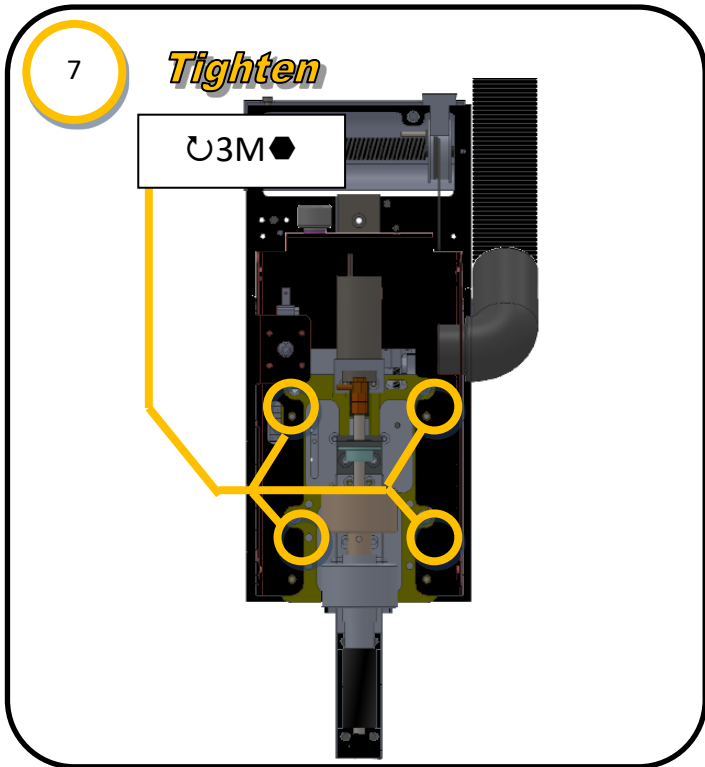
Insert M3

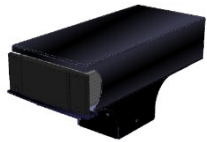


Raise the alignment 2-3mm from the nest

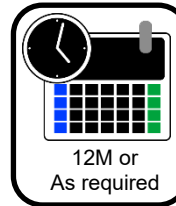


Adjust the alignment plate until it is parallel with the nest

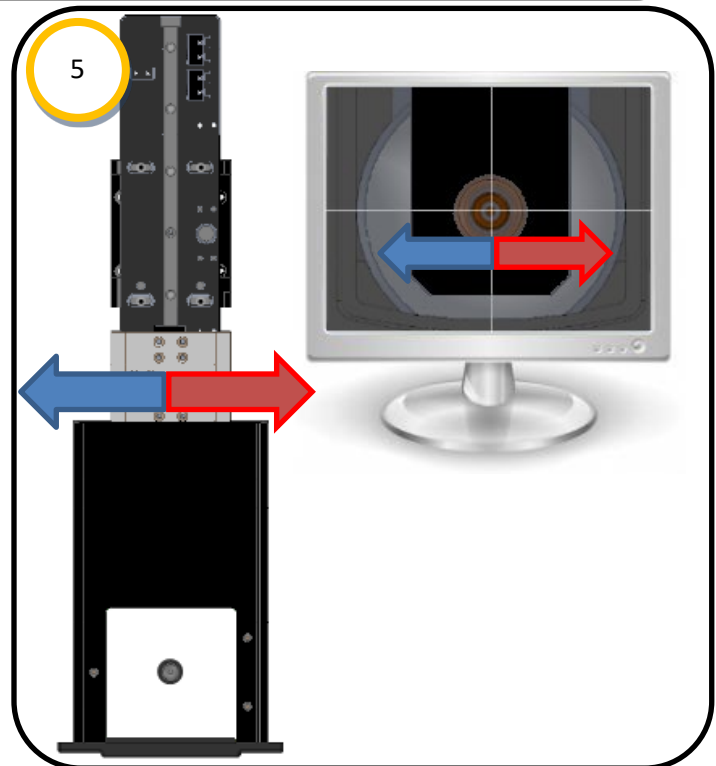
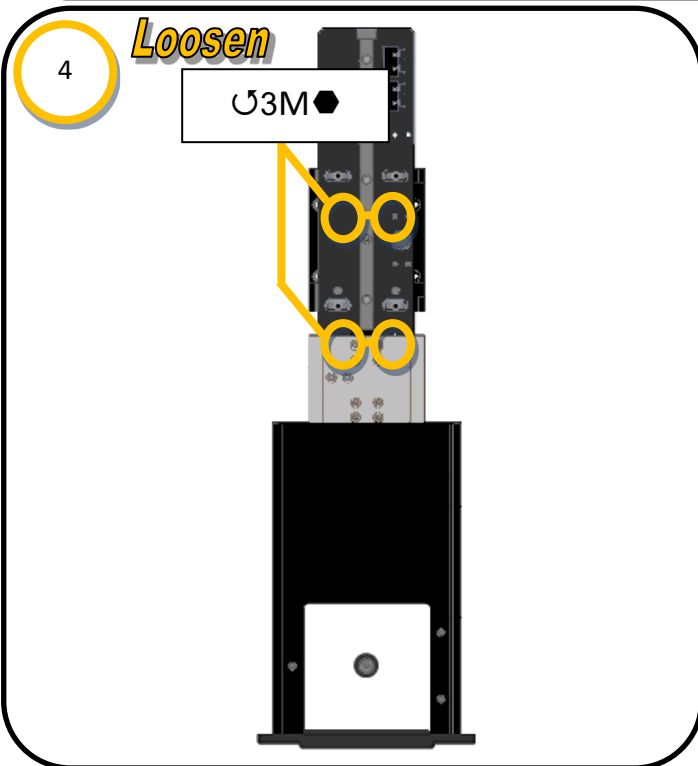
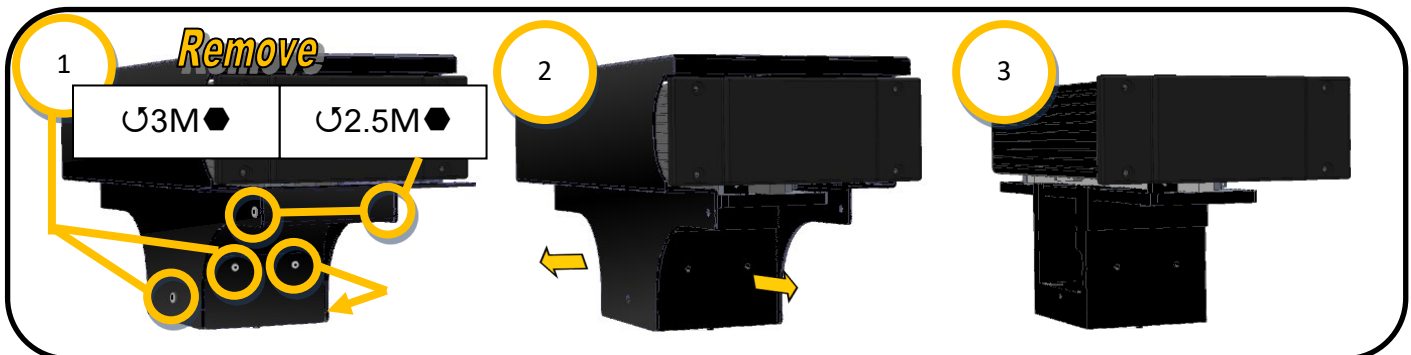


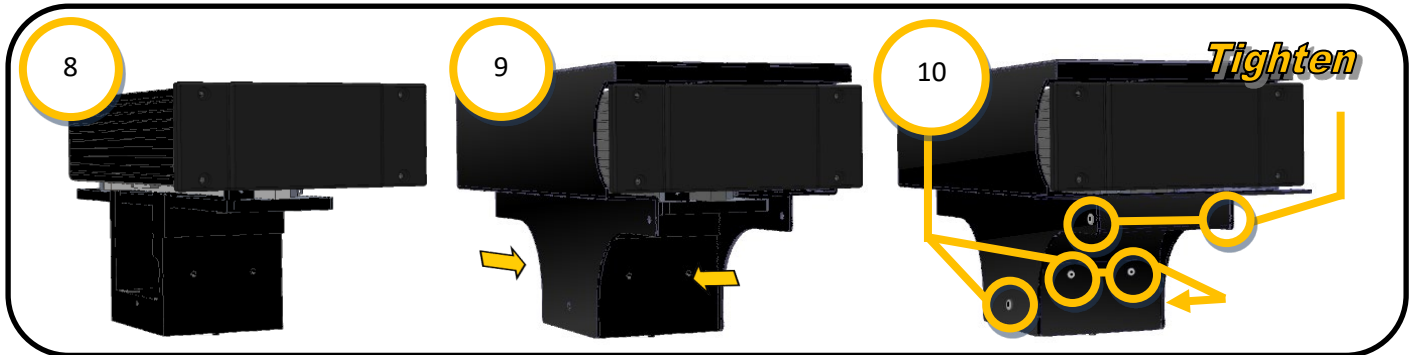
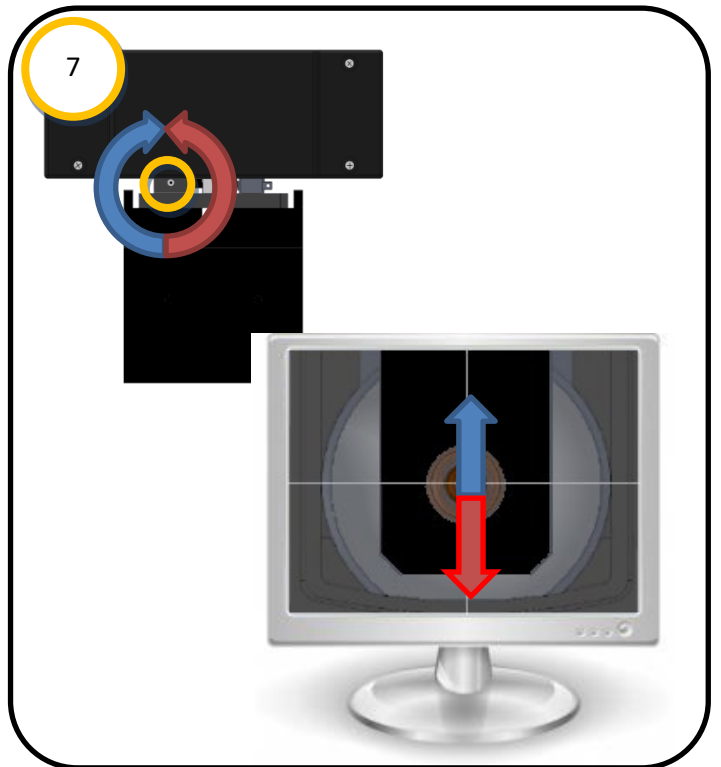
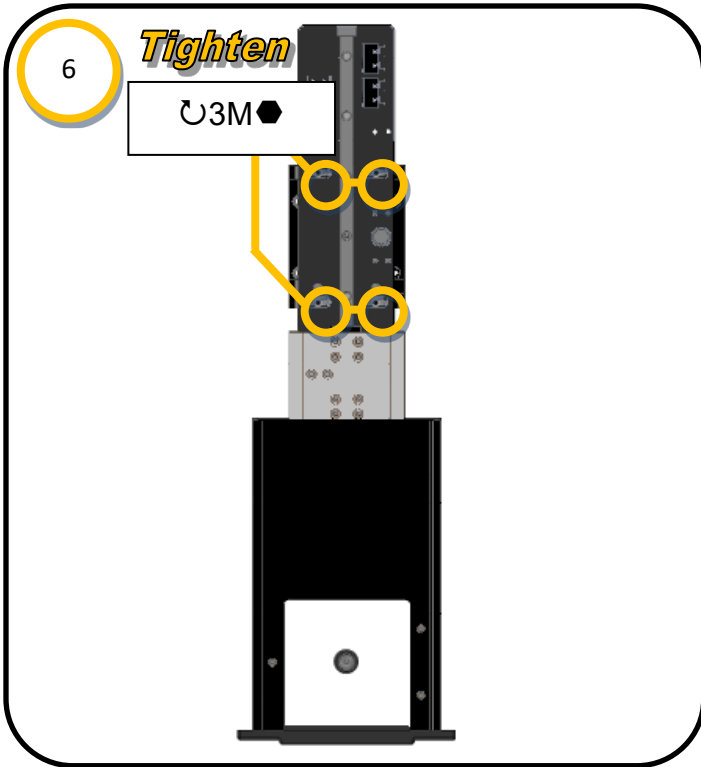


SmartPlace Technology Camera Mount Adjustment



- The end of the vacuum shaft should intersect the on screen camera crosshairs.

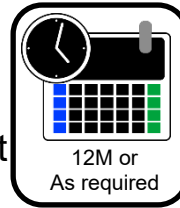




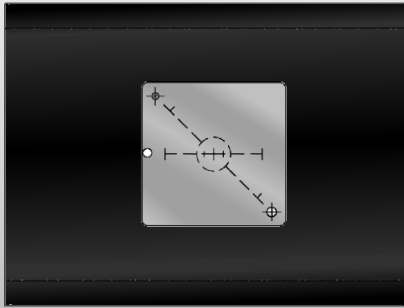
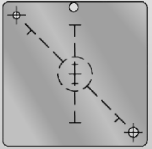


SmartPlace Technology

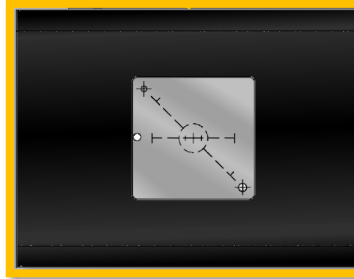
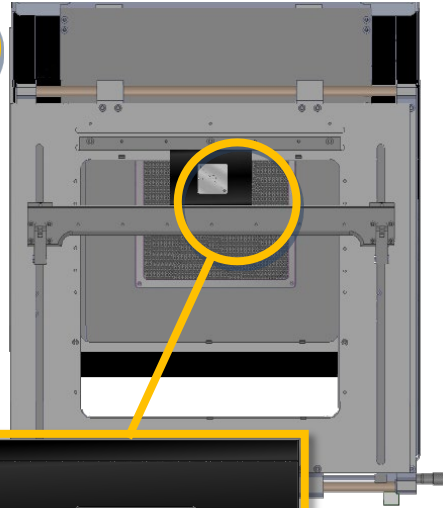
Camera Sensor to Optical path alignment



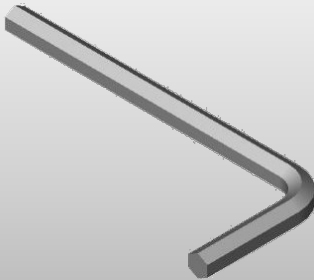
SRS-OVK



1

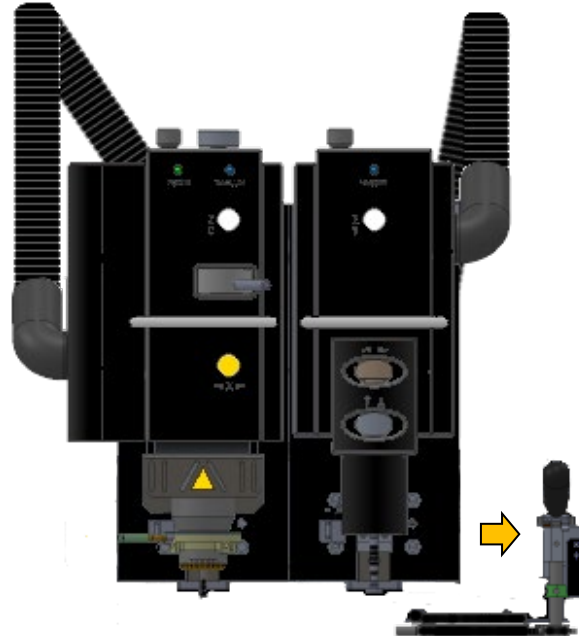
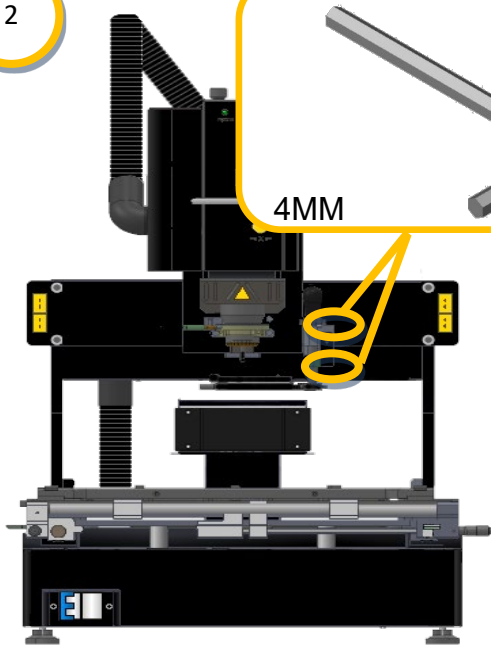


4MM
7/64





2

4MM

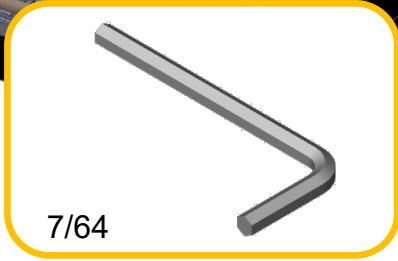
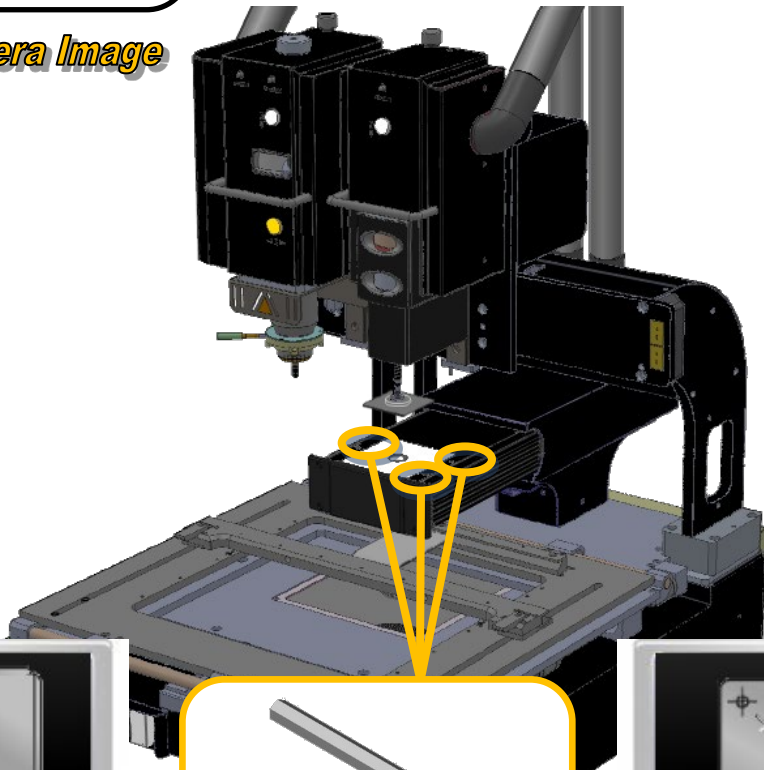


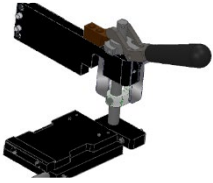


 Activate the vacuum pump

 Pick up the alignment plate with the vacuum nozzle from the mating part.

Adjust Camera Image



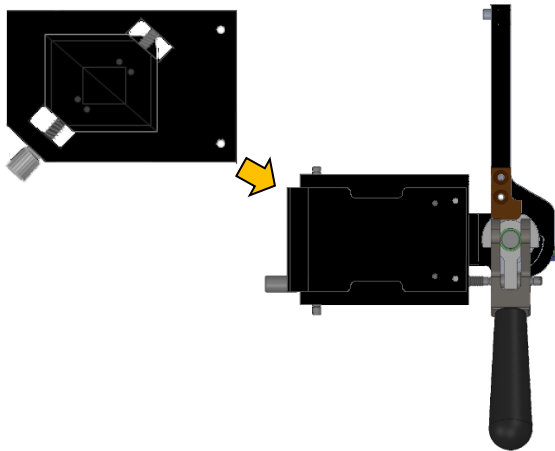


Component Arm Adjustment

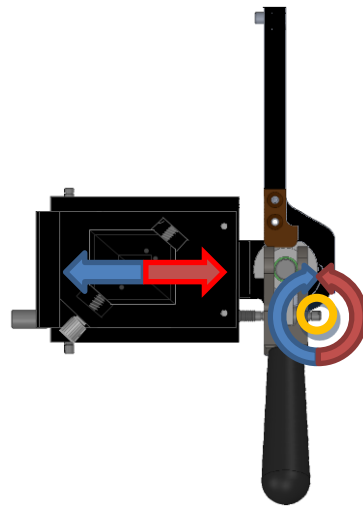


- Adjust the component tray arm until the component tray is centered on the vacuum tube.

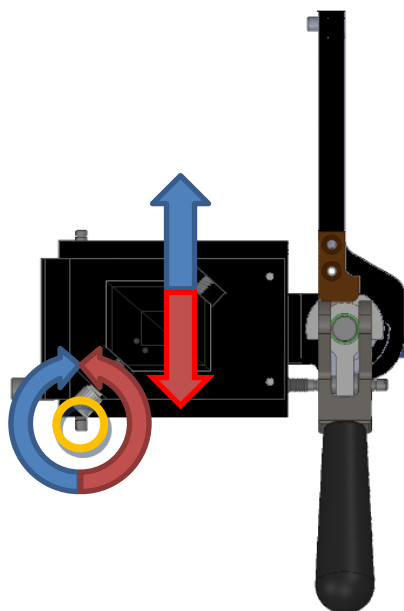
1



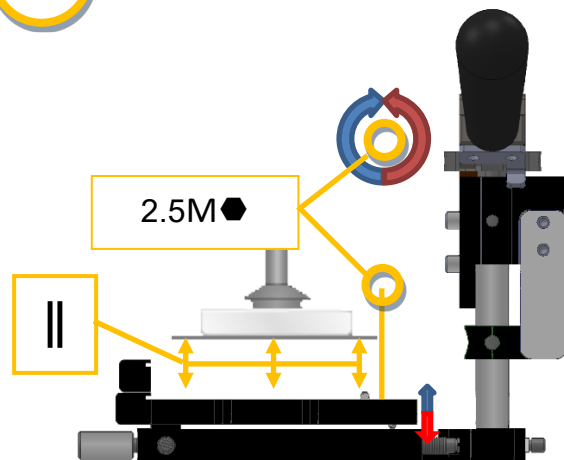
2



3

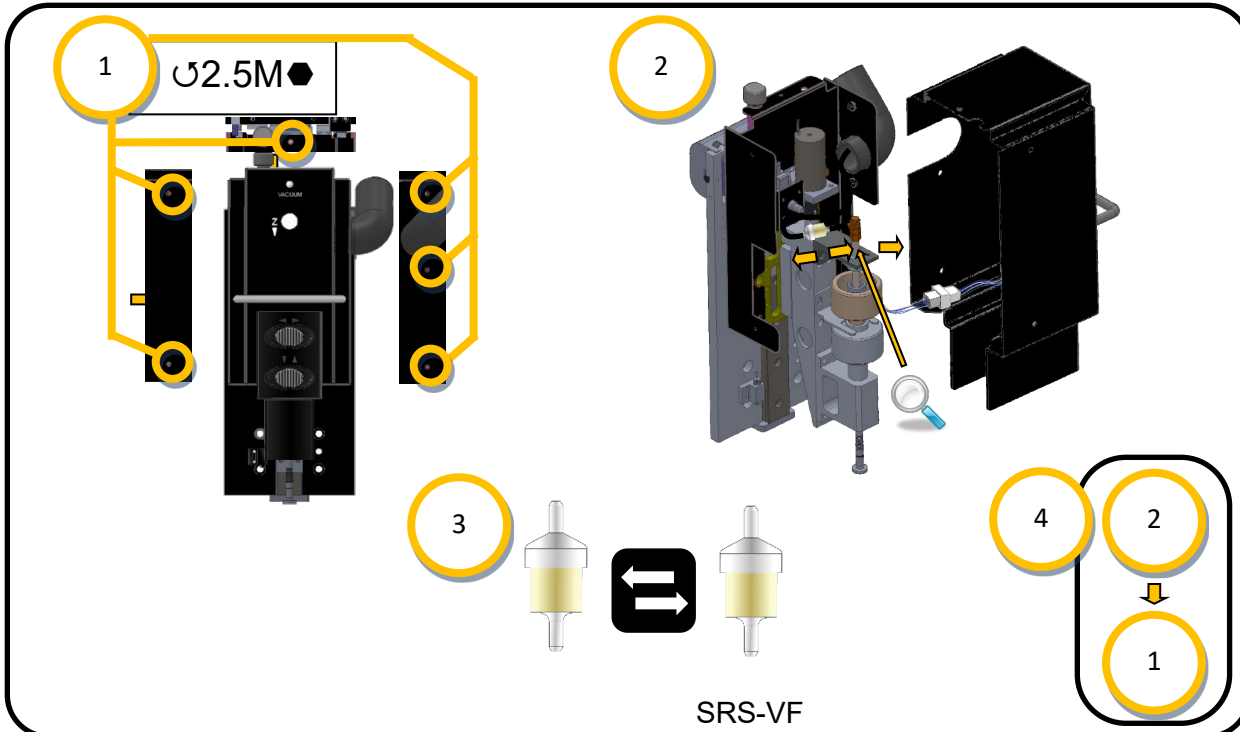
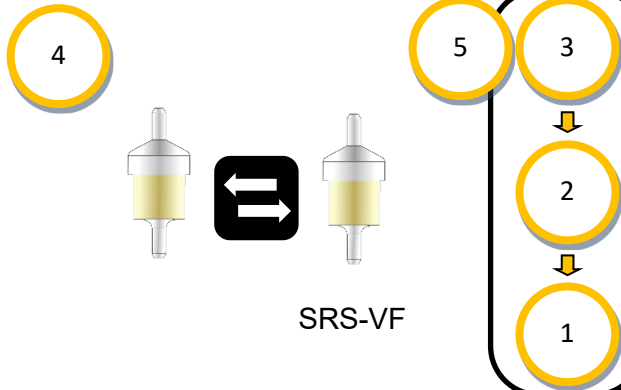
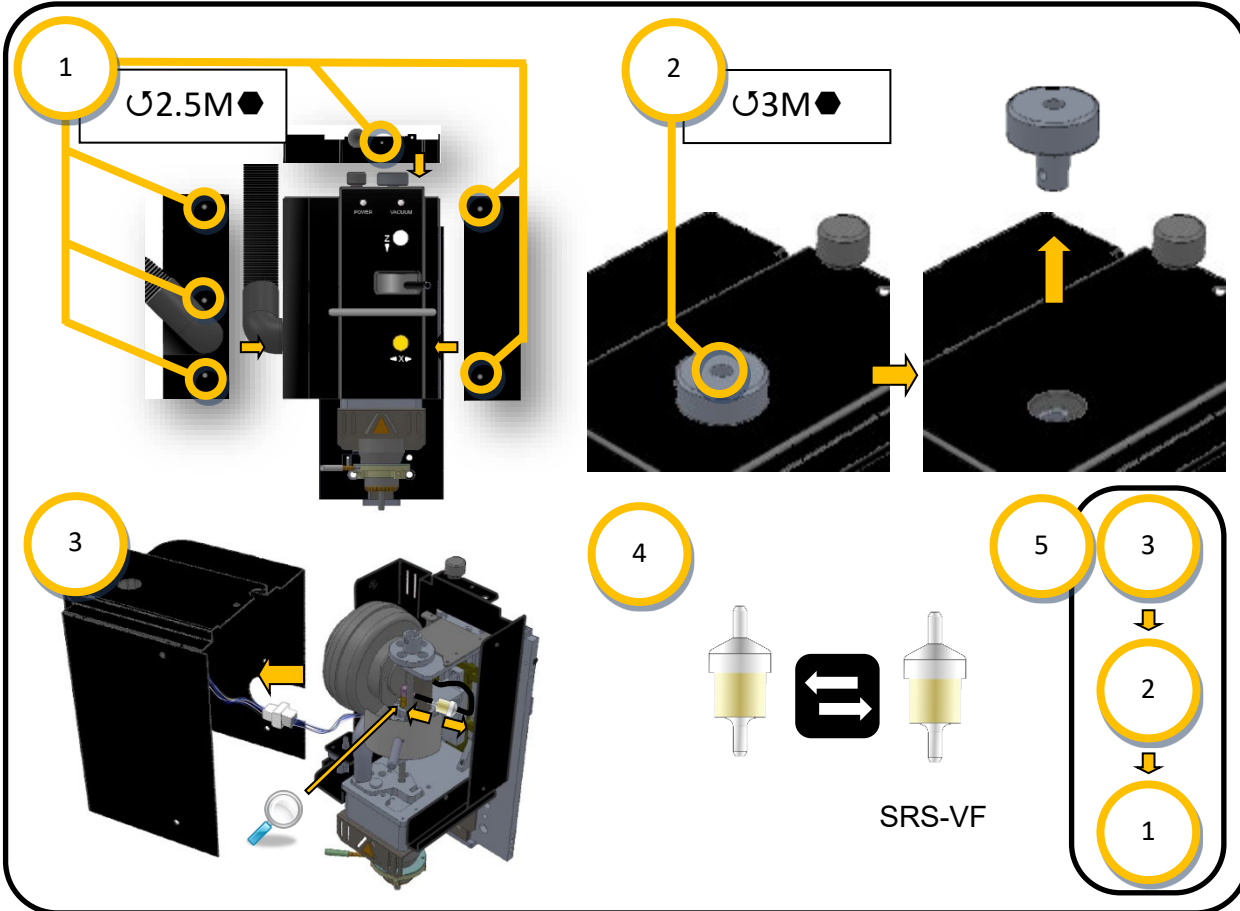
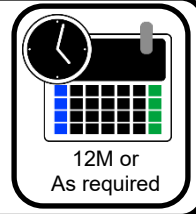


4





Vacuum Filter Replacement





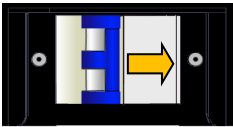
Scorpion Software Installation



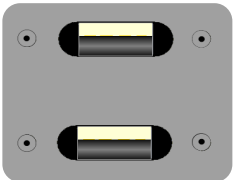
- Download the latest version of the Scorpion software from APR-Rework.com/Software-Downloads.aspx



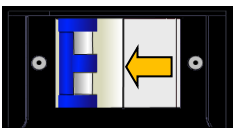
- Transfer the downloaded file to an USB Flash drive with a 2GB or greater capacity.



- Turn the power off to the Scorpion.



- Insert the USB flash drive with the software into an available USB port.



- Turn the power on to the Scorpion.



- The system will automatically detect and install new software. Unmount and remove the USB flash drive when complete.



Factory Restore



- Hover the cursor over the factory restore icon



- Left click the factory restore icon to restore saved settings.



Save Factory Default



- Hover the cursor over the factory restore icon



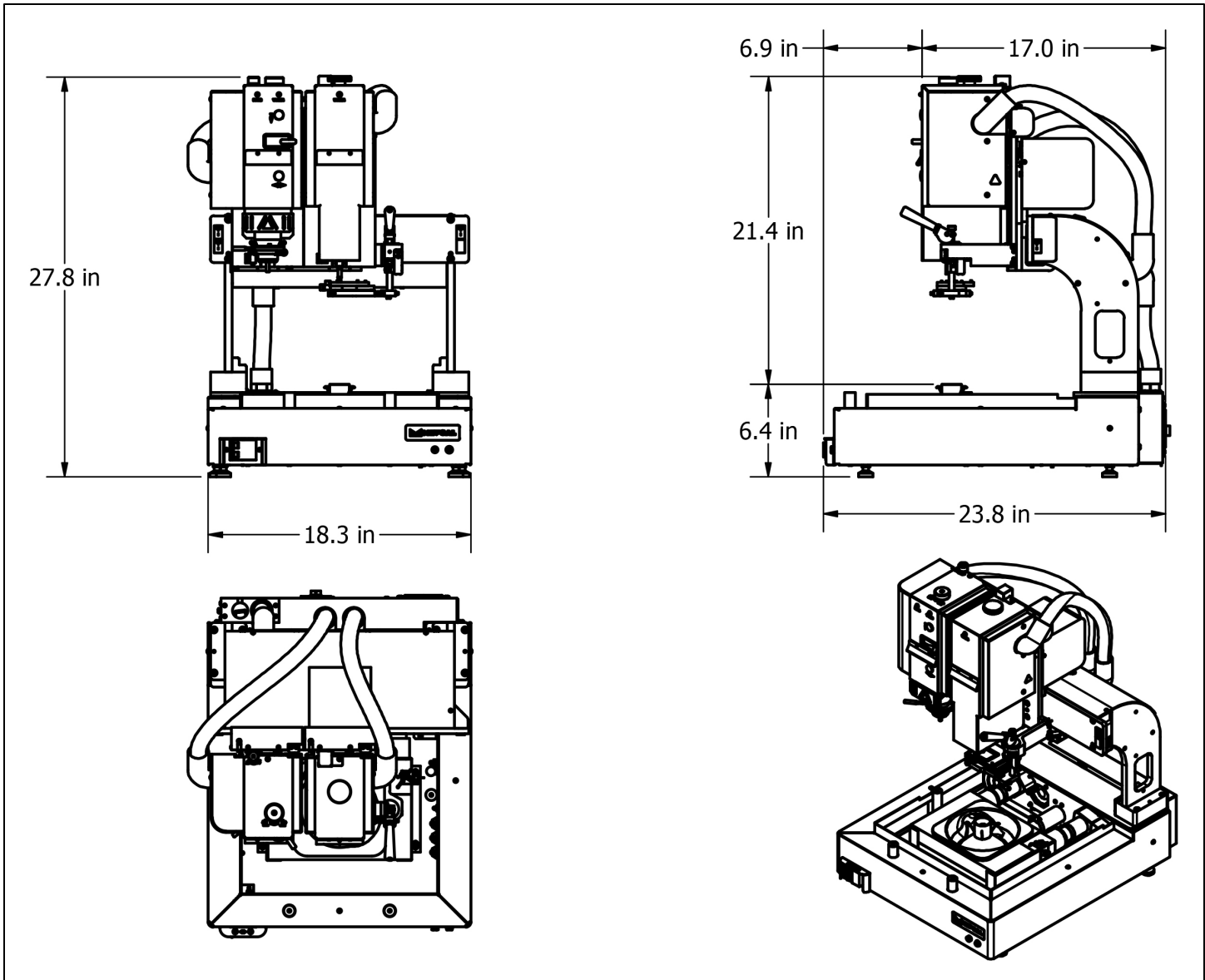
- Right click the factory restore icon to save the settings.

Specifications

Scorpion Rework System

Models: APR-1200-SRS, APR-1200-SRS-MOB, APR-1200A-SRS, APR-1200A-SRS-MOB

Input Voltage	200-240VAC, 50/60Hz, 15 Amp Single Phase
Power Consumption	
System Total	2800W (average)
Inner Pre-Heater	900W (rated)
Outer Pre-Heater	1800W (rated)
Reflow Heater	550W (rated)
Operating Temperature	41 to 104°F (5 to 40°C)
Maximum Relative humidity	80% at 88°F (31°C) decreasing linearly to 50% at 104°F (40°C)
Maximum Altitude	6500 ft. (2 km)
Pollution Degree	2 per IEC 644
Insulation category	II
Temperature Control Type	Closed-Loop Control (Thermocouple)
Maximum Source Temperature	
Reflow Head	400°C (752°F)
Pre-Heater (Inner/Outer)	350°C (662°F)
Airflow	
Control	Low, Medium, & High
Supply	Embedded 24 VDC Blower
Component Handling	
Placement Accuracy	0.0254 mm
Maximum Field of View	1.77" x 2.24" (45 x 57 mm)
Minimum Size	0.016" x 0.008" (0.4 x 0.2 mm)
Maximum Weight	1.94 oz. (55 g)
PCB Handling Capability	
Maximum Size	13.5" x open (343 mm x open)
Maximum Thickness	0.25" (6 mm)
Board Holder Range of Motion (from center position)	3.0" (76 mm) Left 3.0" (76 mm) Right 4.75" (121 mm) Toward the Operator
Dimensions	
Crated	27" W x 33" D x 31" H (686 x 838 x 787 mm)
Uncrated	18" W x 24" D x 28" H (457 x 610 x 711 mm)
Weight	
Crated	190 lbs. (86.2 kg)
Uncrated	140 lbs. (63.5 kg)
Certifications	None

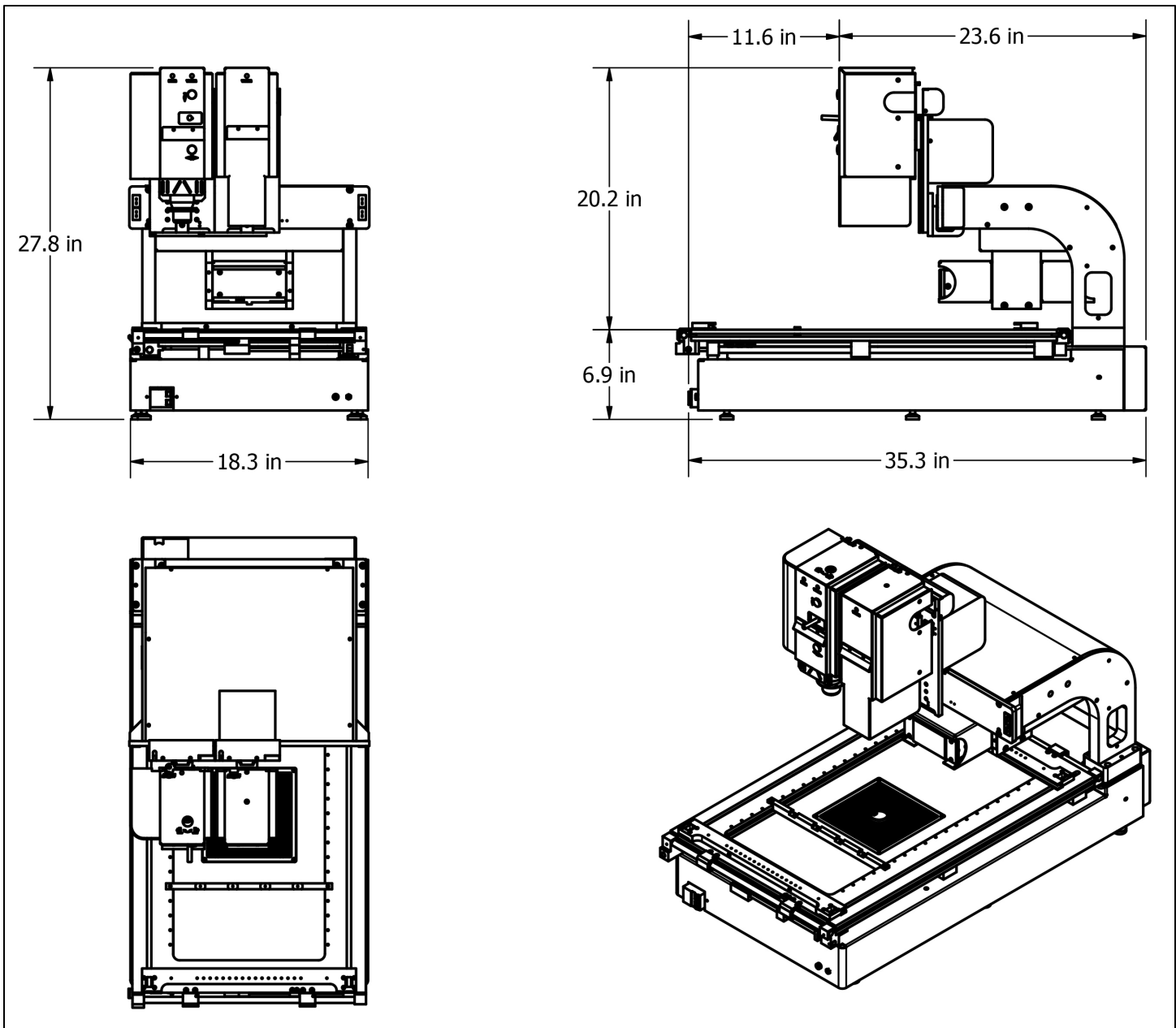


General dimensions of the Scorpion Rework System

Scorpion XL Rework System

Models: 670050, 670051

Input Voltage	200-240VAC, 50/60Hz, 15 Amp Single Phase
Power Consumption	
System Total	2800W (average)
Inner Pre-Heater	900W (rated)
Outer Pre-Heater	1800W (rated)
Reflow Heater	550W (rated)
Operating Temperature	41 to 104°F (5 to 40°C)
Maximum Relative humidity	80% at 88°F (31°C) decreasing linearly to 50% at 104°F (40°C)
Maximum Altitude	6500 ft. (2 km)
Pollution Degree	2 per IEC 644
Insulation category	II
Temperature Control Type	Closed-Loop Control (Thermocouple)
Maximum Source Temperature	
Reflow Head	400°C (752°F)
Pre-Heater (Inner/Outer)	350°C (662°F)
Airflow	
Control	Low, Medium, & High
Supply	Embedded 24 VDC Blower
Optional Nitrogen Input	90 psi (6.2 bar) recommended
Component Handling	
Placement Accuracy	0.0254 mm
Maximum Field of View	1.77" x 2.24" (45 x 57 mm)
Minimum Size	0.016" x 0.008" (0.4 x 0.2 mm)
Maximum Weight	1.94 oz. (55 g)
PCB Handling Capability	
Maximum Size	24" x open (610 mm x open)
Maximum Thickness	0.25" (6 mm)
Board Holder Range of Motion (from center position)	3.0" (76 mm) Left 3.0" (76 mm) Right 10.25" (260 mm) Toward the Operator
Dimensions	
Crated	30" W x 47" D x 40" H (762 x 1,194 x 1,016 mm)
Uncrated	18" W x 35.5" D x 28" H (457 x 902 x 711 mm)
Weight	
Crated	215 lbs. (98 kg)
Uncrated	147 lbs. (67 kg)
Certifications	None



General dimensions of the Scorpion XL Rework System

Reflow Nozzles

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Reflow-Nozzles/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Reflow-Nozzles/)

Vacuum Nozzles

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Vacuum-Nozzles/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Vacuum-Nozzles/)

Placement Nozzles

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Placement-Nozzles/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Placement-Nozzles/)

Pre-Heater Nozzles

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Pre-Heater-Nozzles/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Pre-Heater-Nozzles/)

Accessories

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Accessories/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Accessories/)

Calibration Kits

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Calibration-Kits/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Calibration-Kits/)

Replacement Parts

[APR-Rework.com/APR-Catalog/Scorpion-Essentials/Replacement-Parts/](https://www.apr-rework.com/APR-Catalog/Scorpion-Essentials/Replacement-Parts/)

Customer Service

Service@APR-Rework.com

Limited Warranty

[APR-Rework.com/Limited-Warranty.aspx](https://www.apr-rework.com/Limited-Warranty.aspx)