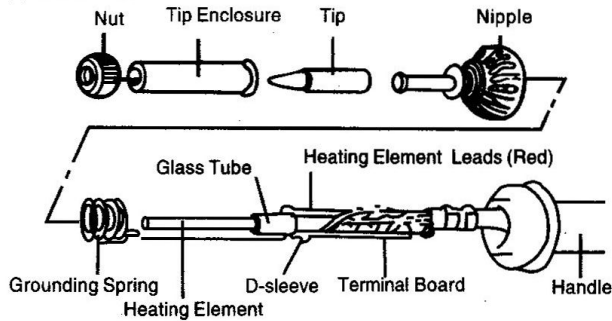


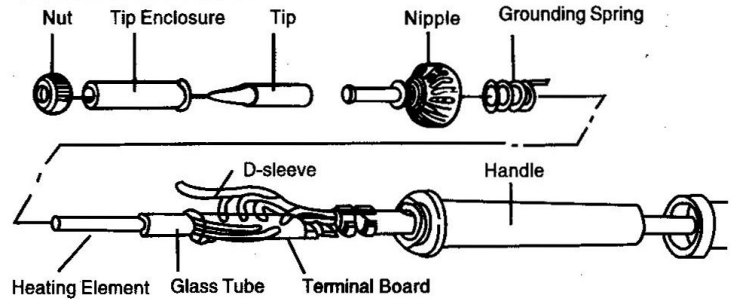
Replacing the Heating Element

Part Names

900M/L



907/908/913/914

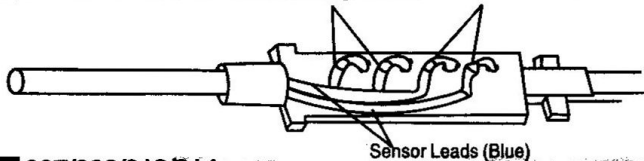


※HAKKO 913 and 914 are different from HAKKO 907 and 908 in shape of the handle.

① Measure the resistance values at the Heating Element.

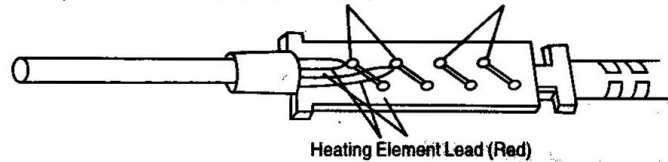
1. Remove the nut, tip enclosure, tip and nipple.
2. Push the cord asse'y in the direction of the tip and remove the terminal board from the handle.
3. Remove the grounding spring from the D-sleeve.
4. Measure the resistance values at the sensor and heating element of the terminal board in normal condition.

900M/L Resistance Value of Heating Element Resistance Value of Sensor



907/908/913/914

Resistance Value of Heating Element Resistance Value of Sensor



Resistance value of heating element(red): 2.5-3.5

Resistance value of sensor (blue): 43-58

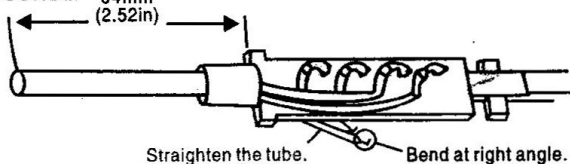
If the value you gets is outside this range, replace the heating element.

If the resistance value is normal, the cord asse'y may be broken.

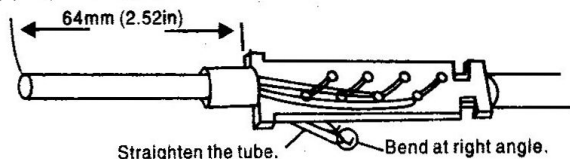
② Replace the Heating Element.

1. Desolder the heating element leads and sensor leads.
2. Remove the old heating element and replace it with a new one.
 - There is no polarity between leads of the same colors.
 - Bend the leads at right angle to prevent short-circuit.

900M/L



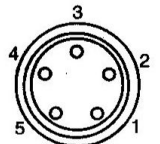
907/908/913/914



3. Solder the new heating element lead to the terminal board. then cut the extra lead.

③ Reassemble in reverse order.

a	Between pins 4 & 5 (Heating Element)	2.5 - 3.5 (Normal)
b	Between pins 1 & 2 (Sensor)	43 - 58 (Normal)
c	Between pins 3 & Tip	Under 2



After replacing the heating element,

1. Measure the resistance value between pins 4 & 1 or 2, pins 5 & 1 or 2. If it is not ∞ , the heating element and sensor are touching.
2. Measure the resistance value 'a', 'b', and 'c' to confirm that the leads are not twisted and that the grounding spring is properly connected.

④ Recalibrate the Temperature.

To ensure accurate soldering temperatures, always calibrate the temperature after replacing the heating element.

HAKKO 926 . 928 . 936 . 700 . 701

1. Set the temperature control knob to 400°C (750°F).
2. Turn the power switch on and wait until the L.E.D. heater lamp comes on and off.
3. Using a straight-edge(-) or small cross point screwdriver, adjust the temperature calibrator(marked "CAL") so that the tip temperature is 400°C (750°F).

HAKKO 927 . 937

1. Turn the power switch on and insert the card. Set the temperature to 400°C (750°F).
2. Wait until the digital display indicates a tip temperature of 400°C (750°F).
3. Using a straight-edge(-) or small cross point screwdriver, adjust the temperature calibrator(marked "CAL") so that the tip temperature is 400°C (750°F).

※Turn the temperature calibrator clockwise to increase the temperature and counterclockwise to reduce the temperature.

※Using the supplied hex wrench, remove the screw(M4X5mm) labeled "CAL" on the bottom of the station, and then turn the power on. (HAKKO 927)

※Remove the CAL pot plug before calibrating HAKKO 936/937

※We recommend the HAKKO 191/192 thermometer for measuring the tip temperature.

NOTE

When repairs are needed, please send both the soldering iron and the station to your sales agent. ※Specifications subject to change without notice.



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