



**1. PACKING LIST AND PART NAMES** Please check to make sure that all items listed below are included in the package.

Diagram illustrating the components of the HAKKO FX-300 soldering station and its accessories:

- Hexagon wrench
- Solder pot
- Spatula
- J-shaped waste collector
- Power cord
- Solder pot mounting screws (both sides)
- Power switch
- Fuse
- Temperature regulator knob

|                                 | 50 × 50 Square   | 75 × 75 Square                                      |
|---------------------------------|--|---|
| Power consumption               | 100V - 195W, 110V - 220W, 120V - 200W, 220V - 190W, 230V - 205W, 240V - 215W |   |
| Temperature range               | 200 - 450°C (400 - 840°F)  | 200 - 380°C (400 - 720°F)                           |
| Solder pot dimensions           | 50 (W) × 50 (D) × 43.5 (H) mm (2.0 × 2.0 × 1.7 in.)                          | 75 (W) × 75 (D) × 52.5 (H) mm (3.0 × 3.0 × 2.1 in.) |
| Molten solder capacity          | 0.85 kg (1.87 lb.)   | 1.2 kg (2.64 lb.)                                   |
| Weight<br>(w/o solder and cord) | 1.7 kg (3.74 lb.)  |   |
| Outer dimensions                | 143 (W) × 100 (H) × 220 (D) mm (5.6 × 4.0 × 8.7 in.)                         |   |

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**⚠ WARNING**

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

**⚠ WARNING**

**Observe the following precautions to ensure safety.**

**CAUTION**

- Use this product on highly stable metal workbench. Never use it near paper or other flammable materials.
- Inform others in the area that the product is hot and should not be touched.
- Never put water in the solder pot as this will cause solder to spatter out of the solder pot.
- Turn the power off when not in use, or left unattended.
- Before changing parts or storing the unit, be sure to turn the power off and allow the unit to cool to room temperature.
- This appliance is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.
- Children should be supervised to ensure that they do not play with the appliance.

**Observe the following precautions to prevent accidents or damage to the unit.**

- Do not use the HAKKO FX-300 for applications other than soldering.
- Do not modify the HAKKO FX-300.
- Use only genuine HAKKO replacement parts.
- Do not allow the HAKKO FX-300 to become wet, or use it with wet hands.
- Be sure the work area is well ventilated. Soldering produces smoke.
- Do not do anything else that might be dangerous.

- ⚠ CAUTION**  
Make sure the power switch is off before plugging in the power plug.

### Temperature regulator knob

The set temperature can be changed with the temperature regulator knob. Turning the knob clockwise increases the set temperature and turning the knob counterclockwise decreases the set temperature.

- | Knob | Temperature (50 × 50 Square) | Temperature (75 × 75 Square) |
|------|------------------------------|------------------------------|
| 1-3  | Approximately 200°C (400°F)  | Approximately 200°C (400°F)  |
| 3-4  | Approximately 300°C (570°F)  | Approximately 300°C (570°F)  |
| 4-5  | Approximately 400°C (750°F)  | Approximately 350°C (660°F)  |
| 5-6  | Approximately 450°C (840°F)  | Approximately 380°C (720°F)  |

**NOTE:**  
Temperature depends on a soldering pot. Please use the table above as a guide.  
Measure an exact temperature by the FG-100 or the FG-101 with an applicable temperature probe if necessary.

※ 各言語（日本語、英語、中国語、フランス語、ドイツ語、韓国語）の取扱説明書は以下のURL、HAKKO Document Portalからダウンロードしてご覧いただけます。  
(商品によっては設定の無い言語がありますが、ご了承ください。)

\* 各国語言（日語、英語、中文、法語、德語、韓語）的使用説明書可以通过以下网站的HAKKO Document Portal 下載參閱。  
(有一部分的产品沒有設定外語對應、請見諒)

\* Instruction manual in the language of Japanese, English, Chinese, French, German, and Korean can be downloaded from the HAKKO Document Portal.  
(Please note that some languages may not be available depending on the product.)



<https://doc.hakko.com>

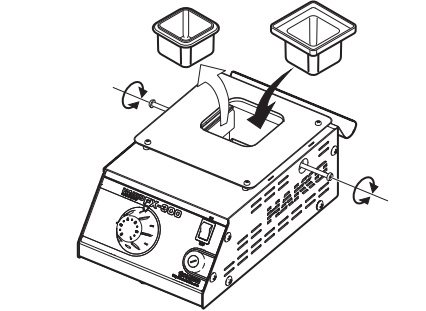


6. MAINTENANCE

⚠ WARNING

Unless otherwise directed, carry out these procedures after turning the power switch OFF, unplugging the power plug and waiting for both the unit and the solder to sufficiently cool down.

● Changing the solder pot



⚠ WARNING

When the power is ON, the temperature of the melted solder in the solder pot is approximately 450°C/842°F. Before changing the solder pot, be sure to unplug the power cord and let the solder and the unit cool to room temperature.

● Replacing the heating element

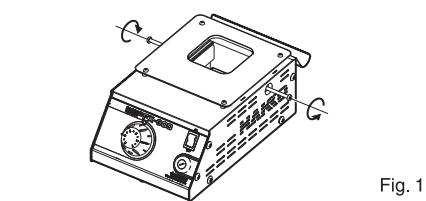


Fig. 1

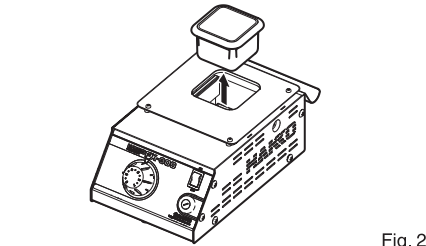


Fig. 2

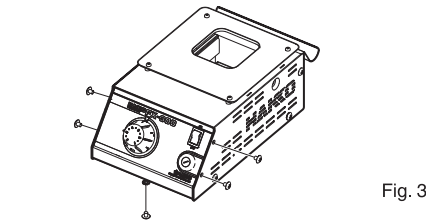


Fig. 3

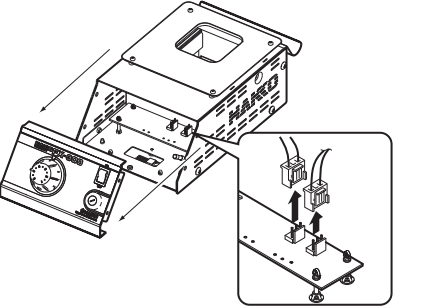


Fig. 4

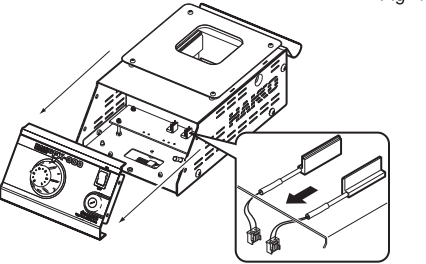


Fig. 5

- Using the hexagon wrench (provided with the HAKKO FX-300) to loosen the screws on both sides of the unit.

NOTE:

Screws do not have to be removed.

- Pull out the solder pot.

- Insert a new solder pot and then tighten the screws on both sides.

⚠ CAUTION

Check that the solder pot has been locked now. Otherwise, the temperature may not increase properly.

- Loosen the screws on both sides of the unit. (Fig. 1)

NOTE:

Screws do not have to be removed.

- Pull out the solder pot. (Fig. 2)

- Remove the setscrews (5 pieces) on the unit. (Fig. 3)

- Slide the front panel frontward, disconnect the two connectors (Fig. 4) from the connector circuit board, and then pull out the units of the heating elements (Fig. 5).

- Insert the right and left heating elements in the reverse procedure to removing the heating elements.

⚠ CAUTION

The heating element is a discrete type.

● Daily Check

Solder gradually corrodes and makes holes through the stainless solder pot, which can lead to solder leakage from the holes.

Daily check and replacement (if necessary) of the solder pot is recommended to ensure comfortable and safe execution of work.

⚠ CAUTION

Make sure that the solder pot has sufficiently cooled down before performing the daily check.

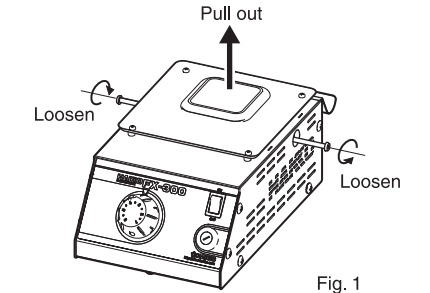


Fig. 1

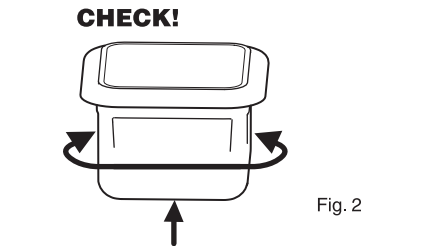


Fig. 2

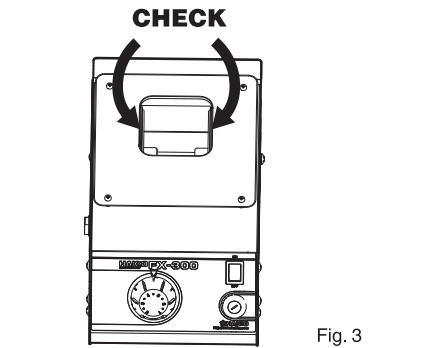


Fig. 3

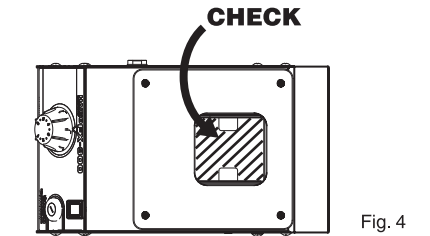


Fig. 4

7. TROUBLE SHOOTING GUIDE

⚠

- Before checking the inside of the FX-300 or replacing parts, be sure to disconnect the power plug.
- If the power cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified person in order to avoid personal injury or damage to the unit.

- The unit does not operate when the power switch is turned on.

CHECK

: Is the power cord and/or the connection plug disconnected?

ACTION

: Connect it.

CHECK

: Is the fuse blown?

ACTION

: Investigate why the fuse blew and then replace the fuse. If the cause can not be determined, replace the fuse. If the fuse blows again, send the unit in for repair.

How to check

- Loosen two mounting screws on both sides of the unit to pull out the solder pot. (Fig. 1)

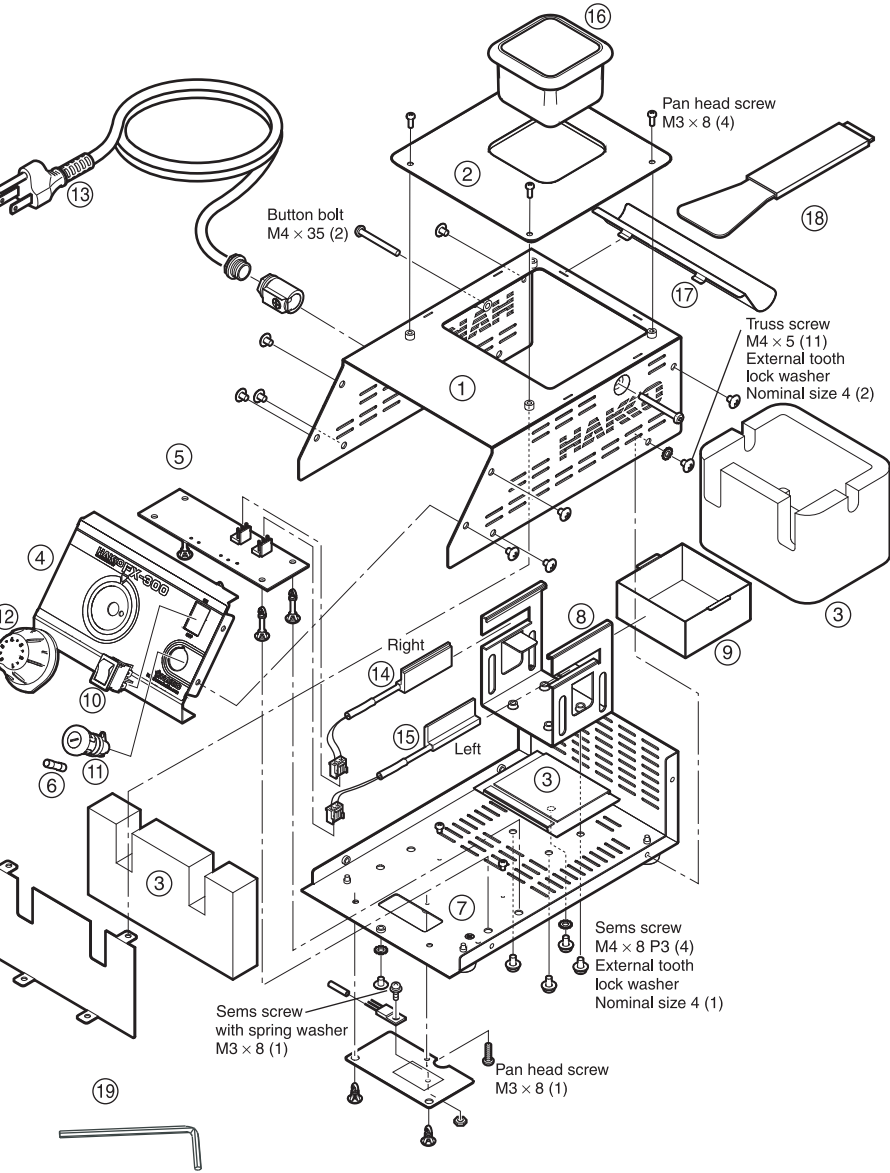
- Check for holes or leaks by visually inspecting the surface of the solder pot. (Fig.2)

NOTE:

Visually inspect sides and bottom of the solder pot. The life of the solder pot can be increased if the pot is reinstalled with its orientation being changed by 90 degrees.

- Check the following areas for solder sticking.
  - Overflow tray
  - Around the heater of the unit, insides of the heat insulator (Fig.3 and Fig.4)

8. PARTS LIST



| ● FX-300 Soldering pot |          |  |                                 |
|------------------------|----------|--|---------------------------------|
| Item No.               | Part No. | Part Name                                  | Specifications                  |
| ①                      | B3382    | Cover                                      |                                 |
| ②                      | B2918    | Overflow tray                              |                                 |
| ③                      | B2916    | Heat insulator                             |                                 |
| ④                      | B3383    | Front panel                                | With membrane sheet             |
| ⑤                      | B3385    | P.W.B.                                     | 100 - 110V                      |
|                        | B3386    | P.W.B.                                     | 120V                            |
|                        | B3387    | P.W.B.                                     | 220 - 240V                      |
|                        | B2705    | Midget fuse/125V-5A                        | 100 - 110V                      |
|                        | B2468    | Fuse/125V-5A                               | 120V                            |
| ⑥                      | B2922    | Fuse/250V-5A                               | 220 - 240V                      |
|                        | B3045    | Fuse/250V-5A CE                            | 230V CE, KTL for SG, MY, ID, PH |
|                        |          |  | With rubber feet                |
| ⑦                      | B3384    | Chassis                                    |                                 |
| ⑧                      | B2927    | Solder pot support                         |                                 |
| ⑨                      | B2928    | Solder pot tray                            |                                 |
| ⑩                      | B1487    | Power switch                               | 100 - 120V                      |
| ⑪                      | B2604    | Power switch                               | 220 - 240V                      |
| ⑫                      | B1134    | Fuse holder                                |                                 |
| ⑬                      | B3348    | Knob                                       |                                 |
|                        | B1238    | Power cord, 2 wired cord & flat 2 pin plug |                                 |
|                        | B1795    | Power cord, 3 wired cord & American plug   | For USA                         |
|                        | B1796    | Power cord, 3 wired cord but no plug       |                                 |
|                        | B2913    | Power cord, 3 wired cord & BS plug         |                                 |
|                        | B2914    | Power cord, 3 wired cord & Chinese plug    |                                 |
|                        | B1797    | Power cord, 3 wired cord & European plug   | KTL, CE                         |
|                        | B1798    | Power cord, 3 wired cord & Australian plug |                                 |
|                        | B3046    | Power cord, 3 wired cord & BS plug CE      |                                 |
|                        | B3513    | Power cord, 3 wired cord & American plug   |                                 |

| ● Replacement parts |          |                          |  |
|---------------------|----------|--------------------------|--|
| Item No.            | Part No. | Part Name                | Specifications                           |
| ⑭                   | A1551    | Heating element/Right    | 100 - 110V                               |
|                     | A1553    | Heating element/Right    | 120V                                     |
|                     | A1549    | Heating element/Right    | 220 - 240V                               |
| ⑮                   | A1552    | Heating element/Left     | 100 - 110V                               |
|                     | A1554    | Heating element/Left     | 120V                                     |
|                     | A1555    | Heating element/Left     | 220 - 240V                               |
| ⑯                   | A1517    | Solder pot               | 50 × 50 × 43.5(mm) /2.0 × 2.0 × 1.7(in.) |
| ⑰                   | B2919    | J-shaped waste collector |  |
| ⑱                   | B2932    | Spatula                  |  |
| ⑲                   | B1417    | Hexagon wrench           |  |

| ● Optional parts |            |  |
|------------------|------------|--|
| Part No.         | Part Name  | Specifications   |
| A1539            | Solder pot | Special coating 50 × 50 × 43.5(mm) /2.0 × 2.0 × 1.7(in.) |
| A1540            | Solder pot | Special coating 75 × 75 × 52.5(mm) /3.0 × 3.0 × 2.1(in.) |
| A1518            | Solder pot | 75 × 75 × 52.5(mm) /3.0 × 3.0 × 2.1(in.)                 |