



HAKKO SOLDERING POT

No.96, No.96-1

Instruction Manual

Thank you for purchasing the HAKKO Soldering Pot.

The HAKKO Soldering Pot is temperature controlled soldering pot which incorporate ceramic heating element for high efficiency.

These models can be put to a wide range of uses including joining electrical wire ends, soldering and desoldering printed circuit board components and melting wax.

Safety Precautions

CAUTION

When the power is on, the solder bath and the unit can reach high temperatures. The temperature of the melted solder in the solder bath is approximately 450°C/842°F. **Mishandling may result in burns or fire.** Please make sure to comply with the following rules.

- Use this product only on highly stable metallic workbench. Never use it near paper or other flammable materials.
- Never put water in the solder bath as this will cause solder to spatter out of the solder bath.
- Turn the power off while taking breaks and when you are finished using the unit.
- Before changing parts or storing the unit, be sure to turn the power off and left the unit cool to room temperature.

Using the HAKKO Soldering Pot

1. Insert the power cord plug into a power outlet.
2. Cut the solder sticks into small pieces and put them in the solder bath.
3. Set the temperature referring to the following table.
4. Turn on the power switch.
5. When the solder has melted, check the level in the solder bath. If necessary add more solder to bring the level up to the required amount.
6. After confirming that solder is completely melted, check the temperature of the solder with a thermometer before beginning to use.

CAUTION

Oxide of the surface on the melted solder in the solder bath can affect the quality and efficiency of your soldering operations. Before beginning soldering operations, be sure to remove (with the attached spatula) all oxide from the solder bath.

Deposit onto J-shaped waste collector.

Temperature setting		
	96	96-1
1	100°C/212°F approx.	100°C/212°F approx.
2	140°C/284°F	140°C/284°F
3	280°C/536°F	250°C/482°F
4	350°C/662°F	300°C/572°F
5	400°C/752°F	340°C/644°F
6	450°C/842°F	380°C/716°F

Maintenance

The heating element and the solder bath are expendable. Replace them as follows.



WARNING

Remove the power cord from the power outlet and confirm that the unit is cool enough before replacing the heating element or solder bath.

Replacing the Heating Element

1. Remove 8 chassis screws at the both sides of the unit and the chassis.
2. Remove 2 heating elements from the inlets of heating element.
3. Slide the glass tube away, and remove 2 heating element securing screws.
Connect the new heating element and cover the connector with glass tube.
4. Insert the new heating elements into the inlets of heating element.
5. Reassemble in reverse order.

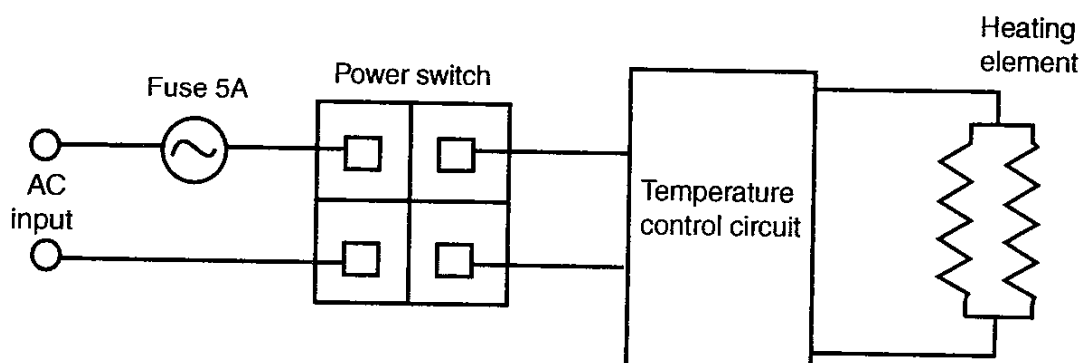
Replacing the Solder Bath

1. Remove the heating elements from the inlets of heating element.
(Refer to "Replacing the Heating Element")
2. Remove 4 solder bath support screws at the bottom of the unit, and lift out the solder bath.
3. Remove 2 solder bath screws and attach the new solder bath to the solder bath support.
4. Secure the new solder bath into the cover, facing the inlets of heating element to the heating element. Make sure to place the heating insulator between the cover and the solder bath support.
5. Reassemble in reverse order.

Specifications

No.		96	96-1
Power Consumption		200W	
Heating Element		100W ceramic heater X 2	
Temperature of Soldering Bath	(°C)	100~450	100~380
	(°F)	212~842	212~716
Insulating Resistance		Over 100MΩ (at 250°C/482°F)	
Dimension of Solder Bath(W×D×H)	(mm)	50×50×54	70×70×64
	(in.)	1.97×1.97×2.13	2.76×2.76×2.52
Bath Capacity	(kg/lb.)	0.85/1.8	1.2/2.6
Weight	(kg/lb.)	1.5/3.3	1.6/3.5
Outer Dimensions (W×D×H)	(mm)	135×224×105	135×224×120
	(in.)	5.31×8.82×4.13	5.31×8.82×4.72

Wiring Diagram



Replacement Parts

Part No.	Part Name	Specifications
96-HC	Heating Element for 96/96-1	200W
96-2	Solder Bath for 96	50×50×54/1.97×1.97×2.13
96-1-2	Solder Bath for 96-1	70×70×64/2.76×2.76×2.52
96-001	Spatula for 96/96-1	



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