



# CATALOG

Quality Tools for the electronics Industry

**HAKKO**FX-951 **ESD SAFE**  
SOLDERING STATION

350

- Soldering
- Rework
- Desoldering
- Smoke Absorber
- Static Control
- Heating Gun
- Glue Gun
- Other Tools

**“To deliver excitement to our customers”  
This statement reflects Hakko’s ideal.**

In creating products, we not only make products as a manufacturer, but also add hospitality, in order to express our ideal of delivering excitement to our customers. The ideal is also our basis for continuing to meet the challenges of creating new possibilities.

Hakko’s products offer the best soldering for any component, in any environment, from the latest electronics to hobbies and crafts. Each genre is expanding without limits as the 21st century technology continues to advance and the world becomes increasingly borderless.

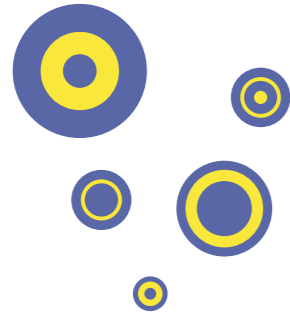
We give form to ideas beyond the norm by facing the user’s true needs with a welcoming feeling. Hakko confidently introduces soldering irons and related equipment with world class quality, starting with the new products designed in Blue & Yellow.



The Blue which inherited from the HAKKO corporate blue, this expresses both the tradition that we continue and the beauty of the global environment.

The Yellow which is resonating with HAKKO corporate blue, this yellow express the imagination of every single employee and our team spirit.

# HAKKO BLUE & YELLOW



**FRIENDLY** innovation



*Blue meets yellow*  
**GREEN PROJECT**

Not only has Hakko been approved by ISO 9001 & 14001, but we are also conducting our own campaigns. We are involved in improving quality through 3 “friendlies.”

**“Hakko is friendly to customers”**

We always strive to take on the perspective of our customers and think outside the normal frameworks to deliver products that amaze and excite customers.

**“Hakko is friendly to society”**

We take the environment into careful consideration when creating the products so that people and nature co-exist. In addition, each individual carries out activities that are valuable to the society.

**“Hakko employees are friendly to each other”**

Teamwork is very important in order to deliver the products that excite the customers. Creative power stems from the relations among the employees as well as between the Hakko international groups.

Hakko, as a specialized manufacturer of soldering irons, has established the Green Project.

We promote the development of products that are friendly to the environment (e.g., conforming to the EU RoHS directives, etc.), starting with products compatible with lead-free soldering.

We rapidly respond to the latest needs of our customers. Our lineup of products, including new products designed in Blue & Yellow and products compatible with lead-free soldering (e.g., soldering irons for various purposes, desoldering stations, etc.), could only be offered by a specialized manufacturer like Hakko.

Furthermore, our Green Project not only eliminates the hazardous materials from the products, but also aims to expand our activities so that our business is friendly to the people and the society. Hakko is always moving forward with our eyes on the future to deliver products that excite customers throughout the world.



Our company has been certified under ISO 9001 (JIS Q 9001), the international quality system standards. We are also certified under ISO 14001 (JIS Q 14001) and are actively involved in preserving the global environment.



Quality Tools for the electronics Industry

# Products List

Soldering Station



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P.70

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Helps you lead-free solder application.



ESD safe by design.

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# HAKKO FX-888 ESD SAFE

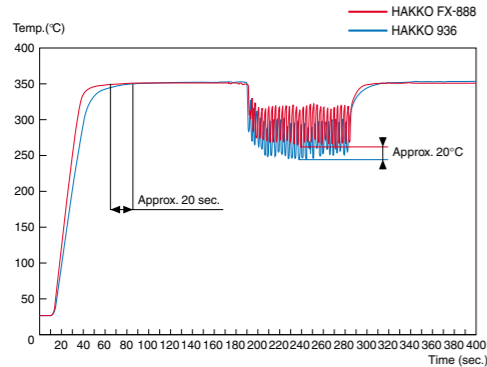


- Heater output increased to 65W.
- Excellent thermal recovery.
- The calibration (CAL) screwdriver is included as a standard accessory.
- 3 types of cleaning methods available in one soldering iron holder.
- Space-saving compact design.

### Heater output increased to 65W

Output has been increased by 30% compared to that of the HAKKO 936. The conventional tip design was reviewed and the shape was improved to provide more efficient heat transfer from the heating element. As a result, the thermal recovery time to 350°C is 20 seconds faster, and the drop in tip temperature during continuous work is reduced (refer to the thermal recovery graph), enabling the time for performing the same work to be shortened (refer to the graph showing performance comparison) and work efficiency to be greatly increased.

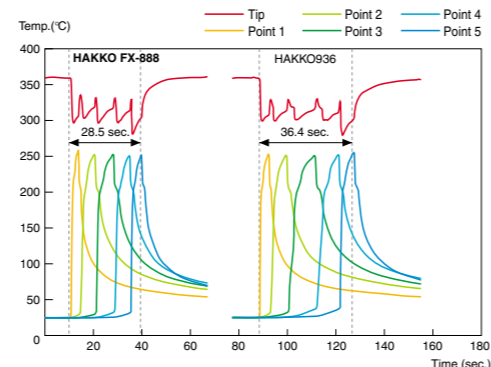
### Thermal recovery graph



#### Test criteria

- Board: Paper phenol copper
- Solder:  $\phi 1.6 \times 5\text{mm}$  Cycle: Every 3 sec.
- Lead-free solder is used.

### HAKKO FX-888 performance comparison graph with conventional station

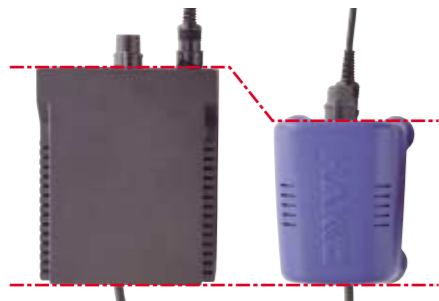


#### Test criteria

- Board: Paper phenol copper
- Solder:  $\phi 1.6 \times 5\text{mm}$  Cycle: Every 3 sec.
- Lead-free solder is used.

### Downsized to save space

The new FX-888 realizes space savings of approx. 50% in mounting area in comparison with conventional stations. It enables working space to be secured, which is important factor with the introduction of cell production.



Comparison in size between FX-888 and HAKKO 936.

### The calibration (CAL) screwdriver is included as a standard accessory

The calibration (CAL) screwdriver (resin) is stored in the bottom of station as a standard accessory. This enables temperature compensation to be adjusted easily and reduces the possibility of damage to the calibration volume.



### Design improved for ease of use

#### 3 types of cleaning methods available in one soldering iron holder

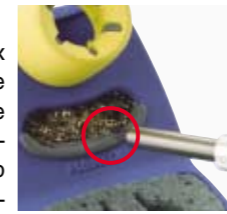
##### Cleaning sponge

Residual solder and flux adhering on the tip can be wiped off by the sponge soaked with water.



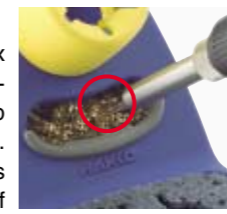
##### Rubber cleaner

Residual solder and flux adhering on the tip can be wiped off on the silicone rubber cleaner. Use without water prevents the tip temperature from decreasing rapidly or tip oxidation from being promoted.



##### Cleaning wire

Residual solder and flux adhering on the tip is removed by inserting the tip into a thin metallic wire. This cleaning wire leaves an appropriate amount of solder on the tip end, which prevents the tip from being oxidized. Use without water prevents the tip temperature from decreasing rapidly or tip oxidation from being promoted.



#### Reduce sounds with storing the iron



A protective cap installed in the iron receptacle is provided to reduce sounds when storing the iron.

#### Easy trashing of solder waste



The iron holder base is provided with a detachable waste collecting plate, which improves its maintainability.

### Specifications

Model No.	FX-888
Power Consumption	70W
Temperature Range	200-480°C
Temperature Stability	$\pm 1^\circ\text{C}$
Temperature Setting Lock Type	Dial screw type

### Station

Voltage	26V
Dimensions	100(W) x 120(H) x 130(D)mm
Weight (w/o cord)	1.3kg

### Iron

Model No.	FX-8801
Power Consumption	65W (26V)
Tip to Ground Resistance	$< 2\Omega$
Tip to Ground Potential	$< 2\text{mV}$
Cord	1.2m
Total Length (w/o cord)	190mm
Weight (w/o cord)	44g

### Replacement Tips

Please refer to page 8.

### Packing List

Model Name	Contents
HAKKO FX-888	Station ..... 1
	Iron (FX-8801) ..... 1
	Iron holder with rubber cleaner and cleaning sponge (No.FH800-01BY) ..... 1
	Cleaning wire ..... 1
	Hexagon wrench ..... 1
	CAL adjustment driver* ..... 1

\*CAL adjustment driver is attached to the bottom of the station.

### Replacement and Optional Parts

Part No.	Name/Description
FX8801-01	Soldering iron FX-8801/26V-65W
FH800-01BY	Iron holder FH-800/blue & yellow
A1559	Cleaning sponge
A1561	Cleaning wire
B3474	Rubber cleaner
A1560	Heating element/26V-65W
B3469	Tip enclosure
B1785	Nut
B2022	Nipple
B3466	CAL adjustment driver

Optional Tips

Unit : mm

<p>T18-B</p>	<p>T18-C1</p>	<p>T18-I</p>
<p>T18-CF1</p>	<p>T18-K</p>	<p>T18-CF15</p>
<p>T18-SB</p>	<p>T18-C2</p>	<p>T18-C05</p>
<p>T18-CF2</p>	<p>T18-CSF25</p>	<p>T18-D08</p>
<p>T18-C3</p>	<p>T18-D12</p>	<p>T18-CF3</p>
<p>T18-D16</p>	<p>T18-C4</p>	<p>T18-D24</p>
<p>T18-CF4</p>	<p>T18-D32</p>	

**HAKO FX-888 ESD SAFE**  
SOLDERING STATION

can provide the solution to all your needs.  
Lead-free soldering, reducing costs, cell production, improving quality, etc.

# HAKKO FX-951 ESD SAFE



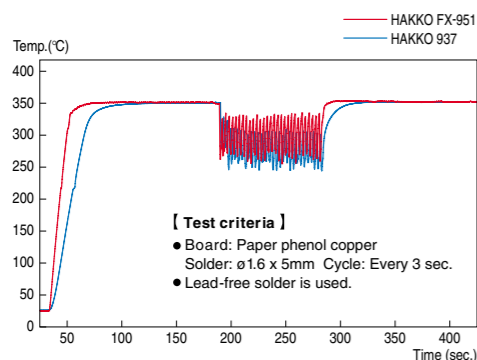
- Excellent thermal recovery **Digital type**
- Suitable for various kinds of applications from touch up to heavy duty application.
- Informs you of errors via a warning buzzer or display.
- "Control Card" can lock the temperature settings.
- Quick and easy offsetting of tip temperature by the digital offset function.
- Low temperature alarm function is provided.
- Sleep function prevents the tip from being oxidized and extends the tip life.
- Energy-saving automatic power shut-off function.
- Space-saving compact design
- Antibacterial color sleeve enables the tip replacement to be easier and more comfortable.

# HAKKO FX-950 ESD SAFE

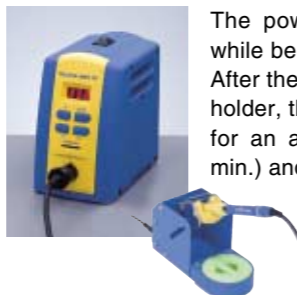


- Excellent thermal recovery **Analog type**
- Suitable for various kinds of applications from touch up to heavy duty application.
- "Lock key" can lock the temperature settings.
- Offset function
- Space-saving compact design
- Informing of various errors by lamp.

### Thermal Recovery Graph



### Power-save Function (HAKKO FX-951)



The power-save function operates while being linked to the iron holder. After the iron is inserted into the iron holder, the sleep function\*1 activates for an arbitrarily-set time (0 to 29 min.) and the tip temperature will decrease to 200°C. After 30 minutes have elapsed, the automatic power shutoff function\*2 activates.

\*1 To use sleep function, it is necessary to set the desired time arbitrarily in advance. For using the sleep function with the FX-950, the FH200-01 or the FH 200-02 iron holder is required, which is sold as option. Then, the time before activating the sleep function is fixed by 6 minutes and cannot be changed.

\*2 In order to use the automatic power shutoff function, it is necessary to set it in advance. The FX-950 is not equipped with the automatic power shutoff function.

### Performance comparison table

	FX-950	FX-951
Analog/Digital type	Analog	Digital
Thermal setting lock	Lock key	Control card
Power-save function	Auto-power shutoff function	○
	Sleep function	○ Fixed: 6min.
Low temperature alarm function	×	○

### Specifications

Model No.	FX-950	FX-951
Power Consumption	75W	
Temperature Range	200-450°C	
Temperature Stability	±5°C	

### Station

Model No.	FX-950	FX-951
Output Voltage	24V	
Dimensions	80(W) x 118(H) x 138(D)mm	80(W) x 130(H) x 131(D)mm
Weight (w/o cord)	1.2kg	

### Iron

Model No.	FM-2028
Power Consumption	70W (24V)
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Cord	1.2m
Total Length (w/o cord)	188mm with 2.4D tip
Weight (w/o cord)	30g with 2.4D tip

### Replacement Tips

Please refer to page 12-13.

### Replacement and Optional Parts

Part No.	Name/Description
FM2028-01	HAKKO FM-2028 24V/70W w/yellow sleeve
FM2028-02	HAKKO FM-2028 24V/70W w/blue sleeve
FH200-02	HAKKO FH-200 <cleaning sponge type>
FH101-02	HAKKO FH-101 <cleaning sponge type>
B3253	Connecting cable
A1536	Cleaning sponge, green
599B-02	HAKKO 599B tip cleaner
B2756	Tip tray
B3216	Sleeve assembly, yellow
B3217	Sleeve assembly, orange
B3218	Sleeve assembly, blue
B3219	Sleeve assembly, green

### Sleeve Assembly



Four color sleeve assemblies are available. Workability increases if sleeves are changed according to the tip shape and job application.

### Packing List

Model Name	Contents
HAKKO FX-951	Station ..... 1
	Iron (FM-2028) ..... 1
	Power cord ..... 1
	Iron holder with cleaning sponge (No.FH200-02) ..... 1
	Control card ..... 1
HAKKO FX-950	Station ..... 1
	Iron (FM-2028) ..... 1
	Power cord ..... 1
	Iron holder with cleaning sponge (No.FH101-02) ..... 1
	Lock key ..... 1
	Heat resistant pad ..... 1

\* Tips are optional parts.

### Iron Holder

The unit can be used with HAKKO 599B instead of a cleaning sponge.



### Tip Tray



No. B2756

For storage of tip

- Option
- Tips are not included.

### N<sub>2</sub> System



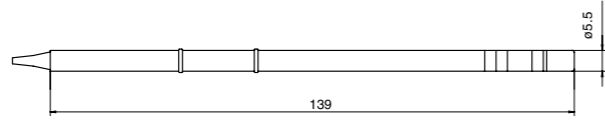
Combination sample with the N<sub>2</sub> system HAKKO FX-951, HAKKO FM-2026, HAKKO FX-780, HAKKO FX-791

\* For further details, refer to page 18-21.



Optional Tips

Unit : mm



	T12-B Shape-B	T12-B2 Shape-0.5B	T12-B3 Shape-0.7B	T12-B4 Shape-0.4B
SHAPE B				
	T12-BL Shape-BL			
SHAPE BC	T12-BC1 Shape-1BC T12-BCF1*	T12-BC2 Shape-2BC T12-BCF2*	T12-BC3 Shape-3BC T12-BCF3*	
	T12-C08 Shape-0.8C	T12-C1 Shape-1C	T12-C4 Shape-4C T12-CF4*	
SHAPE C				
	T12-D08 Shape-0.8D	T12-D12 Shape-1.2D	T12-D16 Shape-1.6D	T12-D24 Shape-2.4D
SHAPE D				
	T12-D4 Shape-4D	T12-D52 Shape-5.2D	T12-DL08 Shape-0.8DL	T12-DL12 Shape-1.2DL
	T12-DL32 Shape-3.2DL	T12-DL52 Shape-5.2DL		
SHAPE I	T12-I Shape-I	T12-IL Shape-IL	T12-ILS Shape-ILS	
	T12-J02 Shape-0.2J	T12-JL02 Shape-0.2JL	T12-JS02 Shape-0.2JS	
SHAPE J				
	T12-K Shape-K	T12-KF Shape-KF	T12-KL Shape-KL	T12-KR Shape-KR
SHAPE K				
	T12-KU Shape-KU			

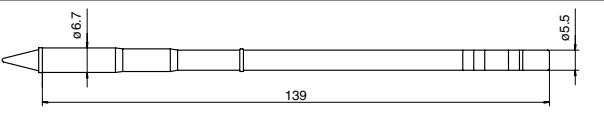
SMD TYPE

QUAD	T12-1201 Quad 13.6 x 8.5	T12-1202 Quad 10.3 x 10.3	T12-1203 Quad 12.8 x 12.8	T12-1204 Quad 17.9 x 17.9
	T12-1205 Quad 23.4 x 17.3	T12-1206 Quad 22.5 x 16.5	T12-1207 Quad 15.5 x 15.5	T12-1208 Quad 15.8 x 15.8
	T12-1209 Quad 8.4 x 8.4			
TUNNEL	T12-1001 Tunnel 5.1 x 4.6	T12-1002 Tunnel 5.1 x 10.4	T12-1003 Tunnel 9.5 x 18.3	T12-1004 Tunnel 9.5 x 15.8
	T12-1005 Tunnel 9.5 x 13.2	T12-1006 Tunnel 6.9 x 11.4	T12-1007 Tunnel 7.9 x 18.8	T12-1008 Tunnel 19.5 x 10.2
	T12-1009 Tunnel 13.4 x 20.5	T12-1010 Tunnel 19.5 x 12		
	T12-1401 Spatula 10.4	T12-1402 Spatula 15.7	T12-1403 Spatula 21.2	T12-1404 Spatula 25
T12-1405 Spatula 32	T12-1406 Spatula 40			

SPECIAL APPLICATIONS TYPE

T12-B2Z Shape-0.5B (Z)	T12-BC1Z Shape-1BC (Z) T12-BCF1Z*	T12-BC2Z Shape-2BC (Z) T12-BCF2Z*	T12-BC3Z Shape-3BC (Z) T12-BCF3Z*
T12-BZ Shape-B (Z)	T12-C4Z Shape-4C (Z) T12-CF4Z*	T12-D12Z Shape-1.2D (Z)	T12-D16Z Shape-1.6D (Z)
T12-D24Z Shape-2.4D (Z)	T12-D4Z Shape-4D (Z)	T12-KFZ Shape-KF (Z)	T12-KRZ Shape-KR (Z)
T12-BCM2 Shape-2BC Bevel with indent**	T12-BCM3 Shape-3BC Bevel with indent**		

HEAVY DUTY TYPE



T12-WB2 Shape-0.5WB	T12-WD08 Shape-0.8WD	T12-WD12 Shape-1.2WD	T12-WD16 Shape-1.6WD	T12-WD52 Shape-5.2WD	T12-WI Shape-WI

\* These tips are tinned on the soldering surface only.  
\*\* T12-BCM2 and T12-BCM3 are not available for sale or use in the U.S.A.

# HAKKO FM-203 SOLDERING STATION ESD SAFE



**A single station plays multiple roles of soldering, desoldering and SMD rework.**

- Two connection ports:—  
Two soldering irons can be connected at the same time, which allows users to select and use the appropriate one without having to connect them alternatively.
- Powerful thermal recovery
- Sleep function
- Auto power shutoff function

## Soldering



### HAKKO FM-2027 SOLDERING IRON ESD SAFE

- Light weight grip provides fatigueless work even for extended jobs.
- New colored antibacterial sleeves can be replaced more easily than conventional ones.
- Four colored sleeves are provided. Using color classification for tip shape enables convenient work.

## SMD Rework

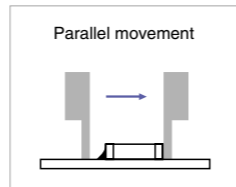


### HAKKO MODEL FM-2022 PARALLEL REMOVER ESD SAFE • HAKKO MODEL FM-2023 PARALLEL REMOVER ESD SAFE

- Unique parallel movement of tips allows easy removal.
- Direct heating prevents damage to neighboring sensitive components comparing with hot air.

FM-2022:—  
Can be used for chips and flat packages up to 25mm in size.

FM-2023:—  
Standard or reverse tweezers action can be selected with a switch lever.  
Equipped with a small ergonomic grip.



## Desoldering-external air compressor type



### HAKKO MODEL FM-2024 DESOLDERING TOOL ESD SAFE

- Small ergonomic style grip with light weight provides fatigueless work.
- New design with reduced distance between the nozzle end and filter pipe prevents clogging by sucked solder.
- Easy maintenance:—  
Uses disposable paper filter pipes.  
One-touch nozzle replacement.
- Detachable handle allows two-way use: gun type or straight type
- Safe design:—  
Equipped with a nozzle lock function.  
Nozzles can be safely replaced with the nozzle remover.

\* Before using the FM-2024 unit, connect to a compressor.



\* Desoldering Control Box (DCB) for MODEL FM-2024

## Conversion Kit

FM-2027 Conversion Kit (No.FM2027-03)



FM-2022 Conversion Kit (No.FM2022-04)



FM-2023 Conversion Kit (No.FM2023-04)



FM-2024 Conversion Kit



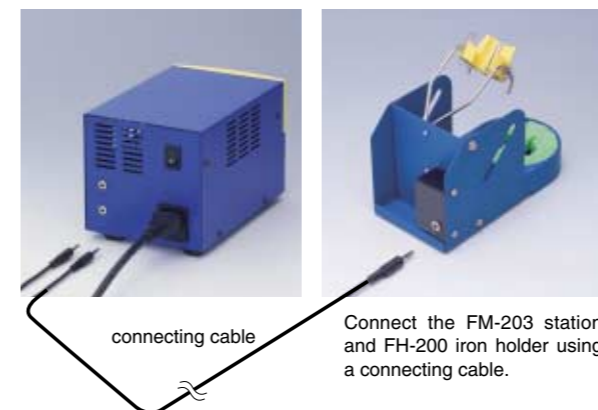
\* The part number of "Conversion kit" varies from the input voltage. Please contact with the nearest representative for the further information.

## Sleep function

After the iron is inserted into the iron holder, the sleep function activates for a user-settable time (0 to 29 min.) and the tip temperature will decrease to approximately 200°C.

## Auto power shutoff function

When 30 minutes have elapsed after inserting the iron into the iron holder, the auto power shut-off function activates and stops to apply power to the heating element.



\* It is necessary to change unit settings before using sleep and auto power shut-off functions.

## Combination examples

Since all handpieces cannot be connected to each connector port, refer to the following table.



Handpiece	Channel D connector	Channel S connector
FM-2027	○	○
FM-2022 *1	○	×
FM-2023 *1	○	×
FM-2024 *2	○	○
FM-2026 *3	○	○

\*1 If the FM-2022 or the FM-2023 handpiece is connected to the channel D connector the other handpiece connected to the channel S connector can be used with it at the same time. If either handpiece is used, the non-used handpiece will be automatically subject to sleep mode.

\*2 If two FM-2024 handpieces are connected to both channel connectors connect each of them to the desolder control box.

\*3 The N<sub>2</sub> generator and N<sub>2</sub> airflow meter must be connected before using the FM-2026. For further details, refer to page 18-21.

Specifications

<b>FM-203</b>	
Model No.	FM-203
Power Consumption	140W
Temperature Range	200-450°C
Temperature Stability	±5°C at idle temperature

Station

Output	24V
Dimensions	120 (W) x 120 (H) x 190 (D) mm
Weight	2.7kg

FM-2027

Model No.	FM-2027
Power Consumption	70W (24V)
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Total Length (w/o cord)	188mm with 2.4D tip
Weight (w/o cord)	30g with 2.4D tip
Cord	1.2m

MODEL FM-2022/MODEL FM-2023

Model No.	FM-2022	FM-2023
Power Consumption	140W (24V)	
Temperature Range	200-400°C	
Tip to Ground Resistance	< 2Ω	
Tip to Ground Potential	< 2mV	
Total Length (w/o cord & tip)	148mm with SOP 25L tip	117mm with I tip
Weight (w/o cord)	64g with SOP 25L tip	37g with I tip
Cord	1.2m	

MODEL FM-2024

Model No.	FM-2024
Power Consumption	70W (24V)
Temperature Range	350-450°C
Tip to Ground Potential	< 2mV
Tip to Ground Resistance	< 2Ω
Total Length (w/o cord)	180mm with ø1.0 nozzle
Weight (w/o cord & hose)	65g with ø1.0 nozzle
Cord	1.2m

Desolder Control Box

Power Consumption	12W
Output	24V
Vacuum Generator	Ejector type
Vacuum Pressure (Max.)	93kPa (700mmHg)
Suction Flow	28ℓ/min.
Nozzle to Ground Potential	< 2mV
Applied Air Pressure	490kPa (5.0kgf/cm <sup>2</sup> ) when in use (trigger or button is pressed.)
Compressed Air Consumption	1.62 c.f.m (46ℓ/min.)
Dimensions	119(W) x 45(H) x 172(D)mm
Weight (w/o cord)	1.2kg

Replacement Tips and Nozzles

FM-2027: Please refer to page 12-13. MODEL FM-2022, MODEL FM-2023, MODEL FM-2024: Please refer to page 17.

N<sub>2</sub> System



Combination sample with the N<sub>2</sub> system HAKKO FM-203, HAKKO FM-2026, HAKKO FX-780, HAKKO FX-791  
\* For further details, refer to page 18-21.

Packing List

Model Name	Contents	
HAKKO FM-203	Station .....1	
	Soldering iron (FM-2027) .....1	
	Power cord .....1	
	Iron holder with 599B tip cleaner (No.FH200-01) .....1	
	Control card .....1	
	Connecting cable .....1	
	Tip tray .....1	
	Heat resistant pad .....1	
	* Tip is an optional part.	
	HAKKO FM-2027 (Conversion kit)	Soldering iron (FM-2027) .....1
Iron holder with 599B tip cleaner (No.FH200-01) .....1		
Connecting cable .....1		
Heat resistant pad .....1		
* Tip is an optional part.		
HAKKO MODEL FM-2022 (Conversion kit)	Parallel remover (MODEL FM-2022) .....1	
	Iron holder with cleaning sponge (No.FH200-03) .....1	
	Connecting cable .....1	
	Heat resistant pad .....1	
* Tip is an optional part.		
HAKKO MODEL FM-2023 (Conversion kit)	Mini parallel remover (MODEL FM-2023) .....1	
	Tips (T9-I/2pcs of set) .....1	
	Iron holder with cleaning sponge (No.FH200-04) .....1	
	Connecting cable .....1	
	Heat resistant pad .....1	
HAKKO MODEL FM-2024 (Conversion kit)	Desoldering tool (MODEL FM-2024) .....1	
	Desolder control box (DCB) .....1	
	Iron holder with 599B tip cleaner (No.FH200-05) .....1	
	Connecting cable .....1	
	Cleaning drill .....1	
	Ceramic paper filter .....10	
	Filter pipe assembly .....1	
	Handle (for gun configuration) .....1	
	Nozzle remover .....1	
	* Nozzle is an optional part.	

Replacement Parts

Part No.	Name/Description
FM2027-02	HAKKO FM-2027/Connector assembly 24V-70W
FM2022-02	MODEL FM-2022/24V-140W
FM2023-02	MODEL FM-2023/24V-140W
FM2024-02	MODEL FM-2024/24V-70W
B3216	Sleeve assembly, yellow
B3218	Sleeve assembly, blue
B3217	Sleeve assembly, orange
B3219	Sleeve assembly, green
599B-02	Tip cleaner
B3253	Connecting cable
A1514	Ceramic paper filter/10 pcs
A1512	Front holder
A1511	Filter pipe assembly
B2756	Tip tray

Replacement Tips and Nozzles

Unit : mm

T8 Series For MODEL FM-2022	T8-1001 Chip 0.5I	T8-1002 Chip 0.5C	T8-1003 Chip 1L	T8-1004 Chip 2L	T8-1013 Chip 3L
CHIP					
SOP	T8-1005 SOP 6L	T8-1006 SOP 8L	T8-1007 SOP 10L	T8-1008 SOP 13L	T8-1009 SOP 16L
	T8-1010 SOP 20L	T8-1011 SOP 25L	T8-1012 SOP 18L		

T9 Series For MODEL FM-2023

\* 1set: 2pcs.

T9 Series For MODEL FM-2023	T9-I Chip I	T9-L1 Chip 1L	T9-L2 Chip 2L
CHIP			

N1 Series For MODEL FM-2024

N1 Series For MODEL FM-2024	N1-06 Nozzle 0.6mm	N1-08 Nozzle 0.8mm	N1-10 Nozzle 1.0mm	N1-13 Nozzle 1.3mm
	N1-16 Nozzle 1.6mm	N1-20 Nozzle 2.0mm	N1-23 Nozzle 2.3mm	N1-L10 Nozzle 1.0mm Long

# N<sub>2</sub> System

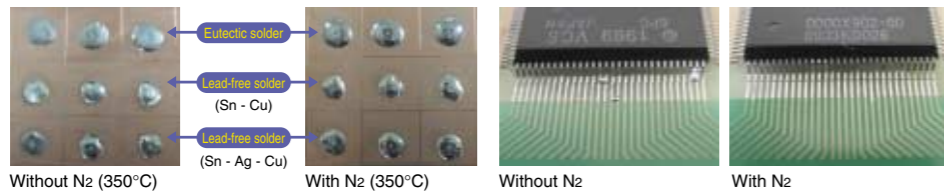


**N<sub>2</sub> gas and preheating effect improves the solderability greatly!**

- The preheating effect is achieved by passing Nitrogen gas along the heating element in the hand piece. Soldering can be done on multilayer PWB and high density PWB sensitive to heat without raising the temperature of the tip excessively, even when the melting point of lead-free solder is high.
- Improvement of wettability and spreadability.
- Preventing oxidation.
- Space saving:—  
In case of setting with HAKKO FX-951, the dimensions are 163(W) x 280(H) x 110(D)mm  
In case of setting with FM-203, the dimensions are 201(W) x 280(H) x 190(D)mm

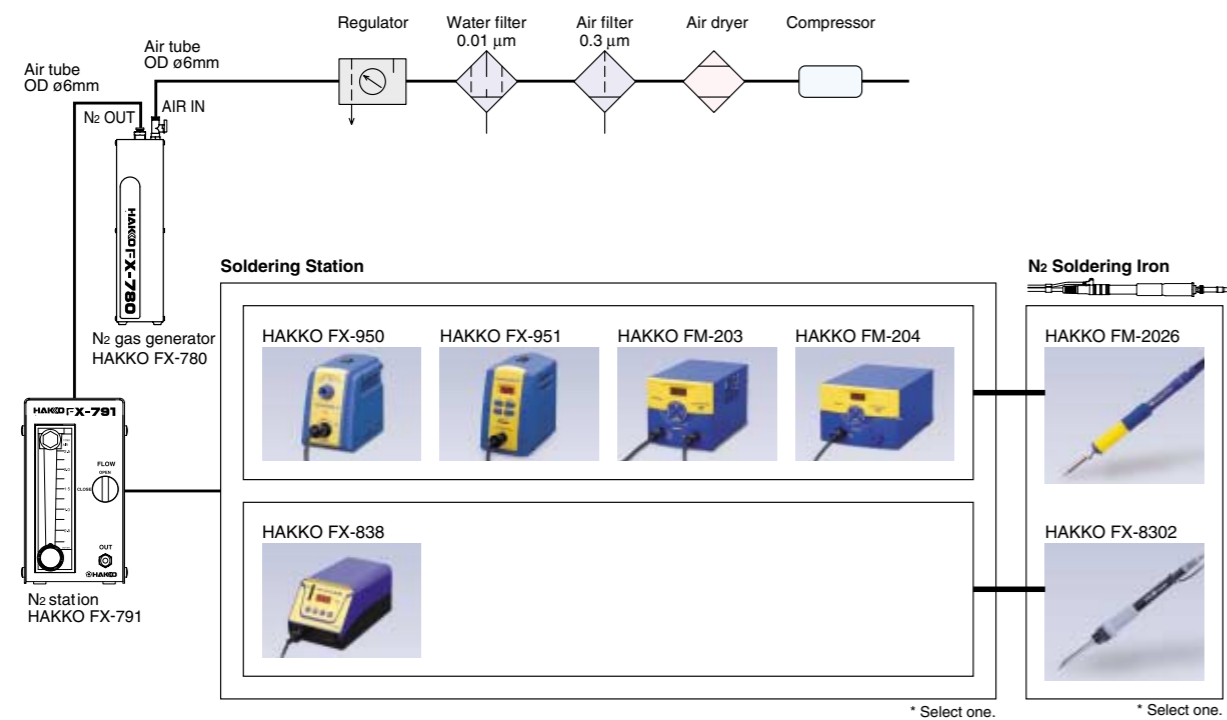
Setting example with the FX-951  
\* HAKKO FX-951, HAKKO FM-2026  
HAKKO FX-780, HAKKO FX-791

## Comparison of wettability and spreadability



Less bridge is generated even for components susceptible to bridging.

## Connection method



## Compact High-Performance N<sub>2</sub> Generator



### HAKKO FX-780

- HAKKO FX-780 generate Nitrogen gas at a maximum concentration of 99.9%. It is very compact and can be installed in a minimal space. Moreover, it can be placed perpendicularly or horizontally.

## Compact N<sub>2</sub> Flow Meter



### HAKKO FX-791

- This meter is very compact and can be installed in a minimal space next to the soldering station. The flow meter has a range between 0.25-2.5ℓ/min, allowing easy control.  
(Recommended flow rate is 0.5ℓ/min. to 1.5ℓ/min. Adjust the flow rate depending on the tip shape.)

## N<sub>2</sub> Soldering Iron

Nitrogen gas passes between the tip and nozzle assembly uniformly and the soldering tip is entirely covered with Nitrogen gas, which intercepts oxygen to prevent the soldering tip and solder from being oxidized and increases the preheating effect. It allows more stable and uniform soldering.



### HAKKO FM-2026 ESD SAFE

- N<sub>2</sub> Soldering iron with high-out 70W  
FM-2026 Conversion Kit (No.FM2026-04)



Iron holder (No.FH200-01) is included.

#### ● Sleep Function

Station	FX-950	FX-951		FX-952*		FM-203	FM-204	FM-202*
Conversion Kit	Former	Latest	Former	Latest				
FM-2026 Conversion Kit (No.FM2026-04)	○	×	○	×	○	○	○	×

○ ... Equipped with the sleep function    × ... Not equipped with the sleep function

\* Discontinued Product



### HAKKO FX-8302 ESD SAFE

- Heavy-duty soldering iron 150W
- Easy tip replacement  
—A cartridge type soldering tip can be replaced easily and quickly.

**Specifications**

<b>FX-780</b>	
Model No.	FX-780
Air Supply Pressure	0.3-0.7MPa
Concentration of Generated N <sub>2</sub>	99.9% (Max.)
Amount of Generated N <sub>2</sub>	1.5ℓ/min. (When compressed air of 0.5MPa is supplied at 25°C, the concentration of generated nitrogen is 98%.)
Dimensions (w/o sockets & valve)	73(W) x 282(H) x 71(D)mm
Weight (w/o racks)	1.5kg

<b>FX-791</b>	
Model No.	FX-791
Dimensions	70(W) x 121(H) x 134(D)mm
Weight	600g
Pressure Gauge for Discharged Gas	0.2MPa (2.0kgf/cm <sup>2</sup> )
Gas flow	0.25-2.5ℓ/min

<b>FM-2026</b>	
Model No.	FM-2026
Power Consumption	70W (24V)
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Cord	1.2m
Total Length (w/o cord)	205mm with 2.4D tip
Weight (w/o cord)	45g w/nozzle assembly C & 2.4D tip

<b>FX-8302</b>	
Model No.	FX-8302
Power Consumption	150W
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Cord	1.2m
Total Length (w/o cord)	195mm with 2.4D tip
Weight (w/o cord)	41g w/nozzle assembly D & 2.4D tip

**Packing List**

Model Name	Contents
HAKKO FX-780	N <sub>2</sub> generator .....1 Racks for station .....2
HAKKO FX-791	N <sub>2</sub> station .....1
HAKKO FM-2026 (Conversion kit)	N <sub>2</sub> soldering iron (FM-2026) .....1 Iron holder with 599B tip cleaner (No.FH200-01) .....1 Connecting cable .....1 Heat resistant pad .....1 * This unit does not include a soldering tip or nozzle assembly. When purchasing this unit, please buy your desired soldering tip and nozzle assembly together.
HAKKO FX-8302	N <sub>2</sub> soldering iron (FX-8302) .....1 * This unit does not include a soldering tip or nozzle assembly. When purchasing this unit, please buy your desired soldering tip and nozzle assembly together.

**Replacement and Optional Parts**

Part No.	Name/Description
FM2026-02	HAKKO FM-2026/24V-70W
B2974	Sleeve cover
B2765D	Sleeve assembly, yellow
B2768D	Sleeve assembly, orange
B2769D	Sleeve assembly, blue
B2998*	Nitrogen guard

\* When using the soldering iron holder cover, install it into your soldering iron holder.

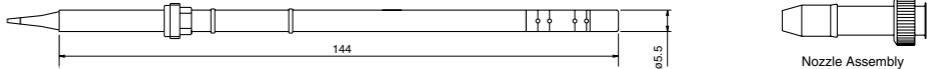
**Sleeve Assemblies**



**Optional Tips and Nozzle Assemblies**

Unit : mm

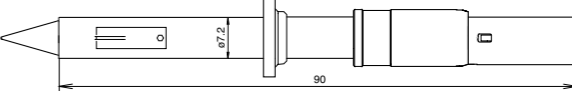
**For FM-2026**



Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly
T13-B2 Shape-0.5B	B2708 Nozzle assembly C	T13-BL Shape-BL	B2898 Nozzle assembly E	T13-BC1 T13-BCF1* Shape-1BC	B2899 Nozzle assembly F
T13-BC2 T13-BCF2* Shape-2BC	B2706 Nozzle assembly A	T13-BC3 T13-BCF3* Shape-3BC	B2900 Nozzle assembly G	T13-D08 Shape-0.8D	B2709 Nozzle assembly D
T13-D16 Shape-1.6D	B2708 Nozzle assembly C	T13-D24 Shape-2.4D	B2708 Nozzle assembly C	T13-J02 Shape-0.2J	B2707 Nozzle assembly B
T13-KF Shape-KF	B2923 Nozzle assembly J	T13-KR Shape-KR	B2902 Nozzle assembly I	T13-KU Shape-KU	B2901 Nozzle assembly H
T13-BCM2 Bevel with indent** Shape-2BC	B2706 Nozzle assembly A	T13-BCM3 Bevel with indent** Shape-3BC	B2900 Nozzle assembly G		

\* These tips are tinned on the soldering surface only.  
\*\* T13-BCM2 and T13-BCM3 are not available for sale or use in the U.S.A.

**For FX-8302**



Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly
T20-B2	B3121 Nozzle assembly A	T20-BC2 T20-BCF2* <sup>ø8</sup>	B3124 Nozzle assembly D	T20-BC3 T20-BCF3* <sup>ø12</sup>	B3124 Nozzle assembly D
T20-BC4 T20-BCF4*	B3124 Nozzle assembly D	T20-C5	B3124 Nozzle assembly D	T20-C6	B3124 Nozzle assembly D
T20-D16	B3123 Nozzle assembly C	T20-D24	B3124 Nozzle assembly D	T20-D32	B3124 Nozzle assembly D
T20-D6	B3561 Nozzle assembly E	T20-J02	B3122 Nozzle assembly B	T20-K	B3123 Nozzle assembly C
T20-KU	B3122 Nozzle assembly B	T20-BL	B3121 Nozzle assembly A	T20-BL2	B3121 Nozzle assembly A
T20-BL3	B3123 Nozzle assembly C	T20-BCM2**	B3124 Nozzle assembly D		

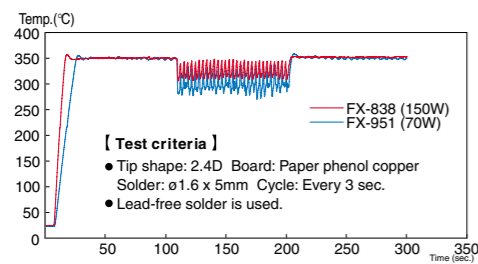
\* Tinned on the soldering surface only.  
\*\* The part number T20-BCM2 is not available for sale or use in the U.S.A.

# HAKKO FX-838 ESD SAFE



- High Power 150W Soldering Station suitable for soldering from large to fine components.
- Great thermal recovery improves the soldering environment.
- Easy and speedy tip replacement is possible.
- Equipped with high-power mode for soldering heat sinks, shield cases and chassis, which require high heat capacity in particular.
- Operate at Maximum Temperature of 500 degrees.
- Temperature preset mode saves time and effort.
- Auto sleep function
- Auto power shutoff function

### Thermal Recovery Graph



### Easy Tip Replacement

Tips can be quickly and easily replaced because they are of the cartridge type.



### Specifications

Model No.	HAKKO FX-838
Power Consumption	158W

### Station

Output Voltage	27V
Temperature Range	200-500°C
Temperature Stability	±5°C
Dimensions	110(W) x 110(H) x 205(D)mm
Weight (w/o cord)	3.2kg

### Iron

Model No.	HAKKO FX-8301
Power Consumption	150W
Tip to Ground	< 2Ω
Resistance	< 2mV
Tip to Ground Potential	Ceramic heater
Heating Element	1.2m
Length of Cord	175mm with 2.4D tip
Length (w/o cord)	31g with 2.4D tip

### Packing List

Model Name	Contents
Hakko FX-838	Station .....1
	Iron (FX-8301) .....1
	Control card .....1
	Power cord .....1
	Iron holder with cleaning sponge and 599B .....1
	Connecting cable .....1
	Heat resistant pad .....1

\* Tip are optional parts.

### N<sub>2</sub> Soldering Iron (Optional)



### N<sub>2</sub> System to Expand the HAKKO FX-838 Functions

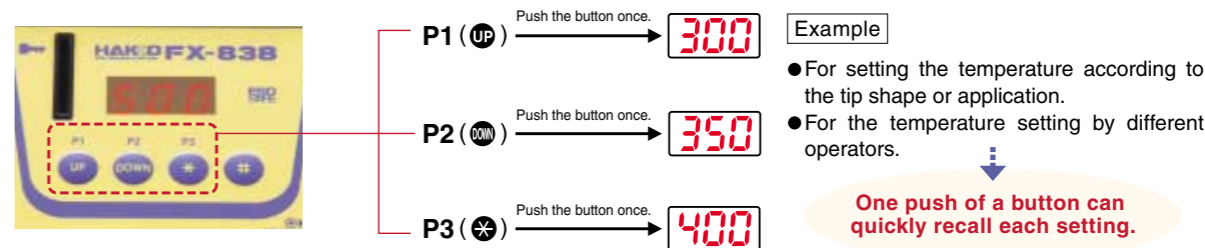


Combination sample  
HAKKO FX-838,  
HAKKO FX-8302\*,  
HAKKO FX-780,  
HAKKO FX-791.

\* Optional HAKKO FX-8302 is required to complete N<sub>2</sub> System.

### Temperature preset mode

The temperature preset mode allows you to input three frequently-used temperatures in advance and recall them with one push of a button.



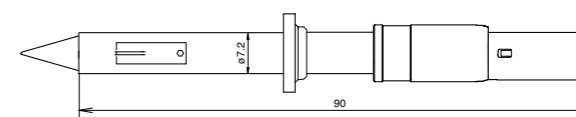
\* Factory default is nomal. Change the parameter to use 'temperature preset mode'.  
\* Factory default: 300°C for P1, 350°C for P2 and 400°C for P3

**A great change!**

- Because 500°C is the maximum setting temperature, work which is assumed to suffer from insufficient thermal power can be done.

### Replacement Tips

Unit : mm



Tip	Applicable Nozzle Assembly	Diagram	Applicable Nozzle Assembly	Diagram	Applicable Nozzle Assembly	
T20-B2	B3121 Nozzle assembly A		T20-BC2 T20-BCF2*	B3124 Nozzle assembly D	T20-BC3 T20-BCF3*	B3124 Nozzle assembly D
T20-BC4 T20-BCF4*	B3124 Nozzle assembly D		T20-C5	B3124 Nozzle assembly D	T20-C6	B3124 Nozzle assembly D
T20-D16	B3123 Nozzle assembly C		T20-D24	B3124 Nozzle assembly D	T20-D32	B3124 Nozzle assembly D
T20-D6	B3561 Nozzle assembly E		T20-J02	B3122 Nozzle assembly B	T20-K	B3123 Nozzle assembly C
T20-KU	B3122 Nozzle assembly B		T20-BL	B3121 Nozzle assembly A	T20-BL2	B3121 Nozzle assembly A
T20-BL3	B3123 Nozzle assembly C		T20-BCM2**	B3124 Nozzle assembly D		

\* Tinned on the soldering surface only.  
\*\* The part number T20-BCM2 is not available for sale or use in the U.S.A.

# HAKKO 937 ESD SAFE



- Digital indicator ensures accurate temperature setting by all personnel.
- Once set, temperature cannot be changed without inserting the control card, providing easy temperature management.
- Compact unit takes up little space on the workbench.
- Thinner grip for easier use.
- ESD safe by design.

## Irons for Soldering Stations

3 Types of iron available: for HAKKO 937 Soldering Stations

Type	Small: For micro soldering	Medium: Standard	Large: For heavy duty soldering
Model No.	900S-ESD	907-ESD	908-ESD
Thermal recovery graph*			

\* Test criteria  
Board: Paper phenol copper  
Solder:  $\phi 1.6 \times 5\text{mm}$   
Cycle: Every 3 sec.

## Specifications

Model No.	937		
Power Consumption	60W		
<b>Station</b>			
Output Voltage	AC 24V		
Temperature Range	200-480°C		
Dimensions	120(W) x 93(H) x 170(D)mm		
Weight (w/o cord)	1.3kg		
<b>Iron</b>			
Model No.	900S	907	908
Type	S	M	L
Style	Regular   ESD	Regular   ESD	Regular   ESD
Power Consumption	50W (24V)		
Standard Tip	900S-T-1	900M-T-B	900L-T-B
Tip to Ground Resistance	< 2 $\Omega$		
Tip to Ground Potential	< 2mV (Typ.0.6mV)		
Heating Element	Ceramic Heater		
Total Length (w/o cord)	176mm	190mm	200mm
Weight (w/o cord)	25g	44g	54g

## Packing List

Model Name	Contents
HAKKO 937	Station.....1
	Iron (900S/907/908) .....1
	Iron holder with cleaning sponge (900S-No.C1141, 907/908-No.C1142) .....1
	Control card.....1

When ordering or HAKKO 937, please specify the type of Iron (S, M or L).

## Replacement Tips

Please refer to page 25.

## Optional Parts

Please refer to page 27, 59.



Stackable design puts two units in the bench space of one unit.

## Replacement Tips

Unit : mm

### Small For 900S, 900S-ESD

Model No.	Shape	Model No.	Shape	Model No.	Shape	Model No.	Shape
900S-T-B	Shape-B	900S-T-1C	Shape-1C	900S-T-2C	Shape-2C	900S-T-1.2D	Shape-1.2D
900S-T-1.6D	Shape-1.6D	900S-T-I	Shape-I				

### Medium For 900M, 900M-ESD, 907, 907-ESD, 933

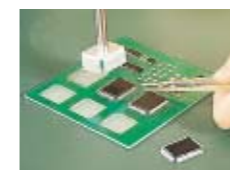
Model No.	Shape	Model No.	Shape	Model No.	Shape	Model No.	Shape
900M-T-B	Shape-B	900M-T-0.5C	Shape-0.5C	900M-T-0.8C	Shape-0.8C	900M-T-1C	Shape-1C
900M-T-1.5CF*	Shape-1.5C	900M-T-2C	Shape-2C	900M-T-3C	Shape-3C	900M-T-4C	Shape-4C
900M-T-0.8D	Shape-0.8D	900M-T-1.2D	Shape-1.2D	900M-T-1.6D	Shape-1.6D	900M-T-2.4D	Shape-2.4D
900M-T-3.2D	Shape-3.2D	900M-T-H	Shape-H	900M-T-1.8H	Shape-1.8H	900M-T-I	Shape-I
900M-T-K	Shape-K	900M-T-LB	Shape-LB	900M-T-1.2LD	Shape-1.2LD	900M-T-2LD	Shape-2LD
900M-T-R	Shape-R	900M-T-RT	Shape-RT	900M-T-S3	Shape-S3	900M-T-S4	Shape-S4
900M-T-SB	Shape-SB	900M-T-SI	Shape-SI				

### Large For 900L, 900L-ESD, 908, 908-ESD, 934

Model No.	Shape	Model No.	Shape	Model No.	Shape	Model No.	Shape
900L-T-B	Shape-B	900L-T-2B	Shape-2B	900L-T-2C	Shape-2C	900L-T-3C	Shape-3C
900L-T-4C	Shape-4C	900L-T-5C	Shape-5C	900L-T-2.4D	Shape-2.4D	900L-T-3.2D	Shape-3.2D
900L-T-I	Shape-I	900L-T-K	Shape-K	900L-T-S1	Shape-S1		

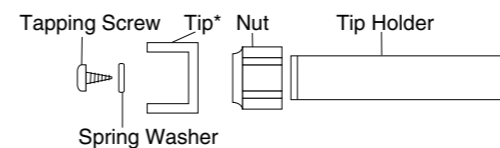
\*These tips are tinned on the soldering surface only.

## For SMD Desoldering



907	907 ESD	900M	900M ESD
+			
Tip Holder (No.900M-1000)			
+			
Tip			

## No.900M-1000



\* Tip is not included.

## Optional Tips

Unit : mm

Part No.	Tip Size			
	A	B	C	D
924-T-1002	12.5	9.5	12.5	9.5
924-T-1003	15.5	12.5	15.5	12.5
924-T-1004	16.3	13.3	16.3	13.3
924-T-1005	17.0	14.0	17.0	14.0
924-T-1006	23.0	20.0	17.0	14.0
924-T-1007	20.0	17.0	20.0	17.0

Part No.	Tip Size	
	A	B
924-T-1010	6.0	5.0
924-T-1011	6.0	10.0
924-T-1012	7.0	12.5
924-T-1013	9.0	15.2
924-T-1014	9.0	18.0

Part No.	Type
924-T-1020	Spatula 9.5



- Two soldering irons of different thermal capacities may be used simultaneously.
- Choose the exact irons you need for your soldering applications.
- Cost effective and practical in production, using up less available space.
- Super quick heat-up and faster thermal recovery, permitting high quality soldering at lower temperature.
- Two separate controls, independent of each other.

### Specifications

Model No.	928
Power Consumption	120W

### Station

Output Voltage	AC 24V
Temperature Range	200-480°C
Dimensions	135(W) x 88(H) x 190(D)mm
Weight (w/o cord)	2.7kg

### Iron

Model No.	900S-ESD	900M-ESD	900L-ESD
Power Consumption	50W (24V)		
Standard Tip (Shape-B)	900S-T-I	900M-T-B	900L-T-B
Tip to Ground Resistance	2Ω		
Tip to Ground Potential	< 2mV (Typ.0.6mV)		
Heating Element	Ceramic Heater		
Total Length (w/o cord)	176mm	190mm	200mm
Weight (w/o cord)	25g	45g	55g

### Replacement Tips

Please refer to page 25.

### Optional Parts

Please refer to page 27, 59.

### Packing List

Model Name	Contents
HAKKO 928 (LL)	Station .....1
	Iron (900L-ESD, 900L-ESD).....2
	Iron holder with cleaning sponge (No.631-03) .....1
HAKKO 928 (LM)	Station .....1
	Iron (900L-ESD, 900M-ESD).....2
	Iron holder with cleaning sponge (No.631-03) .....1
HAKKO 928 (LS)	Station .....1
	Iron (900L-ESD, 900S-ESD) .....2
	Iron holder with cleaning sponge (No.631-04) .....1
HAKKO 928 (MM)	Station .....1
	Iron (900M-ESD, 900M-ESD).....2
	Iron holder with cleaning sponge (No.631-03) .....1
HAKKO 928 (MS)	Station .....1
	Iron (900M-ESD, 900S-ESD).....2
	Iron holder with cleaning sponge (No.631-04) .....1
HAKKO 928 (SS)	Station .....1
	Iron (900S-ESD, 900S-ESD) .....2
	Iron holder with cleaning sponge (No.631-05) .....1





- Available for your Hakko 701, 702B, 928 or 937.
- ESD safe by design.
- Compact design and light weight.
- Easy positioning for the solder feeding.
- A variety of tip type.

## Specifications

Model No.	951	952
Type	M	L
Power Consumption	50W (24V)	
Temperature Range	200-480°C	
Tip to Ground Resistance	< 2Ω	
Tip to Ground Potential	< 2mV (Typ.0.6mV)	
Heating Element	Ceramic Heater	
Standard Tip	900M-T-S10 (Shape-S10)	900L-T-B (Shape-B)
Standard Guide Nozzle	ø1.0mm (No.B2654)	
Usable Solder Dia.	ø0.6, 0.8, 1.0, 1.2, 1.6mm	
Cord	1.1m	
Dimensions (w/o cord)	170 (W) × 180 (H)mm	
Weight (w/o cord)	177g	187g

## Optional Parts

Part No.	Name/Description
B2652	Guide nozzle/ø0.6mm ESD
B2653	Guide nozzle/ø0.8mm ESD
B2654	Guide nozzle/ø1.0mm ESD
B2655	Guide nozzle/ø1.2mm ESD
B2656	Guide nozzle/ø1.6mm ESD
A1321	Heating element
C1437	Iron holder

## Replacement Tips

Unit : mm

### Medium For 951, 958

Part No.	Shape	Part No.	Shape	Part No.	Shape	Part No.	Shape
900M-T-B 900M-T-BF2*	Shape-B	900M-T-0.8C	Shape-0.8C	900M-T-2C 900M-T-2CF*	Shape-2C	900M-T-3C 900M-T-3CF*	Shape-3C
900M-T-4C 900M-T-4CF*	Shape-4C	900M-T-1.6D	Shape-1.6D	900M-T-2.4D	Shape-2.4D	900M-T-3.2D	Shape-3.2D
900M-T-K	Shape-K	900M-T-SB	Shape-SB	900M-T-S3	Shape-S3	900M-T-S4	Shape-S4
900M-T-S10	Shape-S10	900M-T-S11	Shape-S11				

Tip Out Dia ø6.5mm

### Large For 952, 959

Part No.	Shape	Part No.	Shape	Part No.	Shape	Part No.	Shape
900L-T-B	Shape-B	900L-T-2B	Shape-2B	900L-T-2C 900L-T-2CF*	Shape-2C	900L-T-3C 900L-T-3CF*	Shape-3C
900L-T-4C 900L-T-4CF*	Shape-4C	900L-T-5C 900L-T-5CF*	Shape-5C	900L-T-2.4D	Shape-2.4D	900L-T-3.2D	Shape-3.2D
900L-T-K	Shape-K	900L-T-S1	Shape-S1				

Tip Out Dia ø8.5mm

\* These tips are tinned on the soldering surface only.  
 \* 900M-T-BF2 is tinned a distance of 2mm from the end of the tip.  
 \* For heavy duty soldering HAKKO recommends the 952 and the 959 with heavier tips.

**CAUTION**

Use only genuine replacement tips for Hakko 951, 952, 958, 959.  
 The tips for Hakko Dash are not available to use.

## HAKKO 933·934

SOLDERING IRON



- Simple and quick temperature setting by inserting the appropriate temperature button into the handle.
- Easy temperature management—preset temperature can be seen at a glance.
- More efficient use of work space.

### Specifications

Model No.	933	934
Power Consumption	51W	
Standard Tip	900M-T-B (Shape-B)	900L-T-B (Shape-B)
Temperature	300 · 330 · 360 · 390 · 420 · 450 · 480°C	
Tip to Ground Resistance	< 2Ω	
Tip to Ground Potential	< 2mV (Typ.0.6mV)	
Heating Element	Ceramic Heater	
Total Length (w/o cord)	200mm	210mm
Weight (w/o cord)	55g	65g

### Replacement Tips

Please refer to page 25.

- Tips for HAKKO 933 = Tips for M-Type Iron
- Tips for HAKKO 934 = Tips for L-Type Iron

### Optional Parts

Part No.	Name/Description
B1766	Temp. setting button 300°C
B1767	Temp. setting button 330°C
B1768	Temp. setting button 360°C
B1769	Temp. setting button 390°C
B1770	Temp. setting button 420°C
B1771	Temp. setting button 450°C
B1772	Temp. setting button 480°C

### Packing List

Model Name	Contents
HAKKO 933	Iron (M) .....1
	Temperature setting button .....3 (360°C-No.B1768, 390°C-No.B1769, 420°C-No.B1770)
HAKKO 934	Iron (L) .....1
	Temperature setting button .....3 (360°C-No.B1768, 390°C-No.B1769, 420°C-No.B1770)

\* 390°C button is originally set into the iron.  
Other setting buttons are available as optional parts.

### Recommended Iron Holders



No.606



No.633-01



No.633-02

### Temp. Setting Button





- Begin soldering in only 10 seconds!
- Greater thermal capacity and rapid transmission to the tip means faster thermal recovery.
- The temperature control sensor is built into the heating element for faster, more stable temperature control.
- The highly insulated ceramic heater never overheats.  
An insulation factor of over 100MΩ can be maintained even during actual use.
- The compact, light weight design with high cooling efficiency at the handle permits fatigue-free soldering over long periods for maximum work efficiency.

## Specifications

Model No.	918	920	921	922
Power Consumption	55W			
Standard Tip	918-T-B (Shape-B)	920-T-SB (Shape-SB)	920-T-B (Shape-B)	
Temperature	420°C	300°C	370°C	420°C
Heating Element	Ceramic Heater			
Insulation Resistance	100MΩ			
Total Length (w/o cord)	220mm		210mm	
Weight (w/o cord)	70g		50g	

## Recommended Iron Holders



No.606



No.633-01

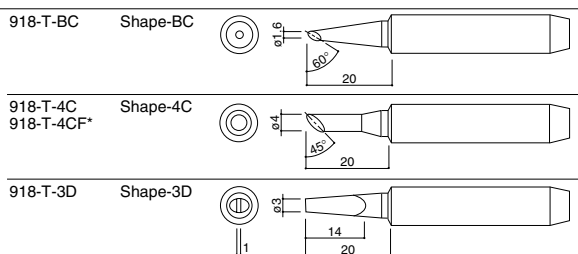
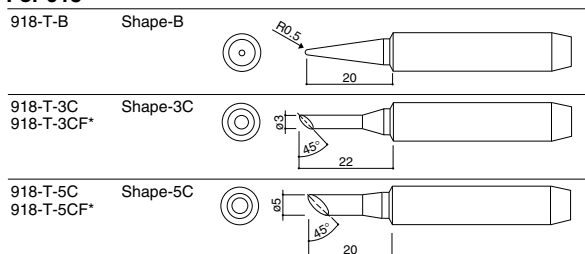


No.633-02

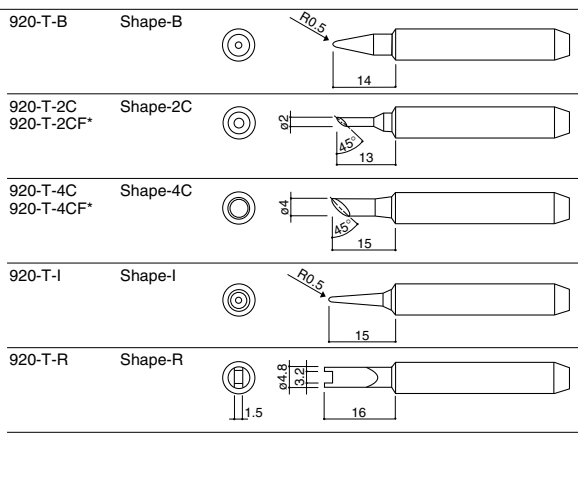
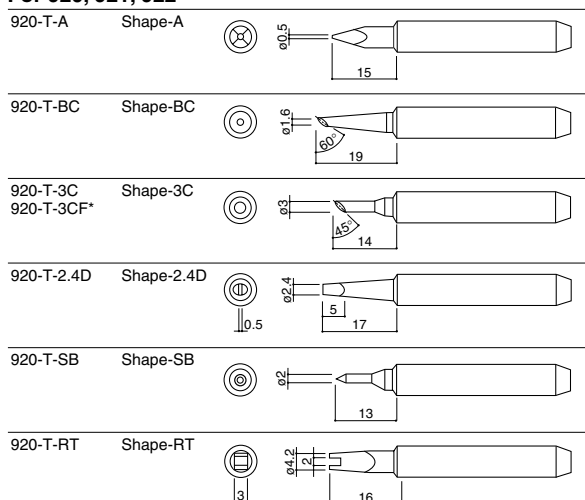
## Replacement Tips

Unit : mm

### For 918



### For 920, 921, 922



\* These tips are tinned on the soldering surface only.

## HAKKO DASH

SOLDERING IRON



### Specifications

Model No.	N452	N453	N454
Power Consumption	15W	20W	25W
Standard Tip	N452-T-B (Shape-B)		N454-T-B (Shape-B)
Heating Element	Ceramic Heater		
Insulation Resistance	200MΩ	100MΩ	
Total Length (w/o cord)	185mm		192mm
Weight (w/o cord)	47g		57g

- Compact, light weight design with a slender handle for a more comfortable grip.
- Rod-type ceramic heater brings high insulation, and reduces the handle-to-tip distance for faster soldering with a minimum of movement.
- Special alloy heating element is printed in the alumina ceramic insulating layer and then sintered to the ceramic main body, thus completely sealing the heating element off from air. This protects the heating element from oxidation, and ensures years of trouble-free use.

### Recommended Iron Holders



No.602



No.603



No.606



No.633-01



No.633-02

### Replacement Tips

Unit : mm

#### For N452, N453

N452-T-B	Shape-B	
N452-T-1C N452-T-1CF*	Shape-1C	
N452-T-3C N452-T-3CF*	Shape-3C	
N452-T-D	Shape-D	
N452-T-SB	Shape-SB	
N452-T-SD	Shape-SD	

N452-T-C	Shape-C	
N452-T-2C N452-T-2CF*	Shape-2C	
N452-T-4C N452-T-4CF*	Shape-4C	
N452-T-I	Shape-I	
N452-T-SC	Shape-SC	

#### For N454

N454-T-B	Shape-B	
N454-T-3C N454-T-3CF*	Shape-3C	
N454-T-5C N454-T-5CF*	Shape-5C	
N454-T-I	Shape-I	

N454-T-2C N454-T-2CF*	Shape-2C	
N454-T-4C N454-T-4CF*	Shape-4C	
N454-T-D	Shape-D	

\* These tips are tinned on the soldering surface only.

# HAKKO 455.456

SOLDERING IRON



- Both the HAKKO 455-456 incorporate a ceramic heating element, which provides a longer service life than conventional nichrome heating element.
- Alloy-coated iron tips ensure long-lasting protection from corrosion.
- The HAKKO 455 is perfect for soldering tuners, inverters and similar components.
- The HAKKO 456 is ideal for soldering chassis, dynamos, large harnesses, transformers and other parts which require a large amount of soldering.

## Specifications

Model No.	455	456
Power Consumption	40W	60W
Standard Tip	A1047 (Shape-B)	A1023 (Shape-2B)
Heating Element	Ceramic Heater	
Total Length (w/o cord)	215mm	250mm
Weight (w/o cord)	100g	150g

## Recommended Iron Holders



No.633-01



No.633-02

## Replacement Tips

Unit : mm

### For 455

A1047	Shape-B		A1048	Shape-3C	
A1049	Shape-4C		A1050	Shape-5C	
A1051	Shape-6C		A1052	Shape-5D	
A1053	Shape-K				

### For 456

A1023	Shape-2B		A1024	Shape-4C	
A1031	Shape-6C		A1025	Shape-8C	
A1026	Shape-5D		A1032	Shape-K	

## HAKKO PRESTO

SOLDERING IRON



- The HAKKO PRESTO features two operating wattages-20W and 130W, which can be switched by simply pressing a button according to the component size you want to solder.
- The HAKKO PRESTO is available in both pen and gun types so you can select the type that best matches your needs.
- A Safety cap is available for 984 and 985. You can put in a toolbox immediately after finishing soldering work.

### Specifications

Model No.	980	981	984	985
Type	Pen	Gun	Pen	Gun
Safety Cap	—	—	○	○
Power Consumption	20W/130W			
Standard Tip	980-T-B (Shape-B)			
Heating Element	Ceramic Heater			
Insulation Resistance	Over 100MΩ (20W)			
Total Length (w/o cord)	205mm	160mm	205mm	160mm
Weight (w/o cord)	48g	92g	56g	100g

### Recommended Iron Holders



No.606

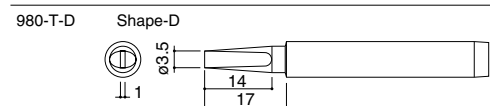
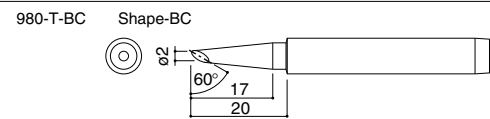
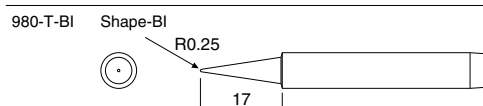
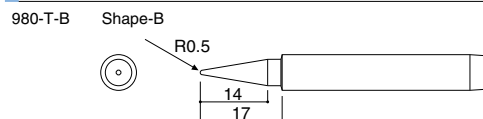


No.633-01



No.633-02

### Replacement Tips



Unit : mm

## HAKKO RED

SOLDERING IRON



- Ideal for use in a variety of soldering works like hobbies, repairing electric household appliances.
- 20W-40W ...  
Circuit Boards, small electrical parts, etc.
- 60W ...  
Connectors, heavier wiring connections, etc.

### Specifications

Model No.	500	501	502	503
Power Consumption	20W	30W	40W	60W
Standard Tip	BB3 (ø3mm)	BB4 (ø4mm)	BB6 (ø6mm)	
Heating Element	Nichrome Heater			
Total Length (w/o cord)	197mm	205mm	238mm	
Weight (w/o cord)	40g		70g	

### Recommended Iron Holders



No.602



No.603

### Replacement Tips

Part No.	Name/Description
BB3	Black tip ø3mm
BB4	Black tip ø4mm
BB6	Black tip ø6mm

## HAKKO FX-901

CORDLESS IRON



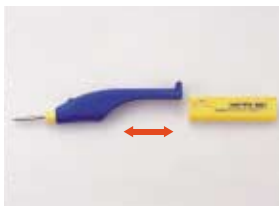
- Various soldering application is available such as hobby, field service and repair.
- Quick & Easy tip replacement.
- Various types of batteries are available such as Alkaline Battery, Nickel-Cadmium Battery, and Nickel-Hydrogen Battery.

### Specifications

Model No.	FX-901
Power Supply	"AA" x 4 pcs.
Continuous Operating Time	Alkaline Batteries: Approx. 60 min. Nickel-Hydrogen Batteries (2150mAh): Approx. 120 min.
Power Consumption	Alkaline Batteries: 6V (6W) Nickel-Hydrogen Batteries (2150mAh): 4.8V (5W)
Standard Tip	T11-B (Shape-B)
Weight (w/o battery)	76g
Total Length (w/o cap)	212mm

\* Measurement conditions  
When using new batteries. Serviceable time varies depending on battery type.  
When the tip temperature is maintained at 300°C or higher.  
The operation time was started to measure immediately after powered on.  
\* When using the batteries except specified above, performance and hours vary.

### Battery: Selective & Cartridge



### Packing List

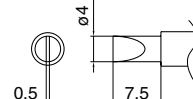
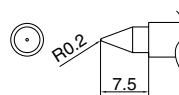
Model Name	Contents
HAKKO FX-901	Cordless iron .....1 Cap .....1

\* Battery is not included.

### Replacement Tips

Unit : mm

T11-B Shape-B T11-D4 Shape-4D



## HAKKO MG

SOLDERING GUN



- Trigger operation for easy one-hand soldering.
- Quick solder wire replacement with a simple upward push of the trigger.
- Solder feed control for precise adjustment of the amount of solder wire feed to the tip.  
<Min: 3mm Max: 8mm>
- Simple heating element replacement procedure requires no special skills.

### Specifications

Model No.	582	583	585	587	589	592
Power Consumption	30W	40W	60W	80W	100W	150W
Standard Tip	582-T-4 (ø4mm)	585-T-6 (ø6mm)	587-T-8 (ø8mm)	592-T-10 (ø10mm)		
Packed in Guide Nozzle	582-N-1.6 & 582-N-2.3					
Heating Element	Nichrome Heater					
Dimensions (W) x (H)	197 x 149mm	213 x 149mm	227 x 149mm	241 x 149mm		
Weight (w/o cord)	266g	290g	318g	322g	380g	

### Replacement Tips

Part No.	Name/Description
582-T-4	Tip ø4mm
585-T-6	Tip ø6mm
587-T-8	Tip ø8mm
592-T-10	Tip ø10mm

### Optional Parts

Part No.	Name/Description
582-N-0.8	Guide nozzle/ø0.8mm
582-N-1.0	Guide nozzle/ø1.0mm
582-N-1.2	Guide nozzle/ø1.2mm
582-N-1.6	Guide nozzle/ø1.6mm
582-N-2.3	Guide nozzle/ø2.0-2.3mm
582-022	Spool holder <Core size 29mm x ø19mm>
607	Iron holder

### Recommended Iron Holder



No.607

### Spool Holder



No.582-022





- Easy one-hand soldering.
- Uniform soldering work.
- High-accuracy thermal control allows lead-free soldering.
- Thermal capacity can be selected according to the soldering applications.
- Space-saving design.

\* Setting example: HAKKO 958, HAKKO 937 and HAKKO 373.  
(HAKKO 937, HAKKO 373 and the iron holder are sold separately.)

## Combination Example

### Soldering gun

M type : HAKKO 958



L type : HAKKO 959



\* Select one.

### Soldering station

HAKKO 928



HAKKO 937



HAKKO 701



HAKKO 702B



\* Select one.

### Solder-feeding unit

HAKKO 373



Solder dia.  
adjustment ring



\* Select one.

### Option

Mounting plate No.B3270



\* For 937 only.

Iron holder No.C1437



\* Soldering gun is not included.

## Specifications

Model No.	958	959
Type	M	L
Power Consumption	50W (24V)	
Temperature Range	200-480°C	
Tip to Ground Resistance	< 2Ω	
Tip to Ground Potential	< 2mV (TYP.0.6mV)	
Heating Element	Ceramic Heater	
Standard Tip	Shape-B (No.900M-T-B)	Shape-B (No.900L-T-B)
Tube Unit	S: Applicable solder dia. (ø0.6~1.0mm) L: Applicable solder dia. (ø1.2~1.6mm)	
Guide Nozzle	ø0.6, 0.8, 1.0, 1.2, 1.6mm	
Usable Solder Dia.	ø0.6, 0.8, 1.0, 1.2, 1.6mm	
Cord	1.1m	
Dimensions (w/o cord)	170(W) x 180(H) x 23(D)mm	
Weight (w/o cord and tube unit)	177g	187g

## Packing List

Part No.	Contents
958-01	Soldering gun (HAKKO 958) .....1
	Guide nozzle .....3 (ø0.6mm-No.B2652, ø0.8mm-No.B2653, ø1.0mm-No.B2654)
	Tube unit S (No.B3268) .....1
958-02	Soldering gun (HAKKO 958) .....1
	Guide nozzle .....2 (ø1.2mm-No.B2656, ø1.6mm-No.B2655)
	Tube unit L (No.B3269) .....1
959-01	Soldering gun (HAKKO 959) .....1
	Guide nozzle .....3 (ø0.6mm-No.B2652, ø0.8mm-No.B2653, ø1.0mm-No.B2654)
	Tube unit S (No.B3268) .....1
959-02	Soldering gun (HAKKO 959) .....1
	Guide nozzle .....2 (ø1.2mm-No.B2656, ø1.6mm-No.B2655)
	Tube unit L (No.B3269) .....1

\* When ordering HAKKO 958 or 959, Please select the suitable model for your using solder wire diameter.

## Replacement Tips

Please refer to page 27.

# HAKKO 373 SELF FEEDER ESD SAFE



- Can be used with a wide range of Hakko brand soldering irons, permitting selection of the most appropriate iron for the task at hand. If you already own one of these compatible Hakko soldering irons, you won't need to buy another.
- ESD design helps protect electrically sensitive parts.
- Can be connected to simple soldering equipment by using a switching jack.
- Adjustable solder return function reduces waste, permits fully automatic soldering.

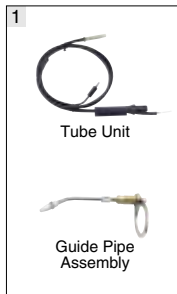
## Set Up



HAKKO 373



Solder Dia. Adjustment Ring



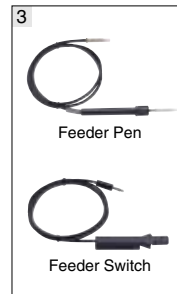
Tube Unit

Guide Pipe Assembly



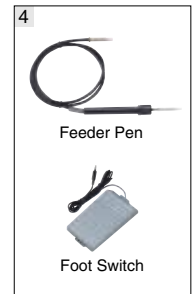
Tube Unit for MACH-I

Guide Pipe Assembly



Feeder Pen

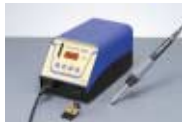
Feeder Switch



Feeder Pen

Foot Switch

## Compatible Soldering Iron



HAKKO FX-838 (Iron: FX-8301)



HAKKO FX-888



HAKKO FX-951



HAKKO FX-950



HAKKO FM-203



HAKKO 937\*



HAKKO 928\*



HAKKO MACH-I



HAKKO DASH



HAKKO 958 - 959

## Specifications

Model No.	373
Power Consumption	6W
Motor Output	DC 24V, 3.2W
Solder Feed Time	0-7sec. (Auto Mode)
Solder Feed Speed	4.5-26mm/sec.
Solder Feed Q'ty	0-182mm (Auto Mode)
Solder Return Q'ty	0-5mm
Usable Solder Dia.	ø0.6, 0.65, 0.8, 1.0, 1.2, 1.6mm*
Usable Solder	1kg roll bobbin (Max.)
Dimensions	107(W) x 110(H) x 215(D)mm
Weight (w/o cord)	1.5kg

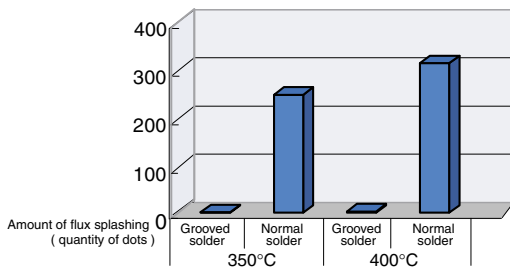
\* ø1.6mm "Lead-free solder" is not available for use.

\* 900S soldering iron is not compatible with HAKKO 373.



- Reducing flux splashing and solder balls generated during soldering operation.
- Compact design to save work bench.
- Can be installed to your solder reel stand.

### Effects of Using Cut Solder



• Test criteria  
Feed  $\phi 1.0 \times 500$  mm of lead-free solder (Sn-3Ag-0.5Cu) to one of our soldering irons, which has tip temperature setting at 350 and 400°C and measure the amount of flux splashing. The effects of flux splashing prevention may differ under different test criteria.

### Specifications

Model No.	375
Rating	DC24V 75mA
Motor rating	DC24V 130mA
Dimensions	76(W) x 96(H) x 50(D)mm
Weight (w/o cord)	590g

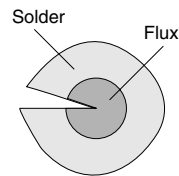
### AC adapter

Rating	DC24V 250mA
--------	-------------

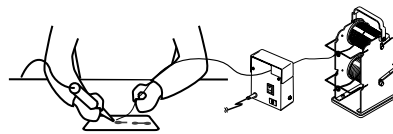
### Optional Parts

Part No.	Name
B1649	Foot switch
B2763	Hand switch

### Cross Section of Solder



### Set Up



### Packing List

Model Name	Contents
HAKKO 375	Unit .....1
	AC adapter .....1



No. B1649



No. B2763

# HAKKO FG-100

THERMOMETER



Enables you to perform temperature control surely and easily, which is essential during lead-free soldering.

- Suitable for Lead-Free solder:-  
Quick and accurate tip temperature measurement using a fine CA wire sensor (Dia.0.2mm)  
Disposable sensor always maintains accurate temperature measurement.  
Sensor has twice service life of conventional one.
- MAX HOLD function
- Auto shutoff function
- Compact size

### 3-Dimensional Measurement



Allows you to measure from any desired direction according to tip shape.

# HAKKO FG-101

SOLDERING TESTER



- Tip temperature, leak voltage and ground resistance of soldering irons can be measured.
- Soldering irons can be controlled based on the MIL-HDBK-263B standard.
- Soldering irons can be controlled based on the IPC J-STD.
- MAX HOLD function.
- Leak voltage and ground resistance can be easily measured.

### Specifications

HAKKO FG-100	
Resolution	1°C
Temperature measurement range	0-700°C
Applicable sensor	K (CA) type thermocouple
Measurement tolerance	±3°C (between 300 and 600°C)
Display	Besides measured temperatures, display indications include the following: Battery low alarm <sup>1</sup> Burnout alarm <sup>2</sup> MAX HOLD
Power Supply	006P 9V dry battery (alkaline cell recommended)
Outline dimensions	68(W) x 140(H) x 38(D)mm (excluding protrusions)
Weight	115g (excluding battery)
Ambient temperature/humidity range	0-40°C, 20-90%RH, without condensation
Environmental Condition	Applicable rated pollution degree 2 (According to IEC/UL61010-1)

<sup>1</sup> When appears, be sure to replace the battery. Failure to do so will result in incorrect temperature measurements.  
<sup>2</sup> This alarm indicates a sensor burnout. If this alarm occurs, replace the sensor.

HAKKO FG-101		
Temperature	Resolution	1°C
	Measurement Range	0-700°C*1
Voltage	Precision	±3°C (between 300 and 600°C) ±5°C (other than above)
	Sensor	K (CA) type thermocouple
Resistance	Resolution	0.1mV
	Measurement Range	0 to 40mV (AC)
Display	Precision	±(5% of reading + 1 digit)
	Resolution	0.1Ω
Power Consumption	Measurement Range	0 to 40Ω
	Precision	±(5% of reading + 1 digit)
Dimensions	LCD	3 1/2 digits
	Over Range <sup>2</sup>	
Weight	Burnout <sup>3</sup>	
	MAX HOLD	Shown as "MAX HOLD" in the lower right on the display
Ambient Temperature/Humidity Range	100V-2.6W, 110V-2.9W, 120V-2.6W, 220V-2.7W, 230V-2.8W, 240V-3.0W	
Environmental Condition	200(W) x 50(H) x 120(D)mm	
	1kg	
	0-40°C, 20-90%RH (Non condensing)	
	Applicable rated pollution degree 2 (According to IEC/UL61010-1)	

\*1 Temperature sensor (No.191-212) can only be used to measure temperatures below 500°C. To measure higher temperature, use an applicable temperature probe.  
\*2 An Over Range alarm occurs during temperature measurement when the temperature sensor is not attached, and during voltage and resistance measurement when the tip is not in contact with the conduction plate.  
\*3 When a sensor burns out, the same alarm symbol as the one for Over Range alarm is also displayed. If this alarm occurs, replace the sensor.

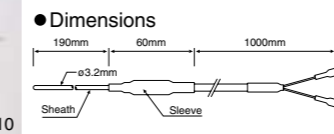
### Packing List

Model Name	Contents
HAKKO FG-100	Thermometer .....1
	006P 9V battery .....1
	Sensor .....10
HAKKO FG-101	Soldering tester.....1
	Fuse .....1
	Conduction wire .....1
	Multi-adapter .....1
	Ground clip .....1
	Power cord .....1
	Sensor .....10

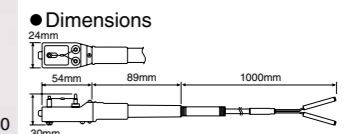
### Temperature Probe

For measuring the temperature of solder in pots, automatic solder machine and hot air.

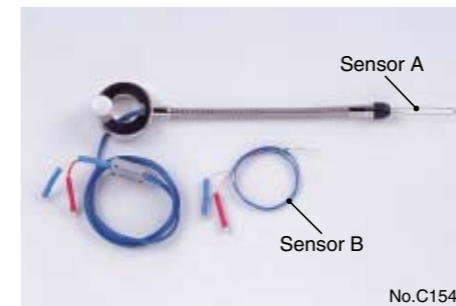
#### For Solder in Pots



#### For Automatic Solder Machine



#### For Hot Air

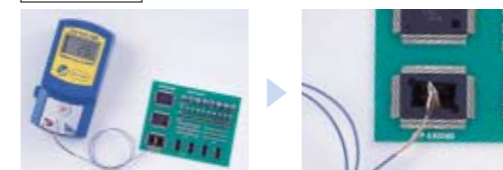


- Sensor A  
Sensor A is primarily used to measure the temperature of hot air.
- Sensor B  
Sensor B is primarily used to measure the temperature of works.

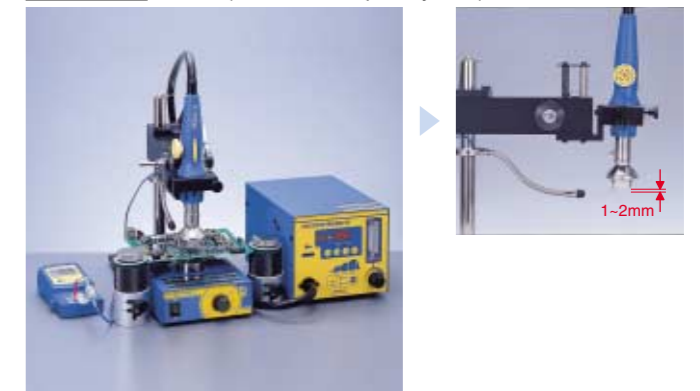
#### How to use 1 Hot Air (FR-803B)



#### How to use 3 Works



#### How to use 2 Hot Air (SMD-BGA Repair System)



# HAKKO FX-301B



LEAD FREE

Digital type

- Easy pot replacement.
- Selectable heating programs allows to get optimum temperature quickly.
- Select from four heating programs: Sn-Pb (Tin/Lead), Sn-Ag-Cu (Tin/Silver/Copper), Sn-Cu (Tin/Copper), and Sn (Tin).
- Special coating pot for long life as standard.
- Precise temperature control by digital temperature display & offset function.
- A timer function helps you keep tabs on how long the soldering pot has been in use, making it easy to judge the time for pot replacement.

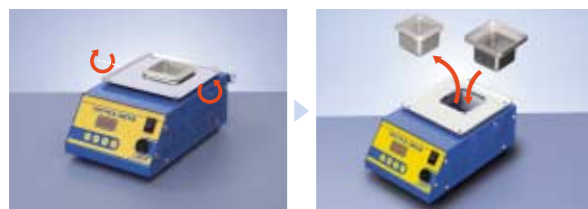
# HAKKO FX-300



Analog type

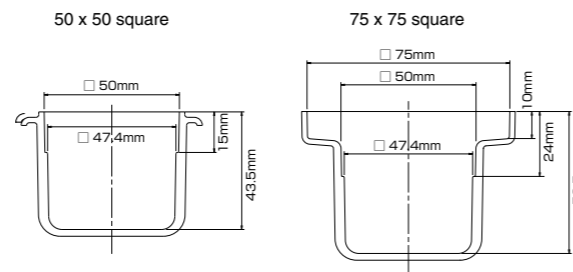
- Easy pot replacement.
  - Use different pots for different composition solder, or different pot sizes (50 mm square and 75 mm square) with the same unit.
- Special coating pot for long life. (Option)

### Easy Pot Replacement



Loosen the screws on both sides of the pot. Replace the pot and retighten the screws.

### Dimensions of Solder Pot



### Performance comparison table

	FX-300	FX-301B
Analog/Digital type	Analog	Digital
Parameter setting	×	○ Four heating programs
Offset function	×	○
Timer function	×	○
Standard pot/Special coating pot (50mm square and 75mm square)	○	○

### Specifications

Model No.	FX-301B	FX-300
Power Consumption	200W	195W
Weight (w/o solder & cord)	1.7kg	
Dimensions	143(W) x 100(H) x 220(D)mm	

### Soldering Pot

	50 x 50 Square	75 x 75 Square
Temperature Range	200-450°C	200-380°C
Dimensions	50(W) x 43.5(H) x 50(D)mm	75(W) x 52.5(H) x 75(D)mm
Molten Solder Capacity	0.85kg	1.2kg

\* Only a 50 x 50 square solder pot is included in this product.  
\* The 75 x 75 square solder pot is an optional part.

### Replacement and Optional Parts

Part No.	Name/Description
A1517	Solder pot/50 x 50mm
A1518	Solder pot/75 x 75mm
A1539*	Solder pot/50 x 50mm Special coating for long life
A1540*	Solder pot/75 x 75mm Special coating for long life

\* A special coating is applied to increase the corrosion resistance of the solder pot and provide extended life. The corrosion resistance test<sup>①</sup> shows that the life of this solder pot is more than 5 times longer compared to that of the standard pot. This pot is compatible with both lead-free and tin-lead soldering.

① The data are based on our comparison test. actual life varies depending on the use conditions.

### Packing List

Model Name	Contents
HAKKO FX-301B	Unit .....1
	Spatula .....1
	J-shaped waste collector .....1
	Hexagon wrench .....1
HAKKO FX-300	Unit .....1
	Spatula .....1
	J-shaped waste collector .....1
	Hexagon wrench .....1

### Temperature Probe

Part No.	Name/Description
A1310	Temperature probe for solder in pots



\* For further details, refer to page 39.

# HAKKO 96



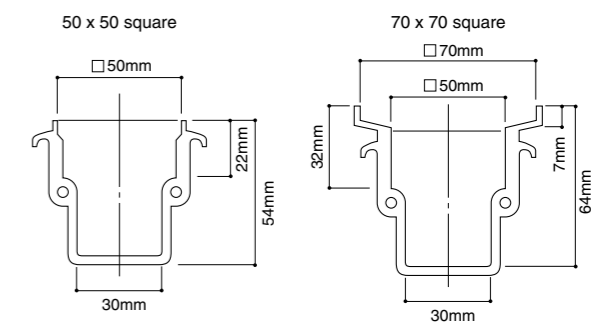
- Large-capacity solder pot holds a larger amount of solder, the solder temperature remains high even during continuous soldering operations.
- The stainless steel solder pot and other heavy-duty components offer greater durability, while the solder overflow prevention rim around the pot provides greater safety.
- The raised rim around the pot enhances soldering and desoldering efficiency.
- A waste collector adds a final touch of operating ease and efficiency.



### Specifications

Model No.	96	96-1
Power Consumption	200W	
Heating Element	Ceramic Heater	
Dimensions	135(W) x 107(H) x 222(D)mm	135(W) x 117(H) x 222(D)mm
Weight (w/o cord)	1.5kg	1.6kg
Temperature	100-450°C	100-380°C
Insulation Resistance	Over 100MΩ (250°C)	
Dimension of Solder Pot	50(W) x 54(H) x 50(D)mm	70(W) x 64(H) x 70(D)mm
Molten Solder Capacity	0.85kg	1.2kg

### Dimensions of Solder Pot



### Packing List

Model Name	Contents
HAKKO 96	Unit .....1
	Spatula .....1

## HAKKO 485

SOLDERING SYSTEM



- Compact and high performance soldering system developed for soldering and desoldering components and connectors mounted on circuit boards.
- The solder flow is both temperature controlled and time controlled.
- Many different nozzle sizes are available.
- Soldering and desoldering cycles are automatic and precise.
- A built-in locator light pinpoints the exact position for component placement.
- Solder remaining in the through hole is completely removed by utilizing the air unit.

### Operation



### Specifications

Model No.	485
Input Voltage	AC100V 50/60Hz
Power Consumption	850W
<b>Main Unit</b>	
Part No.	485-1
Room Temperature	-5~400°C
Temperature Range	Normal Temperature-229°C
Capacity of Solder Bath	10kg
Heating Element	800W (400W x 2)
Dimensions	500(W) x 245(H) x 550(D)mm
Weight (w/o cord)	35kg w/o Solder
<b>Air Unit</b>	
Part No.	486
Air Pressure	196-686kPa (2-7kgf/cm <sup>2</sup> )
Dimensions	150(W) x 100(H) x 300(D)mm
Weight (w/o cord)	3.5kg

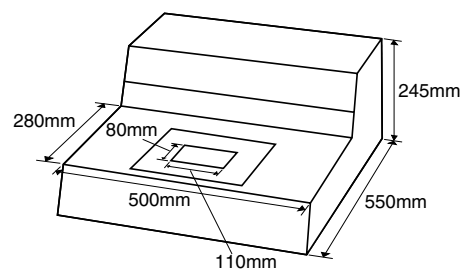
### Replacement Parts

Nozzle		Air Hood	
Unit : mm		Unit : mm	
Part No.	Inner Dia.	Part No.	Inner Dia.
485-N-01	21 x 11	485-28	21 x 10
485-N-02	26 x 11	485-29	25 x 10
485-N-03	38 x 18	485-30	34 x 17
485-N-04	54 x 19	485-31	52 x 17
485-N-11	55 x 7	485-32	51 x 7
485-N-12	68 x 7	485-33	64 x 7
485-N-13	81 x 7	485-34	77 x 7
485-N-14	30 x 30	485-35	30 x 30
485-N-15	50 x 50	485-36	50 x 50
485-N-16	11 x 21 Cross		
485-N-17	11 x 26 Cross		
485-N-18	18 x 38 Cross		
485-N-19	19 x 54 Cross		

### Packing List

Model Name	Contents
HAKKO 485	Main unit (No.485-1) .....1
	Air Unit (No.486) .....1
	Nozzle (No.485-N-01-04) .....1 each
	Air hood (No.485-28-31) .....1 each
	IC tweezers .....1
	Anti-oxidizer .....1
	Spatula .....1
	Lamp (6V-10V) .....1
	Horizontal gauge .....1
	Positioning board .....1
	Waste collector .....1
	Locator light .....1
	Foot switch .....1

### Dimensions



## HAKKO FT-710 TIP CLEANER ESD SAFE



- Prevents from solder splashing and tip oxidation.
- Compatible with various HAKKO soldering irons and tips.
- Controls the amount of solder to be left on tips.
- Minimizes the drop of tip temperature
- Easy to maintain
- ESD safe (A ground wire is not included)
- Silent design

### Solder-splashing prevention

The encapsulated design prevents solder from splashing during tip cleaning, which could become a significant cause of failure.



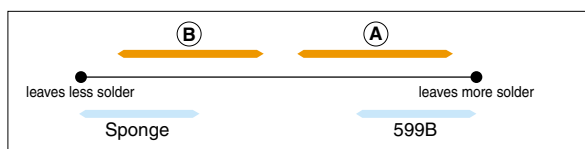
Because the housing is encapsulated, solder does not splash.

### Controllable degree of solder removal

Two types of cleaning brushes are available. Selection of brushes can control the amount of solder to be left.

Brush	Cleaning brush A (Standard accessory)	Cleaning brush B (Optional)
Material	Resin	Metal
Image after cleaning	Solder slightly remains	Solder is fully removed
Benefit	Prevents tip from being oxidized and extends service life of tip	Suitable for soldering to a tiny section which requires control of solder amount

Combines the best properties of a cleaning sponge and cleaning wire (HAKKO 599B).



(A) : FT-710 with cleaning brush <A> (B) : FT-710 with cleaning brush <B>

### Packing List

Model Name	Contents
Hakko FT-710	HAKKO FT-710 (With cleaning brush A and solder waste collector) ...1
	Receptacle (No.3517, B3518) .....2
	Lock nut .....1
	AC adapter .....1
	Gauge .....1

### Compatible with various HAKKO soldering irons and tips

A suitable receptacle can be selected and the height can be adjusted according to the soldering iron and tip to be used.

#### Applicable table

Applicable tip	Receptacle A	Receptacle B	Receptacle C
T12, T11	○		
T18, 900M, T14		○	
T10, T20, T13, T17			○

\*This cleaner cannot be used for shape of 0.2JL, quad type, tunnel type, spatula type of the T12 series.

\*There are some tips with dimensions that cannot be adjusted with the standard receptacles. In this case, please consult with your nearby dealer or distributor.

### Easy to maintain

The metallic waste collector enables you to clean easily. In addition, the driving parts are isolated from other parts, which prevents solder waste from entering.



Remove the plug of the adapter.

Hold the cover and remove it from the base.

Pick up the waste collector from the base and throw away solder accumulated on the waste collector.

### Specifications

Model No.	HAKKO FT-710
Motor Rating	DC24V 50mA
Power Consumption	5W
Standby Power Consumption	0.6W
Dimensions	71(W) x 77(H) x 107(D)mm
Weight	450g
Brush Rotational Speed	2500rpm

#### AC adapter

Rating	DC24V 130mA
Dimensions	45(W) x 40(H) x 65(D)mm
Weight	0.25kg

### Replacement and Optional Parts

Part No.	Name/Description
A1566	Cleaning brush A/set of 2
A1567	Cleaning brush B/set of 2
B3520	Pulley belt
B3521	Solder waste collector
B3523	Lock nut
B3517	Receptacle A
B3518	Receptacle B
B3519	Receptacle C

# HAKKO FT-700 · HAKKOF S-100

TIP POLISHER

CHEMICAL PASTE



No. FT-700



No. FS-100

- Removes oxides without damaging the tip.
- Does not contain any diammonium phosphate, so it is safe to tip, P.W.B., operator and global environment.
- Energy-saving design consumes only 4.5W.



Before cleaning



After cleaning

### A simple procedure that's easy to learn.



1 Place the tip of the soldering iron onto the spinning brush of the tip polisher for several seconds to remove oxides.



2 Re-solder plating using chemical paste FS-100.  
\*There is another way to solder plating is that apply the using soldering wire to the tip.



3 Wipe the FS-100 remaining cleanly off the tip before start soldering work.



4 Apply and melt wire solder on the tip before start soldering work.

### Use the brush to remove tough oxide.

Use the accessory brush to remove tough oxides. The procedure is as follows: First, remove the oxide using the brush. Second, clean the tip using the tip polisher.



### Specifications

#### FT-700

Model No.	FT-700
Power Consumption	100V 3W, 110-120V 4.5W, 220-240V 4.5W
Dimensions	70(W) x 54(H) x 101(D)mm
Weight (w/o cord)	650g

#### FS-100

Model No.	FS-100
Amount	10g
Contents	Flux paste, tin
Dimensions	ø34 x 9(H)mm

### Packing List

Model Name	Contents
HAKKO FT-700	Tip polisher .....1
	Chemical paste .....1
	Brush .....1



# HAKKO IRON HOLDER



## Specifications

Model No.	Dimensions of Cleaner	Dimensions	Weight
599B*		ø70 x 71(H)mm	65g
602	65 x 45 x 15mm	92(W) x 108(D)mm	80g
603	70 x 70 x 15mm	82(W) x 95(D)mm	500g
606	65 x 45 x 15mm (w/Aluminum Case)	100(W) x 160(D)mm	310g
607	70 x 70 x 15mm	98(W) x 166(D)mm	600g
633-01	ø70 x 71(H)mm	84(W) x 186(D)mm	380g
633-02	ø70 x 15mm	84(W) x 186(D)mm	340g

### HAKKO 599B\*

- Replacement cartridge for HAKKO 633.
- No water required.
- Helps your lead-free solder application.

## HAKKO 611 ESD SAFE SOLDER REEL STAND



- ESD safe by design.
- Keep your bench neat.
- Draw out the solder wire smoothly.

## Specifications

Part No.	611-1	611-2
Dimensions	86(W) x 114(H) x 78(D)mm	87(W) x 200(H) x 141(D)mm
Shaft Dia.	ø15mm	
Usable Solder	1kg roll bobbin (Max.) x 1	1kg roll bobbin (Max.) x 2
Weight	550g	750g

# HAKKO FM-204 ESD SAFE

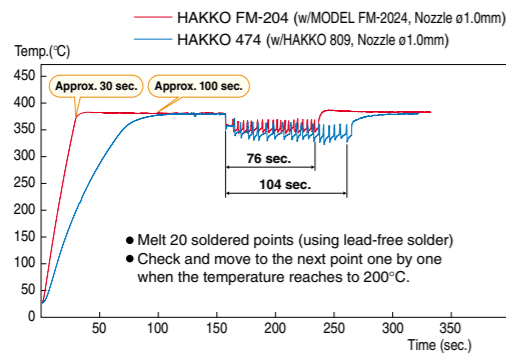


\*When the gun grip is detached

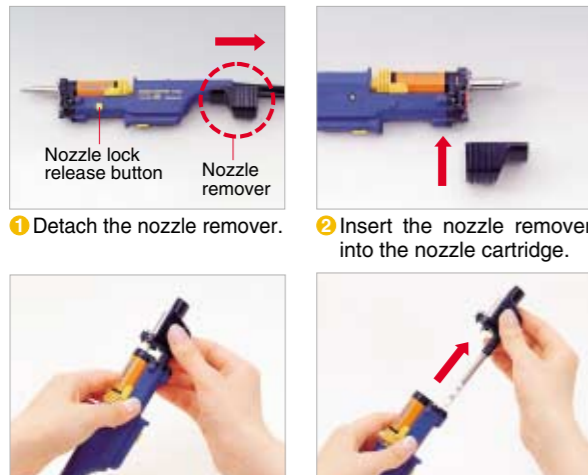
### Easier to use!

- **Excellent thermal recovery:-**  
The integrated nozzle contains both heater and sensor to provide more powerful thermal recovery than conventional tips.
- **New design with reduced distance between the nozzle end and filter pipe prevents clogging by sucked solder.**
- **Easy maintenance:-**  
Uses disposable paper filter pipes. Allows paper and solder to be disposed of separately. One-touch nozzle for replacement. Nozzle can be replaced safely with the provided nozzle remover.
- **Safe design:-**  
Equipped with a nozzle lock function. Inserting a nozzle into the grip automatically locks it in place and prevents the nozzle cartridge from being pulled out suddenly.
- **Sleep function**
- **Auto power shutoff function**
- **Detachable handle allows two-way use: gun type or straight type**

### Thermal Recovery Graph



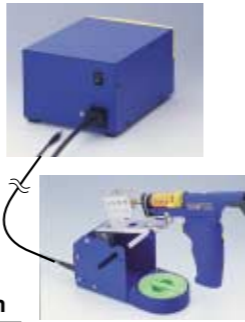
### Simple and Safe Nozzle Replacement



- 1 Detach the nozzle remover.
- 2 Insert the nozzle remover into the nozzle cartridge.
- 3 Press the nozzle lock release button on the back side.
- 4 Pull out the nozzle to replace.

### Sleep function

After the iron is inserted into the iron holder, the sleep function activates after a user-settable time (0 to 29 min.) and the tip temperature will decrease to approximately 200°C.



Connect the FM-204 station and FH-200 iron holder using a connecting cable.

### Auto power shut-off function

After 30 minutes have elapsed after inserting the iron into the iron holder, the auto power shut-off function activates and stops to apply power to the heating element.

\* It is necessary to change unit settings before using sleep and auto power shut-off functions.

### Specifications

HAKKO FM-204	
Power Consumption	120W
Temperature Range	200-450°C
Temperature Stability	±5°C at idle temperature
Station	
Output	24V
Dimensions	160(W) x 120(H) x 225(D)mm
Weight	3.7kg
Vacuum Generator	Vacuum pump, double cylinder type
Vacuum Pressure (Max.)	80kPa (600mmHg)
Suction Flow	15ℓ/min
MODEL FM-204 Desoldering Tool	
Power Consumption	70W (24V)
Temperature Range	350-450°C
Nozzle to Ground Resistance	< 2Ω
Nozzle to Ground Potential	< 2mV
Total Length (w/o cord)	180mm with ø1.0 nozzle
Weight (w/o cord & hose)	65g with ø1.0 nozzle
Cord	1.2m

### Replacement and Optional Parts

Part No.	Name/Description
FM204-02	MODEL FM-204 24V/70W
A1514	Ceramic paper filter/10 pcs
A1512	Front holder
A1511	Filter pipe assembly
B3253	Connecting cable
FM2027-03*	HAKKO FM-2027 Conversion kit
FM2026-04*	HAKKO FM-2026 Conversion kit

\* Iron holder (No.FH200-01) is included.

### Packing List

Model Name	Contents	
HAKKO FM-204	Station.....1	
	Desoldering tool (MODEL FM-204).....1	
	Control card.....1	
	Power cord.....1	
	Connecting cable.....1	
	Ceramic paper filter.....10	
	Filter pipe assembly (Originally equipped x 1, additional replacement x 1).....2	
	Handle (for gun configuration).....1	
	Nozzle remover.....1	
	Iron holder with 599B tip cleaner (No.FH200-05).....1	
	Cleaning drill.....1	
	* Nozzle is an optional part.	

### Increase your options

The FM-204 is a desoldering station as standard, but it can be operated with optional FM-2027 and FM-2026 soldering handpieces. A single station plays multiple roles: soldering and desoldering.

#### Soldering



HAKKO FM-2027

#### N<sub>2</sub> System



\* For further details, refer to page 18-21.

### Optional Nozzle

Unit : mm

Part No.	Nozzle	Part No.	Nozzle	Part No.	Nozzle	Part No.	Nozzle
N1-06	Nozzle 0.6mm	N1-08	Nozzle 0.8mm	N1-10	Nozzle 1.0mm	N1-13	Nozzle 1.3mm
N1-16	Nozzle 1.6mm	N1-20	Nozzle 2.0mm	N1-23	Nozzle 2.3mm	N1-L10	Nozzle 1.0mm Long



## HAKKO 484

DESOLDERING TOOL



- Complete with an inner pump, which can be easily carried. Therefore, suction work is possible anywhere that there is an electric source available.
- The nozzle and heating core have been specially designed so solder can be absorbed in the filter while it is still in the molten state. Consequently maintenance time has been reduced and work efficiency improved.
- To clean, simply pull the knob to remove the filter pipe. The filter pipe is made of heat-proof transparent glass, therefore the accu-

### Specifications

Model No.	484
Power Consumption	60W
<b>Station</b>	
Vacuum Generator	Double Cylinder Type
Vacuum Pressure (Max.)	80kPa (600mmHg)
Suction Flow	10/12ℓ/min (50/60Hz)
Motor Output	12W
Dimensions	135(W) x 75(H) x 180(D)mm
Weight (w/o cord)	2.5kg
<b>Desoldering Gun</b>	
Standard Nozzle	481-T-1.0 (ø1.0mm)
Heating Element	Ceramic Heater
Insulation Resistance	100MΩ
Weight (w/o cord & hose)	230g

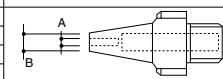
### Packing List

Model Name	Contents	
HAKKO 484	Station.....	1
	Desoldering gun.....	1
	Filter set.....	1
	Cleaning pin for heating core.....	1
	Cleaning pin for ø1.0mm nozzle.....	1
	Cleaning wrench.....	1
	Silicone grease.....	1
	Anti-seizure.....	1
	Iron holder.....	1

### Replacement Nozzles

Unit : mm

Part No.	A	B
481-T-0.8	0.8	2.5
481-T-1.0	1.0	2.5
481-T-1.3	1.3	2.5
481-T-1.6	1.6	3.0



## HAKKO 808

DESOLDERING TOOL



- The unique Hakko design places the pump and motor above, not inside the grip, so vibration is minimal and the grip is thin and easy to hold.
- The new, miniature, high-performance diaphragm pump is housed in the pump chamber at the rear of the unit. So, pump maintenance is quick and easy—simply remove the cover of the pump chamber.
- The optional carrying case makes it easy to transport the unit to wherever it is needed.

### Specifications

Model No.	808
Power Consumption	70W
Motor Output	6.5W
Temperature Range	380-480°C
Standard Nozzle	A1005 (ø1.0mm)
Nozzle to Ground Resistance	< 2Ω
Nozzle to Ground Potential	< 2mV
Vacuum Generator	Double-Cylinder Type
Vacuum Pressure	80kPa (600mmHg)
Suction Flow	10ℓ/min
Dimensions	235(W) x 170(H)mm
Weight (w/o cord)	420g

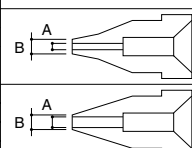
### Packing List

Model Name	Contents	
HAKKO 808	Desoldering gun.....	1
	Filter pipe with filter holder and pre-filter (Alum.).....	1
	Cleaning pin for nozzle ø1.0mm.....	1
	Cleaning pin for heating element.....	1
	Pre-filter (Alum.).....	3
	Ceramic paper filter (L).....	4
	Wrench.....	1

### Replacement Nozzles

Unit : mm

Part No.	A	B
A1002	0.8	1.8
A1003	1.0	2.0
A1004	0.8	2.3
A1005	1.0	2.5
A1006	1.3	3.0
A1007	1.6	3.0



### Carrying Case



No. C1099

### Iron Holder



No.C1100

# HAKKO SPPON

DESOLDERING TOOL



- Light weight and economical design.
- Powerful enough for both occasional and heavy duty desoldering applications efficiently.
- Unique cleaning shaft allows you to clean the nozzle quickly and easily.

## Specifications

Model No.	18	18G	20	20G
	---	w/guard	---	w/guard
Absorption Capacity	12cm <sup>3</sup> (12 c.c.)		20cm <sup>3</sup> (20 c.c.)	
Spare Nozzle				

# HAKKO WICK

DESOLDERING WIRE



- Regular Type
- Unflux Type
- No Clean Type

## Specifications

### Regular Type < Flux >

Part No.	Name/Description
FR100-00	HAKKO WICK <REGULAR> 1.5m x 0.6mm
FR100-01	HAKKO WICK <REGULAR> 1.5m x 0.9mm
FR100-02	HAKKO WICK <REGULAR> 1.5m x 1.4mm
FR100-03	HAKKO WICK <REGULAR> 1.5m x 1.9mm
FR100-04	HAKKO WICK <REGULAR> 1.5m x 2.5mm
FR100-05	HAKKO WICK <REGULAR> 1.5m x 3.3mm
87-2-30	HAKKO WICK <REGULAR> 30m x 1.5mm
87-3-30	HAKKO WICK <REGULAR> 30m x 2.0mm
87-4-30	HAKKO WICK <REGULAR> 30m x 2.5mm
87-4-100	HAKKO WICK <REGULAR> 100m x 2.5mm

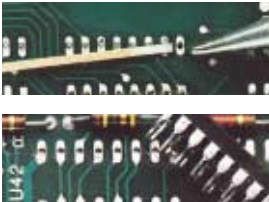
### Unflux Type < Unflux >

Part No.	Name/Description
FR110-00	HAKKO WICK <UNFLUXED> 1.5m x 0.6mm
FR110-02	HAKKO WICK <UNFLUXED> 1.5m x 1.4mm
FR110-03	HAKKO WICK <UNFLUXED> 1.5m x 1.9mm
FR110-04	HAKKO WICK <UNFLUXED> 1.5m x 2.5mm
FR110-05	HAKKO WICK <UNFLUXED> 1.5m x 3.3mm

### No Clean Type < No Clean Type >

Part No.	Name/Description
FR120-00	HAKKO WICK <NO CLEAN> 1.5m x 0.6mm
FR120-01	HAKKO WICK <NO CLEAN> 1.5m x 0.9mm
FR120-02	HAKKO WICK <NO CLEAN> 1.5m x 1.4mm
FR120-03	HAKKO WICK <NO CLEAN> 1.5m x 1.9mm
FR120-04	HAKKO WICK <NO CLEAN> 1.5m x 2.5mm
FR120-05	HAKKO WICK <NO CLEAN> 1.5m x 3.3mm

Removal for thru-hole...



Removal for bridging...



**HAKKO FR-801 FR-802 FR-803B** ESD SAFE LEAD FREE

For lead-free soldering with sufficiently high power HAKKO hot air lineup allows easier thermal control.



**HAKKO FR-801** ESD SAFE Analog

The air outlet is provided with new mechanism to reduce the temperature irregularity in hot air.

- The air outlet is provided with a new mechanism to reduce the temperature irregularity. Supplies hot air at a stable temperature.
- Comes with an airflow meter to allow more accurate and easier control of flow rate.



New mechanism to reduce temperature irregularity



**HAKKO FR-802** ESD SAFE Digital display

The digital thermal display allows easier temperature control.

- Comes with the offset function to compensate for difference of air outlet temperatures depending on the nozzle size.
- The power saving function (30 min./60 min./∞ can be selected) will automatically stop the hot airflow after a specific time passes.
- Comes with the auto cool-down function. If the power is turned off and then continues to supply air until the temperature in the nozzle pipe decreases down to 100°C to protect the heating element.
- Card lock function to lock the setting details.

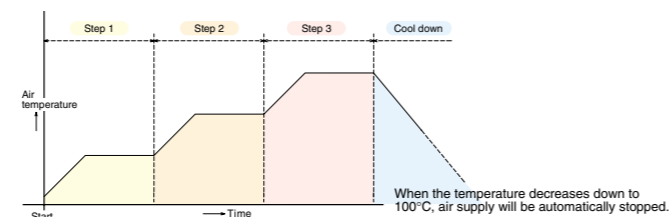


**HAKKO FR-803B** ESD SAFE Digital display with 50 memories/ 3 steps temperature profile

Preheating, main heating and cooling down 50 memories/3 steps temperature profile can be set.

- For more effective rework operation, it can be interfaced to the HAKKO FR-830.
- The heating conditions can be recreated due to the sensor feedback temperature control. 50 memories/3 steps temperature profile can be set, allowing easier control for temperature, flow rate and time. Highly accurate job can be standardized.
- The power saving function (30 min/60 min/∞ can be selected) will automatically stop the hot airflow after a specific time passes.
- Comes with an offset function.

**3 steps Temperature Profile**



3-step 'temperature and time' are pre-programmed. Sensor feedback temperature control is adopted.

**Performance comparison table**

		FR-801	FR-802	FR-803B
Basic Ability	<ul style="list-style-type: none"> <li>The air outlet is provided with new mechanism.</li> <li>Comes with an airflow meter.</li> <li>Space-saving design</li> <li>ESD safe by design</li> </ul>	○	○	○
		Digital Function	<ul style="list-style-type: none"> <li>Offset function</li> <li>Auto cool-down function</li> <li>Power-saving design</li> <li>Card-lock function</li> </ul>	○
Ideal Function	<ul style="list-style-type: none"> <li>3-step temperature profile can be set.</li> <li>Comes with a vacuum pipe.</li> </ul>			

**Specifications**

Model No.	FR-801	FR-802	FR-803B
Power Consumption	100V-310W, 110V-360W, 120V-430W, 220V-570W, 230V-630W, 240V-680W		
<b>Station</b>			
Model No.	FR-801	FR-802	FR-803B
Power Consumption	30W (Stand-by power consumption 100-120V 4W, 220-240V 7W)	30W (Stand-by power consumption 100-120V 4W, 220-240V 4W)	
Capacity (Air blow)	5-20 l/min. (Max.)		
Temperature Range	100-500°C (Use A1130)	100-500°C (Sensor)	
Modes	-	-	Manual/Auto
Timer	-	-	50 memories/3 steps temperature profile
Dimensions	160(W) x 145(H) x 230(D)mm		
Weight (w/o cord)	4kg	4.3kg	5kg
<b>Handpiece</b>			
Power Consumption	100V-280W, 110V-330W, 120V-400W, 220V-540W, 230V-600W, 240V-650W		
Total Length (w/o hose)	185(L)mm	200(L)mm	
Weight (w/o hose)	115g	200g	

**Packing List**

Model Name	Contents
HAKKO FR-801	Station .....1
	Handpiece .....1
	Power cord .....1
	Handpiece holder .....1
	FP pick-up .....1
	FP pick-up wire (S) .....1
HAKKO FR-802	Station .....1
	Handpiece .....1
	Power cord .....1
	Handpiece holder .....1
	Control card .....1
	FP pick-up .....1
HAKKO FR-803B	Station .....1
	Handpiece .....1
	Power cord .....1
	Handpiece holder .....1
	Control card .....1
	Vacuum pipe control knob (L) .....1
	Pad (ø3mm) .....2
	Pad (ø5mm) .....2
Pad (ø7.6mm) .....2	

**Optional Nozzles**

Please refer to page 54, 55.

**SMD-BGA Repair System**



Combination of HAKKO FR-803B and FR-830 allows the SMD and BGA rework equipment to set up at a lower price.

\* For further details, refer to page 56.

**Temperature Probe**

Part No.	Name/Description
C1541	Temperature probe for hot air

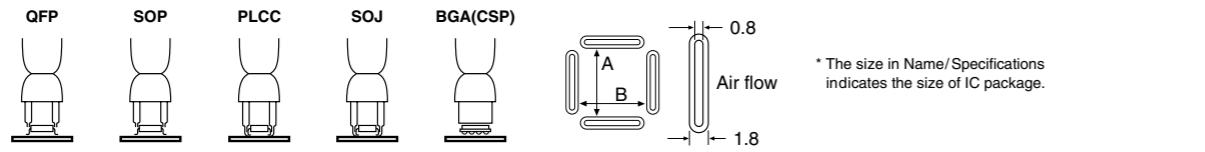


For measuring the temperature of hot air.

\* For further details, refer to page 39.

\* Nozzle is an optional part.

Optional Nozzles



Unit : mm

QFP	A1125B QFP 10 x 10	A1262B QFP 12 x 12	A1126B QFP 14 x 14
	A:10.2 B:10.2	A:12.2 B:12.2	A:15.2 B:15.2
	A1128B QFP 14 x 20	A1127B QFP 17.5 x 17.5	A1261B QFP 20 x 20
	A:15.2 B:21.2	A:19.2 B:19.2	A:20.2 B:20.2
	A1129B QFP 28 x 28	A1263B QFP 28 x 40	A1265B QFP 32 x 32
A:29.7 B:29.7	A:27.7 B:39.7	A:32.2 B:32.2	
A1203B QFP 35 x 35	A1264B QFP 40 x 40	A1215B QFP 42.5 x 42.5	
A:35.2 B:35.2	A:40.2 B:40.2	A:42.5 B:42.5	
A1180B BQFP 17 x 17	A1181B BQFP 19 x 19	A1182B BQFP 24 x 24	
A:18.2 B:18.2	A:19.2 B:19.2	A:24.2 B:24.2	
SOP TSOL	A1257B SOP 11 x 21	A1259B SOP 13 x 28	A1131* SOP 4.4 x 10
	11.7	13.5	4.8
	A1132* SOP 5.6 x 13	A1133* SOP 7.5 x 15	A1134* SOP 7.5 x 18
	5.7	7.2	7.2
	A1258B SOP 7.6 x 12.7	A1260B SOP 8.6 x 18	A1185B TSOL 13 x 10
8.2	8.7	11.9	
A1186B TSOL 18 x 10	A1187B TSOL 18.5 x 8		
18.2	18.5		

PLCC	A1140B PLCC 11.5 x 11.5 (28 Pins)	A1141B PLCC 11.5 x 14 (32 Pins)	A1139B PLCC 12.5 x 7.3 (18 Pins)
	A:13 B:13	A:15 B:13	A: 9 B:14
	A1135B PLCC 17.5 x 17.5 (44 Pins)	A1136B PLCC 20 x 20 (52 Pins)	A1137B PLCC 25 x 25 (68 Pins)
A:18.5 B:18.5	A:21 B:21	A:26 B:26	
A1138B PLCC 30 x 30 (84 Pins)	A1189B PLCC 34 x 34 (100 Pins)	A1188B PLCC 9 x 9 (20 Pins)	
A:31 B:31	A:36.5 B:36.5	A:11 B:11	
SOJ	A1214B SOJ 10 x 26	A1183* SOJ 15 x 8	A1184B SOJ 18 x 8
	12	8	10
	A1470 BGA 8 x 8	A1471 BGA 12 x 12	A1472 BGA 13 x 13
9	13	14	
BGA	A1473 BGA 15 x 15	A1474 BGA 18 x 18	A1475 BGA 27 x 27
	16	19	28
	A1476 BGA 35 x 35	A1477 BGA 38 x 38	A1478 BGA 40 x 40
36	39	41	
Single	A1124B* Single ø2.5	A1130* Single ø4.4	A1142B* Bent Single 1.5 x 3
	ø2.5(I.D)	ø4.4(I.D)	45° 1.5 (I.D) 3 (I.D)
	A1190* Dual Single 2.5 x 9.5	A1325* Dual Single ø 1.5 x 5-10 Adjustable Pitch	
ø2.5(I.D)	5 10 5 10 ø1.5 (I.D)		
A1191* SIP 25L	A1192* SIP 50L		
26	52.5		

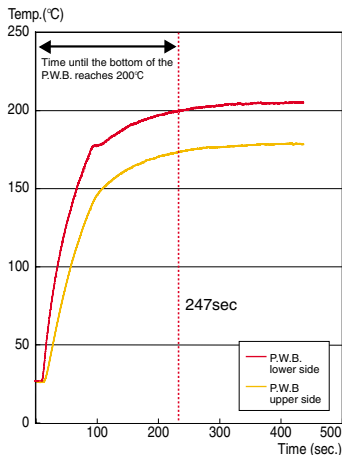
\* These nozzles are vacuum function inoperative. The vacuum function is not available in the FR-801 and the FR-802.

# HAKKO FR-830 PREHEATER ESD SAFE



- Safe design to protect the heating elements and P.W.B. of the unit
- Equipped with automatic cool-down function
- Space-saving compact design

## Temperature characteristics graph



### 【 Test criteria 】

- Setting temperature: 300°C
- Distance between air outlet and P.W.B.: 10mm
- Temperature measured using sensors mounted on both the top and bottom surfaces of the P.W.B.

With the FR-830, improvements in the air outlet structure enables heat to be applied more effectively than the previous model (FR-820), reducing the time needed to heat the P.W.B.

## Specifications

Power Consumption	100V-210W, 110V-240W, 120V-470W 220V-230W, 230V-250W, 240V-270W
Control Temperature	150-300°C (Above the hot air outlet)
Dimensions	140(W) x 75*(H) x 185(D)mm
Weight (w/o cord)	750g
Air Flow	0.15m <sup>3</sup> /min (fan capability)

\* Height (H) is the distance from the bottom of the foot to the top of the hot air outlet.

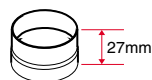
## Packing List

Model Name	Contents
HAKKO FR-830	Preheater .....1 Power cord .....1

## Extension pipe w/Lid



For local heating



No. B3263

## Hand switch



No. B2763

## Foot switch



No. B1649

# SMD-BGA Repair System



Setting example  
HAKKO FR-803B, HAKKO FR-830, Rework Fixture, Omnivise

- Combination of HAKKO FR-803B and FR-830 allows the SMD and BGA rework equipment to set up at a lower price.

## Rework Fixture



The rework fixture is compact and stable.  
Smooth vertical motion makes operation easy.

No. C1392B

## Omnivise



Hold boards easily, safety and securely. Unique design allows 360° use. Five(5) adjustable heights. Can accommodate any board size.

No. C1390C

## Nozzle Tray



Convenient storage for nozzles. Removal and installation slots make changing nozzles safe, fast and easy.

No. C1391B



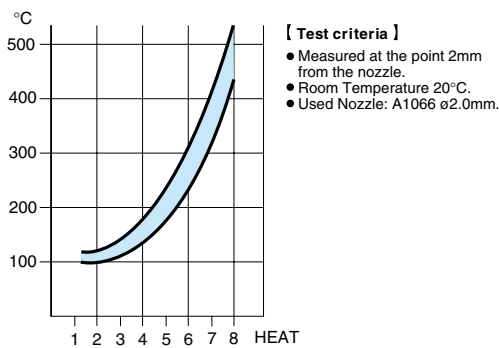


- Adjustable temperature control: 100-540°C.
- Air volume selector switch with ultra-light setting.
- ESD design and grounding measure to minimize damage from current leakage and electrostatic discharge.

### Applications

- Soldering and desoldering of small surface-mounted chip components.
- Shrinking tubing, heating tests and other local heating operations.

### Temperature Distribution Chart



### Specifications

Model No.	851
Power Consumption	85W

#### Station

Pump	Diaphragm Type
Capacity	6ℓ/min. (Max.)
Dimensions	167(W) x 101(H) x 182(D)mm
Weight (w/o cord)	1.8kg

#### Iron

Power Consumption	80W
Temperature Range	100-540°C
Standard Nozzle	A1066 (ø2.0mm)
Total Length (w/o hose)	217mm
Weight (w/o hose)	180g

### Packing List

Model Name	Contents
HAKKO 851	Station .....1
	Handpiece .....1
	Iron holder .....1

### Replacement Nozzles

Part No.	Name/Description
A1065	Nozzle ø1.5mm
A1066	Nozzle ø2.0mm
A1067	Nozzle ø3.0mm
A1147	Nozzle ø1.0mm

**HAKKO** MODEL **FM-2022**  
PARALLEL REMOVER

**ESD SAFE**

**HAKKO** MODEL **FM-2023**  
MINI PARALLEL REMOVER

**ESD SAFE**

**ESD SAFE**

**LEAD FREE**

**ESD SAFE**



No. MODEL FM-2022



No. MODEL FM-2023

- Unique parallel movement of tips allows easy removal.
- Direct heating prevents damage to neighboring sensitive components comparing with hot air.

#### FM-2022:-

- Can be used for chips and flat packages up to 25mm in size.

#### FM-2023:-

- Standard or reverse tweezers action can be selected with a switch lever.
- Equipped with a small ergonomic grip.

\* MODEL FM-2022, FM-2023 must be used with MODEL FM-202<sup>Ⓞ</sup> or FM-203. Please refer to page 14 about FM-203.

<sup>Ⓞ</sup> Discontinued product

### Specifications

Model No.	FM-2022	FM-2023
Power Consumption	140W (24V)	
Temperature Range	200-400°C	
Tip to Ground Resistance	< 2Ω	
Tip to Ground Potential	< 2mV	
Total Length (w/o cord & tip)	148mm with SOP 25L tip	117mm with I tip
Weight (w/o cord)	64g with SOP 25L tip	37g with I tip
Cord	1.2m	

### Replacement Tips

Please refer to page 17.

### Set Up



\* The MODEL FM-2022 and FM-2023 are not included with the FM-203 station.

### Packing List

Model Name	Contents
HAKKO MODEL FM-2022 (Conversion kit)	Parallel remover (MODEL FM-2022) .....1
	Iron holder with cleaning sponge (No.FH200-03) .....1
	Connecting cable .....1
	Heat resistant pad .....1
	* Tip is an optional part.
HAKKO MODEL FM-2023 (Conversion kit)	Mini parallel remover (MODEL FM-2023) .....1
	Tips (T9-I/2pcs of set) .....1
	Iron holder with cleaning sponge (No.FH200-04) .....1
	Connecting cable .....1
	Heat resistant pad .....1
Component bed .....1	

### Conversion Kit

FM-2022 Conversion Kit (No.FM2022-04)

FM-2023 Conversion Kit (No.FM2023-04)





- Available for your HAKKO 936, 937, 701, 702B, 928 stations.
- Direct heating; less influence upon surrounding components on crowded boards.
- Easy removes SMD chips and flat pack's up to 25mm.
- The collet allows easy replacement and alignment of the tips.

\* The HAKKO 950 is not included with the stations.

**Operation**      **Easy Replacement of Tip**      **Easy Alignment of Tip**      **Recommended Iron Holder**



No.C1313

**Specifications**

Output Voltage	AC 24V
Power Consumption	50W
Temperature Range	200-400°C
Standard Tip	A1378 (Chip 2L)
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV (Typ.0.6mV)
Heating Element	Ceramic Heater
Total Length (w/o cord)	186mm
Weight (w/o cord)	93g

**Packing List**

Model Name	Contents
HAKKO 950	SMD hot tweezers .....1
	Heat resistant pad .....1
	Tip alignment tool .....1

**Replacement Tips**

Unit : mm

	Part No.	Name	A(a)	T	H	Size A (a) x T (Thickness) x H (Height)
CHIP	A1379	Tip/Chip 1L	1.0	1.0	13.0	
	A1378	Tip/Chip 2L	2.0	1.0	13.0	
	A1388	Tip/Chip 0.5C	1.5(0.5)	1.0	13.0	
	A1389	Tip/Chip 0.5I	R0.25		18.5	
SOP	A1390	Tip/Chip 4L	4.0	1.0	8.0	
	A1391	Tip/Chip 6L	6.0	1.0	8.0	
	A1380	Tip/Chip 8L	8.0	1.0	8.0	
	A1381	Tip/Chip 10L	10.0	1.0	8.0	
	A1382	Tip/Chip 13L	13.0	1.0	8.0	
	A1392	Tip/Chip 15L	15.0	1.0	8.0	
	A1383	Tip/Chip 18L	18.0	1.0	8.0	
	A1384	Tip/Chip 20L	20.0	1.0	8.0	
	A1385	Tip/Chip 25L	25.0	1.0	8.0	



- The economical iron for desoldering flat packages.
- The answer to every professional engineering need.
- The ceramic heating element provides faster heat transmission and excellent insulation.



**Specifications**

Model No.	924
Power Consumption	55W
Heating Element	Ceramic Heater
Insulation Resistance	> 100mΩ
Total Length (w/o cord)	210mm
Weight (w/o cord)	60g

\* Tip is an optional part.

**Optional Tips**

Please refer to page 25 (for SMD Desoldering).



- The all-in-one systems for soldering and desoldering.
- ESD safe by design.
- Compact design for minimum use of bench space.

### Specifications

Model No.	701
Power Consumption	150W

#### Station

Soldering	Output Voltage	AC 24V
	Temperature Range	200-480°C
Desoldering	Output Voltage	AC 24V
	Vacuum Generator	Double Cylinder Type
	Vacuum Pressure	80kPa (600mmHg)
	Motor Output	12W
	Temperature Range	380-480°C
	Suction Flow	15ℓ/min
Dimensions	190(W) x 130(H) x 250(D)mm	
Weight (w/o cord)	5kg	

#### Soldering Iron

Model No.	907-ESD
Power Consumption	50W (24V)
Standard Tip	900M-T-B (Shape-B)
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Heating Element	Ceramic Heater
Total Length (w/o cord)	190mm
Weight (w/o cord)	44g

#### Desoldering Gun

Model No.	809
Power Consumption	50W (24V)
Standard Nozzle	A1003 (ø1.0mm S Type)
Heating Element	Ceramic Heater
Dimensions	135(W) x 174(H)mm
Weight (w/o cord)	200g

### Packing List

Model Name	Contents
HAKKO 701	Station .....1
	Soldering iron (907-ESD) .....1
	Desoldering gun (809) .....1
	Filter pipe .....1
	Cleaning pin for ø1.0mm nozzle .....1
	Cleaning pin for heating element .....1
	Cleaning drill for ø1.0mm nozzle .....1
	Ceramic paper filter (S) .....2
	Ceramic paper filter (L) .....4
	Spring filter .....3
	Silicone grease .....1
	Wrench .....1
	Iron holder for soldering iron (No.C1142) .....1
	Iron holder for desoldering gun (No.631-06) .....1

### Replacement Tips

Please refer to page 25 (for M-Type iron).

### Replacement Nozzles

Unit : mm

Part No.	A	B	
A1002	0.8	1.8	
A1003	1.0	2.0	
A1004	0.8	2.3	
A1005	1.0	2.5	
A1006	1.3	3.0	
A1007	1.6	3.0	



- Compact design for minimum use of bench space, incorporating : two soldering irons.  
desoldering gun.  
handpiece for hot-air SMD rework.
- Replacement tip/nozzle are available from Hakko's well-known series.
- ESD safe by design.

### Specifications

Model No.	702B
Power Consumption	500W

#### Station

Soldering	Output Voltage	AC 24V
	Temperature Range	200-480°C
Desoldering	Output Voltage	AC 24V
	Vacuum Generator	Double Cylinder Type
	Vacuum Pressure	80kPa (600mmHg)
	Suction Flow	15ℓ/min
SMD Rework	Temperature Range	380-480°C
	Input Voltage	AC 100, 110, 220-240V
	Pump	Diaphragm Pump
	Capacity	23ℓ/min (Max.)
Dimensions	360(W) x 266(H) x 150(D)mm	
Weight (w/o cord)	10kg	

#### Soldering Iron

Model No.	900S-ESD	907-ESD
Power Consumption	50W (24V)	
Tip to Ground Resistance	< 2Ω	
Tip to Ground Potential	< 2mV	
Heating Element	Ceramic Heater	
Standard Tip	900S-T-I (Shape-I)	900M-T-B (Shape-B)
Cord	1.2m	
Total Length (w/o cord)	176mm	190mm
Weight (w/o cord)	25g	44g

#### Desoldering Gun

Model No.	809
Power Consumption	50W (24V)
Nozzle to Ground Resistance	< 2Ω
Nozzle to Ground Potential	< 2mV
Standard Nozzle	A1003 (ø1.0mm S Type)
Dimensions	135(W) x 174(H)mm
Weight (w/o cord & hose)	200g

#### Handpiece for SMD Rework

Power Consumption	250W
Total Length (w/o cord)	196mm
Weight (w/o hose)	120g

### Packing List

Model Name	Contents
HAKKO 702B	Station .....1
	Soldering iron (900S-ESD, 907-ESD) .....2
	Desoldering gun (809) .....1
	Handpiece for SMD rework .....1
	Iron holder for soldering iron (No.C1141, No.C1142) .....2
	Iron holder for desoldering gun (No.631-06) .....1
	Handpiece holder .....1
	Nozzle tray .....1
	Filter pipe .....1
	Cleaning pin for ø1.0mm nozzle .....1
	Cleaning pin for heating element .....1
	Cleaning drill for ø1.0mm nozzle .....1
	Ceramic paper filter (S) .....2
	Ceramic paper filter (L) .....4
	Spring filter .....3
	Silicone grease .....1
	Wrench .....1
	FP pick-up .....1
	FP pick-up wire (S, L) .....2
	Nozzle for SMD rework handpiece (No.A1124B, A1128B) .....2

### Replacement Tips and Nozzles

- Soldering iron: Please refer to page 25.  
 Desoldering gun: Please refer to page 49.  
 Handpiece for SMD Rework: Please refer to page 54-55.

# HAKKO 490

SMOKE CLEANER



- Compact and noise free, making it perfect for low-noise environments and desktop use.
- Use compressed air - no power supply is necessary.

## Compatible Soldering Iron



HAKKO FX-888



HAKKO FX-950



HAKKO FX-951



HAKKO FM-203



HAKKO FX-838  
(Iron: FX-8301)



HAKKO 937\*  
(Iron: 907/908)



HAKKO 928\*  
(Iron: 900M/L)



HAKKO 933/934



HAKKO DASH



HAKKO 701\*  
(Iron: 907/908)



HAKKO 702B\*  
(Iron: 907/908)

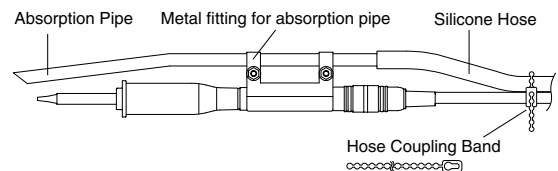
\* 900S soldering iron and desoldering gun are not compatible with HAKKO 490.

## Specifications

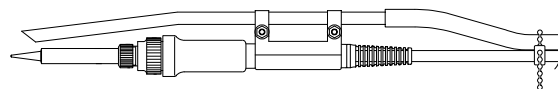
Model No.	490
Height	200mm
Diameter	120mm
Weight	1.5kg
Noise Level	39db
Working Pressure	4~7kgf/cm <sup>2</sup> (392~686kPa)
Air Consumption	40ℓ/min (5kgf/cm <sup>2</sup> )
Suction Flow	2.3ℓ/min (5kgf/cm <sup>2</sup> )

## Set Up

### ■ FM-2028, FM-2027



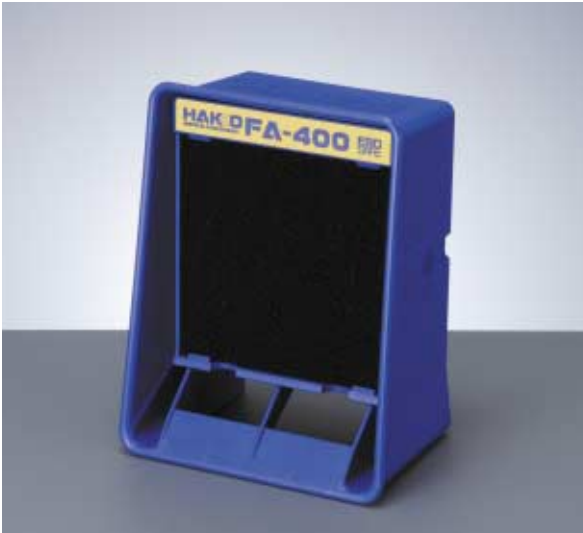
### ■ 917, 907, 908, 900M, 900L, 902, 933, 934, DASH



## Packing List

Model Name	Contents
HAKKO 490	Unit .....1
	Absorption pipe set (No.C1540) .....1

\* A second soldering iron can be attached to HAKKO 490 by purchasing an additional Absorption pipe set.



- Smoke absorber available to use in 2ways, "normal" and "face-down" position
- Space-saving compact design
- ESD safe by design
- Easy filter replacement



## Specifications

Model No.	HAKKO FA-400	
Power	50Hz	15W(100V) 18W(110V) 19W(220V) 22W(230V) 24W(240V)
Consumption	60Hz	13W(100V) 15W(110V) 16W(220V) 18W(230V) 19W(240V)
Airflow*	normal	1.0m <sup>3</sup> /min.(50Hz) 1.1m <sup>3</sup> /min.(60Hz)
	horizontal	0.4m <sup>3</sup> /min.(50Hz) 0.5m <sup>3</sup> /min.(60Hz)
Flow rate*	normal	1.0m/s(50Hz) 1.1m/s(60Hz)
	horizontal	2.6m/s(50Hz) 2.9m/s(60Hz)
Dimensions	166(W) x 212(H) x 113(D)mm	
Weight	930g	
Accessory	Filter(1pc)	

\*with filter

## Packing List

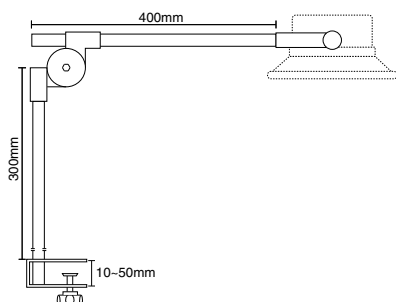
Model Name	Contents
HAKKO FA-400	Unit .....1
	Filter.....1

## Replacement Parts

Part No.	Name/Description
A1001	Filter set (5 pcs)

## Optional Attachment

Part No.	Name/Description
C1568	Arm stand w/knobs(set of 2,ESD)
B1166	Knob/set of 2,ESD



## User-Selectable Arrangement

In addition to horizontal and vertical installations, an optional arm stand allows use in suspended.



### Normal installation

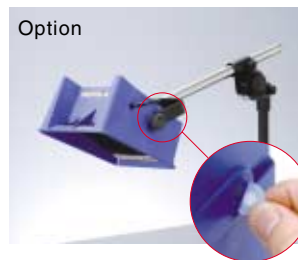
Wide-angle smoke absorption.



Flow rate  
Approx.2.5  
times faster

### Horizontal installation

Powerful absorption at closer area with high flow rate. Because of low height, it gives less shade keeping your working area light.



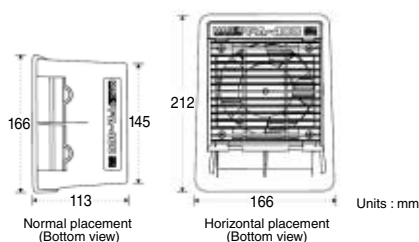
Option

### Suspended by Arm Stand

Convenient for approach from above or use in a limited space.

\*Arm stand is an optional part.  
\*The screw holes on FA-400 are covered by stickers.  
Peel off the stickers before mounting the absorber in the arm stand.

## Footprint



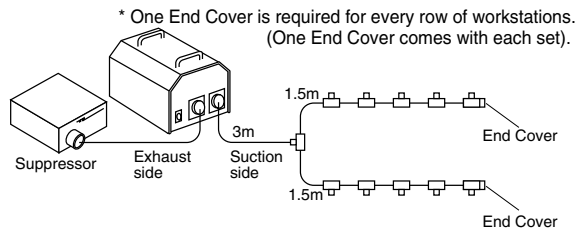
## HAKKO 494 SMOKE ABSORBER



- Compact, light weight design.
- Convenient operation-easy to install flexible ducts permit quick and simple system adoption to longer or relocated production lines.
- Highly efficient operation-fumes and flux are absorbed at their source and trapped by a double filter system.
- One HAKKO 494 system handles Max. 10 soldering irons.

### Examples of Installation

Parallel piping joint (No.B1246) permits a variety of piping layouts to be used.



### Specifications

Model No.	494	
Frequency	50Hz	60Hz
Power Consumption	150W	200W
Static Pressure	2.3kPa (240mm/Aq)	3.2kPa (325mm/Aq)
Absorption Capacity	1.56m <sup>3</sup> /min.	1.82m <sup>3</sup> /min.
Length of Duct (Inlet)	< 20m	
Length of Duct (Outlet)	< 5m	
Dimensions (w/o duct)	322(W) x 300(H) x 386(D)mm	
Weight (w/o cord & duct)	18kg	

\* Above Measurement Value: Unit only

### Optional Attachments

Part No.	Name/Description	Accessories
C1029	Absorption Pipe Set A for HAKKO DASH, 900M, 900L	Absorption pipe .....1 Silicone hose 1m .....1 Hose coupling band .....5 Metal fitting for absorption pipe ...1
C1030	Absorption Pipe Set B for HAKKO MACH-I (920-922)	
C1031	Absorption Pipe Set C for HAKKO MACH-I (918)	
C1033	Absorption Pipe Set E for HAKKO MG (except 150W)	
C1034	Absorption Pipe Set F for HAKKO 455	
C1035	Absorption Pipe Set G for HAKKO 456	
C1086	Absorption Pipe Set H for HAKKO 902, 904	
C1540	Absorption Pipe Set R*	

\* No.C1540 can be attached to: FM-2027, FM-2028, 917, 907, 908, 900M, 900L, 902, 933, 934, DASH.

### Packing List

Model Name	Contents
HAKKO 494	Unit .....1
	Absorption pipe set .....1
	Duct 3m .....1
	Filter case .....1
	Filter cap .....1
	End cover .....1
	Nylon strap .....2
	Main filter .....5
	Exhaust duct 5m .....1
	Pre-filter .....5
	Suppressor .....1
Inlet socket for smoke absorber .....1	

When ordering HAKKO 494, please specify the model number of soldering station/iron and q'ty to be used for additional parts arrangement.

### Duct Set

Part No.	Part Name	Contents
C1028	Duct Set	Filter cap .....1
		Pre-filter .....5
		Filter case .....1
		Duct 1.5m .....1
		Nylon strap .....2



# HAKKO FE-500

STATIC ELIMINATOR



**Safe and easily maintained portable static eliminator ±5V ion balance.**

- Safety functions
  - Fan motor rotation monitoring function (force detection)
  - High voltage output shutdown function (overload detection)
  - As soon as the fan guard is detached, the power supply is automatically shut off.
- The voltage will be neutralized within 5V in approximately 10 seconds.
- Multiple power supplies allow use in many places. (100V~240V)

### Specifications

Model No.	FE-500
Input Voltage	DC24V ± 5% 360mA
Output Voltage	AC3.5kV
Ion Balance	Factory adjusted to within ± 5V (at 300 mm from the front panel)
Airflow	1.5 to 3.0m <sup>3</sup> /min (variable)
Noise	52dB (A) With maximum wind volume
Ozone Production	0.03 ppm or less (at a point 300 mm from the outlet and aligned with the center of the outlet)
Maximum Allowable Ambient Temperature	40°C
Filter	Pre-filter level
Dimensions	140(W) x 190(H) x 81(D)mm
Weight (w/o AC Adapter)	1.4kg
AC Adapter Input	AC100-240V 50/60Hz 0.4A
Weight of AC Adapter (w/o cord)	135g

### Packing List

Model Name	Contents
HAKKO FE-500	Unit .....1
	Cover securing bracket .....1
	AC adapter .....1

### Replacement Parts

Part No.	Name/Description
A1525	Filter
B3120	Discharge electrode

### Easy Maintenance



Easy to clean



Easy to replace electrodes

### Optional Attachment

Part No.	Name/Description
C1023	Arm stand/1.8kg



### Check the ion balance



HAKKO FG-450 checks the ion balance status.

# HAKKO FG-450

STATIC LEVEL METER



- Two modes for measuring electric potential:
  - Electrostatic potential of object or human body
  - Ion balance of ionizer
- Adjusts zero point easily with just a single touch of a button.
- Battery indicator informs you the replacement timing of battery.
- Easy-to-see with large figures and color display.

## Specifications

Signal detection method	Oscillating chopper method
Display refresh frequency	0.5 seconds
Measurable potential range	Normal mode: 0.00 to ±19.99kV (resolution: 0.01kV)
	LB (Ion balance) mode: 0.000 to ±1.999kV (resolution: 0.001kV)
Measurement precision	±10% of reading ±2 digit
Continuous operating limit	Approximately 10 hours (with alkaline battery)
Measuring distance	30 mm (between object being measured and sensor)
Measuring distance adjustment	Red LED beam focusing method
Sensor head rotation angle	180° (stops every 45°)
Display	LCD display with built-in backlight
Polarity display	+ polarity / - polarity display
Mode switching	Switch modes by pressing MODE button
Battery check	Remaining charge displayed in display panel
Battery	DC9V alkaline rectangular dry cell battery 006P
Operating temperature/ humidity range	0 - +40°C, 20 - 70%RH, non-condensing
Dimensions	68 mm x 22 mm x 138 mm (W x D x H)
Weight	Approximately 160g (including battery)

## Packing List

Model No.	Contents	
HAKKO FG-450	Unit (With case) .....	1
	Grounding wire .....	1
	Strap .....	1
	Battery (DC9V alkaline rectangular dry cell battery 006P) *For trial* .....	1
	Ion Balance Plate (With screw) .....	1

## Replacement Parts

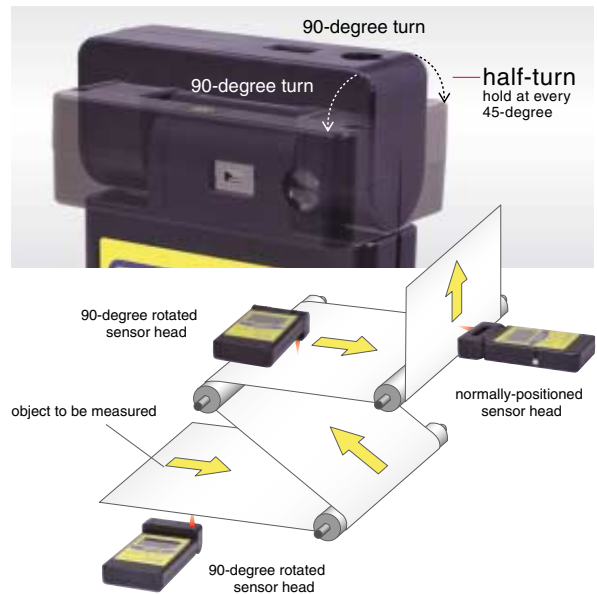
Part No.	Name/Description
B3584	Grounding wire
B3585	Ion balance plate

## Optional Parts

Part No.	Name/Description
B3586	Charging level measurement plate for body

## Rotary Sensor Head

Sensing area rotates and you can locate it at any position which allows easy readout under any situations as shown in the illustration.



## Measuring Method

Because the ion balance plate is supplied with the unit as the standard accessory, you can check ion balance quickly in addition to measuring electrostatic potential.



**Ion Balance Measurement**  
Ion balance can be measured in 1-V intervals.



**Electric Potential Measurement**



**Measuring Plate for electrostatic potential of the human body (option)**  
You can measure the electrostatic potential of the human body easily with the exclusive Measuring Plate.

## HAKKO 442B

WRIST STRAP



- Comfortable and light weight.
- Standard ground termination is alligator clip & w/banana plug.
- With adjustable wrist band.
- Available in blue color.

### Specifications

Part No.	442B-01	442B-02
Color	Blue	
Grounding Wire	1.5m	2.5m

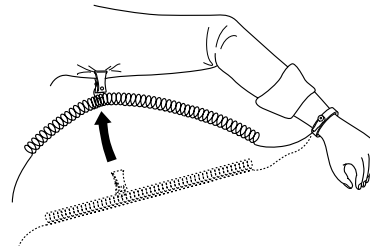
### Replacement Parts

Part No.	Name/Description
B2760	Strap
B2758	Grounding wire/1.5m
B2759	Grounding wire/2.5m

### Packing List

Model Name	Contents
HAKKO 442B	Wrist band .....1
	Grounding wire .....1
	Cord helper .....1

### How To Use The Cord Helper



## HAKKO 496

WRIST STRAP



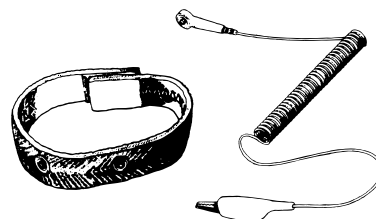
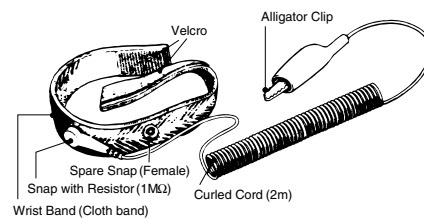
- Comfortable and light weight.
- Available in blue, wine and green color.
- 'Velcro' & 'Snap' help quick and easy adjusting.
- Standard ground termination is alligator clip.

### Specifications

Part No.	496B	496R	496G
Color	Blue	Wine	Green
Grounding Wire	2m		

### Replacement Parts

Part Name	Name/Description
496-1B	Wrist band <Blue>
496-1R	Wrist band <Wine>
496-1G	Wrist band <Green>
496-2B	Grounding wire <Blue>
496-2R	Grounding wire <Wine>
496-2G	Grounding wire <Green>



# HAKKO 498

SYSTEM TESTER



- Can be used anywhere quickly and easily to check a variety of grounding systems.
- Ensures employee's safety.
- Eliminates product defects caused by static electricity.



### Quickly and simply checks

Wrist straps and grounding wires.

The contact resistance between the wrist strap and the skin.

### Operation

Simply connect the grounding wire and press the pad.

If the grounding system is safe, the green 'GOOD' lamp will light up and an audible signal will be heard.

### Specifications

Model No.	498
Power Supply	9V Battery
Grounding Wire	2.5m
Operating Environment	0 to 40°C, 20 to 90%RH, no dew formation

LED Indication	Calibration Resistance	Buzzer
LOW (Red)	$R < 800K\Omega$	OFF
GOOD (Green)	$800K\Omega \leq R \leq 9M\Omega$	ON
HIGH (Red)	$R > 9M\Omega$	OFF

### Packing List

Model No.	Contents
HAKKO 498	Unit ..... 1
	Grounding wire ..... 1

## HAKKO HEATING GUN



No. 880B/881



No. 882

- Ideal for use in a variety of heating operations including drying paint, processing shrink films and shrink tubing, drying resin putty for sheet metal, repairing automobile urethane bumpers and applying long-length floor materials or vinyl moldings.
- Powerful heating for a wide range of work.
- Light weight, ergonomic design for easier handling and simpler operation.

### Specifications

Model No.	880B	881	882
Power Consumption	800W	1000W	
Maximum Temperature*	400°C	450°C	
Temp. Control Function	---	---	Room Temp. ~450°C
Air Velocity	330m/min.	360m/min.	
Air Flow	0.18m³/min.	0.2m³/min.	
Dimensions	245(W) x 185(H) x 70(D)mm		285(W) x 185(H) x 70(D)mm
Weight (w/o cord)	550g		700g

\* Max. Temp. is approximate one which measured at the point 10mm from the pipe.

### Compatibility Chart

The optional attachments that can be used depend on the model. Use the chart below to check for compatibility.

Model No.	880B	881	882
Part No.			
A1108			
A1109	○	○	○
A1110	○	○	○
A1111	○	○	○
*A1112		○	○
*A1113	○		
*A1114	○	○	○
B1419	○	○	
B1420			○

○ ... Usable

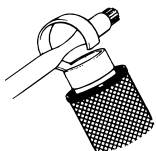
\* Indicate optional attachments that require the A1111 for use.

### Optional Parts & Operating Technique

(The temperature of No. 882 is at Temp. Control knob 6.)

#### No.A1109 Nozzle/Hook Type

Ideal for the circumference heating of shrink tubing, plastic shafting etc.



#### No.A1110 Nozzle/Spatula Type 62mm

Ideal for heating of large items like shrink film.

	880B	881.882
Temperature	350°C	400°C
Air Velocity	270m/min.	300m/min.

#### No.A1111 Nozzle Holder

Attach this nozzle according to drawing, and use for partial heating.

	880B	881.882
Temperature	450°C	500°C
Air Velocity	580m/min.	630m/min.

#### No.A1112 Nozzle

Insert this nozzle into No. A1111. Ideal for repairing carpet etc. where an adhesive agent is used.

	881.882
Temperature	550°C
Air Velocity	780m/min.

#### No.A1113 Nozzle/Single ø5

Insert this nozzle into No. A1111. Ideal for partial heating.

	880B
Temperature	550°C
Air Velocity	780m/min.

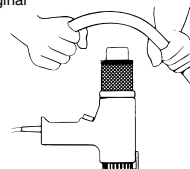
#### No.A1114 Nozzle/Spatula Type 20mm

Attach this nozzle on No. A1111. Ideal for adhesion of vinyl chloride sheet etc.

	880B	881.882
Temperature	450°C	500°C
Air Velocity	720m/min.	780m/min.

#### No.B1419 Stand No.B1420 Stand

For vertical operation. Remove original and attach.



# HAKKO MELTER



## Major Applications

### When using polyamide adhesives

- Reinforce and insulate soldered parts.
- Fasten capacitors, resistors, etc.
- Fasten jumper wires.
- Perform insulation potting for terminals.
- Fasten the ends of coils.
- Fasten deflecting yokes and variable coils.

### When using EVA adhesives

- Glue paper products. (cardboard boxes, gift boxes, etc.)
- Fasten wood products.
- Fasten plastics & metals.
- Fasten textiles and shock absorbent packing.
- Reseal products during packaging.

## Adhesive Used

This model has been designed for stick adhesives (those hardened into the shape of a stick) only. Be sure to use adhesives recommended by HAKKO. (No. 810: UL94V-O Recognized)

Part No.	810	811	812
Name	Polyamide	EVA	
Packing	1kg		14 pcs
Color	Yellowish-Brown	Milky-White	
Size	ø11.5 x 220mm		
Viscosity	2,300 cps. (2,300mPa·s)	5,800 cps. (5,800mPa·s)	
Open Time*	10 seconds	40 seconds	
Temperature at which adhesive is heat-resistant	100°C	55°C	
Suitability	P.W.B.	○	
	Wood	○	○
	Paper	○	○
	Metal	○	○
	Plastic	○	○
Packing	in aluminum foil bag	in polyethylene bag	in blister pack

Adhesives marked with ○ are more suited for that material than ○.

\* Application Period.

- Temperature control function enables use of polyamide adhesives that are ideal for use with electronic components.
- Superior thermal recovery makes the unit tough enough to handle several operations in succession.

## Specifications

Model No.	804
Power Consumption	100W
Standard Nozzle	A1083 (ø2.0mm)
Melting Temperature	100-200°C variable
Discharge Capacity	900g/hour
Dimensions	215(W) x 170(H) x 45(D)mm
Weight (w/o cord)	350g

## Packing List

Model No.	Contents
HAKKO 804	Unit .....1
	Stand assembly .....1
	Spanner(13, 14) .....2

## Replacement Nozzles

Unit : mm

Part No.	Name/Description	Diagram
A1088	Nozzle ø1.0mm	
A1086	Nozzle ø1.5mm	
A1083	Nozzle ø2.0mm	
A1089	Long nozzle ø1.0mm	
A1087	Long nozzle ø1.5mm	
A1084	Long nozzle ø2.0mm	

# HAKO CUTTING TOOL



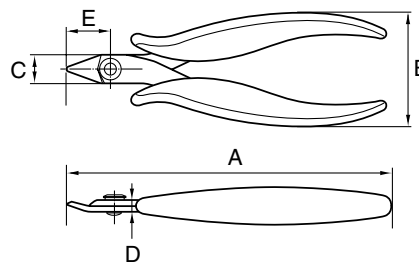
- Designed for precision assembly of delicate, complex electronic work.
- Soft-touch grip ensures long and comfortable work.
- Recommend to cut copper & soft lead wires.

## Specifications

Model No.	Name	Maximum cutting capability for copper wire
106-01	Flush Cut with Safety Clip	1.3mm
106-02	Flush Cut with Angled Blade	1.3mm
106-03	Flush Cut with Small Blade	0.8mm
106-04	For a Front, Flush Cut	1.0mm
106-05	Flush Cut	1.3mm
106-06	Short Nose Pliers	-
106-07	Long Nose Pliers	-
106-08	Bent Nose Pliers	-

Unit : mm

Model No.	A	B	C	D	E
106-01	132	54	13.5	5	20
106-02	129	54	13.5	5	16
106-03	130	54	9.5	4	18
106-04	138	54	14	6	27
106-05	132	54	13.5	5	20
106-06	140	54	13	6	29
106-07	154	54	13	6	40
106-08	146	54	13	4	35



**HAKKO 392** VACUUM PICK-UP **ESD SAFE**



- A built-in diaphragm pump eliminates the need for a separate air supply unit.
- Lifts objects weighting up to 120g.
- Pen, suction pads and air hoses are all made of anti-static materials for greater safety and reduced risk of damage to delicate parts.

**Easy To Set Up, Easy To Use**



1. Place the nozzle or pad on the object to be picked up.
2. Place a finger over the hole in the pen.  
A vacuum is instantly created and the resulting suction at the tip of the pen "holds" the object to the pen.
3. Now raise the pen and the object is lifted along with the pen.

**Specifications**

Model No.	392
Power Consumption	5W
Pump	Diaphragm Type
Maximum Pressure	37.3kPa (280mmHg)
Dimensions	Station : 132(W) x 83(H) x 170(D)mm
	Pen : 123(L) x 10 (outer dia.)mm
	Air Hose: 1100(L) x 6 (outer dia.)mm
Weight (w/o cord)	Station : 1.65kg
	Pen : 25g

**Vacuum Pickup Performance**

Nozzle/Pad	Maximum Item Weight	Applications
Bent Nozzle <0.4mm>	0.6g	Chip resistors and tiny components
Bent Nozzle <1.1mm>	2g	Small ICs (8~40 pins)
Bent Nozzle <1.1mm> + Pad <3mm>	20g	ICs (40 pins or greater)
Bent Nozzle <1.1mm> + Pad <7mm>	120g	Large electronic components, etc

**Packing List**

Model No.	Contents
HAKKO 392	Unit ..... 1
	Bent nozzle.....2 (Inner Dia. 0.4mm, 1.1mm)
	Pad .....2 (Outer Dia. 3mm, 7mm)



# HAKKO 394

VACUUM PICK-UP



- A built-in very small, but powerful pump eliminates the needs of power cord and air tube.
- Easy to handle for continuous pickup.
- Anti-static material are used.

## Service Life of Battery

Pickup repetition limit*1	Continuous pickup time*2
Approx. 30,000 pickup times (With alkaline batteries)	Approx. 15 hours

\*1 26mm x 26mm QFP is pickup for 2 seconds using a 10 mm dia. pad and then released for 1 second. This cycle is repeated continuously until the QFP is no longer picked up.

\*2 This is the time period from the moment 26mm x 26mm QFP starts being pickup using a 10 mm dia. pad to the moment the QFP drops.



Applicable for Chip Components  
(With A1164 Bent Nozzle)

## Specifications

Model No.	394
Power Supply	Alkaline Battery "AAA" x 2
Dimensions	130(L) x 22(W) x 29(H)mm
Weight (w/o batteries)	43g

## Replacement Parts

Part No.	Name/Description
A1164	Bent nozzle 0.4mm
A1165	Bent nozzle 1.1mm with stopper
A1198	Bent nozzle 0.26mm
A1486	Straight Nozzle 1.1mm with stopper
A1166	Pad 3mm
A1312	Pad 5mm
A1167	Pad 7mm
A1311	Pad 10mm

## Packing List

Model Name	Contents
HAKKO 394	Unit .....1
	Bent nozzle 1.1mm with stopper (No.A1165) .....1
	Pad 5mm (No.A1312) .....1
	Pad 10mm (No.A1311) .....1
	Alkaline battery "AAA" .....2

## Pickup Power

Part No.	Name/Description	Pickup Performance
A1166	Pad 3mm	6 gf
A1312	Pad 5mm	40 gf
A1167	Pad 7mm	80 gf
A1311	Pad 10mm	120 gf

\* The max. pickup performance shown above slightly differs depending on the surface of the object.

# HAKKO 153·154

LEAD FORMER



## Specifications

Part No.	153-1	154-1
Forming Size	5.6mm Pitch	5mm Pitch
Max. Diameter of Lead*	ø0.8mm	ø0.5mm
Compatible Taping Dimension	Outer Width of Tape	Max. 85mm
	Pitch	5mm
Dimensions	125(W) x 130(H) x 110(D)mm	
Weight	2kg	

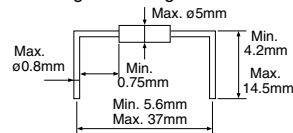
**CAUTION** \* For annealed copper lead only.

## Cutting and forming for tape-type axial components

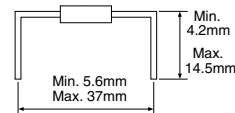
- Easy to use—simply set the taped components in place and turn the handle. Ideal for processing tape-type components.
- Improved, longer-life cutting blade for a clean, smooth cut.
- Sealed bearings for longer service life and greater durability and efficiency.
- Can be used for forming and cutting, forming only, or cutting only.

### HAKKO 153

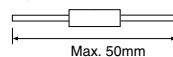
· Cutting & Forming



· Forming only

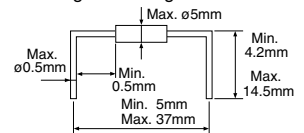


· Cutting only

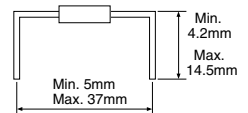


### HAKKO 154

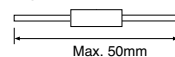
· Cutting & Forming



· Forming only



· Cutting only



# HAKKO 155

LEAD CUTTER



## Specifications

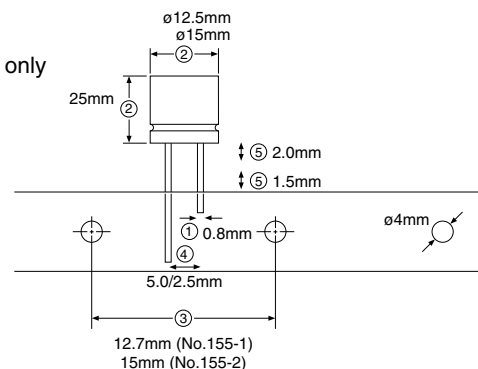
Part No.	155-1	155-2
① Max. Diameter of Lead Wire	ø0.8mm	
② Max. Processing Part Size	ø12.5mm~25mm	ø15mm~25mm
③ Feed Hole Pitch	12.7mm	15mm
④ Lead Pitch	2.5mm*, 5.0mm	5.0mm
⑤ Min. Processing Size	1.5mm from taping end	2.0mm from part end
Dimensions	125(W) x 110(H) x 140(D)mm	
Weight	1.7kg	

\* When processing a part with a lead pitch of 2.5mm, be sure to adjust the cutting wheel. Parts with a pitch of 2.5mm can be processed only on the No.155-1.

## Cutting for tape-type radial components

- Easy to use—simply set the taped components in place and turn the handle. The super-sharp, high quality cutting blade allows you to cut all types of tape-type radial parts, including resistors, capacitors, transistors, etc. cleanly and smoothly. Continuous operation ensures faster, more efficient processing.
- Sealed bearings make it long-lasting, durable and efficient.
- The compact design allows you to place it virtually anywhere.

· Cutting only



# HAKKO 152B

MOTOR DRIVE



\* Combination with HAKKO 153.  
\* The HAKKO 153 is not included with the HAKKO 152B.

## Specifications

Model No.	152B	
Rotary	28rpm (50Hz), 34rpm (60Hz)	
Max. Processing Capacity	36,000 pcs/hr (w/HAKKO 153. 154)	18,000 pcs/hr (w/HAKKO 155)
Dimensions	430(W) x 150(H) x 140(D)mm	
Weight (w/o cord)	5.6kg	

## Automatic cutting and forming

- Constant-torque drive ensures uniform processing quality.
- Processes up to 36,000 pieces per hour when used with the HAKKO 153.154, up to 18,000 pieces per hour with the HAKKO 155.
- Speed control knob permits adjustment of the processing speed.

# HAKKO DIPLINER

LEAD STRAIGHTENER



- Low-cost, high-performance tool for reforming IC and LSI leads.
- Speeds IC and LSI insertion.
- No more broken leads during IC and LSI insertion or transportation.
- Simply insert the IC case into the Dipliner chute, and the leads are protected right through circuit board insertion.
- Adjustable lead former fits all types, sizes and makes of ICs and LSIs.
- Simple mechanism for maintenance-free operation.

## Specifications

Model No.	Width of IC	Number of IC Leads
FT100	7.5mm	8, 14, 16, 18, 20
FT150	10mm	22
FT200	15mm	24, 28, 40, 42
FT300	19mm	64

# Hakko Global Network



## Global and Niche: The Hakko brand is much loved in more than 50 countries worldwide.

We have grown into a global brand. Currently, Hakko soldering irons and related equipment are desired in more than 50 countries in overseas markets. We have local corporations and sales representatives in various regions worldwide, and continue to expand our global network. Again, we believe that creative power stems from connections between the Hakko international groups. Hakko promises to fulfill our customers' needs with our global network of friendly relationships.



<http://www.hakko.com>

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