



# **HAKKO 487** SOLDERING SYSTEM

## Soldering Flow Pot Instruction Manual



Thank you for purchasing the HAKKO 487  
Soldering Flow Pot.  
Please read this instruction manual thoroughly  
before operating the HAKKO 487.  
Store the manual in a safe, easily accessible  
place for future reference.



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## SAFETY PRECAUTIONS

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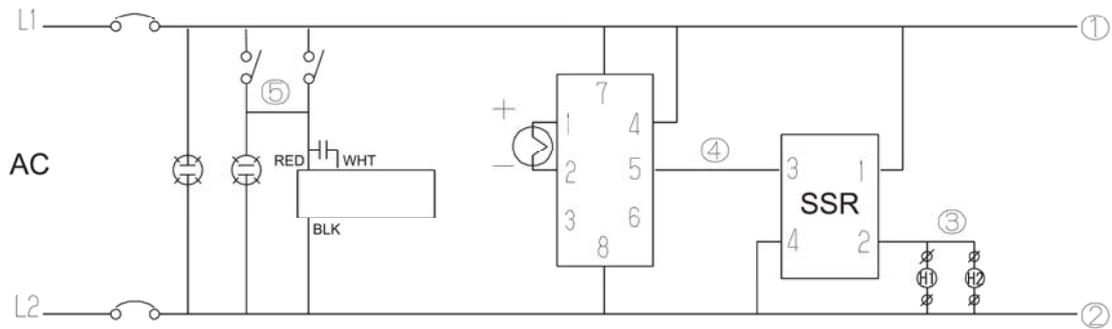
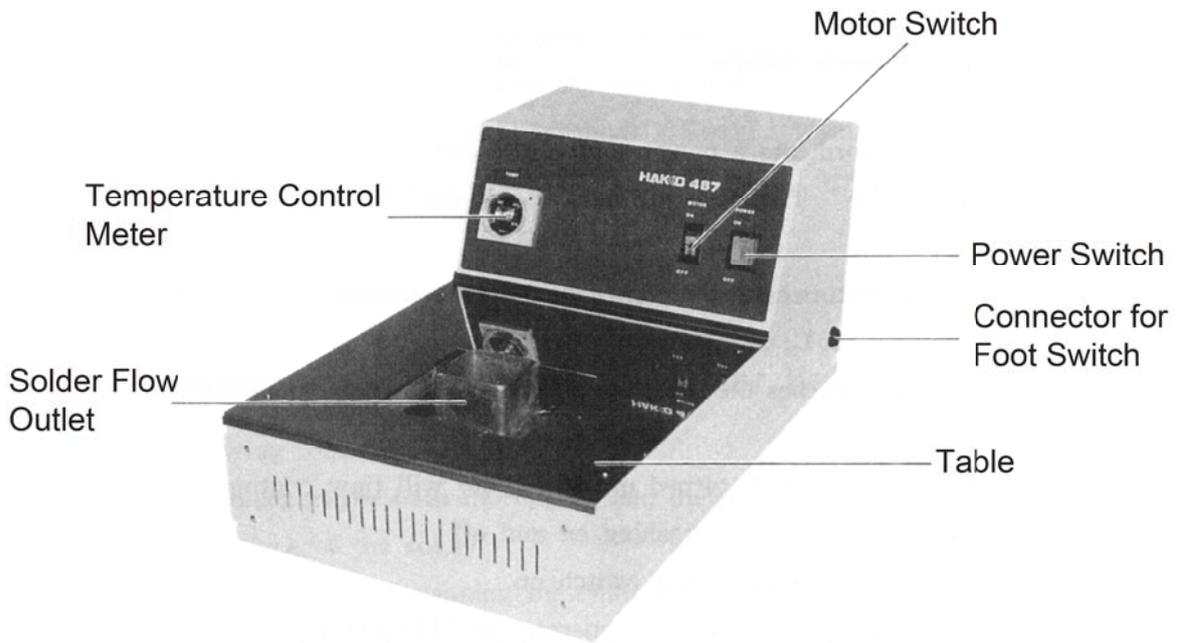
### CAUTION

When the power is on, the solder bath and the unit can reach high temperatures. The temperature of the melted solder in the solder bath is approximately 300°C / 750°F. Mishandling may result in burns or fire. Please make sure to comply with the following rules.

1. Use the product only on highly stable metallic workbench.  
Never use it near paper or other flammable materials.
2. Never put water in the pot as this will cause solder to spatter out of the pot.
3. Turn the power off while taking breaks and when you are finished using the unit.
4. Be careful not to spatter the solder when changing the nozzle.

# 1. CONSTRUCTION

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## 2. OPERATION

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**⚠ CAUTION**

For safety reasons, be sure to ground the unit.

- 1) Plug the power cord into a power source and turn the power switch on the front panel to "ON". The lamp will light up and the heater will begin heating up.
- 2) Adjust the temperature control meter to the desired temperature (between room temperature and 300°C, 572°F).
- 3) When the solder reaches the preset temperature, the lamp will flash on and off.
- 4) When the motor switch is turned on, the solder will flow continuously.  
Be sure the lamp is flashing on and off before turning the motor switch on.  
When using foot switch to operate the HAKKO 487, be sure to first turn the motor switch off.  
Solder will flow when the foot switch is depressed.

**Note:**

The HAKKO 487 is factory-adjusted for use with 60Hz power sources. To use the HAKKO 487 with 50Hz power sources, open the rear panel of the unit, remove the pulley belt from the upper pulley and place it on the lower pulley.

## 3. MAINTENANCE

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- 1) Replacing the heating element
  1. Open the rear panel of the unit and remove the four white leads from the heater connecting terminal.
  2. Remove the table and pull the heat insulating material out away around the solder bath.
  3. Unscrew the nuts securing the heating element with a hex wrench. Push the element forward and remove it from the unit. Replave it with an identical heating element.

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2) Replacing the sensor

Replace temperature control terminals Red(1) and Black(2) by soldering at the back of the unit. Remove the sensor and replace it.

Note:

Temperature control terminal(1) Red(+) terminal.

Temperature control terminal(2) Black(-) terminal.

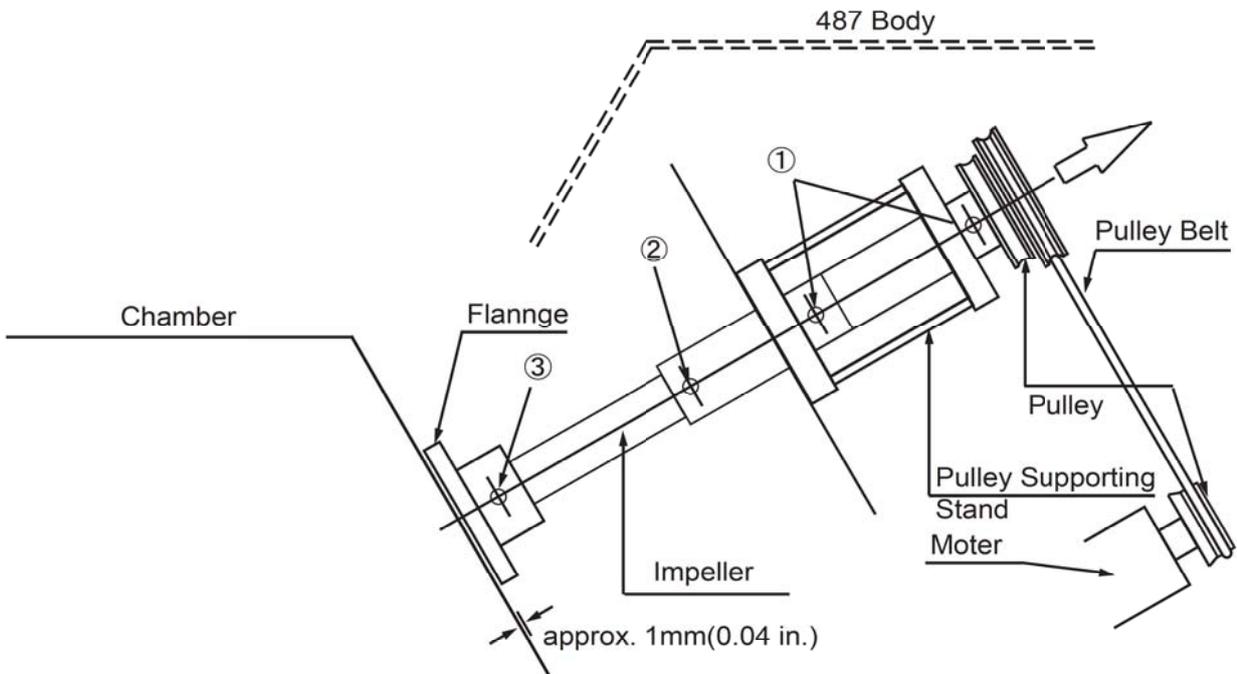
## 4. CLEANING THE INSIDE OF THE SOLDER BATH

1) Removing oxidation

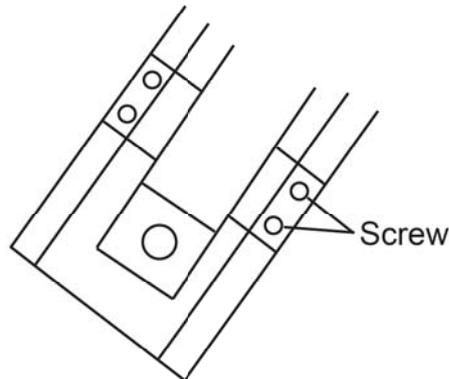
Stir solder in the bath thoroughly and melt it then scrape the oxidation on the surface of the solder.

2) Disassembling and cleaning the chamber

The chamber should be cleaned once a month in order to ensure a smooth and even flow of solder at all times.



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- 1) Turn the power switch on and melt solder in the bath for 30-40 minutes.
  - 2) Remove most of the solder from the bath, leaving just enough so that it is at the level of the flange.  
Loose the hex screw ③(2.0mm, 0.07 in.) securing the flange.
  - 3) Disconnect the power plug from the power outlet.  
Remove the rear cover, and the pulley belt from the pulley of the impeller and the motor.  
Remove the two screws ① and ② on the pulley supporting stand.  
Pull up the pulley in the direction of the arrow and pull down the impeller.
  - 4) Remove the four screws securing the chamber to the unit and remove the chamber.



- 5) Remove any oxidation in the chamber by patting the side and bottom of the chamber and clean it up.
- 6) Insert the impeller into the pulley supporting stand and secure them with screws ① and ②. Place the chamber on the solder bath. Attach the pulley belt on the pulley of the impeller and the motor.  
Decure the chamber to the unit with the 4 chamber screws.

**Note:**

Install the impeller so that it does not touch the bottom plate when the motor is turned on.

- 7) Secure the impeller and the flange.

## 5. SPECIFICATIONS

Name	HAKKO 487
Power Consumption	850W
Temperature Control	normal temperature ~300°C (572°F)
Bath Capacity	approx. 15kg (33lbs.)
Heating Element	400W × 2(cartridge heater)
Outer Dimensions	330(W) × 500(D) × 250(H) mm
	(13 × 19.7 × 9.8 in.)
Weight	approx. 25kg (55lbs.) w/o solder

\*Specifications are subject to change without notice.

### Spare Parts

Part No.	Part Name
487-101	Pulley belt

### Option

Part No.	Part Name
487-101	Pulley belt

### 中国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)
電動機	×	○	○	○	○	○
溫控計	×	○	○	○	○	○
○：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。						



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