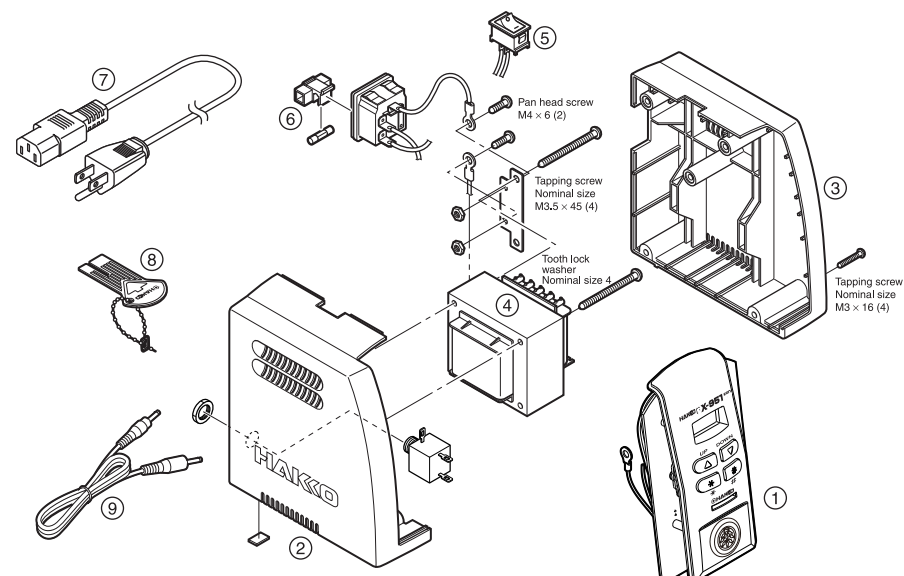


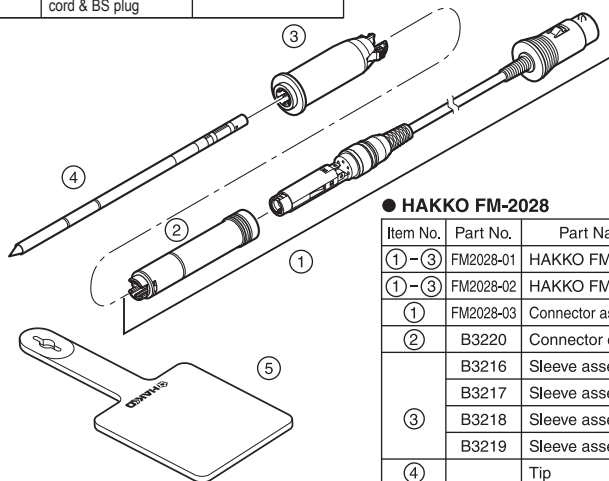
**1. PARTS LIST**



**● HAKKO FX-951 Station**

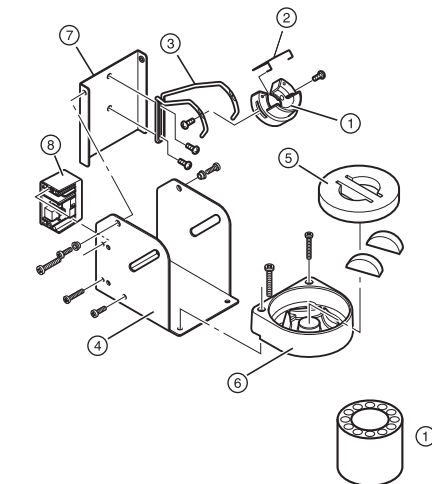
Item No.	Part No.	Part Name	Specifications
①	B3732	Front panel assy.	
②	B3255	Case/Left	With rubber feet
③	B2978	Case/Right	With rubber feet
④	B2979	Transformer	100V
	B2983	Transformer	110V
	B2836	Transformer	120V
	B2984	Transformer	220V
	B2985	Transformer	230V
	B3067	Transformer	240V
⑤	B2852	Power switch	
⑥	B2403	Fuse/250V-2A	100-110V
	B3011	Fuse/250V-2A	120V
	B2987	Fuse/250V-1A	220-240V
⑦	B2419	Power cord, 3-wire cord & American plug	120V USA
	B2421	Power cord, 3-wire cord but no plug	
	B2422	Power cord, 3-wire cord & BS plug	India

Item No.	Part No.	Part Name	Specifications
⑦	B2424	Power cord, 3-wire cord & European plug	220V KTL 230V CE
	B2425	Power cord, 3-wire cord & BS plug	230V CE
	B2436	Power cord, 3-wire cord & Chinese plug	China
	B2426	Power cord, 3-wire cord & Australian plug	
	B3508	Power cord, 3-wire cord & American plug	
	B3550	Power cord, 3-wire cord & SI plug	
	B3616	Power cord, 3-wire cord & BR plug	
⑧	B2972	Control card	
⑨	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
①-⑧	FH200-02	Iron holder	With cleaning sponge

**● Iron Holder Parts**

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

**● Optional Parts**

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

**2. PARAMETER SETTINGS**

The HAKKO FX-951 comes from the factory with the following values preset.

Parameter	Value
Temperature scale	Celsius
Power save	0 min.
Low temperature alarm setting	150°C
Resetting the supervisor or operator control setting	4 0
Setting temperature	350°C
Buzzer setting (C-E sound, S-E sound)	ON
Buzzer setting (Set temperature alert)	ON

**● Entering the parameter**

**1 °C or °F temperature display**

- Turn power OFF.
- Insert the control card into the card slot in the front of the unit.
- Press and hold down the  $\blacktriangle$  and  $\blacktriangledown$  buttons simultaneously, and then turn power ON.
- Hold  $\blacktriangle$  and  $\blacktriangledown$  buttons down until the display shows  $\text{[ } \text{C} \text{]}$  (Celsius) or  $\text{[ } \text{F} \text{]}$  (Fahrenheit).

When either the display shows either  $\text{[ } \text{C} \text{]}$  or  $\text{[ } \text{F} \text{]}$  the station is in parameter input mode.

- Pressing either the  $\blacktriangle$  and  $\blacktriangledown$  button will cause the display to alternate between  $\text{[ } \text{C} \text{]}$  or  $\text{[ } \text{F} \text{]}$ .
- When the desired scale is displayed, select by pressing the  $\text{[*]}$  button. The system will automatically sequence to power save mode.

**2 Power save setting**

Set the time from the placement of the soldering iron on the iron holder to the activation of the sleep function.

**NOTE:**  
When not using the power save function, do not connect the iron holder and the soldering station with the connecting cable.

**Power save example:**

- 2 0 Sleep (immediately after the soldering iron is placed on the iron holder)
- 2 10 Sleep (10 minutes after the soldering iron is placed on the iron holder)
- 2 30 Auto-power shutoff (30 minutes after the soldering iron is placed on the iron holder)

**NOTE:**  
The power save time can be set in steps of one minute (30 minutes max.)

- When the sleep function is activated, the temperature of the tip begins to drop.
- When the display shows  $\text{[ SLP]}$ , pressing any button the power will be turned on again.

**NOTE:**  
The sleep function does not work in case the setting temperature is less than 300°C/570°F.

- When the auto-power shutoff function is activated and power to the heater is shut off, the buzzer sounds three times.
- When the display shows  $\text{[ - -]}$ , and to begin soldering, cycle the power switch OFF, then ON.

**3 Resetting the low temperature alarm tolerance setting**

The unique function alerts the operator when the sensed temperature drops below a set limit. Should this occur, an error message will be displayed, and the buzzer will sound continuously. When the temperature returns within the allowable range, the buzzer will stop.

Range of allowable low temperature alarm tolerance  
for °C: 30 - 150°C  
for °F: 50 - 300°F

- When the station enters low-temperature alarm tolerance setting mode, the hundreds digit begins flashing. Enter and store the value in the same manner as described in "Changing the temperature setting."
- If you enter a value exceeding the allowable range shown to the left, you will be brought back to entering a value in the hundreds digit. If this occurs, reenter a correct value.
- Once the value is stored, the system will automatically sequence to resetting the supervisor/operator control setting mode.

**Example:**

When the setting temperature is 350°C and the low temperature alarm tolerance is 100°C, buzzer will sound when the tip temperature will drop over 250°C.

**4. Resetting the supervisor/operator control setting**

To change the supervisor/operator control settings, the procedure is as follows.

- The display will show  $\text{[ } \text{4 } \text{0]}$  or  $\text{[ } \text{4 } \text{1]}$  when this mode is entered.

$\text{[ } \text{4 } \text{0]}$  : No offset value can be entered without inserting the card.  
 $\text{[ } \text{4 } \text{1]}$  : An offset value can be entered without inserting the card.

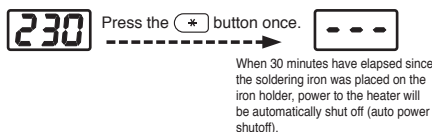
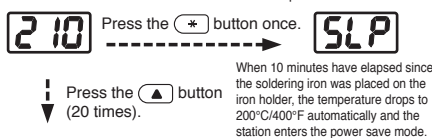
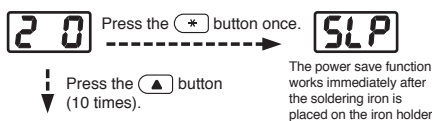
Pressing the  $\blacktriangle$  or  $\blacktriangledown$  button will change  $\text{[ } \text{4 } \text{0]}$  and  $\text{[ } \text{4 } \text{1]}$ .  
When the desired setting is displayed, select by pressing  $\text{[*]}$  button.

The HAKKO FX-951 has the following six parameters:

- °C or °F temperature display selection
- Power save
- Low temperature alarm setting
- Resetting the supervisor/operator control setting
- Buzzer setting (C-E sound, S-E sound)
- Buzzer setting (Set temperature alert)

Once the station enters parameter mode, set the parameters in the order shown below. After all the parameters have been set, normal operation will be resumed.

When the station enters the parameter input mode, the procedure is as follows.



**5. Buzzer setting (C-E sound, S-E sound)**

● In the buzzer sound setting mode, which sets whether to sound the buzzer when a sensor error or soldering iron error occurs,  $\text{[ } \text{5 } \text{0]}$  or  $\text{[ } \text{5 } \text{1]}$  is displayed.

$\text{[ } \text{5 } \text{0]}$  : The buzzer does not sound.  
 $\text{[ } \text{5 } \text{1]}$  : The buzzer sound

Select  $\blacktriangle$  or  $\blacktriangledown$  and press the  $\text{[*]}$  button.

**6. Buzzer setting (Set temperature alert)**

● In the buzzer sound setting mode, which sets whether to sound the buzzer when a sensor error or soldering iron error occurs,  $\text{[ } \text{6 } \text{0]}$  or  $\text{[ } \text{6 } \text{1]}$  is displayed.

$\text{[ } \text{6 } \text{0]}$  : The buzzer does not sound.  
 $\text{[ } \text{6 } \text{1]}$  : The buzzer sound

Select  $\blacktriangle$  or  $\blacktriangledown$  and press the  $\text{[*]}$  button.

The system will exit the parameter setting mode and begin heater control. It is now ready for normal operation.

**3. CHECKING PROCEDURE**

**⚠ WARNING**

Unless otherwise directed, carry out these procedures with the power switch OFF and the power UNPLUGGED.

**● Check for a broken heater or sensor**

- Check for a broken heater or sensor

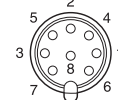
Measure the resistance across this position.



Verify the electrical integrity of the heater and sensor. Measure the resistance of the heater and sensor while at room temperature (15 to 25°C.; 59 to 77°F). It should be 8Ω ±10%. If the resistance exceeds these limits, replace the tip.

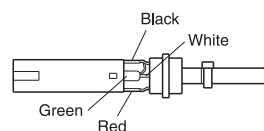
**● Check the grounding line**

- Unplug the connection cord from the station.
- Measure the resistance value between Pin 2 and the tip.
- If the value exceeds 2Ω (at room temperature), perform the tip maintenance described on section 2, maintenance for the tip. If the value still does not decrease, check the connection cord for breakage.



**● Checking the connection cord for breakage**

- Remove the soldering tip and the sleeve assembly.
- Turn the front piece of the HAKKO FM-2028 counterclockwise and remove the cover.
- Measure the resistance values between the connector and the lead wires at the socket as follows:



Pin 1 – Red Pin 2 – Green  
Pin 3 – Black Pin 5 – White

If any value exceeds 0Ω or is ∞, replace the HAKKO FM-2028.

**● Replacing the fuse**

- Unplug the power cord from the power receptacle.
- Remove the fuse holder.
- Replace the fuse.
- Put the fuse holder back in place.

**4. ERROR MESSAGES**

**● Sensor Error**



When there is the possibility that a failure has occurred in the sensor or heater (including the sensor circuit),  $\text{[ } \text{S-E]}$  is displayed and the power is shut down.

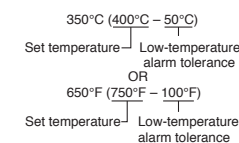
**⚠ CAUTION**  
The sensor error also occurs if the tip is not inserted properly.

**● Low-temperature alarm tolerance error**



If the sensor temperature falls below the difference between the current temperature setting and the low-temperature alarm tolerance,  $\text{[ } \text{H-E]}$  is displayed and the warning buzzer sounds. When the tip temperature rises to a value within the set tolerance, the buzzer will stop sounding.

**EXAMPLE:**



**● Heater terminal short-circuit error**



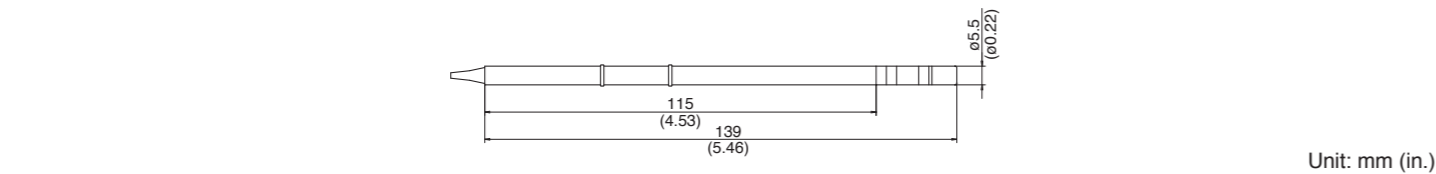
$\text{[ } \text{HSE]}$  will flash, and the buzzer will sound continuously, when the tip is inserted wrong way round, an incompatible tip is inserted, or a foreign object has found its way into the connector.

**● Soldering iron error**

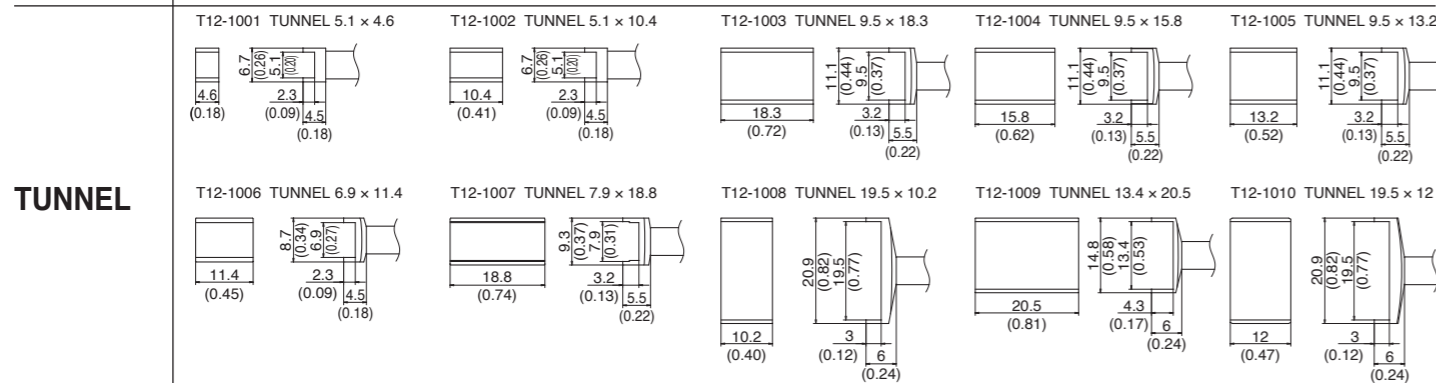
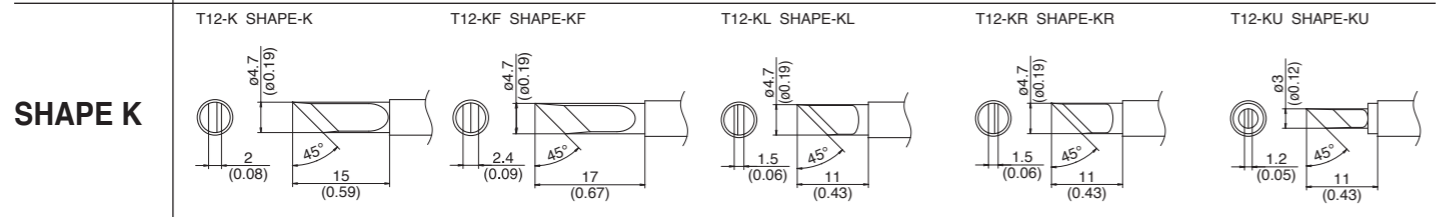
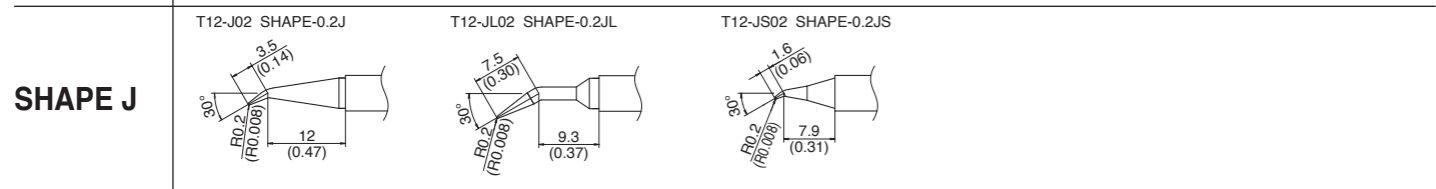
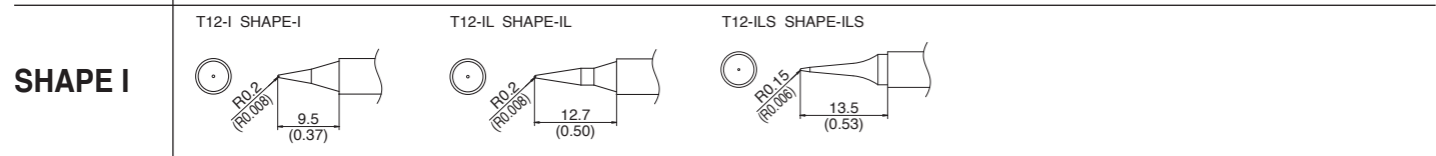
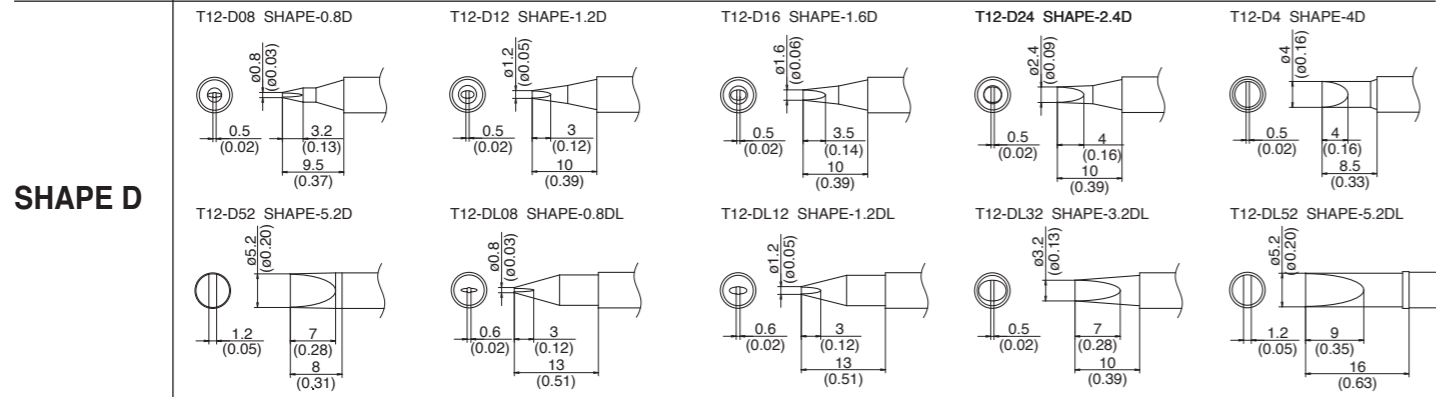
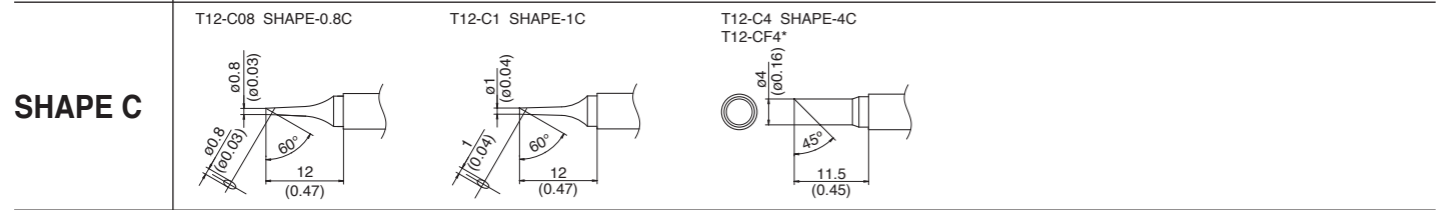
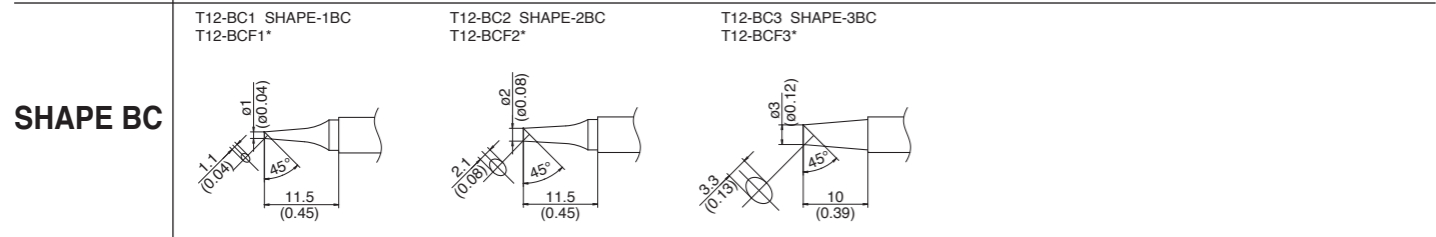
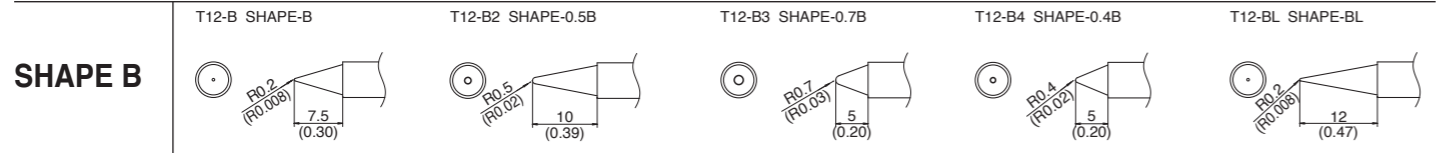


$\text{[ } \text{C-E]}$  will be displayed if the connector cord is not attached to the station OR the wrong soldering iron is connected.

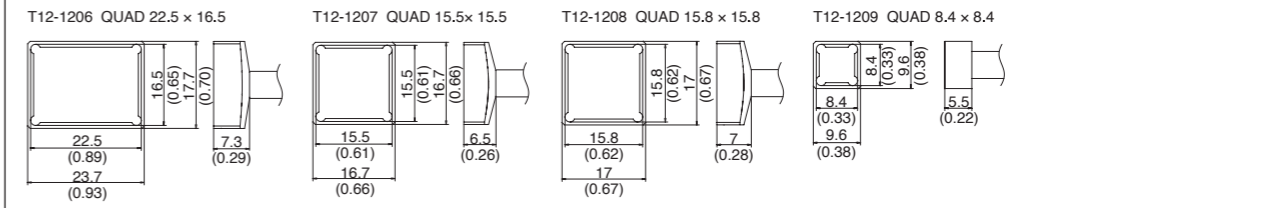
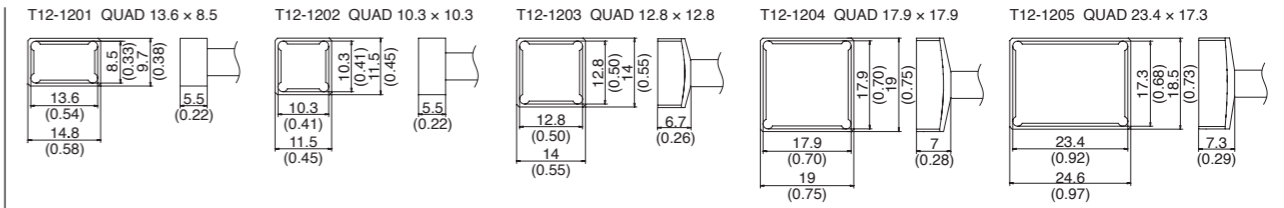
# 5. TIP STYLES



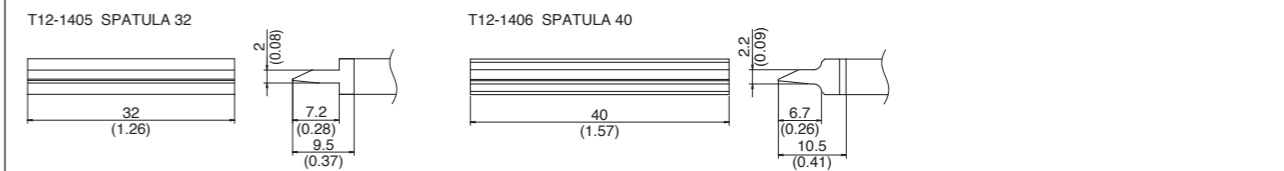
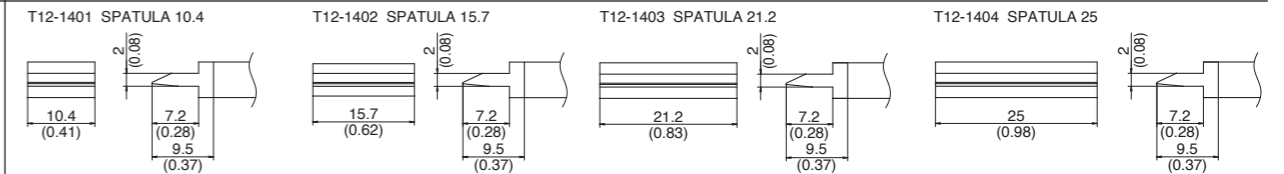
Unit: mm (in.)



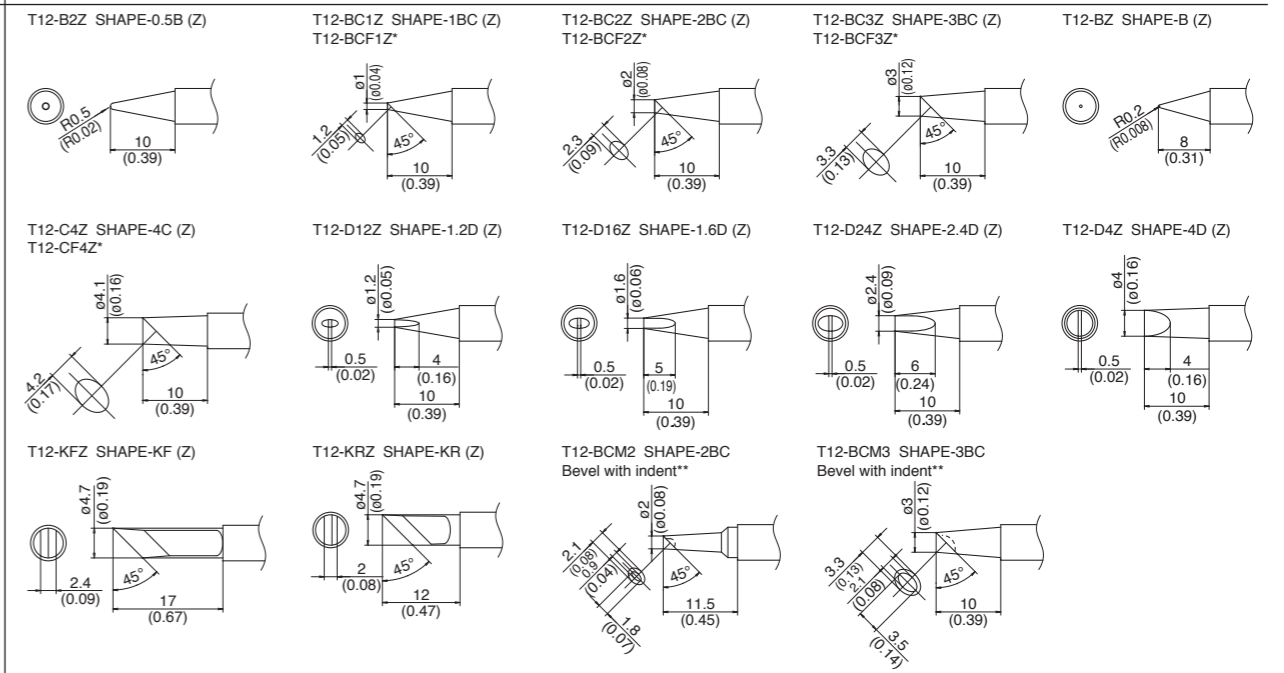
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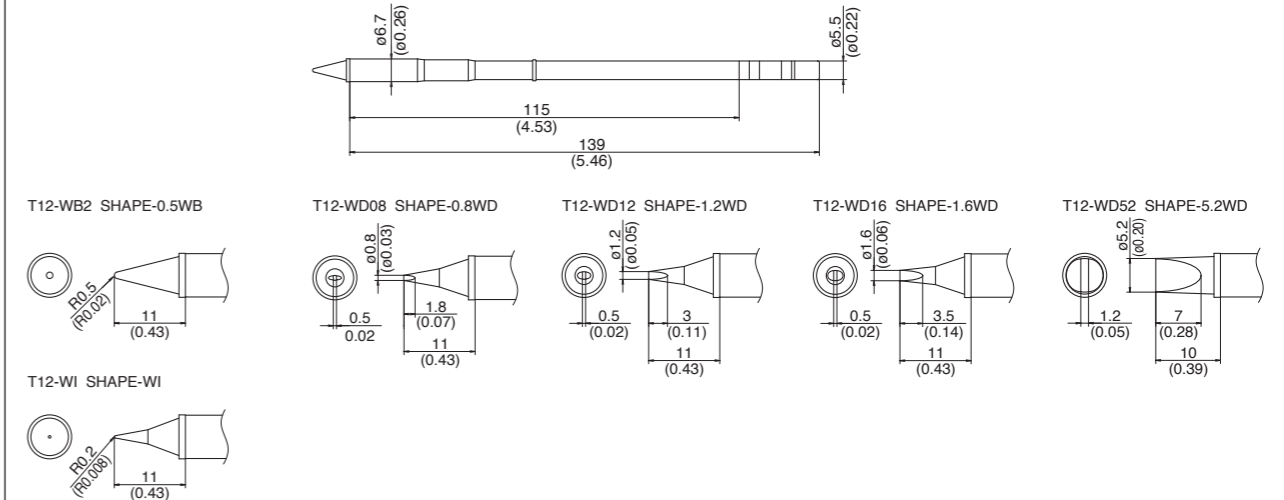
## SPATULA



## SPECIAL APPLICATIONS TYPE



## HEAVY DUTY TYPE



\*Tinned on the soldering surface only.