

# HAKKO FV-802

## SEALER

### Instruction Manual

Thank you for purchasing the HAKKO FV-802 Sealer.  
Please read this manual before operating the HAKKO FV-802.  
Keep this manual readily accessible for reference.

#### 1. PACKING LIST

Please check to make sure that all items listed below are included in the package.

HAKKO FV-802 .....	1	Teflon tape .....	2
Heating element for welding .....	2	Adhesive tape .....	2
Heating element for fusing .....	2	Instruction manual .....	1

#### 2. SPECIFICATIONS

Name	HAKKO FV-802
Power supply	AC 220V
Power consumption	When welding heating element is used 260W When fusing heating element is used 240W
Sealing dimensions	1.6 × 200 mm (Max.)
Sealing thickness	0.2 mm (total thickness more than two layer of polyethylene sheets)
Outer dimensions	80 (W) × 200 ( H) × 330 (L) mm
Weight	Approx.. 2.7kg

\* The power consumption was set to 260W for the welding heating element at factory.  
\* This product meets China RoHS requirements.  
\* Specifications and design are subject to change without notice.

中國RoHS: 產品中有毒有害物質或元素的名稱及含量						
部件名稱	有毒有害物質或元素					
	鉛(Pb)	汞(Hg)	鎳(Cd)	六價鉻 (Cr(VI))	多溴聯苯 (PBB)	多溴二苯醚 (PBDE)
軸	×	○	○	○	○	○
終端	×	○	○	○	○	○
○：表示該有毒有害物質在該部件所有均質材料中的含量均在SJ/T 11363-2006 標準規定的限量要求以下。 ×：表示該有毒有害物質至少在該部件的某一均質材料中的含量超出SJ/T 11363-2006 標準規定的限量要求。						

#### 3. WARNINGS, CAUTIONS AND NOTES

##### ⚠ WARNING

Warnings and cautions are placed at critical points in this manual to direct the operator's attention to significant items. They are defined as follows:

⚠ **WARNING:** Failure to comply with a WARNING may result in serious injury or death.

⚠ **CAUTION:** Failure to comply with a CAUTION may result in injury to the operator, or damage to the items involved.

● Be sure to observe the following for safety.

##### ⚠ CAUTION

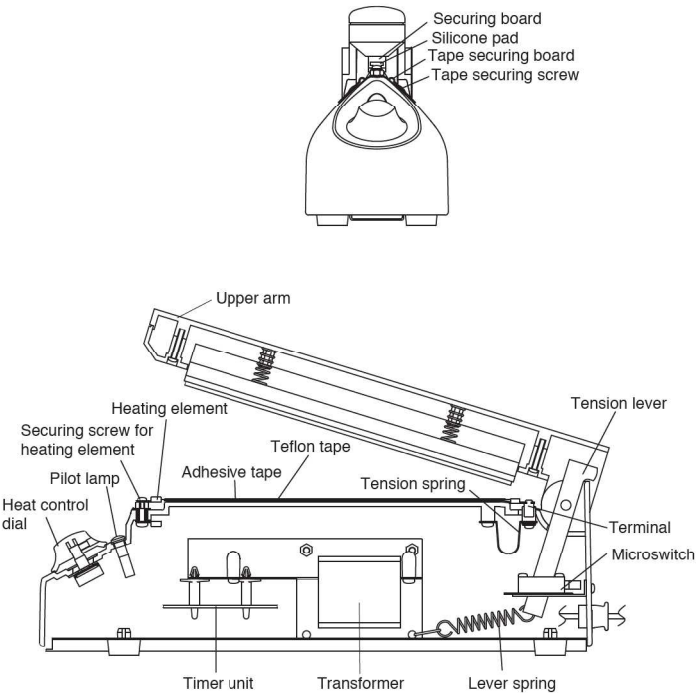
If the unit is mishandled, burn injury or fire may result. Please observe the following precautions.

- Use the heat control dial at the shortest possible time according to the material and thickness of the bag material (this will extend the long service lives of the Teflon tape and the heating element).
- Hold the upper arm pressed for 1 to 2 seconds after the pilot lamp has turned OFF. This will ensure cooling, thereby allowing the seal to be placed properly (at the time of welding).  
(Insufficient cooling causes the seal to become wavy, weak, or otherwise incomplete.)
- When using the HAKKO FV-802 for long production runs, be sure to pause 10 - 15 seconds or more between sealing operations. Performing continuous sealing operations without such pauses can damage the HAKKO FV-802.
- When replacing the heating element, it is recommended that the adhesive tape be also replaced if it is worn out. The use of the worn-out adhesive tape will cause the heating element to be broken.
- Turn the power off when changing parts or storing the HAKKO FV-802.

● To prevent accidents or damage, be sure to observe the following:

- Do not allow the HAKKO FV-802 to become wet, or use it with wet hands
- Do not modify the HAKKO FV-802.
- Use only genuine HAKKO replacement parts.
- Remove power cord by holding the plug - not the wires.
- Do not do anything else that might be dangerous.

#### 4. PART NAMES



#### 5. OPERATION

1. Plug the power cord into a grounded wall socket.
2. Adjust the heat control dial referencing to the table in accordance with the material and thickness of the bag.
3. Place the mouth of the bag on the sealing table and then press down the upper arm.
4. The switch will be turned ON and the pilot lamp will be illuminated for the selected time and then turn OFF.
5. Raise the upper arm 1 to 2 seconds after the pilot lamp has turned OFF.

Heat control table for welding

Dial \ Material	Polyethylene	Polypropylene isothermal film
1		
2	Less than 0.06 mm	
3	Less than 0.10 mm	Less than 0.04 mm
4	Less than 0.20 mm	Less than 0.06 mm
5		Less than 0.08 mm
6		

\* The thickness is the total of two layers

\* The above table shows reference values, which vary depending upon material and voltage. Select the most suitable setting.

#### 6. MAINTENANCE

1. Since the Teflon tape is worn out with heat, replace it as follows: Loosen 4 tape support screws and remove the Teflon tape. Place a new Teflon tape into the tape securing board. Tighten the screws on one side to secure the tape, place the tape into the tape securing board on the other side, and then tighten the screws on that side so that the tape is free from loosening.

##### 2. Heating element replacement

When heating element burns out, replace it as follows:

Remove the teflon tape by the procedure for replacing the Teflon tape and then remove the broken heating element.  
Hook a new heating element at the terminal located on the rear and pull it toward the front. Tighten the securing screws for heating element and set up the Teflon tape above the heating element.

##### ⚠ CAUTION

The temperature of the fusing heating element becomes higher than that of the welding heating element. If the welding heating element is replaced by the fusing heating element, adjust the timer dial.

##### 3. Adhesive tape replacement

Replace worn out adhesive tape under the heating element to avoid a short circuit. Remove the teflon tape and the heating element, remove the worn-out adhesive tape, and set up a new adhesive tape. Subsequently, put the heating element and the teflon tape back in place.

##### ⚠ CAUTION

The adhesive tape has an orientation. Ensure that the adhesive tape is positioned with its auxiliary tape side oriented toward the terminal. (The auxiliary tape is used to reinforce the adhesive tape. Do not remove it.)

Adhesive tape ————— Auxiliary tape

#### 7. TROUBLESHOOTING

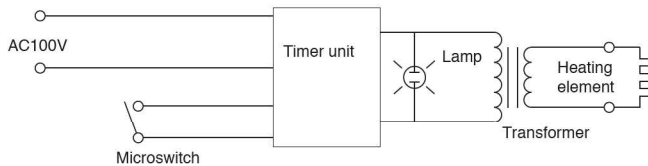
Problem	Cause	Remedy
The pilot lamp and the heating element are not powered.	The power plug is defective.	Replace the plug.
	The power cord is broken.	Replace the cord.
	The timer circuit malfunctions.	Replace the timer unit.
The pilot lamp lights up but heating element do not heat up.	The micro switch is defective.	Replace the microswitch.
	The heater is broken.	Replace the heating element (adhesive tape).
The light remains illuminated and the heating element is overheated.	The timer circuit malfunctions.	Replace the timer unit.
	The micro switch is defective.	Replace the microswitch.
The service lives of the heating element and the teflon tape are too short.	The sealing time is too long.	Set dial to a lower number to avoid oversealing.
	The cooling time is too short.	Allow more time for cooling off.

\*If the cause is unknown, contact our distributor.

#### 8. Replacement parts:

Part No.	Part Name	Specifications
306-H	Heating element for welding	1.6 × 200 mm 5 pcs.
307-H	Heating element for fusing	Piano wire 5 pcs.
306-2	Teflon tape	Cover for heating element 5 pcs.
307-3	Adhesive tape (with auxiliary tape)	Protection for heating element 5 pcs.
306-4	Microswitch	
306-5	Silicone pad	Made of silicone
B2975	Timer unit	For 220V

#### 9. WIRING DIAGRAM



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**日本白光牌**

承蒙惠顧，謹致謝忱。使用HAKKO FV-802之前，  
請詳閱本使用說明書，正確使用。  
閱後請妥為收存，以備日後查閱。

HAKKO FV-802.....	1	特氟隆帶.....	2
溶著用發熱元件.....	2	粘合帶.....	2
溶斷用發熱元件.....	2	使用說明書.....	1

名稱	HAKKO FV-802
功率消耗	使用溶著發熱元件時 260W 使用溶斷發熱元件時 240W
封口尺寸	1.6 × 200 mm (最大)
封口厚度	0.2 mm (超過兩層聚乙烯的總厚度)
外形體積	80 (W) × 200 (H) × 330 (L) mm
重量	約2.7kg

產品中有毒有害物質或元素的名稱及含量

部件名稱	有毒有害物質或元素					
	鉛(Pb)	汞(Hg)	鎘(Cd)	六價鉻 (Cr(VI))	多溴聯苯 (PBB)	多溴二苯醚 (PBDE)
軸	×	○	○	○	○	○
終端	×	○	○	○	○	○

○：表示該有毒有害物質在該部件所有均質材料中的含量均在SJ/T 11363-2006標準規定的限量要求以下。

×

- 切勿將HAKKO FV-802泡水或用濕手使用。
- 切勿改裝本產品。
- 更換部件時，必僅使用HAKKO正廠部件。
- 拔出電線時，請抓住插頭。切勿拉住電線。



故障	原因	解決方法
指示燈不亮，發熱元件不發熱	插頭出問題	更換插頭
	電源線斷線	更換電源線
	計時器回路出問題	更換計時器
	微型開關出問題	更換微型開關
指示燈亮起但發熱元件不發熱	發熱元件短路	更換發熱元件
指示燈不熄滅，而發熱元件出多余的熱量	計時器回路出問題	更換計時器
	微型開關出問題	更換微型開關
發熱元件和特氟隆之壽命短	密封時間太長	將刻度設定較小字以免過度密封
	冷卻不足	給予較長冷卻時間

部件編號	部件名稱	規格
306-H	溶著用發熱元件	1.6 × 200 mm 每套5個
307-H	溶斷用發熱元件	鋼琴線狀 每套5條
306-2	特氟隆	發熱元件蓋用 每套5片
307-3	粘合帶(附補助帶)	保護發熱元件用 每套5片
306-4	微型開關	
306-5	墊子	硅膠
B2975	計時器組件	220V用