



HAKKO 936

電焊臺

Instruction Manual 使用說明書

日本白光牌

English

Thank you for purchasing the HAKKO 936 Soldering Station.

Please read this manual before operating the HAKKO 936. Store the manual in a safe, easily accessible place for future reference.

⚠ CAUTION

When seeking tip replacements, select only "HAKKO" genuine soldering iron tips that are intended for your particular model of soldering iron (Please refer to the instruction manual).

If an incompatible tip or a tip made by another manufacturer is used, the original performance of the soldering iron may not be obtained. Furthermore, the heating element, P.W.B. and transformer may be damaged.

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感謝您購買HAKKO 936電焊臺。使用HAKKO 936前，請詳閱本使用說明書，閱後請妥為收存，以備日後查閱。

⚠ 警告

當您需要更換焊咀或其他配件時，請選擇正確原裝白光配件。如閣下疏忽選擇錯誤，將會引起不必要的嚴重效果。

- * 焊咀可能不升溫或令正常溫度不穩定。
- * 會令發熱元件壽命縮短。
- * 焊臺內的電路板及變壓器容易發生故障。
- * 溫度不正常令焊咀受損不上錫，縮短壽命，影響操作。
- * 如選擇仿造配件安裝在原裝白光產品上，將嚴重影響該產品所有功能。
- ** 對於選擇不正規白光產品或仿造產品及任何配件而引起任何問題與本公司無關。特此聲明。

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Packing List

Please check the contents of the HAKKO 936 package and confirm that all the items listed below are included.

HAKKO 936 station	1	Hex Wrench (1.5 mm, 0.059 in.)	1
Soldering Iron □HAKKO 900 (S), 907 or 908).....	1	Instruction Manual	1
HAKKO Iron Holder (With Cleaning Sponge)	1		

Precautions

English

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.

CAUTION

When the power is on, the tip temperature is between 200°C/392°F and 480°C/896°F. Since mishandling may lead to burns or fire, be sure to comply with the following precautions.

- Do not touch the metallic parts near the Tip.
- Do not use the product near flammable items.
- Advise other people in the work area that the unit can reach a very high temperature and should be considered potentially dangerous.
- Turn the power off while taking breaks and when finished using the unit.
- Before replacing parts or storing the unit, turn the power off and allow the unit to cool to room temperature.

To prevent damage to the unit and ensure a safe working environment, be sure to comply with the following precautions.

- Do not use the unit for applications other than desoldering.
- Do not rap the soldering iron against the work bench to shake off residual solder, or otherwise subject the iron to severe shocks.
- Do not modify the unit.
- Use only genuine HAKKO replacement parts.
- Do not wet the unit or use the unit when your hands are wet.
- The soldering process will produce smoke, so make sure the area is well ventilated.
- While using the unit, don't do anything which may cause bodily harm or physical damage.

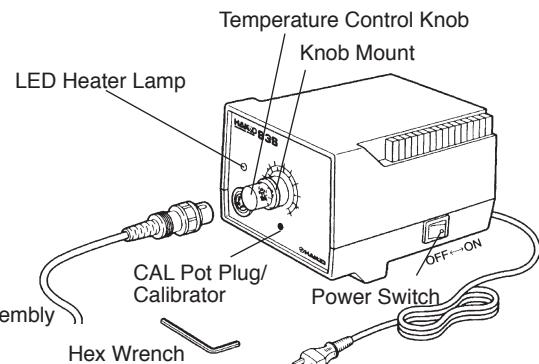
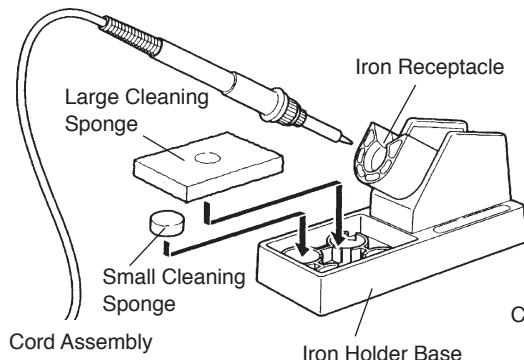
* This product is protected against an electro-static discharge.

CAUTION:

This product includes such features as electrically conductive plastic parts and grounding of the handpiece and station as measures to protect the device to be soldered from the effects of static electricity. Be sure to observe the following instructions:

1. The handle and other plastic parts are not insulators, they are conductors. When replacing parts or repairing, take sufficient care not to expose live electrical parts or damage insulation materials.
2. Be sure to ground the unit during use.

Names of Parts



Setting up & Operating the HAKKO 936

English

⚠ CAUTION

The sponge is compressed. It will swell when moistened with water. Before using the until, dampen the sponge with the water and squeeze it dry. Failure to do so may result in damage to the soldering tip.

A. Iron Holder

1. Small Cleaning Sponge

Dampen the small cleaning sponge with water and then squeeze it dry. Place it in one of the 4 openings of the iron holder base.

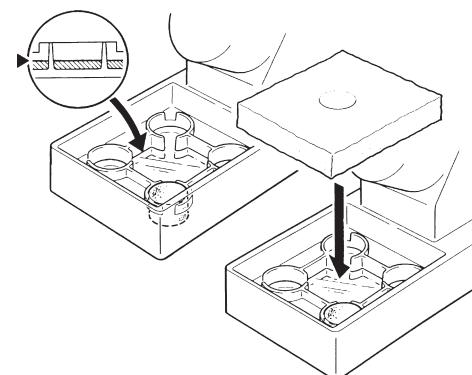
2. Add water to approximately the level as shown. The small sponge will absorb water to keep the larger sponge above it wet at all times.

*The large sponge may be used alone (w/o small sponge & water).

3. Dampen the large cleaning sponge and place it on the iron holder base.

Note: The iron receptacles for the 900 (S) and the 907/908 soldering irons are different.

Be sure to use the proper one for each type of soldering iron. (Refer to Parts List.)



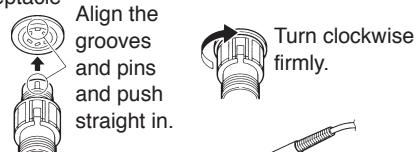
⚠ CAUTION

Be sure to turn off the power switch before connecting or disconnecting the soldering iron. Failure to do so may damage the P.W.B..

B. Connections

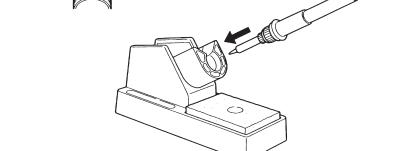
1. Connect the cord assembly to the receptacle.
2. Place the soldering iron in the iron holder.
3. Plug the power cord into the power supply. Be sure to ground the unit.

Receptacle



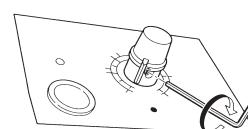
C. Set the Temperature

1. Set the temperature control knob to the desired temperature.
2. Lock the knob.
The HAKKO 936 station is equipped with a temperature control knob lock. After setting the desired temperature, tighten the hex nut on the underside of the knob mount using the supplied hex wrench. Turn the nut clockwise to tighten the knob lock.



⚠ CAUTION

- Don't over tighten the knob lock.
- Don't attempt to turn the knob when the knob lock is on.



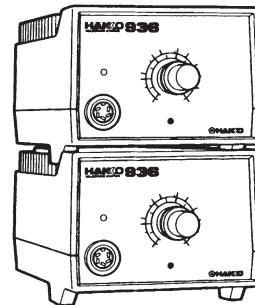
D. Turn on the Power Switch.

The heater lamp blinks on and off when the tip temperature reaches the set temperature. The unit is now ready to perform soldering work.

For greater convenience, and soldering efficiency, two stations can be securely stacked as shown.

⚠ CAUTION

The soldering iron must be placed in the iron holder when not in use.



Tip Care and Use

● Tip Temperature -----

High soldering temperatures can degrade the tip.

Use the lowest possible soldering temperature.

The excellent thermal recovery characteristics ensure efficient and effective soldering even at low temperatures.

This also protects the soldered items from thermal damage.

● Cleaning -----

Clean the tip regularly with a cleaning sponge, as oxides and carbides from the solder and flux can form impurities on the tip.

These impurities can result in defective joints or reduce the tip's heat conductivity. When using the soldering iron continuously, be sure to loosen the tip and remove all oxides at least once a week.

This helps prevent seizure and reduction of the tip temperature.

● When Not in Use -----

Never leave the soldering iron sitting at high temperature for long periods of time, as the tip's solder plating will become covered with oxide, which can greatly reduce the tip's heat conductivity.

● After Use -----

Wipe the tip clean and coat the tip with fresh solder.

This helps prevent tip oxidation.

Maintenance

Inspect and Clean the Tip

⚠ CAUTION

Never file the Tip to remove oxide.

1. Set the temperature to 250°C (482°F).
2. When the temperature stabilizes, clean the tip with the cleaning sponge and check the condition of the tip.
3. If there is black oxide on the solder-plated portion of the tip, apply new solder (containing flux) and wipe the tip on the cleaning sponge. Repeat until the oxide is completely removed. Coat with new solder.
4. If the tip is deformed or heavily eroded, replace it with a new one.

Calibrating the Iron Temperature

The soldering iron should be recalibrated after changing the iron, or replacing the heating element or tip.

- 1) Connect the cord assembly plug to the receptacle on the station.
- 2) Set the temperature control knob to 400°C (750°F).
- 3) Turn the power switch to 'ON' and wait until the temperature stabilizes. Remove the CAL pot plug.
- 4) When the temperature stabilizes, use a straight-edge (-) screwdriver or small plus (+) screwdriver to adjust the screw (marked CAL at the station) until the tip thermometer indicates a temperature of 400°C (750°F). Turn the screw clockwise to increase the temperature and counterclockwise to reduce the temperature. Replace the CAL pot plug.

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

Tips

The tip temperature will vary according to the shape of the tip. The preferred method of adjustment uses a tip thermometer. (See "Calibrating the Iron Temperature" on page 3.)

A less accurate method involves adjusting the temperature control knob according to the adjustment value for each tip.

Example: When using a 900M-T-H tip at 400°C (750°F), the difference between this tip and a 900M-T-B tip is -20°C (-36°F).

Set the temperature control knob to 420°C (786°F).

Refer to the chart for the correct adjustment values on page 15.

Troubleshooting Guide

⚠️WARNING

- * Disconnect the power plug before servicing. Failure to do so may result in electric shock.
- * 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.

Problem 1. The heater lamp does not light up.	Check 1. Is the power cord and/or connecting plug disconnected ? <ul style="list-style-type: none">• Connect it. Check 2. Is the fuse blown? <ul style="list-style-type: none">• Determine why the fuse blew and eliminate the cause, then replace the fuse.a. Is the inside of the iron short-circuited?b. Is the grounding spring touching the heating element?c. Is the heating element lead twisted and short-circuited?
Problem 2. The heater lamp lights up but the tip does not heat up.	Check 3. Is the soldering iron cord broken? <ul style="list-style-type: none">• Refer to 'Checking for breakage in the cord assembly.' Check 4. Is the Heating Element broken? <ul style="list-style-type: none">• Refer to 'Checking for breakage in the heating element.'
Problem 3. The tip heats up intermittently.	→ Check 3
Problem 4. The tip is not wet.	Check 5. Is the tip temperature too high? <ul style="list-style-type: none">• Set an appropriate temperature. Check 6. Is the tip clean? <ul style="list-style-type: none">• Refer to "Tip Care and Use".
Problem 5. The tip temperature is too low.	Check 7. Is the tip coated with oxide? <ul style="list-style-type: none">• Refer to "Inspect and clean the tip". Check 8. Is the iron calibrated correctly? <ul style="list-style-type: none">• Recalibrate.
Problem 6. The tip can not be pulled off.	Check 9. Is the tip seized? Is the tip swollen because of deterioration? <ul style="list-style-type: none">• Replace the tip and the heating element.
Problem 7. The tip doesn't hold the desired temperature.	→ Check 8

Checking for breakage of the heating element and cord assembly

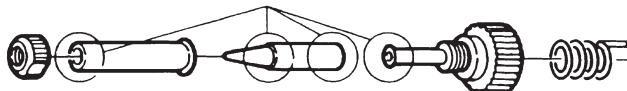
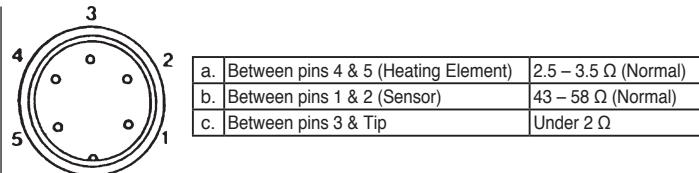
English

Disconnect the plug and measure the resistance value between the connecting plug pins as follows.

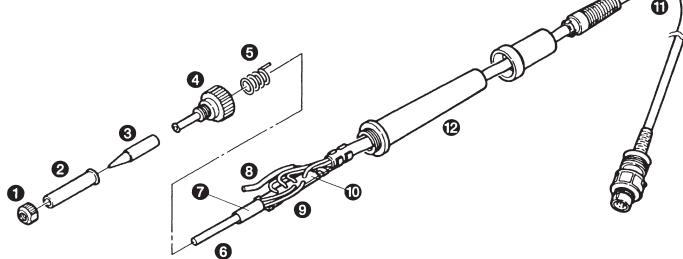
If the values of 'a' and 'b' are outside the above value, replace the heating element (sensor) and/or cord assembly. Refer to Procedures 1 and 2.

If the value of 'c' is over the above value, remove the oxidization film by lightly rubbing with sand-paper or steel wool the point as shown.

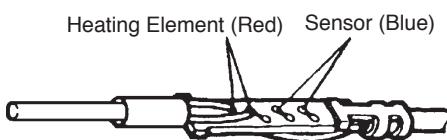
1. Broken Heating Element



Disassembling the 907/908



1. Turn the nut (1) counterclockwise and remove the tip enclosure (2), the tip (3).
2. Turn the nipple (4) counterclockwise and remove it from the iron.
3. Pull both the heating element (6) and the cord assembly (11) out of the handle (12). (Toward the tip of the iron.)
4. Pull the grounding spring (5) out of the D-sleeve.



Measure when the heating element is at room temperature.

1. Resistance value of heating element (RED) 2.5 – 3.5 Ω

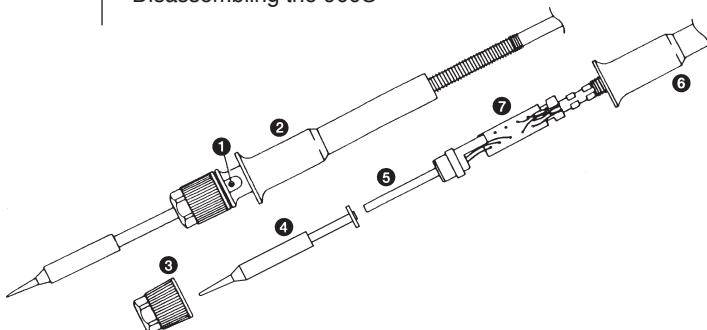
2. Resistance value of sensor (BLUE) 43 – 58 Ω
If the resistance value is not normal, replace the heating element.

(Refer to the instructions included with the replacement part.)

After replacing the heating element.

1. Measure the resistance value between 1) pins 4 & 1 or 2) pins 5 & 1 or 2. If it is not ∞ , the heating element and sensor are touching. This will damage the P.W.B.
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.

Disassembling the 900S



2. Broken Soldering Iron Cord

There are two methods of testing the soldering iron cord.

- Slide the handle cover (2) toward the cord and remove the screw (1) securing the heating element.
- Turn the nut (3) counterclockwise and remove it.
- Remove the tip (4).
- Pull both the heating element (5) and the cord toward the tip of the iron and out of the handle (6).

Measure the resistance values at the sensor and the heating element of the terminal board.

The resistance value should be the same as for the 907, 908.

To replace the heating element, refer to the instructions included with the replacement part.

- Turn the unit ON and set the temperature control knob to 480°C (896°F). Then wiggle and kink the iron cord at various locations along its length, including in the strain relief area.
If the LED heater lamp flickers, then the cord needs to be replaced.



CAUTION

The LED heater lamp will flicker even with a normal Iron cord if the temperature reaches 480°C (896°F).

- Check the resistance between the pin of the plug and the wire on the terminal.

Pin 1: Red Pin 2: Blue Pin 3: Green Pin 4: White Pin 5: Black

The value should be 0 Ω. If it is greater than 0 Ω or is ∞, the cord should be replaced.

3. Replacing the Fuse

Refer to the drawing in the replacement parts section of this manual. Desolder the blown fuse and remove it. Solder on a new one.

Specifications

Name	HAKKO 936
Power Consumption	60W

Station

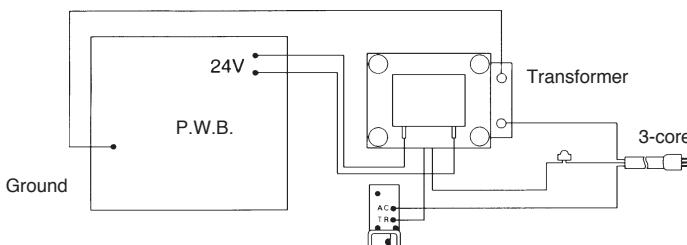
	936 Station / 936 Station ESD
Output Voltage	24V AC
Temperature Range	200°C - 480°C / 392°F - 896°F
Dimensions	120(W) x 938(H)x70(D) mm / 4.7(W)x3.7(H)x6.7(D) in.
Weight (W/O Cord)	1300 g (2.9 lbs.)

- The tip temperature was measured using HAKKO 191 thermometer.
- Specifications and design subject to change without notice.

Soldering Iron

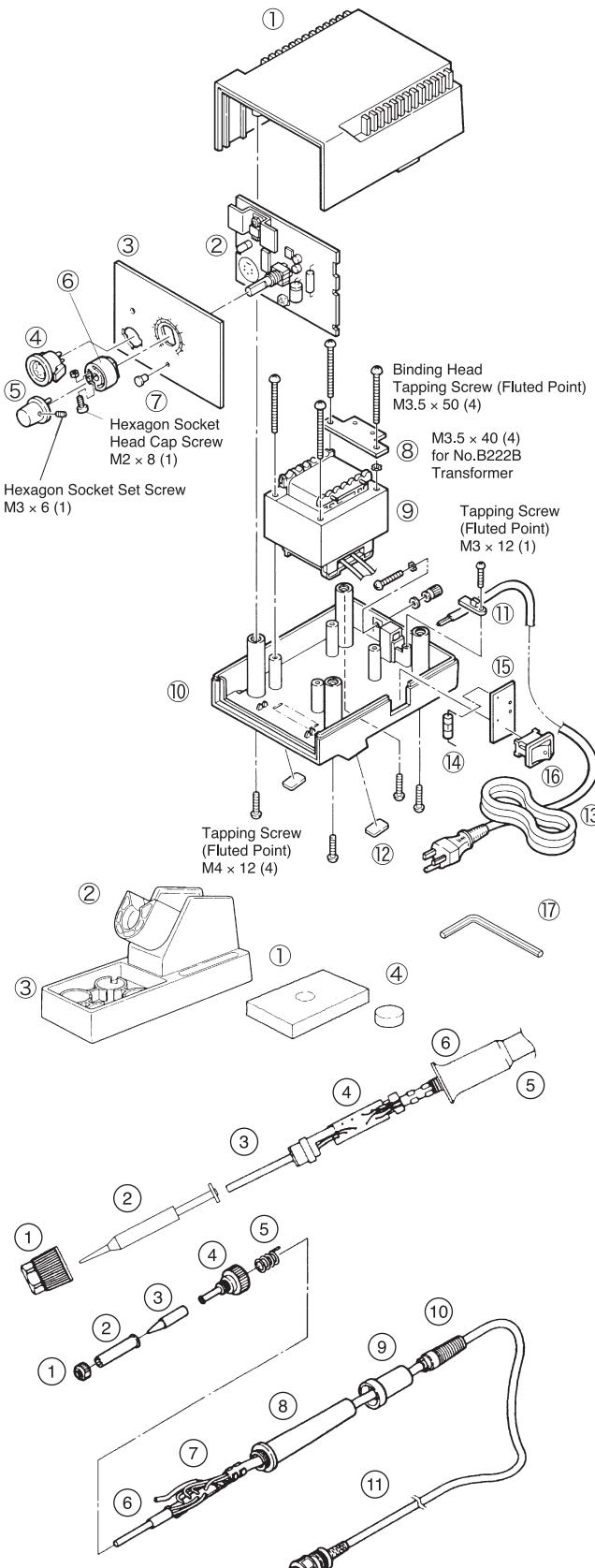
	900S 900S-ESD	907 907-ESD	908 908-ESD
Power Consumption	24V AC - 50W		
Tip to Ground Resistance	Under 2 Ω		
Tip to Ground Potential	Under 2 mV (TYP. 0.6 mV)		
Heating Element	Ceramic heater		
Cord Assembly	1.2 m (4 ft.)		
Total Length (w/o Cord)	176 mm (7 in.)	190 mm (7.5 in.)	200 mm (7.9 in.)
Weight (w/o Cord)	25 g (0.06 lbs.)	44 g (0.09 lbs.)	54 g (0.12 lbs.)

Wiring Diagram



Parts List (Station/Iron Holder/ Iron)

English



Item No.	Part No.	Part Name	Description
①	B2048	Upper Case	100, 110, 220-240 V (Standard)
	B2225	Upper Case / UL	120 V (Standard/UL)
②	B2001	Upper Case	E.S.D.
③	B2319	P.W.B.	AS/NZS
	B2335	P.W.B.	CE
③	B2003	Panel	
	B2287	Panel	E.S.D.
④	B2006	Receptacle	
⑤	B2004	Knob	w/ a screw
⑥	B2005	Knob Mount	w/ a screw
⑦	B2018	CAL Pot Plate	
⑧	B2227	Grounding Plate	
⑨	B2011	Transformer	100 - 24 V
	B2012	Transformer	110 - 24 V
	B2228	Transformer	120 - 24 V (Standard/UL)
	B2013	Transformer	120 - 24 V (D.E.S.)
	B2014	Transformer	220 - 240 - 24 V (CE)
	B2088	Transformer	240 - 24 V (Australia)
⑩	B2000	Lower Case	100, 110, 220-240 V (Standard/UL)
	B2226	Lower Case / UL*	120 V (Standard/UL)
	B2002	Lower Case*	E.S.D. *w/ Rubber Stopper
⑪	B2015	Cord Stopper	
⑫	B2016	Rubber Stopper	Set of 2
⑬	B1318	Power Cord	3 Wired Cord but No Plug
	B1319	Power Cord	3 Wired Cord & American Plug (U.S.A.)
	B2042	Power Cord	3 Wired Cord & Australian Plug
	B2043	Power Cord	3 Wired Cord & European Plug (KT)
	B2098	Power Cord	3 Wired Cord & BS Plug
	B2327	Power Cord	3 Wired Cord & European Plug (CE)
	B2328	Power Cord	3 Wired Cord & BS Plug (U.K.)
	B2486	Power Cord	3 Wired Cord & Chinese Plug
	B3504	Power Cord	3 Wired Cord & American Plug
⑭	B2007	Fuse, 125V-2 A	100, 110 V
	B2224	Fuse, 2A (UL)	120 V
	B2008	Fuse, 250V-0.8A	220-240 V
	B2303	Fuse, 0.63A (CE)	230 V
⑮	B2103	Wiring board for switch	
⑯	B1084	Power switch	
⑰	B2017	Hex Wrench	

Item No.	Part No.	Part Name	Description
①	C1141	Iron Holder	900S
	C1142	Iron Holder	907, 908
②	B2020	Iron Receptacle	900S
	B2021	Iron Receptacle	907, 908
③	B2019	Iron Holder Base	900S, 907, 908
④	A1042	Cleaning Sponge	900S, 907, 908

900S

Item No.	Part No.	Part Name	Description
①	900S-006	Nut	
	900S-006S	Nut	E.S.D.
②		Soldering Tip	See P.15
③	A1322	Heating Element	Old part No.900S-H
④	900S-101	Terminal Board	w/ Cord Stopper
⑤	900S-001	Handle	w/ Handle cover
	900S-001S	Handle	w/ Handle Cover, E.S.D.
⑥	900S-034	Handle Cover	
	900S-034S	Handle Cover	E.S.D.
⑦	900S-010	Cord Busing	(Not shown)
⑧	900S-039	Cord Assembly	(Not shwon)
	900S-039S	Cord Assembly	E.S.D. (Not shown)

907, 908

Item No.	Part No.	Part Name	Description	For
①	B1784	Nut		907
	B1794	Nut		908
②	B1786	Tipe Enclosure		907
	B1787	Tip Enclosure		908
③		Soldering Tip	See P.15	907
		Soldering Tip	See P.15	908
④	B2022	Nipple		907
	B2023	Nipple		908
⑤	B2032	Grounding Spring		907, 908
⑥	A1321	Heating Element	Old Part No. 900M-H No. 900L-H	907, 908
⑦	B2028	Terminal Board	w/ Cord Stopper	907, 908
⑧	B2023	Handle	w/ Handle Cover	907
	B2024	Handle	w/ Handle Cover, E.S.D.	908
	B2025	Handle	w/ Handle Cover	907
	B2026	Handle	w/ Handle Cover, E.S.D.	908
⑨	B2027	Handle Cover		907, 908
⑩	B2031	Cord Bushing		907, 908
⑪	B2029	Cord Asse'y		907, 908
	B2030	Cord Asse'y	E.S.D.	907, 908

包裝清單

請檢查HAKKO 936的包裝，以證實所列清單項目正確無誤：

HAKKO 936電焊臺.....	1	六角頭扳手(1.5 mm).....	1
焊鐵(HAKKO 900(S)或907或908型).....	1	使用說明書	1
HAKKO 焊鐵架(包括潔海綿).....	1		

注意事項

!**警告**

本說明書之注意事項，區分為如下之「警告」「注意」二者而加以表示。請充分理解其內容之後，再閱讀本文。

!警告****： 濫用可能導致使用者死亡或負重傷。

!注意****： 濫用可能導致使用者受傷或對涉及物體造成實質破壞。

為您本人安全著想，請嚴格遵守“注意事項”。

!**注意**

當電源接通時，焊鐵頭溫度高於攝氏200至480度（華氏392至896度）。

鑑於濫用可能導致灼傷或火患，請嚴格遵守以下事項：

- 切勿觸及焊鐵頭附近的金屬部分。
- 切勿在易燃物體附近使用焊鐵頭。
- 通知工場其他人士，焊鐵頭極為灼熱，可能引發危險事故。休息時或完工後應關掉電源。
- 更換部件或裝置焊鐵頭時，應關掉電源，並待焊鐵頭冷卻至室溫。

為免損壞電焊臺，及保持作業環境之安全，應遵守下列事項：

- 切勿使用焊鐵頭進行焊接以外的工作。
- 切勿將焊鐵敲擊工作臺以清潔焊劑殘餘，此舉可能嚴重震損焊鐵。
- 切勿擅自改動電焊臺。
- 更換部件時，應採用HAKKO原件。
- 切勿弄濕電焊臺，或手濕時也不能使用電焊臺。
- 焊接時會冒煙，工場應有良好通風設施。
- 使用電焊臺時，不可作任何可能傷害身體或損壞物體的妄動。

* 本產品有防靜電產品處理。

△注意：

本產品施有防靜電措施，對塑膠導電性，並對焊鐵部與機身部作接地，請特別留意下列注意事項：

1. 手柄等之塑膠，並非絕緣物，而是有導電性塑膠，修理時請十分注意之。進行部件更換或修理時，有電部分不可露出，及切勿損傷絕緣材料。
2. 請務必接地使用之。

中國RoHS: 產品中有毒有害物質或元素的名稱及含量

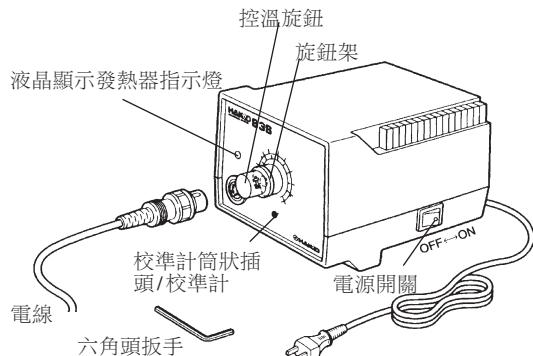
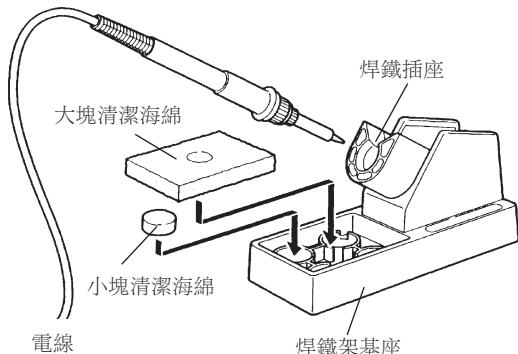
部件名稱	有毒有害物質或元素					
	鉛(Pb)	汞(Hg)	鎘(Cd)	六價鉻(Cr(VI))	多溴聯苯(PBB)	多溴二苯醚(PBDE)
焊鐵部	×	○	○	○	○	○
插座	×	○	○	○	○	○
接地終端板	×	○	○	○	○	○
電路板	×	○	○	○	○	○
插頭	×	○	○	○	○	○

○：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。



部件名稱



裝置和使用HAKKO 936

△注意：

海綿是可擠壓物體，水濕則漲大。使用海綿時，先濕水再擠乾。否則會損壞焊鐵頭。

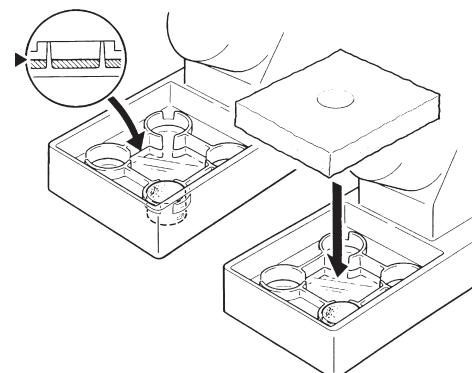
A. 焊鐵架

1. 小塊清潔海綿

將小塊清潔海綿先濕水再擠乾，置入焊鐵架底座四個凹洞之一。

- 添水至圖1所示水平面。小塊海綿吸收水分後，可使置於其上的大塊海綿一直保持潮濕狀態。*
也可以單用大塊海綿(省去小塊海綿和添水)。
- 然後霑濕大塊海綿，置於焊鐵架底座。

註: 900S型和907/908型焊鐵架有所不同。更換焊鐵時，應選用適當款型。請參照“部件清單”。



△注意：

進行連接和解開焊鐵時，切記要關掉電源，以免損壞印刷電路板。

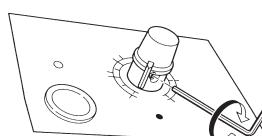
B. 連接

- 將電線裝置連接焊鐵插座。
- 將焊鐵置放於焊鐵架。
- 將插頭插入電源插座。切記要接地。



C. 設定溫度

- 將控溫旋鈕設定在所需溫度點。
 - 鎖定控溫旋鈕。
- HAKKO 936配有溫度調節鉗鎖。當設定所需溫度後，以所供應的六角頭扳手栓緊鉗座旁邊的六角螺帽。依順時針方向栓緊鉗鎖。



△注意：

切勿過度栓緊鉗鎖。
當上鎖後，切勿扭開鉗鎖。

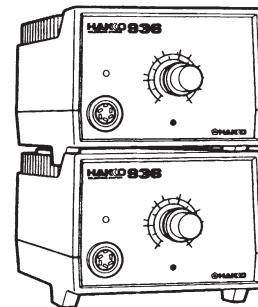
D. 按開開關掣

當焊鐵頭升溫至所設定溫度時，發熱器指示燈即會閃亮，指示可以進行焊接工作。

為了更方便工作和取得更高焊接效率，可以將兩臺電焊臺重疊如圖示。

△注意：

當不使用時，應將焊鐵放置在焊鐵架上。



焊鐵頭的維護和使用

● 焊鐵頭溫度 -----

溫度過高會減弱焊鐵頭功能，因此應選擇盡可能低之溫度。此焊鐵頭的溫度回復力優良，較低的溫度也可充分的焊接，可保護對於溫度敏感之元件。

● 清理 -----

應定期使用清潔海綿清理焊鐵頭。焊接後，焊鐵頭的殘餘焊劑所衍生的氧化物和碳化物會損害焊鐵頭，造成焊接差誤，或者使焊鐵頭導熱功能減退。

長時間連續使用焊鐵時，應每周一次拆開焊鐵頭清除氧化物，防止焊鐵頭受損而減低溫度。

● 當不使用時 -----

不使用焊鐵時，不可讓焊鐵長時間處在高溫狀態，會使焊鐵頭上的焊劑轉化為氧化物，致使焊鐵頭導熱功能大為減退。

● 使用後 -----

使用後，應抹淨焊鐵頭，鍍上新錫層，以防止焊鐵頭引起氧化作用。

保養

檢查和清理焊鐵頭

△注意：

切勿用銼刀剔除焊鐵頭上的氧化物。

1. 設定溫度為攝氏250度（華氏482度）。
2. 溫度穩定後，以清潔海綿清理焊鐵頭，並檢查焊鐵頭狀況。
3. 如果焊鐵頭的鍍錫部份含有黑色氧化物，可鍍上新錫層，再用清潔海綿抹淨焊鐵頭。如此重複清理，直到徹底除去氧化物為止，然後再鍍上新錫層。
4. 如果焊鐵頭變形或衍生重秀鏽，必須替換新的。

校準焊鐵溫度

每當更換焊鐵，或替換發熱器、焊鐵頭後，應重新校準焊鐵溫度。

1. 將電線裝置的插頭插入電焊臺插座。
2. 控溫旋鈕攝定為攝氏400度（華氏750度）。
3. 按開電源，等待溫度穩定後，移去校準計筒狀插頭。
4. 溫度穩定後，以“-”字或小“+”字螺絲起子旋轉螺絲（電焊臺誌有CAL字樣的螺絲），直到溫度計顯示攝氏400度（華氏750度）為止。順時針方向旋轉是昇溫，反時針方向是降溫。接上校準計CAL筒狀插頭。

*我廠建議您採用HAKKO 191/192溫度計測試焊鐵頭溫度。

焊鐵頭

不同款型焊鐵頭的溫度可能有所不同。調節的最理想方法是使用測量焊鐵頭溫度計。（參照第10頁“校準焊鐵頭溫度”）

除了以上的調節方法外，也可以採用下述方法調節。

利用控溫旋鈕按照各款型焊鐵頭溫度調節。

例如： 當使用900M-T-H型溫度在於攝氏400度（華氏750度）時，與900M-T-B型焊鐵頭相差20度。因此必須調節控溫旋鈕為攝氏420度（華氏786度）。

請參閱（第15頁正確）溫度調節表：

排除故障指南

△ 警告：

*進行維修之前應關掉電源，否則可能發生觸電事故。

*若電線損壞，應請廠家或其維修服務代理商或類似之合格人士修理，以免發生傷害身體或損壞電焊臺。

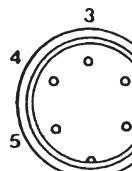
故障1：發熱器指示燈不亮。	檢查1. 電線或連接插頭是否鬆脫? ●重新接妥 檢查2. 保險絲是否燒斷? ●確定保險絲燒斷原因後進行修理，並更換新保險絲。 a. 焊鐵內部是否短路? b. 接地彈簧是否觸及發熱元件? c. 發熱元件引線是否扭曲和短路?
故障2：發熱器指示燈雖亮，但焊鐵頭不昇溫。	檢查3. 焊鐵電線是否破損? ●請參閱“組裝電線破損檢查法”。 檢查4. 發熱元件是否破損 ●請參閱“發熱元件破損檢查法”。
故障3：焊鐵頭斷斷續續地昇溫時。	→檢查3.
故障4：焊鐵頭霑不上鋸錫。	檢查5. 焊鐵頭溫度是否過高? ●重新設定適當溫度。 檢查6. 焊鐵頭是否清理乾淨? ●請參閱“焊鐵頭維護和使用”。
故障5：焊鐵頭溫度太低。	檢查7. 焊鐵頭是否衍生氧化物? ●請參閱“檢查和清理焊鐵頭”。 檢查8. 焊鐵是否正確校準? ●重新校準。
故障6：焊鐵頭拆不開。	檢查9. 焊鐵頭是否被緊夾? 焊鐵頭是否因鏽污而膨脹? ●更換新的焊鐵頭及發熱元件。
故障7：焊鐵頭未昇溫達所需溫度。	→檢查8.

如何檢查發熱元件和組裝電線破損

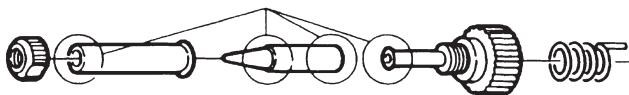
拔出插頭，測試連接插頭的腳與腳之間的電阻值如下：

如果“a”與“b”之間的電阻值有異於上表電阻值，需更換發熱元件（傳感器）和/或電線。請按照程序1和2進行。如果“c”電阻值大於上表電阻值，則要用砂紙或鋼絨輕輕擦除下圖所示部位的氧化層。

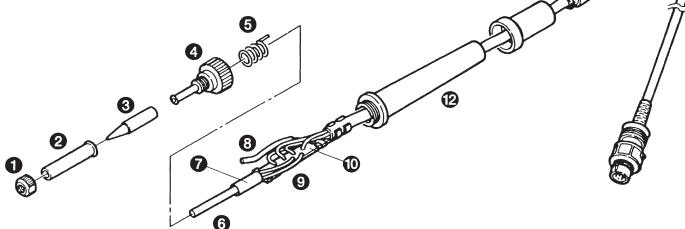
1. 發熱元件破損



a.	第4腳與第5腳之間(發熱元件)	2.5-3.5歐姆(正常)
b.	第1腳與第2腳之間(傳感器)	43-58歐姆(正常)
c.	第3腳與焊鐵頭之間	2歐姆以下



如何拆開907/908型焊鐵



1. 向反時針方向扭開螺帽①，取出焊鐵頭護套②和焊鐵頭③。
2. 向反時針方向扭開套頭④，從焊鐵中拉出套頭。
3. 從手柄⑫中取出發熱元件⑥和電線⑪（向著焊鐵頭方向拉出）。
4. 從D形套中拉出接地彈簧⑤。

當發熱元件回復到室溫時測量：

1. 發熱元件電阻值（紅色）2.5-3.5歐姆
2. 傳感器電阻值（藍色）43-58歐姆

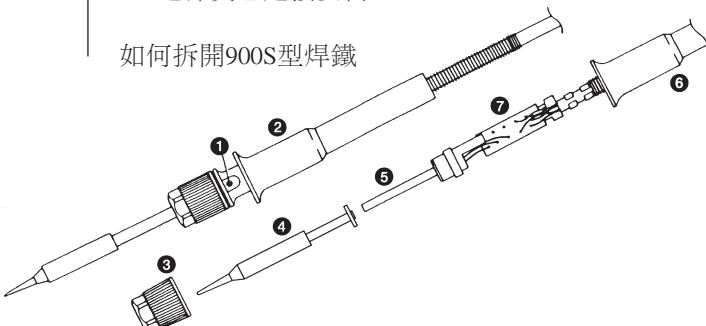
如果電阻值反常，更換發熱元件。

關於更換程序，請參閱更換部件內的說明書。

更換發熱元件後，請進行以下事項。

1. 測量第4腳和第1或第2腳之間，第5腳和第1或第2腳之間電阻值。如果不是 ∞ ，則是發熱元件和傳感器受觸及，這將會損壞印刷電路板。
2. 測量“a”“b”“c”電阻值以確定引線未被扭曲，而接地彈簧也連接妥當。

如何拆開900S型焊鐵



2. 焊鐵電線破損

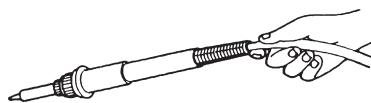
測試焊鐵電線有以下兩個方法：

1. 將手柄護套②從電線方向推移，鬆開栓緊發熱元件的螺絲①。
2. 向反時針方向扭開和取出螺帽③。
3. 取出焊鐵頭④。
4. 向著焊鐵頭方向，從手柄6拉出發熱元件⑤和電線。

測試終端板的傳感器和發熱元件的電阻值。此電阻值應與907和908型一樣。

關於更換程序，請參閱更換部件的使用說明書。

1. 按開焊鐵電源，溫度設定為攝氏480度（華氏896度）。在焊鐵電線的各個不同部位（包括鬆緊部位）搖動或纏結，如果發熱器的液晶指示燈閃亮，則應更換電線。



△ 注意：

雖然焊鐵電線正常，當溫度達到攝氏480度（華氏896度）時，發熱器的液晶指示燈將會閃亮。

2. 測試焊鐵插頭腳和終端板電線之間的電阻值。
腳1-紅色 腳2-藍色 腳3-青色 腳4-白色 腳5-黑色
電阻值應為0歐姆，若大過0歐姆或∞，應更換電線。

3. 更換保險絲

請參閱更換部件的圖示。除去燒斷的保險絲，然後再焊接新的保險絲。

規格

名稱	HAKKO 936
耗電	60瓦特

控制臺

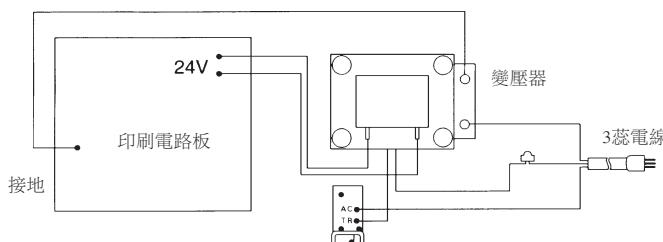
	936電焊臺/936電焊臺ESD
輸出電壓	交流電24伏特
溫度範圍	攝氏200-480度/華氏392-896度
外形體積	寬120x 高93x 深170毫米 / 4.7x3.7x6.7英寸
重量（不包括電線）	1,300克 (2.9磅)

- 焊鐵頭溫度是以HAKKO 191溫度計測量。
- 上述規格和設計可能變更，恕不另行奉告。

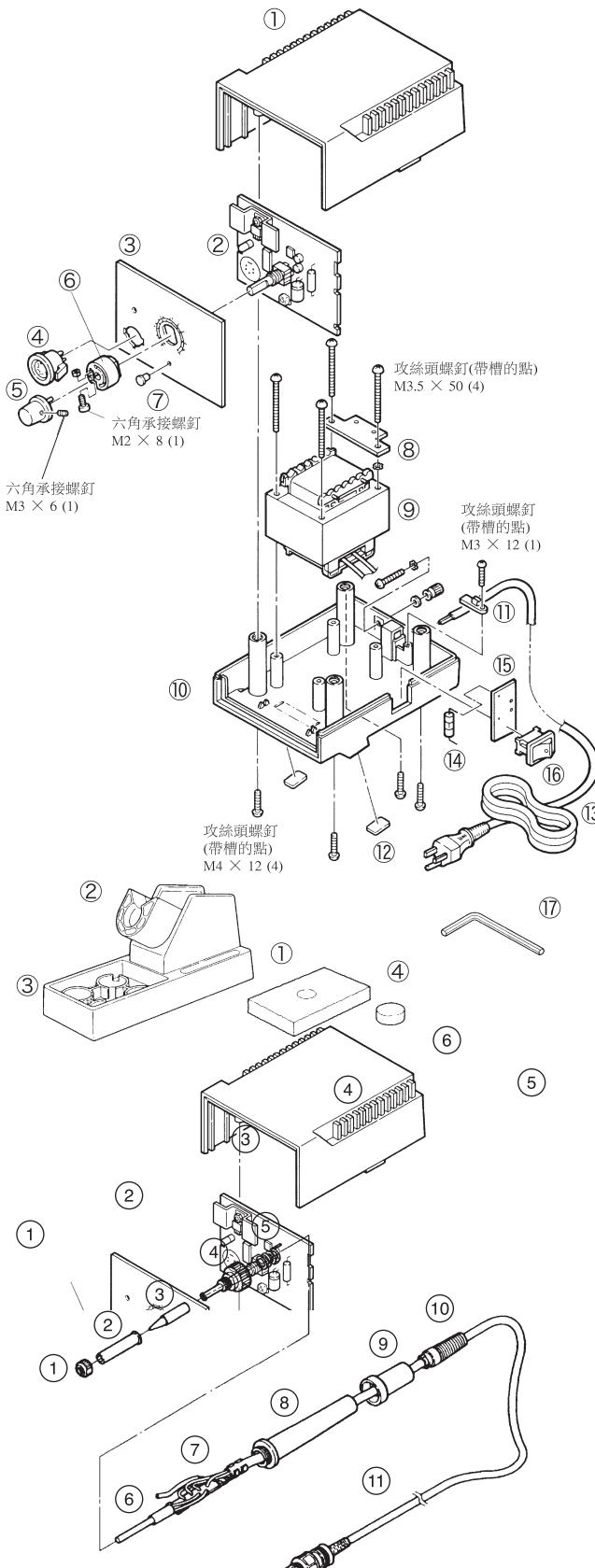
焊鐵

	900S 900S-ESD	907 907-ESD	908 908-ESD
耗電	交流電24伏特-50瓦特		
焊鐵頭至接地電阻	低於2歐姆		
焊鐵頭至接地電勢	低於2毫伏（標準為0.6毫伏）		
發熱元件t	陶瓷發熱器		
電線裝置	1.2米 (4英尺)		
長度（無電線）	176毫米 (7英寸)	190毫米 (7.5英寸)	200毫米 (7.9英寸)
重量（無電線）	25克 (0.061磅)	44克 (0.09磅)	554克 (0.12磅)

電路圖



部件清單 (電焊臺/焊鐵架/焊鐵)



序號	部件編號	部件名稱	說明
①	B2048	上蓋	100 ~ 110 ~ 220-240 V (標準)
	B2225	上蓋 / UL	120 V (標準/UL)
	B2001	上蓋	E.S.D.
②	B2319	印刷電路板	AS/NZS
	B2335	印刷電路板	CE
③	B2003	隔板	E.S.D.
	B2287	隔板	E.S.D.
④	B2006	插座	E.S.D.
⑤	B2004	旋鉗	有六角承接螺釘
⑥	B2005	電鉗	有六角承接螺釘
⑦	B2018	校準計筒狀插頭	
⑧	B2227	接地板	
⑨	B2011	變壓器	100 - 24 伏特
	B2012	變壓器	110 - 24 伏特
	B2228	變壓器	120 - 24 伏特 (標準/UL)
	B2013	變壓器	120 - 24 伏特 (E.S.D.)
	B2014	變壓器	220 - 240 - 24 伏特 (CE)
	B2088	變壓器	240 - 24 伏特 (澳洲)
⑩	B2000	下蓋 (有樹膠塞)	100 ~ 110 ~ 220-240 V (標準/UL)
	B2226	下蓋 / UL (有樹膠塞)	120 伏特 (標準/UL)
	B2002	下蓋 (有樹膠塞)	E.S.D.
⑪	B2015	電線塞	
⑫	B2016	樹膠塞	一套2個
⑬	B1318	電線三芯無插頭	
	B1319	電線三芯美國式插頭	U.S.A.
	B2042	電線三芯澳洲式插頭	
	B2043	電線三芯歐洲式插頭	
	B2098	電線三芯英國式插頭	
	B2327	電線三芯歐洲式插頭	CE
	B2328	電線三芯英國式插頭	U.K.
	B2486	電線三芯中式插頭	
	B3504	電線三芯美國式插頭	
⑭	B2007	保險絲 125V-2 A	100 ~ 110 伏特
	B2224	保險絲 2 A (UL)	120 伏特
	B2008	保險絲 250V-0.8A	220-240 伏特
	B2303	保險絲 0.63A (CE)	230 伏特
⑮	B2103	電源開關用電路板	
⑯	B1084	電源開關	
⑰	B2017	M1.5六角頭扳手	

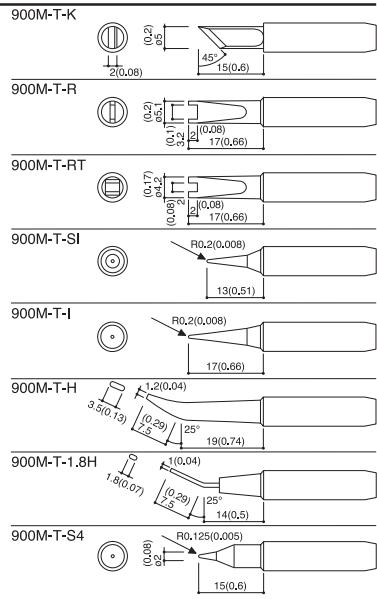
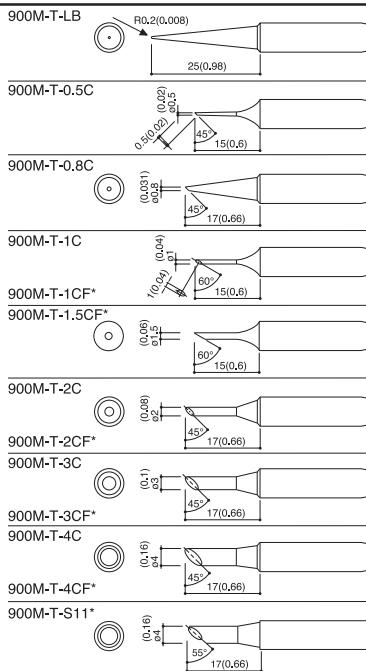
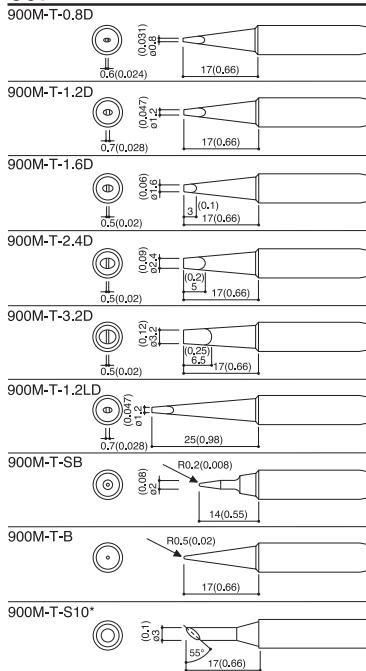
序號	部件編號	部件名稱	說明
①	C1141	焊鐵架	900S
	C1142	焊鐵架	907 ~ 908
②	B2020	焊鐵插座	900S
	B2021	焊鐵插座	907 ~ 908
③	B2019	焊鐵架基座	900S, 907, 908
④	A1042	清潔海綿	900S, 907, 908

序號	部件編號	部件名稱	說明
①	900S-006	螺帽	
	900S-006S	螺帽	E.S.D.
②	C1142	焊鐵頭	參閱第15頁
③	A1322	發熱元件	舊編號900S-H
④	90S-101	終端板	有電線塞
⑤	900S-001	手柄	有手柄護套
	900S-001S	手柄	有手柄護套, E.S.D.
⑥	900S-034	手柄護套	
	900S-034S	手柄護套	E.S.D.
⑦	900S-010	電線束	
⑧	900S-039	組裝電線	
	900S-039S	組裝電線	E.S.D.

序號	部件編號	部件名稱	說明	供用於
①	B1784	螺帽		907
	B1794	螺帽		908
②	B1786	焊鐵頭護套		907
	B1787	焊鐵頭護套		908
③	C1142	焊鐵頭	參閱第15頁	907
	A1322	發熱元件	參閱第15頁	908
④	B2022	套頭		907
	B2023	套頭		908
⑤	B2032	接地彈簧		907 ~ 908
	A1321	發熱元件	舊編號 900M-H 舊編號 900L-H	907 ~ 908
⑦	B2028	終端板	有電線塞	907 ~ 908
⑧	B2023	手柄	有手柄護套	907
	B2024	手柄	有手柄護套, E.S.D.	908
	B2025	手柄	有手柄護套	907
	B2026	手柄	有手柄護套, E.S.D.	908
⑨	B2027	手柄護套		907 ~ 908
⑩	B2031	電線束		907 ~ 908
⑪	B2029	組裝電線		907 ~ 908
	B2030	組裝電線	E.S.D.	907 ~ 908

Tips / 焊鐵頭

907

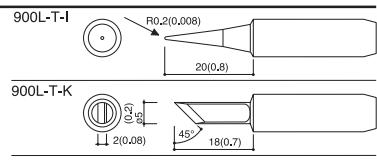
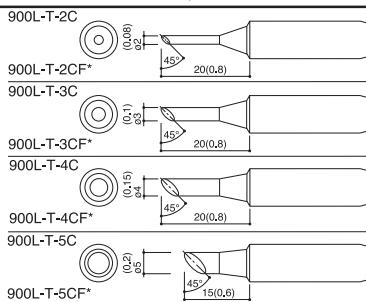
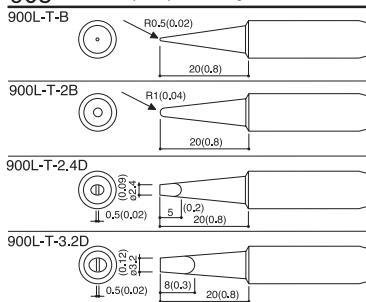


*900M tip Outer Dia. $\Phi 6.5$

*900M型焊鐵頭外徑為 $\Phi 6.5$

908 For heavy duty soldering HAKKO recommends the 908 iron with heavier tips.

*若進行繁重焊接工作,我方建議您選用配備有較強功能焊鐵頭的908型焊鐵。



*900L tip Outer Dia. $\Phi 8.5$

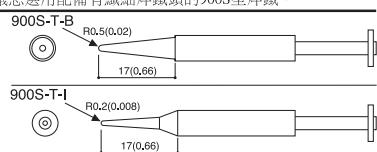
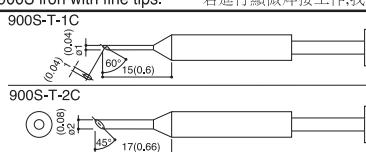
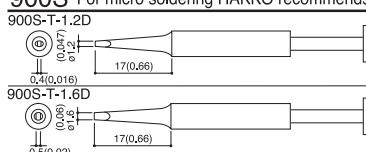
*These tips are tinned flat only.

*900L型焊鐵頭外徑為 $\Phi 8.5$

*此款焊鐵頭只在平坦部份鍍錫。

900S For micro soldering HAKKO recommends the 900S iron with fine tips.

*若進行顯微焊接工作,我方建議您選用配備有纖細焊鐵頭的900S型焊鐵。



*900S tip Outer Dia. $\Phi 5.8$

*900S型焊鐵頭外徑為 $\Phi 5.8$



HAKKO CORPORATION

HEAD OFFICE

TEL:+81-6-6561-3225 FAX:+81-6-6561-8466

<http://www.hakko.com> E-mail:sales@hakko.com

OVERSEAS AFFILIATES

U.S.A.: AMERICAN HAKKO PRODUCTS, INC.

TEL: (661) 294-0098 FAX: (661) 294-0096

Toll Free: (800)88-HAKKO

<http://www.hakkousa.com>

HONG KONG: HAKKO DEVELOPMENT CO., LTD.

TEL: 2811-5588 FAX: 2590-0217

<http://www.hakko.com.hk>

E-mail:info@hakko.com.hk

SINGAPORE: HAKKO PRODUCTS PTE., LTD.

TEL: 6746-2233 FAX: 6744-0033

<http://www.hakko.com.sg>

E-mail:sales@hakko.com.sg

Please access to the following address for
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<http://www.hakko.com>

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