

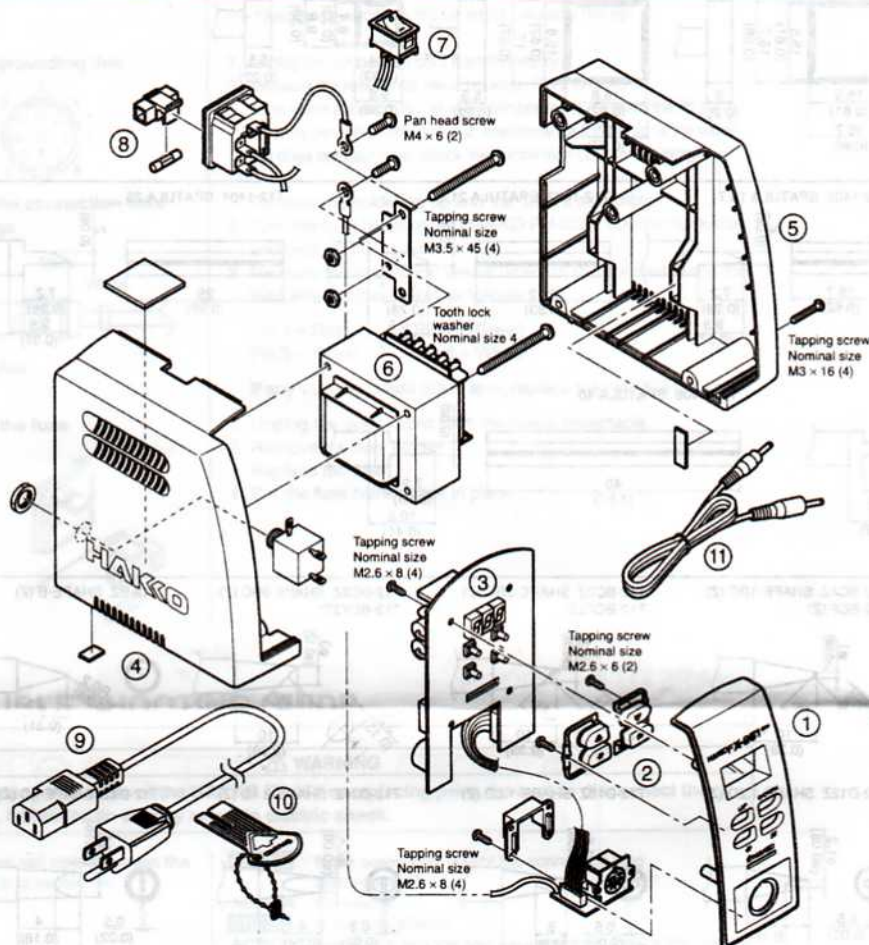
HAKKO FX-951

SOLDERING STATION

High-output, temperature controlled soldering station

Maintenance & Checking

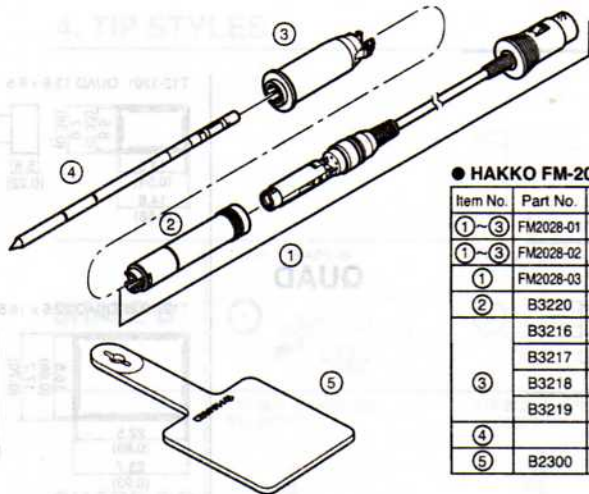
1. PARTS LIST



● HAKKO FX-951 Station

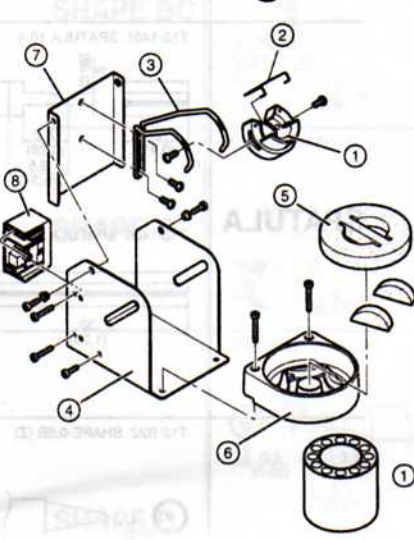
Item No.	Part No.	Part Name	Specifications
①	B2973	Front panel	
②	B2982	Button set	4 each
③	B3256	P.W.B./ temperature control	
④	B3255	Case/Left	With rubber foot and cushion
⑤	B2978	Case/Right	With rubber foot and cushion
⑥	B2979	Transformer	100V
	B2983	Transformer	110V
	B2836	Transformer	120V
	B2984	Transformer	220V
	B2985	Transformer	230V
	B3067	Transformer	240V
⑦	B2852	Power switch	

Item No.	Part No.	Part Name	Specifications	
⑧	B2403	Fuse/250V-2A	100-110V	
	B3011	Fuse/250V-2A	120V	
	B2987	Fuse/250V-1A	220-240V	
⑨	B2419	Power cord, 3 wired cord & American plug		
	B2421	Power cord, 3 wired cord but no plug		
	B2422	Power cord, 3 wired cord & BS plug	India	
	B2424	Power cord, 3 wired cord & European plug	220V KTL 230V CE	
	B2425	Power cord, 3 wired cord & BS plug	230V CE	
	B2436	Power cord, 3 wired cord & Chinese plug	China	
	B2426	Power cord, 3 wired cord & Australian plug		
	⑩	B2972	Control card	
	⑪	B3253	Connecting cable	



● HAKKO FM-2028

Item No.	Part No.	Part Name	Specifications
①-③	FM2028-01	HAKKO FM-2028	3 is yellow
①-③	FM2028-02	HAKKO FM-2028	3 is blue
①	FM2028-03	Connector assembly	
②	B3220	Connector cover	
③	B3216	Sleeve assembly	Yellow
	B3217	Sleeve assembly	Orange
	B3218	Sleeve assembly	Blue
	B3219	Sleeve assembly	Green
④		Tip	See back page.
⑤	B2300	Heat resistant pad	



● Iron Holder

Item No.	Part No.	Part Name	Specifications
①-③	FH200-02	Iron holder	With cleaning sponge

● Iron Holder Parts

Item No.	Part No.	Part Name	Specifications
①	B3001	Iron receptacle	Screws attached
②	B2791	Tip fixing spring	
③	B3248	Holder for iron receptacle	
④	B3251	Iron holder base	Rubber feet attached
⑤	A1536	Cleaning sponge	
⑥	B3249	Cleaner base	Rubber feet attached
⑦	B3250	Stay	
⑧	B3252	Switch case assembly	

● Optional Parts

Item No.	Part No.	Part Name	Specifications
①	B2756	Tip tray	

2. MAINTENANCE/CHECKING PROCEDURE

Performing proper and periodical maintenance extends the products life and contributes to use it always in a good condition. Efficient soldering depends upon the temperature, the quality and quantity of the solder and flux. Apply the following service procedure as dictated by the conditions of the usage.

⚠ WARNING

Since the soldering iron can reach a very high temperature, please work carefully. Except the case especially indicated, always turn the power switch OFF and disconnect the power plug before performing any maintenance procedure.

● Tip maintenance

1. Tip temperature

High temperatures shorten tip life and may cause thermal shock to components. Always use the lowest possible temperature when soldering. The excellent thermal recovery characteristics of the HAKKO FX-951 ensure effective soldering at low temperatures.

2. Cleaning

Always clean the soldering tip before use, to remove any residual solder or flux adhering to it. Use a clean and moist cleaning sponge No. A1536(Provided with the HAKKO FX-951) or the HAKKO 599B tip cleaner. Contaminants on the tip have many deleterious effects, including reduced heat conductivity, which contribute to poor soldering performance.

3. After use

Always clean the tip and coat it with fresh solder after use. This guards against oxidation.

4. When the unit is not being used and the auto power shutoff is not active.

Never allow the unit to idle at a high temperature for extended periods. This will allow the tip to become oxidized. Turn the power switch OFF. If it is to be out of service for several hours, it is advisable to pull the power plug as well.

5. Inspecting and cleaning the tip

This procedure, if followed daily, will materially add to tip life.

1. Set the temperature to 250°C. (482°F.)
2. When the temperature stabilizes, clean the tip (see 2, above) and check the condition of the tip. If the tip is badly worn or deformed, replace it.
3. If the solder plated part of the tip is covered with black oxide, apply fresh solder, containing flux, and clean the tip again. Repeat until all the oxide is removed, then coat the tip with fresh solder.
4. Turn the power OFF and remove the tip, using the heat resistant pad. Set the tip aside to cool.
5. Remaining oxides, such as the yellow discoloration on the tip shaft, can be removed with isopropyl alcohol.

⚠ CAUTION
NEVER file the tip to remove oxides!

