HAKKO

WAVE SOLDERING POT

FX-310

Instruction Manual

Thank you for purchasing a HAKKO product.
This product is a flow-type soldering pot.
Make sure to read this manual before using the product,
and keep it in a safe place for future reference.

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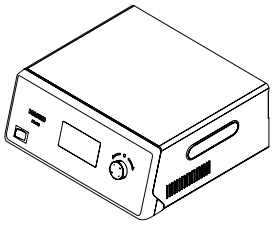
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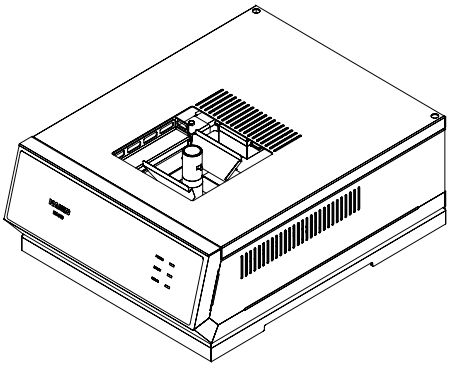
1. Set contents

Confirm the contents before use.

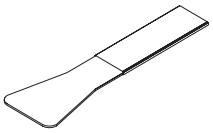
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Control box



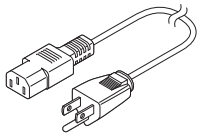
Soldering pot main unit



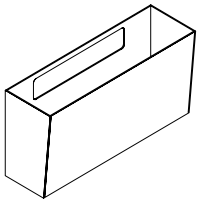
Spatula



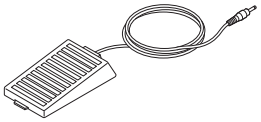
Level



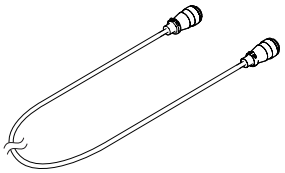
Power cord



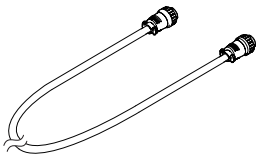
Solder waste collector



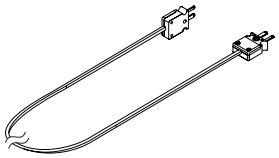
Foot switch



Connection cable (for control)



Connection cable (for power)



Connection cable (for temperature sensor)

See the web page for the product information such as replacement parts/options.
https://www.hakko.com/doc_fx310-e

2. Specifications

Power consumption	1050 W
Temperature range	150 to 380 ºC (300 to 720 ºF)

Control box

Dimensions	253 (W) ×107 (H) ×248 (D) mm (10×4.2×9.8 in)
Weight	2.3 kg (5.1lb)

Soldering pot main unit

Dimensions	350 (W) ×210 (H) ×480 (D) mm (13.8×8.3×18.9 in) (When adjusters are fully extended)
Weight	18 kg (39.7 lb)
Solder pot dimensions (inner)	136 (W) ×69 (H) × 200 (D) mm (5.4×2.7×7.9 in)
Molten solder capacity	Leaded solder: Approx. 10 kg (22 lb) Lead-free solder: Approx. 9 kg (19.8 lb)

- The weight excludes the cords and solder.
- The molten solder capacity is measured using leaded solder: Sn-37Pb, and lead-free solder: Sn-3.0Ag-0.5Cu.
- Please note that the specifications and appearance are subject to change without prior notice for the purpose of improvement.

3. Warnings, cautions, and notes

Warnings, cautions, and notes are placed at critical points in this manual to direct your 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.

NOTE: This indicates procedures or information that are important in a process described in this document.

3. Warnings, cautions, and notes (cont'd)

Be sure to observe the following precautions to ensure safety.

⚠ WARNING

- This appliance can be used by children aged from 8 years and above and persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge if they have been given supervision or instruction concerning use of the appliance in a safe way and understand the hazards involved.
- Children shall not play with the appliance.
- Cleaning and user maintenance shall not be made by children without supervision.
- When the power source is turned on, the solder and the pot reach high temperatures. You may risk getting burned or causing a fire if mishandled.
- Use the product on a stable metal workbench and make sure there are no flammable materials nearby.
- Do not put water into the pot. It is dangerous because solder may scatter.
- Do not touch any metal parts around the pot with bare hands.
- When performing work, be sure to wear heat-resistant gloves and safety goggles.
- Do not place anything that easily burns or ignites near the product.
- Make sure that people nearby are aware of the "high temperature danger".
- When the product is not in use, or before repair or cleaning, turn the power switch off and disconnect the plug from the power outlet.

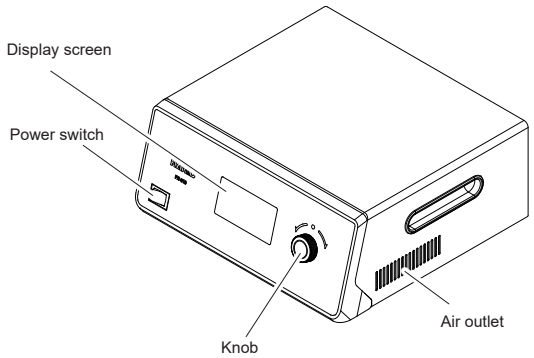
Failure to observe the following precautions to ensure safety might result in electric shock, malfunction or other trouble.

⚠ CAUTION

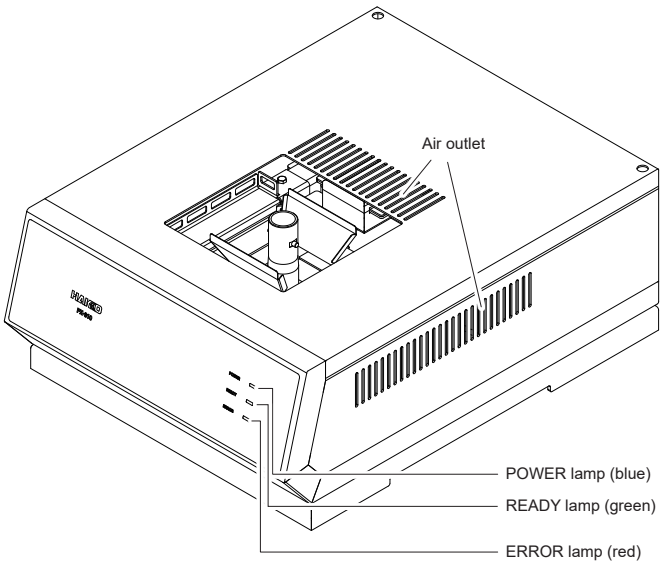
- Before using this product, fully read all descriptions in this document.
- Only use the product for soldering.
- When soldering, smoke and fumes are generated, so please work in a well-ventilated area.
- Do not block the air inlet or air outlet of the control box and the soldering pot main unit.
- Use genuine HAKKO parts for included parts/replacement parts/options.
- When replacing the flow nozzle, exercise sufficient caution to prevent solder from splattering.
- If the amount of solder is insufficient, the flow may stop and the heater may overheat, so be sure to maintain the appropriate amount of solder in the pot.
- Do not modify this product.
- Do not use damaged cords or plugs. Doing so can result in malfunction or injury.
- Do not use the product if it has been dropped or shows signs of damage.
- When inserting and removing the cord, hold the plug body and do not pull the cord.
- Do not allow this product to get wet. Also, do not handle it with wet hands.
- Please perform maintenance regularly.
- When replacing the flow nozzle or performing maintenance, always wear long-sleeved work clothing, protective goggles, and heat-resistant gloves.
- Because this product is heavy, it should be carried by at least 2 people to avoid potential injury or accident.
- Do not perform any other actions that may be considered to be dangerous.

4. Names of parts

●Control box



●Soldering pot main unit



●Lamp

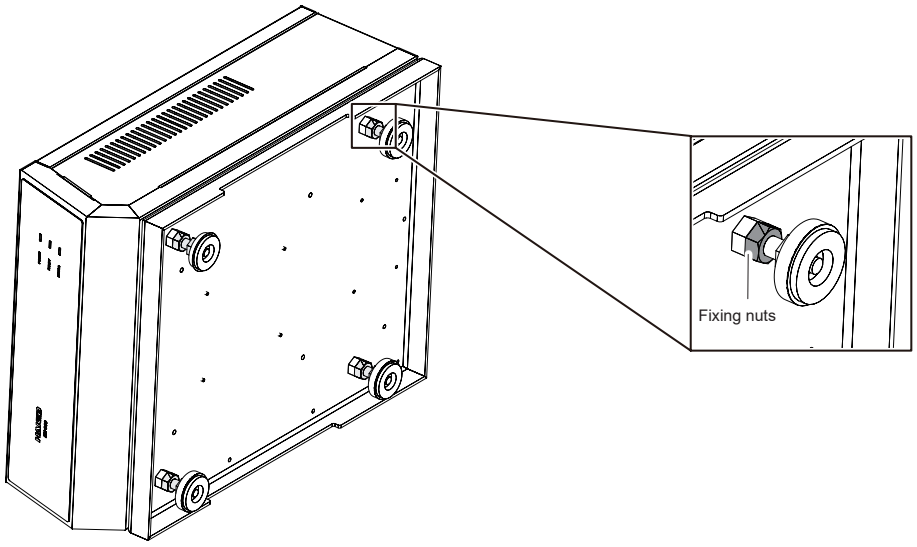
POWER lamp: When the power is turned ON, the blue lamp will light up.
READY lamp : When the set temperature is reached, the green lamp will light up.
ERROR lamp : If an error occurs, the red lamp will light up.

5. Initial setup

5-1. Level adjustment of the soldering pot main unit

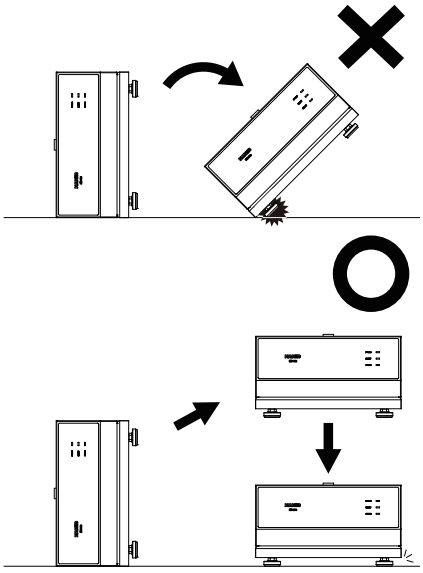
To ensure uniform solder flow, it is necessary to level the solder pot body.

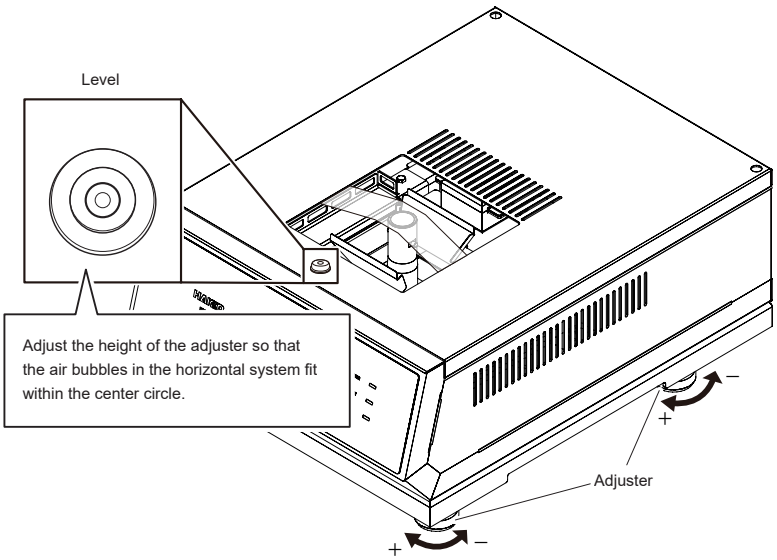
(1) Place the solder pot unit on its side and use a wrench (size 17 mm) to loosen the fixing nuts on the adjusters.



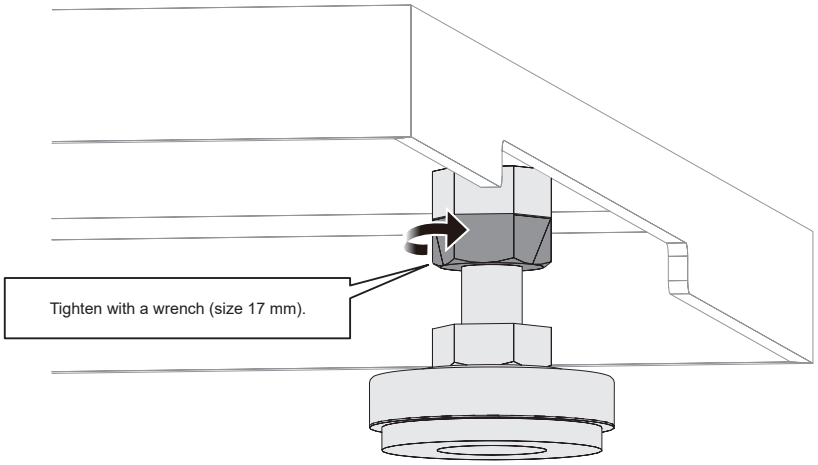
(2) Install the soldering pot main unit on a level surface and use a level to confirm that the main unit is level.
If it is not level, turn the adjusters to adjust the height and bring the main unit to a level position.

NOTE Do not tip the soldering pot main unit onto the adjusters. Place the unit horizontally.



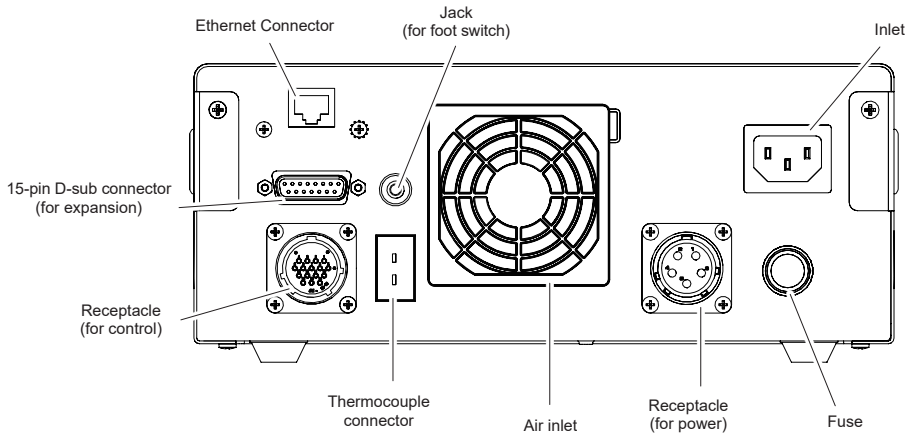


(3) Tighten the fixing nuts using a wrench (size 17 mm).

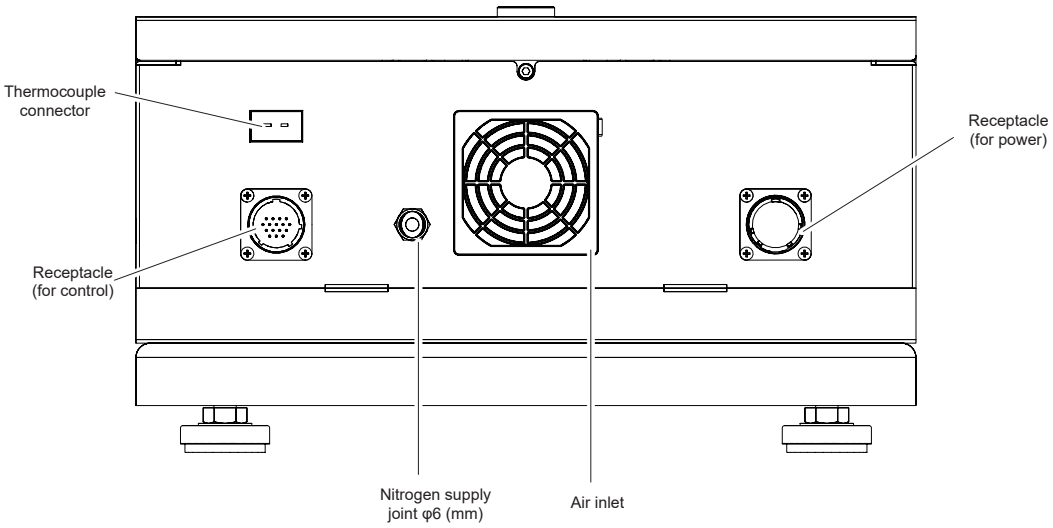


5-2. Connecting the control box and the soldering pot main unit

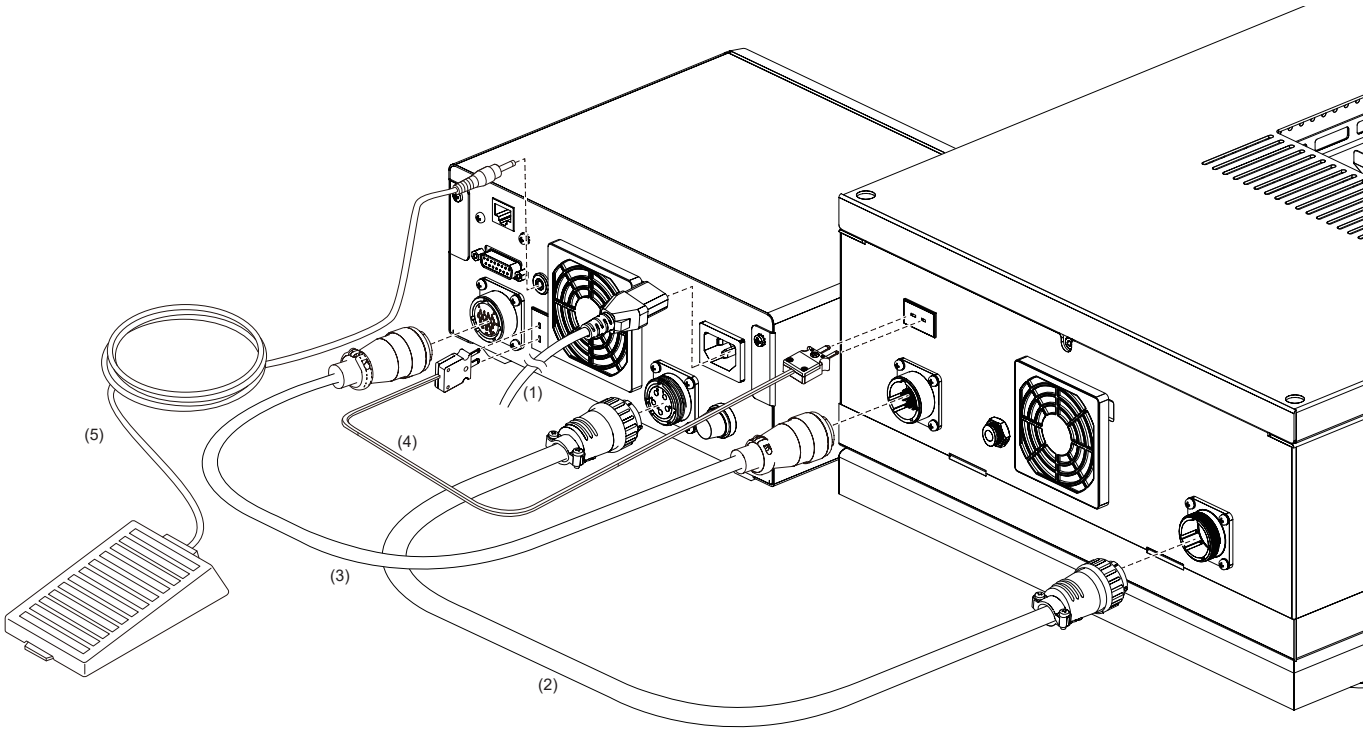
●Rear of control box



●Rear of soldering pot main unit



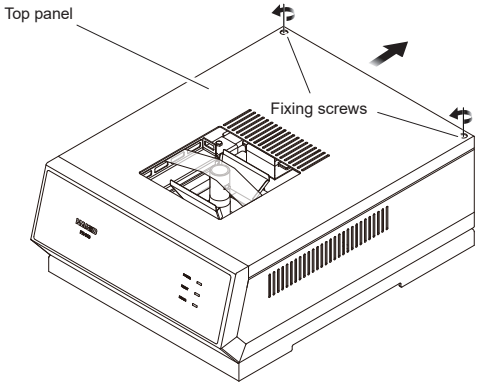
●Connection

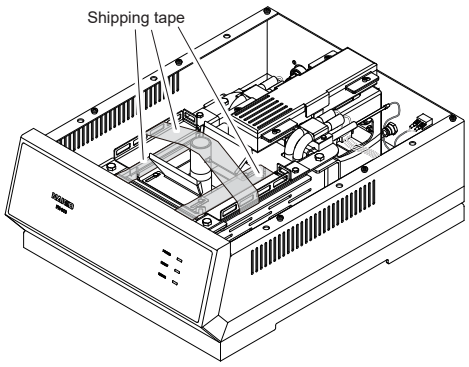


(1) Insert the power cord into the inlet on the rear of the control box.
(2) Connect the power cable between the two units.
(3) Connect the control cable between the two units.
(4) Connect the temperature sensor cable between the two units.
(5) Connect the foot switch.

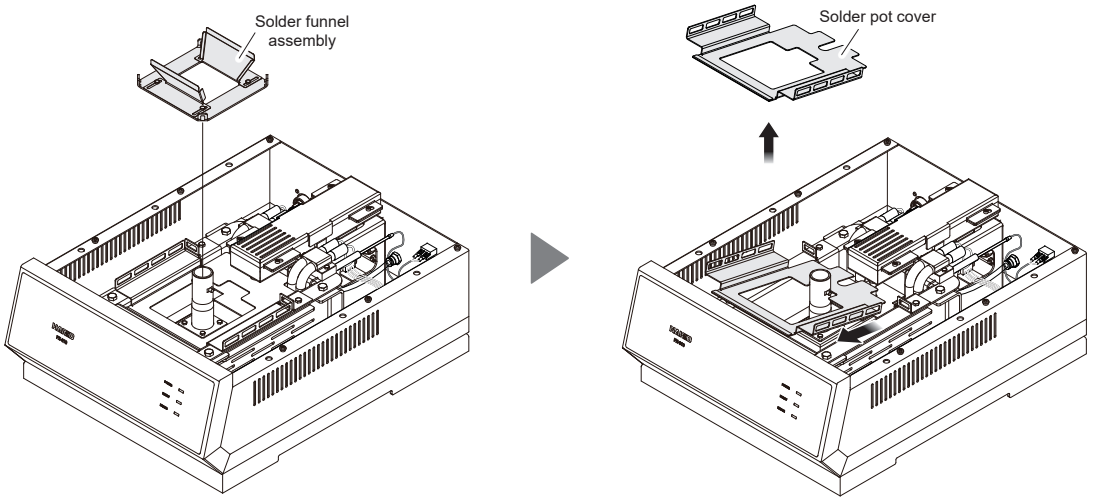
5-3. Preparations

(1) Loosen the fixing screws on the top plate of the solder bath body using a phillips screwdriver. (PH2)
(2) Slide the top panel toward the rear and remove it.
(3) Remove the shipping tape used to secure the solder pot cover.

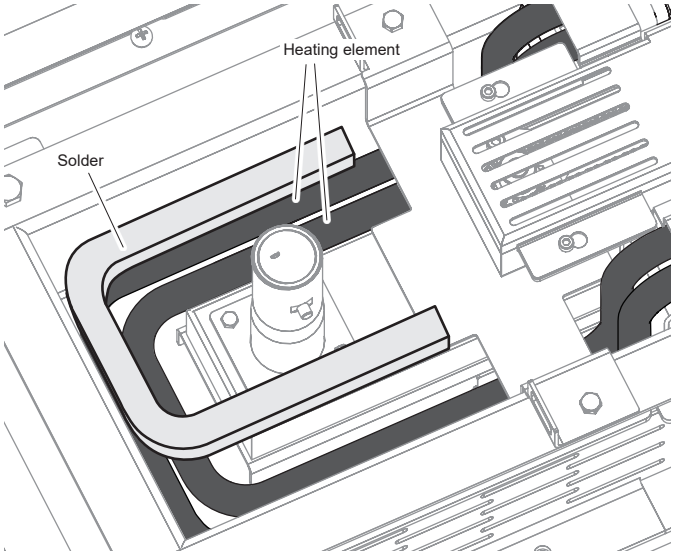




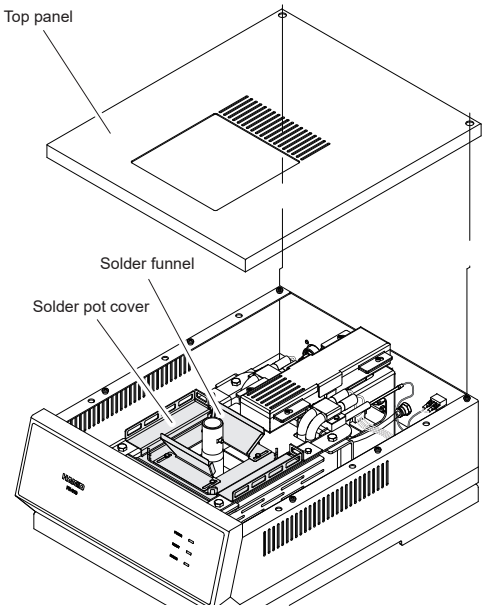
(4) Remove the solder funnel assembly and the solder pot cover in sequence.



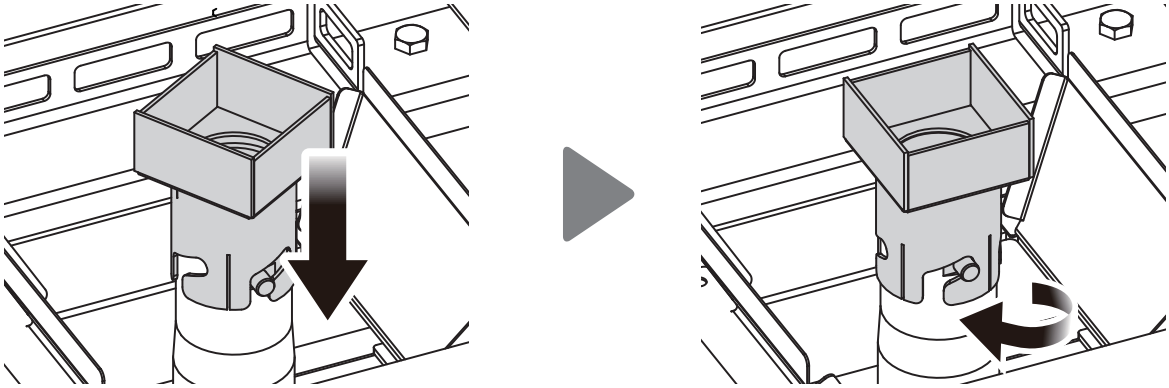
(5) Put solder into the pot.
*Bending and placing solder on top of the heating element will accelerate solder melting.
*The recommended proper amount of solder is 9 kg (19.8 lb).



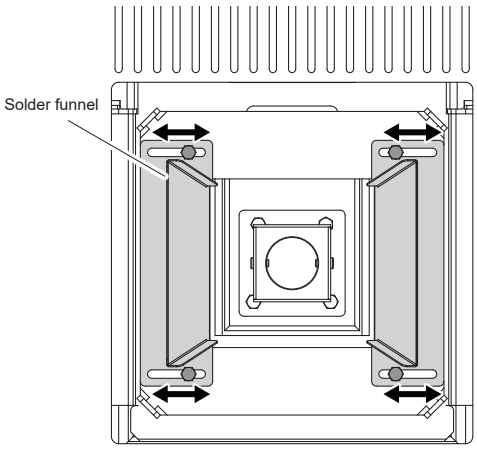
(6) After installing the solder funnel assembly and the solder pot cover, check that there is no internal damage, and then reinstall the top panel.

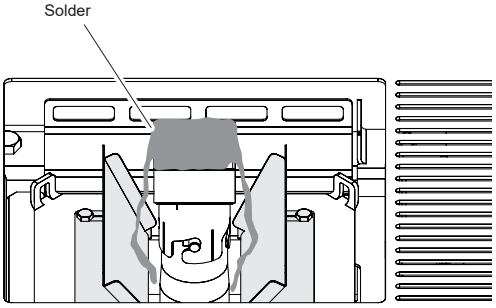


(7) Attach the nozzle (sold separately).



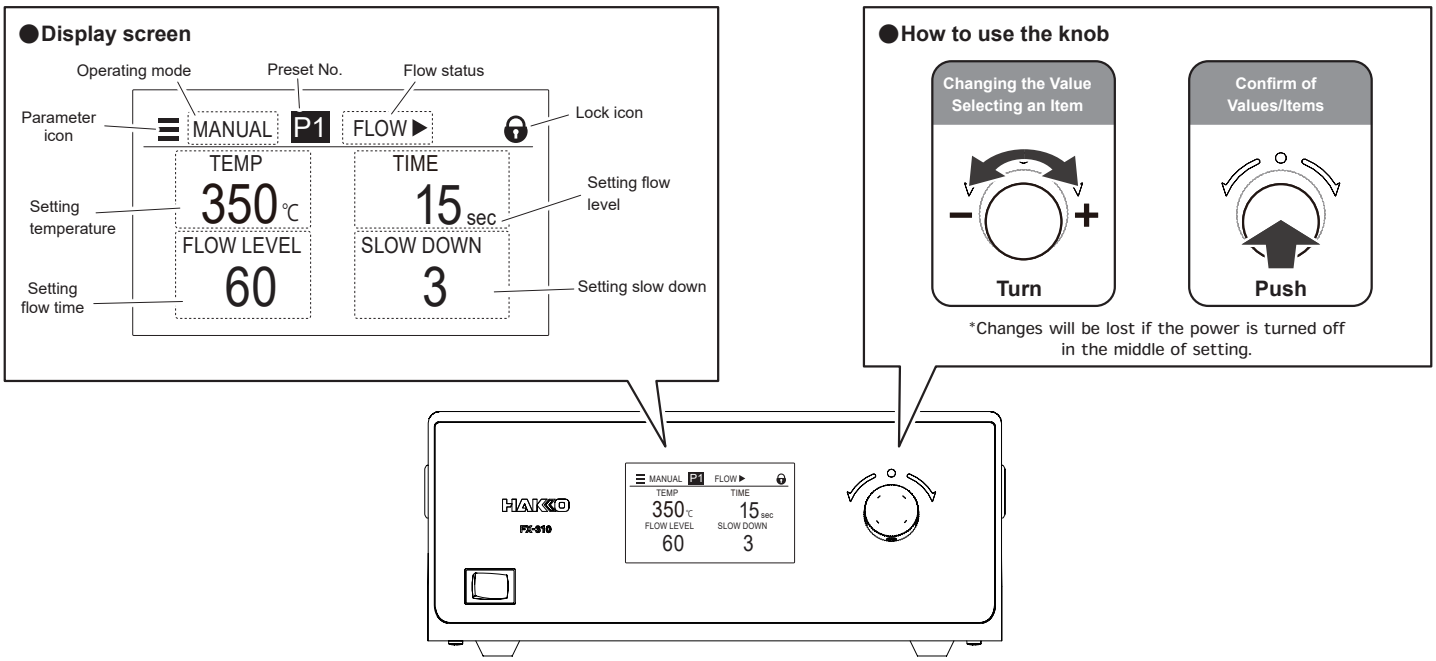
(8) Adjust the solder funnel by loosening the hexagonal bolts with a box driver (size 5.5 mm) according to the shape and orientation of the nozzle.
*Solder flows from the notch.





6. Operation

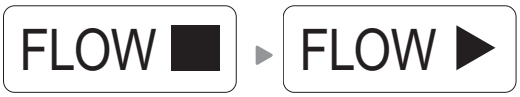
6-1. Control box



●How to use the foot switch

(1) Make sure that the solder is completely melted.

(2) When the foot switch is pressed, solder will flow. The screen display will also change from ■ to ▶ .



Flow stopped　　Flow in progress

MANUAL

While the foot switch is depressed, solder will be flow.
Releasing the foot switch stops the solder flow.

AUTO

Pressing the foot switch once starts the solder flow. When the set flow time reaches 0, the solder flow stops automatically.
(Factory default settings: 15 seconds)
If the foot switch is pressed again within the set flow time, the flow will stop and the unit will return to standby status.

(3) During flow, the flow level can be adjusted.

(4) Turning the knob to the right increases the flow level. Turning it to the left decreases the flow level.

NOTE For the initial setting, gradually increase the flow level from a small value to adjust the flow height.

NOTE Please use caution when setting a high flow level as it may cause solder to spurt out quickly.

6-2. Operation

⚠ CAUTION

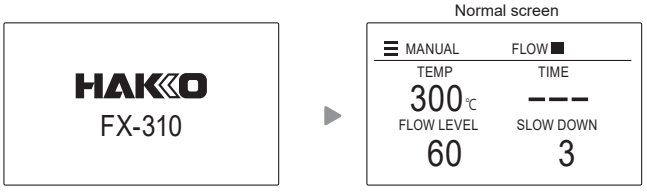
●The top plate of the solder pot and flow outlet become extremely hot. Do not touch with bare hands.
●Make sure the solder is completely melted before starting the flow.

(1) Turn the power ON. The POWER lamp lights up blue.

(2) The display screen on the control box changes as follows.

(3) The temperature of the solder rises.

(4) When the unit reaches the set temperature (factory default: 300 ºC / 580 ºF), the READY lamp lights up green.

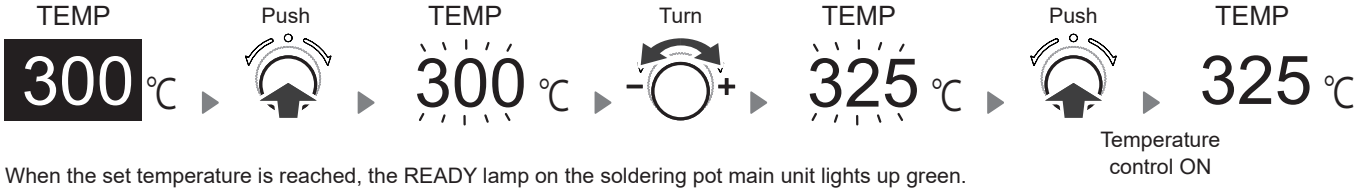


■ Changing the temperature setting

Factory default setting: 300ºC / 580ºF

Turn 	Turn the knob to move the cursor to **TEMP**. The set temperature can be changed. (Setting range: 150 to 380°C / 300 to 720°F)

▼ **To change to 325 ºC**



When the set temperature is reached, the READY lamp on the soldering pot main unit lights up green.

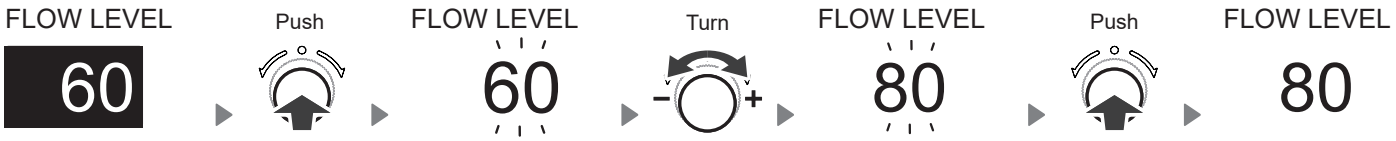
To restrict changes to the setting, change the setting in the parameter [**Lock Mode**].

■ Flow level setting

Factory default settings: 60

Turn 	Turn the knob to move the cursor to **FLOW LEVEL**. The flow level can be changed. (Setting range: 1 to 100)

▼ **To change to 80**



To restrict changes to the setting, change the setting in the parameter [**Lock Mode**].

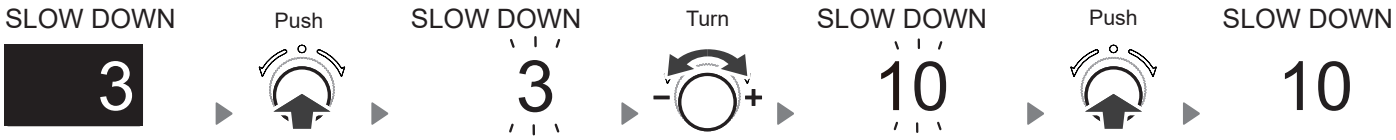
■ Slow down setting

Factory default settings: 3

If bridging or icicles occur due to the pitch of the component leads, adjust the slow down setting to reduce defects.

Turn 	Turn the knob to move the cursor to **SLOW DOWN**. The slow down setting can be changed. The higher the value, the faster the descent speed. (Setting range: 1 to 20)

▼ **To change to 10**



To restrict changes to the setting, change the setting in the parameter [**Lock Mode**].

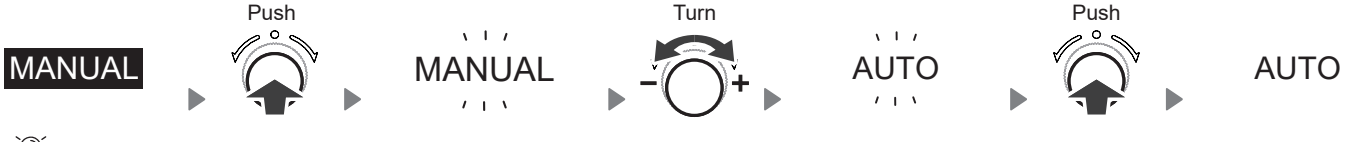
■ Changing the operating mode

(Factory default settings: MANUAL)

This product has two selectable operating modes (**MANUAL** / **AUTO**).
The appropriate mode can be selected according to the work requirements.

Turn 	Turn the knob to move the cursor to the operating mode. The operating mode can be changed.

▼ **To change to AUTO**



To restrict changes to the setting, change the setting in the parameter [**Lock Mode**].

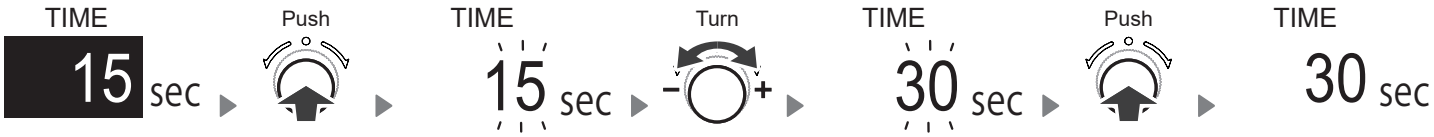
Setting the flow time

(Factory default settings: 15 seconds)

When set to **AUTO** mode, this product will automatically flow for a set time. The flow time can be set as required.

Turn 	Turn the knob to move the cursor to **TIME**. The flow time can be changed. (Setting range : 1 to 999 seconds)

▼ **To change to 30 seconds**



To restrict changes to the setting, change the setting in the parameter [**Lock Mode**].

Changing the preset No.

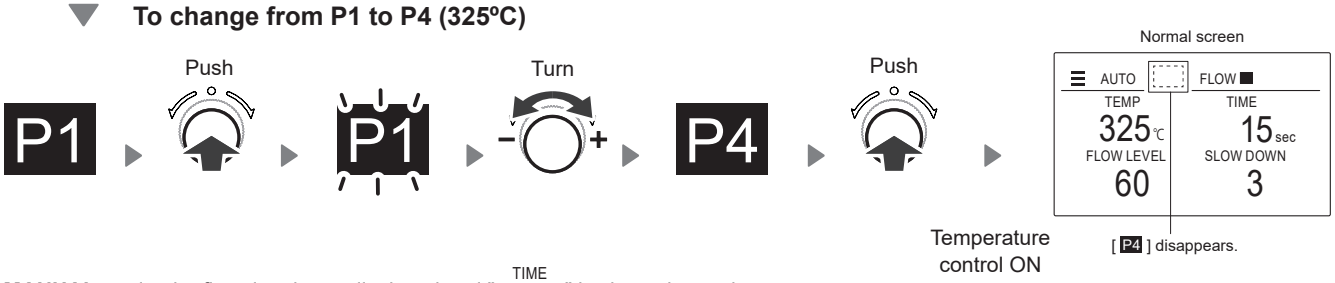
This product registers five frequently used settings and changes the settings by selecting the registration No..

Factory default settings

Preset No.	P1	P2	P3	P4	P5
Setting temperature	250 ºC (480 ºF)	275 ºC (530 ºF)	300 ºC (580 ºF)	325 ºC (620 ºF)	350 ºC (660 ºF)
Flow time	15 seconds	15 seconds	15 seconds	15 seconds	15 seconds
Flow level	60	60	60	60	60
Slowdown level	3	3	3	3	3

Turn 	Turn the knob to move the cursor to the preset No.. Select one of the five registered settings.

▼ **To change from P1 to P4 (325ºC)**



*In **MANUAL** mode, the flow time is not displayed and " TIME ___ " is shown instead.

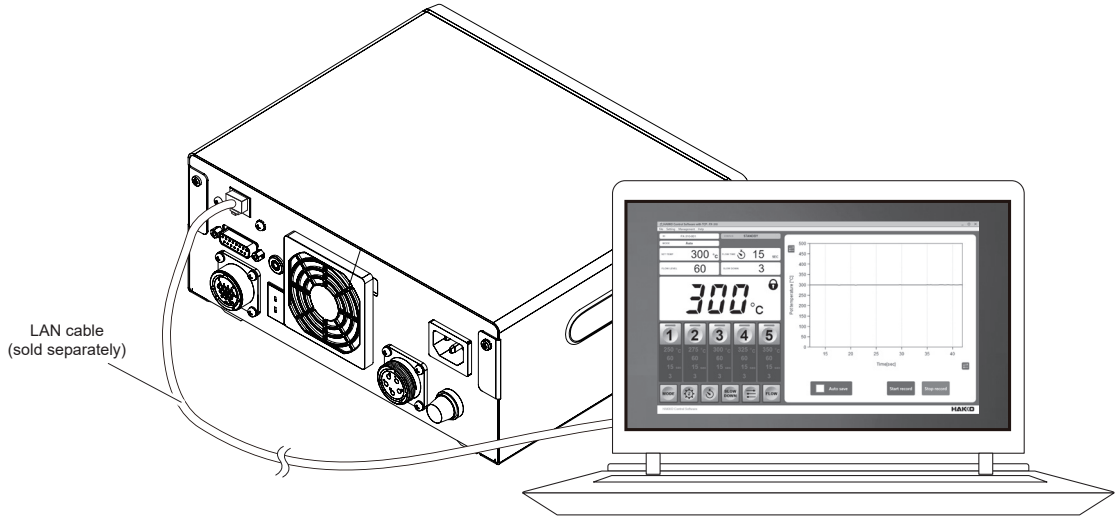
The setting temperature, flow time, flow level, and slow down setting for each preset No. can be changed in the parameter [**Preset**].
(See "8. Parameter setting" (p.11))

To restrict changes to the setting, change the setting in the parameter [**Lock Mode**].

7. Connecting to a computer

The following will become available when the software is installed.

- Change the parameter setting value from the PC
- Save the parameter settings as a CSV file
- Copy the saved parameter settings on another unit



7-1. Operating environment

Supported OS	Windows 10, Windows 11 (Excluding ARM-based Windows)
CPU	1GHz or faster processor or SoC (Excluding ARM processors)

Supported operating systems are based on information as of August 2026 and are subject to change.
The latest information is available on the HAKKO website.

7-2. Downloading the Software (Online)

(1) Go to the HAKKO website and visit **[Customer support \ Support & service \ Login / Signup]**.

https://www.hakko.com/doc_support-e

(2) Follow the on-screen instructions to complete user registration. Once user registration is complete, you can use My Page.

(3) Click **[My page (Product registration from here)]** to register the product.

NOTE The Software cannot be downloaded until product registration has been completed.

(4) Click **[Download of product data]** from the menu at the top right of the page.

(5) Select **[SOFTWARE]** in the document search area.

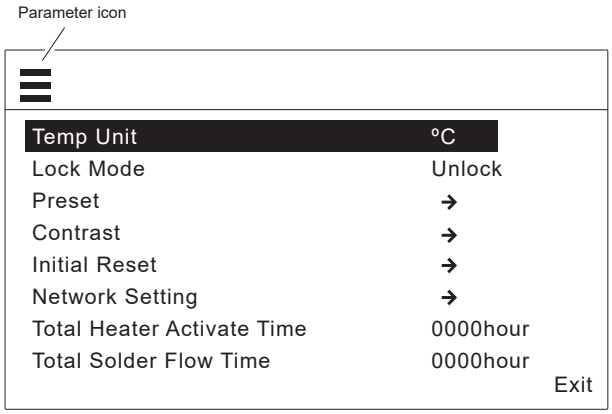
(6) Enter the product name as a keyword.

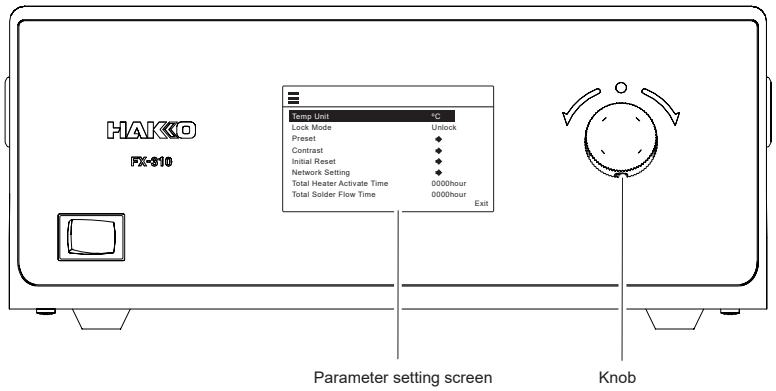
(7) Select a language, and then click **[Search by Condition]**.

(8) Click **[Download]** in the search results.

For installing the software and operation, refer to the manual included in the downloaded data.

8. Parameter setting





Parameter	Parameter name / summary	Setting value
Temp Unit	**Display temperature unit** Select from ºC or ºF. ●All set values are converted to the changed display temperature unit.	ºC / ºF
Lock Mode	**Password lock** Restrict changes to setting value. Limit the scope of change using a combination of six characters [**A**] [**B**] [**C**] [**D**] [**E**] [**F**] and three digits. Select [**Unlock**]..... None are locked Select [**Lock**] ..... Locks all Select [**Partial**] → [Operation Mode set] ..... Lock the operation mode. Select [**Partial**] → [Temp set] ..... Lock the set temperature Select [**Partial**] → [Flow Time set]..... Lock the flow time Select [**Partial**] → [Flow Level set]..... Lock the flow level Select [**Partial**] → [Slow Down set] ..... Lock the slow down setting Select [**Partial**] → [Preset Select]..... Locks preset selection	Unlock / Lock* / Partial* *When selected, a lock icon [🔒] appears on the right side of the normal screen.
Preset	**Preset settings: Change each setting** You can register up to five combinations of set temperature, flow time, flow level, and slow down setting. This function saves time when changing the setting.	Setting Temp: 150 to 380ºC (300 to 720ºF) Flow Time : 1 to 999 sec Flow Level : 1 to 100 Slow Down : 1 to 20

(1) Turn the knob to move the cursor to the parameter icon.

(2) Push the knob.

(3) Use the knob to change the setting.

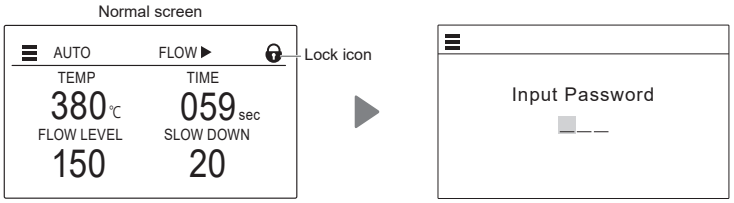
(4) Turn the knob to move the cursor to [**Exit**].

(5) Push the knob.

(6) The normal screen reappears.

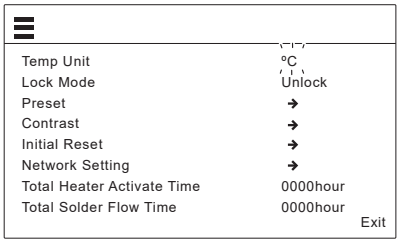
Note

- If the power is turned off while configuring settings, the changes may be lost.
- If you set the password in **[Lock Mode]** the lock icon appears on the normal screen and a password prompt appears before transitioning to the parameter setting screen.
  Contact us if you do not know the password.
  E-mail: support@hakko.com

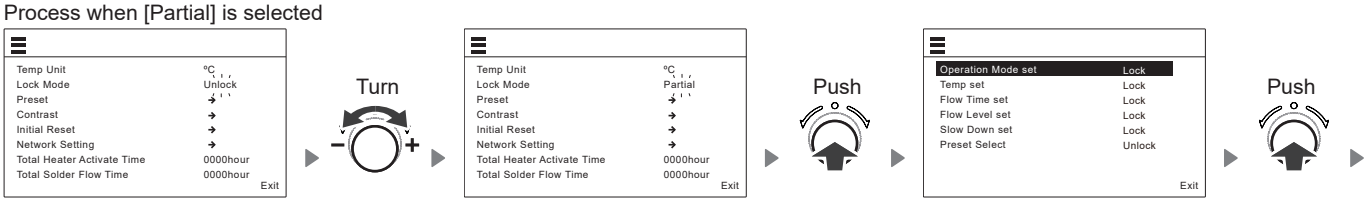


Default values are factory default settings.

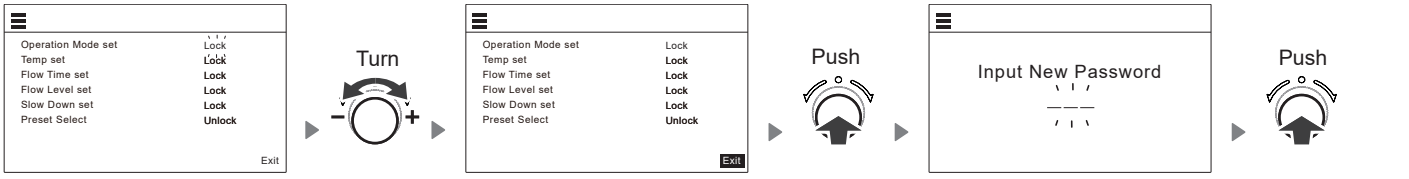
	Default value (Value when implementing [Initial Reset]) / Procedure



Process when [Partial] is selected



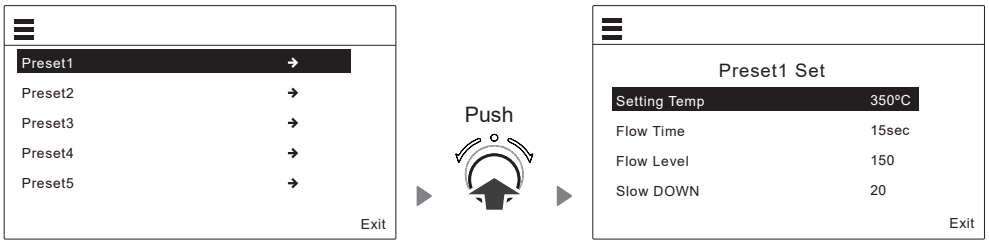
Use the knob to cycle through [Lock] ↔ [Unlock] ↔ [Partial].



Use to set [Lock] or [Unlock] for each item.

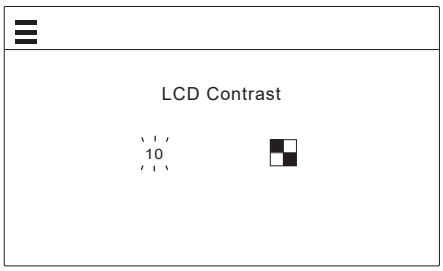
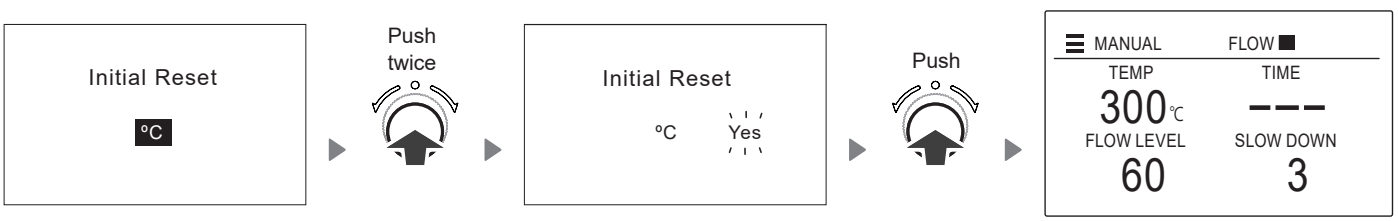
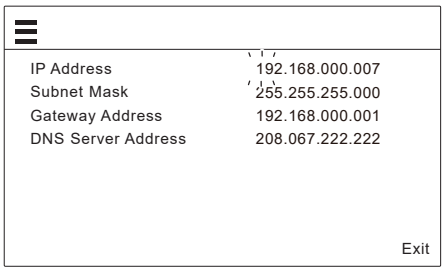
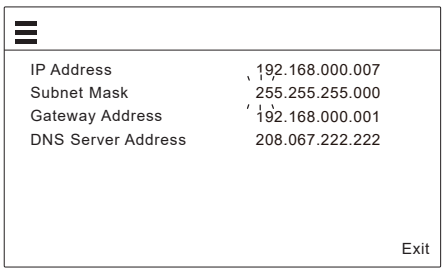
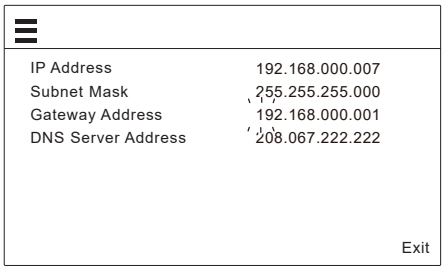
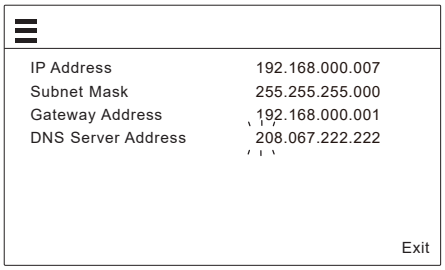
After completing the configuration of each item, move the cursor to [**Exit**].

Use to set [Lock] or [Unlock] for each item.



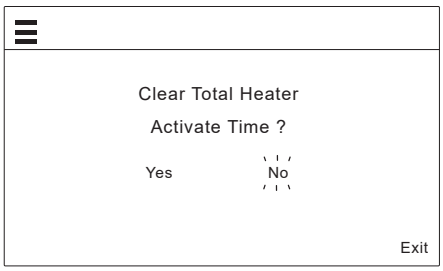
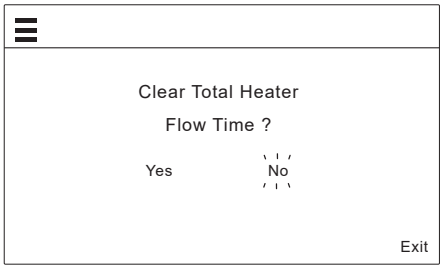
8. Parameter setting (cont'd)

Parameter	Parameter name / summary	Setting value
Contrast	**LCD contrast** Set the contrast of the LCD display.	1 to 20
Initial Reset	**Initial reset** Reset the product to factory default settings.	ºC / ºF
Network Setting	**Network setting** These are network settings for connecting to a PC. Setting the IP address, subnet mask, gateway address, and DNS server address. * When configuring settings, consult your network administrator.	IP Address
		Subnet Mask
		Gateway Address
		DNS Server Address

	Default value (Value when implementing [Initial Reset]) / Procedure
	
	
	
	
	
	

8. Parameter setting (cont'd)

Parameter	Parameter name / summary	Setting value
Total Heater Activate Time	**Cumulative heating element time** Displays the cumulative amount of time the heating element has been in operation. Range from 0 to 9999 hours. Select [**Yes**] ..... Resets the accumulated time. Select [**No**]..... Continues the time accumulation. ●When 9999 hours is exceeded, the accumulation stops and the display maintains [**9999 hour**].	Yes / No
Total Solder Flow Time	**Cumulative solder flow time** Displays the cumulative duration of solder flowing. Range from 0 to 9999 hours. Select [**Yes**] ..... Resets the accumulated time. Select [**No**]..... Continues time accumulation. ●When 9999 hours is exceeded, the accumulation stops and the display maintains [**9999 hour**].	Yes / No

	Default value (Value when implementing [Initial Reset]) / Procedure
	
	

9. Maintenance

⚠ CAUTION

- Turn the power off and unplug the power cord before inspecting or replacing any internal components.
- During maintenance, be careful not to drop screws, washers, or spacers into the solder pot.

Conducting maintenance will help keep the product in good condition and prolong the usage of the unit.

9-1. Inspection

⚠ CAUTION

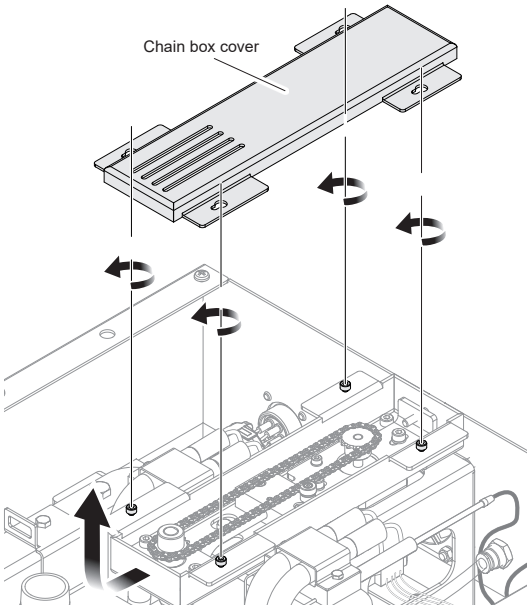
Perform inspection after confirming that the soldering pot main unit has sufficiently cooled down.

9-1-1. Inspection of the chain

(1) Remove the top panel of the soldering pot main unit.
(See "5-3. Preparations" (p.5))

(2) Loosen the screws of the chain box cover using a hex wrench (size 2.5 mm).

(3) After sliding the chain box cover forward, lift it upward and remove it.



(4) Check the chain tension.
If the idler height and the chain height are aligned, there is no issue with the chain tension.

(5) If the chain tension is abnormal, turn the screws with a hex wrench (size 3 mm) and move the tension adjustment plate to adjust the chain tension.

NOTE Excessive chain tension can also cause a malfunction.

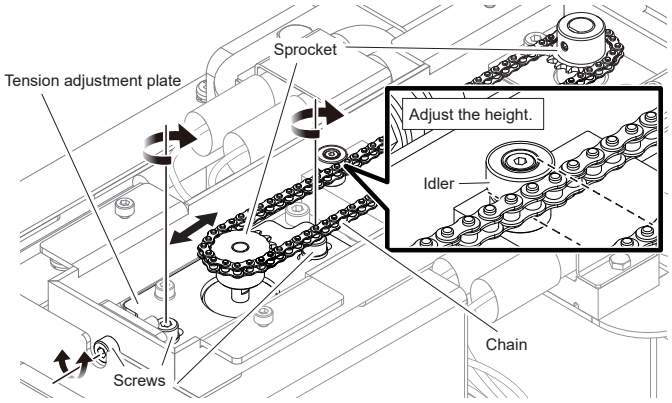
If the chain , idler or sprocket is damaged, replace it.
(See "9-3-3-1. Replacing the chain , idler and sprocket" (p.21))

(6) Remove any dirt from the chain.

(7) Apply grease to the inside of the chain.

(8) Wipe off any excess.

(9) Reassemble using the reverse procedure.



9-1-2. Inspection of the soldering pot

(1) Remove the top panel of the soldering pot main unit.
(See "5-3. Preparations" (p.5))

(2) Visually confirm that no solder has leaked around the solder pot.

9-1-3. Inspection of the solder pot cover

(1) Remove the solder pot cover.
(See "5-3. Preparations" (p.5))

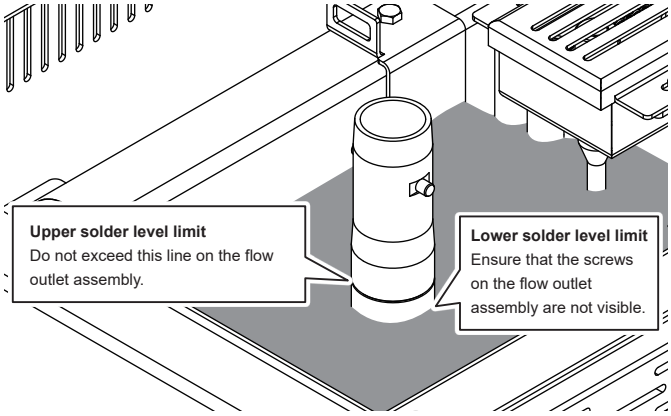
(2) Remove any solder adhering to the solder pot cover.

9-1-4. Inspection of the solder level

(1) Check the solder level.

(2) If the solder level is insufficient, the flow may stop and the heater may overheat, so add solder to maintain proper levels.

NOTE If the solder level is excessive, the nitrogen nozzle will become blocked, which may cause a malfunction.



9-2. Daily maintenance

Wear and tear on the pot will vary due to the operating temperature as well as the quality and amount of solder used.
Perform maintenance accordingly.

Setting temperature	Use the product at temperatures higher than necessary can accelerate deterioration of the pot. Use the lowest temperature whenever possible.
Before beginning work (READY lamp lit)	Use the spatula to remove oxidation and debris from the surface of the molten solder.
During the work	Turn off the power switch when not using the product for a long period of time.

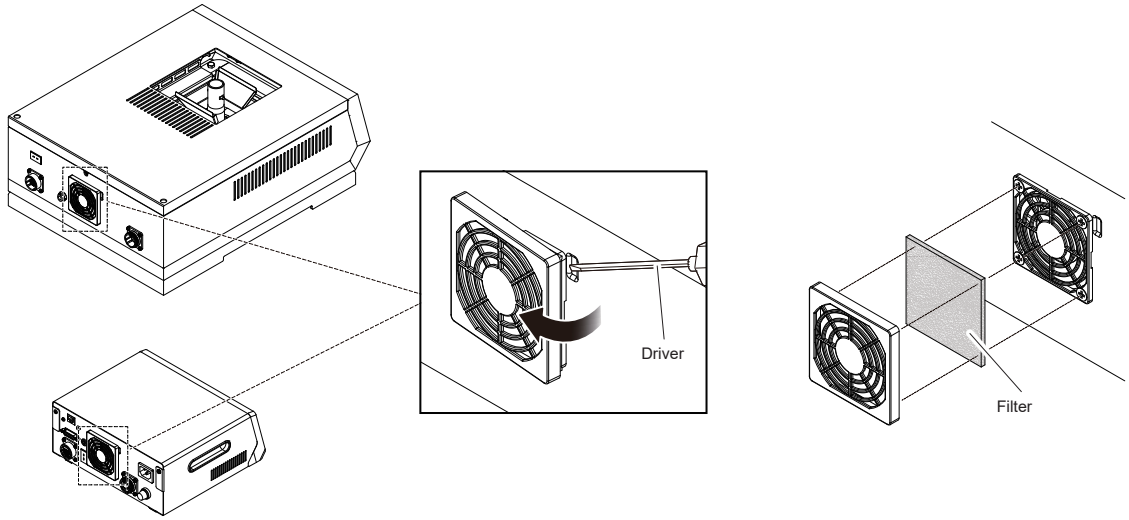
9-3. Periodic maintenance

9-3-1. Filter for air inlet

Check if the filter of the air inlet is clogged.
If clogging occurs, the internal temperature of the control box and the soldering pot main unit will rise, causing malfunction.

⚠ CAUTION

When replacing the filter, turn the power switch off and unplug the plug from the power outlet.



9-3-2. Disassembly and cleaning

⚠ WARNING

Do not touch any metal parts around the solder pot with bare hands.

⚠ CAUTION

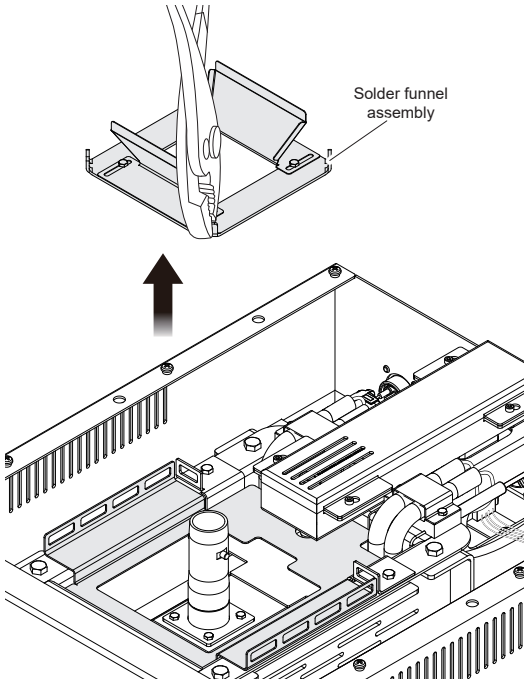
- During maintenance, be sure to wear long-sleeved work clothing, protective goggles, and heat-resistant gloves.
- Complete the cleaning before the solder solidifies.

It is recommended to perform maintenance approximately once a month.

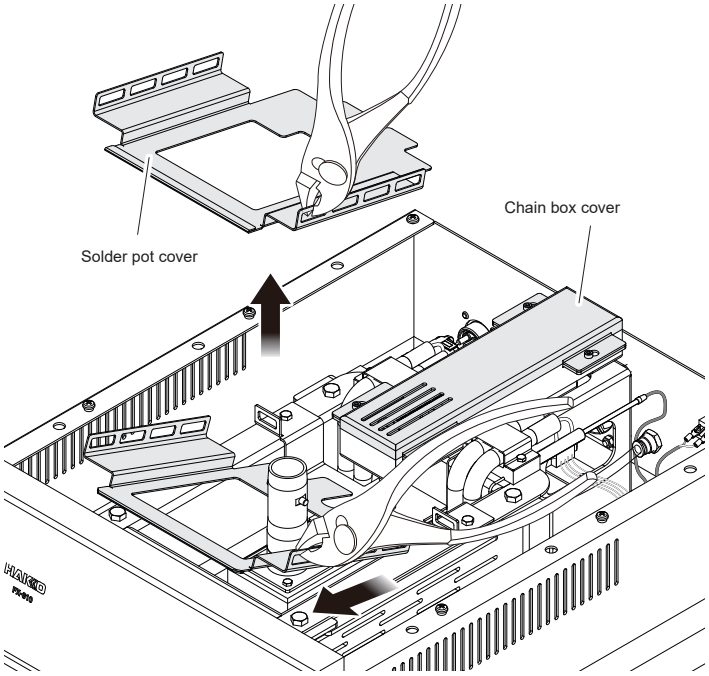
Video

(1) Remove the nozzle.
(2) Set the temperature to the maximum of 380°C to melt the solder.
(3) Turn off the power switch and unplug the power cord.
(4) Remove the top panel of the solder pot main unit. (See "5-3. Preparations" (p.5))

(5) Using pliers, remove the solder funnel assembly.



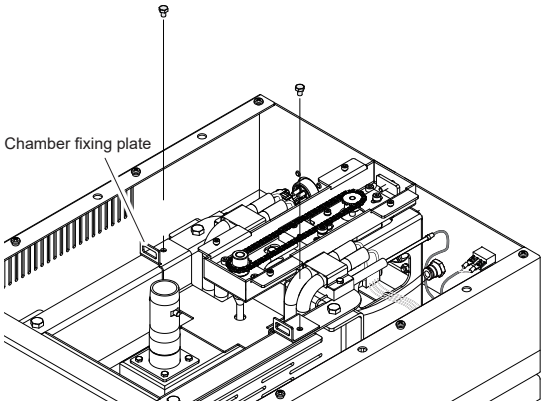
(6) Using pliers, slide the solder pot cover diagonally forward, then lift it upward to remove it.



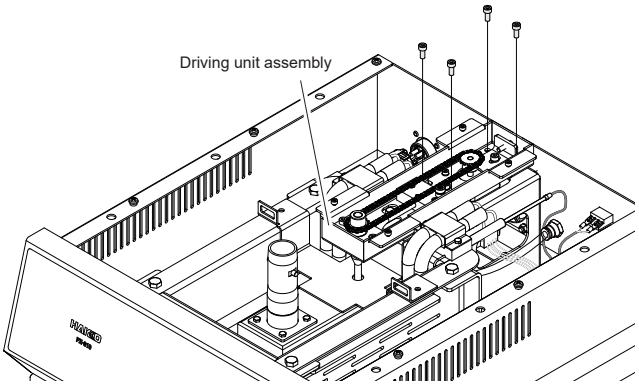
(7) Use the spatula to remove oxidation and debris from the surface of the molten solder.

(8) Remove the chain box cover.
(See "9-1-1. Inspection of the chain" (p.17))

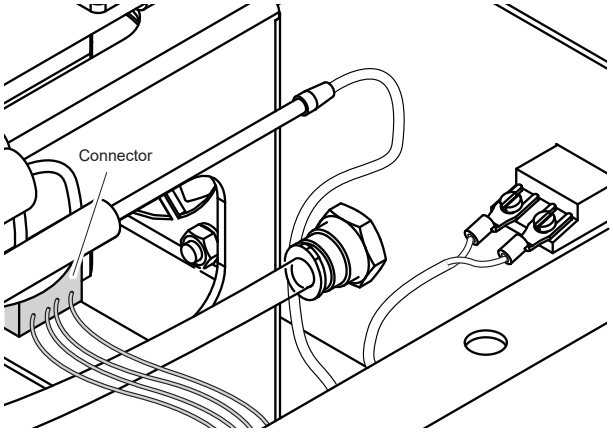
(9) Remove the screws on the chamber fixing plate using a box driver (size 7 mm).



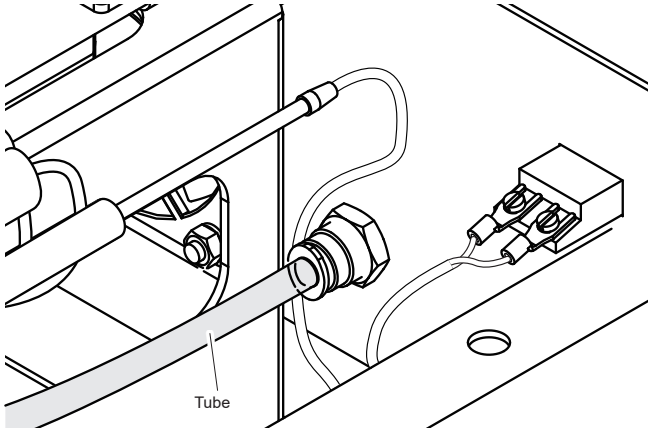
(10) Remove the screws of the driving unit assembly using a hex wrench (size 3 mm).



(11) Disconnect the motor connector.

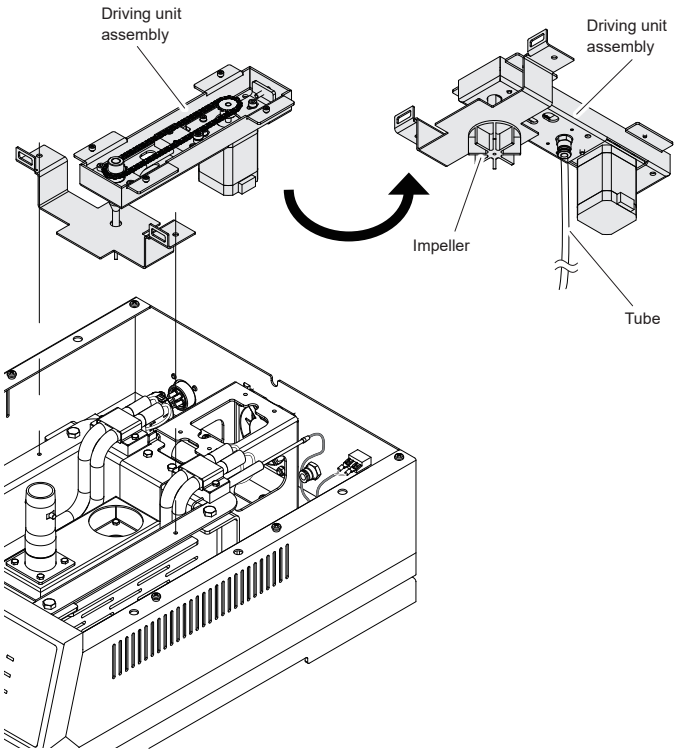


(12) Remove the tube.



(13) Remove the driving unit assembly.

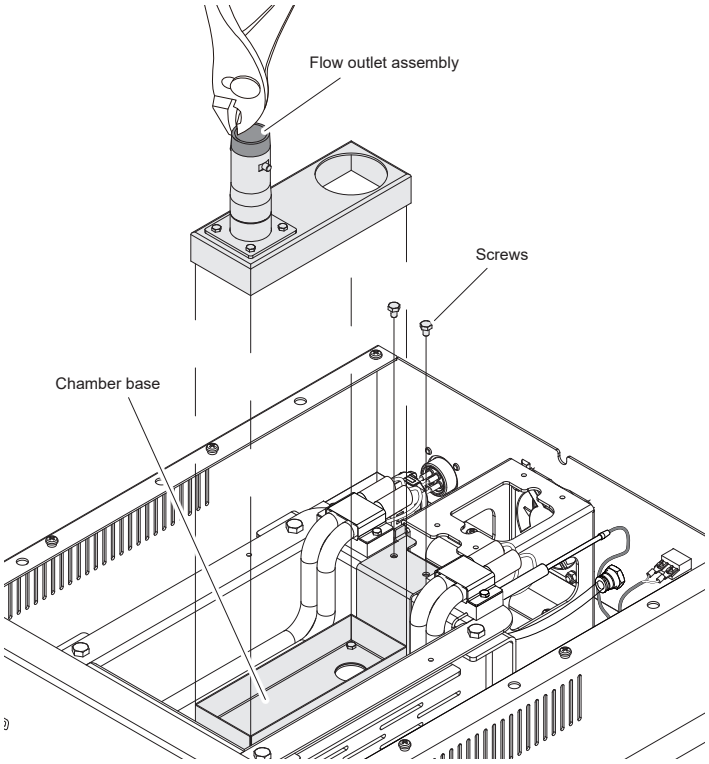
NOTE Remove with caution, ensuring the tube does not come into contact with the solder pot.



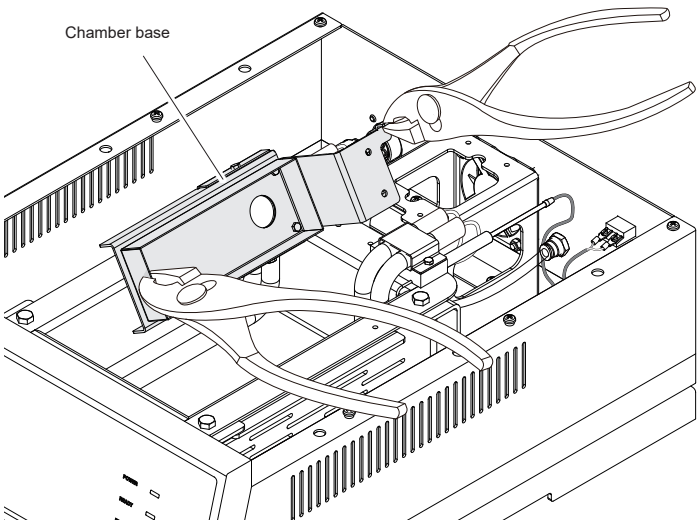
(14) Using plier, slowly lift and remove the flow outlet assembly.

NOTE Grasp the tapered section of the flow outlet.

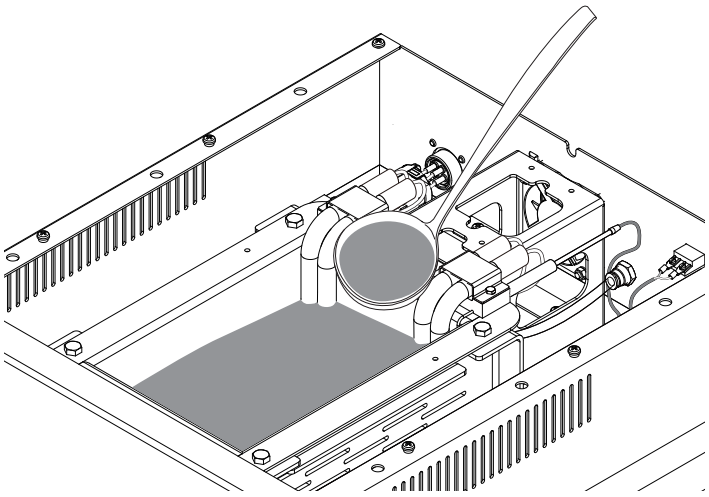
(15) Remove the screws from the chamber base using a box driver (size 7 mm).



(16) Using plier, slowly lift and remove the chamber base, and drain the solder inside the chamber into the solder pot.



(17) Use a stainless-steel ladle to scoop out the solder.



(18) Remove any oxidation or debris adhering to the flow outlet assembly and the chamber base.

NOTE Forcibly scraping off deposits with a sharp-pointed tool may damage the surface.

(19) Remove any oxidation or debris adhering to the impeller and its surrounding area.

NOTE Forcibly scraping off deposits with a sharp-pointed tool may damage the surface.

(20) Reassemble the chamber base, flow outlet assembly and driving unit assembly by performing the procedure in reverse.

NOTE Ensure that the impeller is not in contact with any other component.

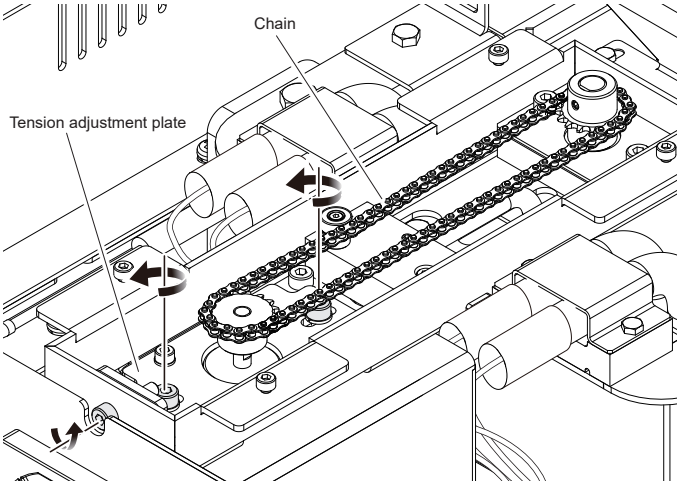
(21) Turn on the power, verify that there are no abnormal noises, and melt the solder.

9-3-3. Component replacement

9-3-3-1.Replacing the chain , idler and sprocket

(1) Loosen the screws with a hex wrench (size 3 mm), then shift the the tension adjustment plate forward to remove the chain.

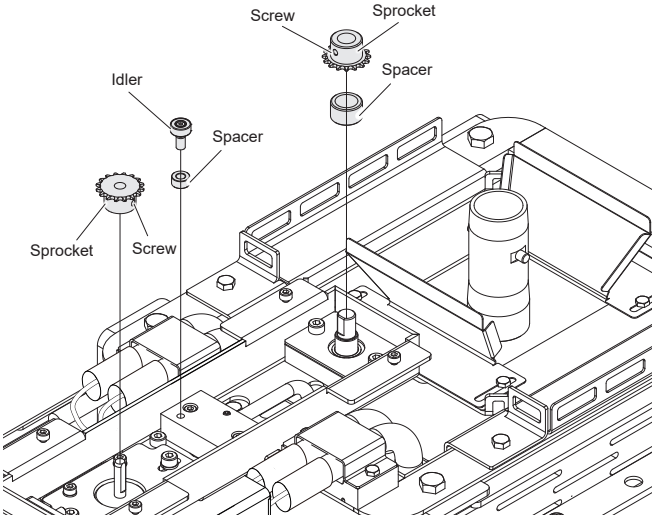
(2) Using a hex wrench (size 1.5 mm), loosen the screw of the idler and replace the idler.



(3) Loosen the sprocket screws with a hex wrench (size 1.5 mm) to remove and replace the sprockets.

NOTE Pay attention to the installation direction of the sprocket.

(4) Replace the chain and adjust the tension.
(See "9-1-1. Inspection of the chain" (p.17))



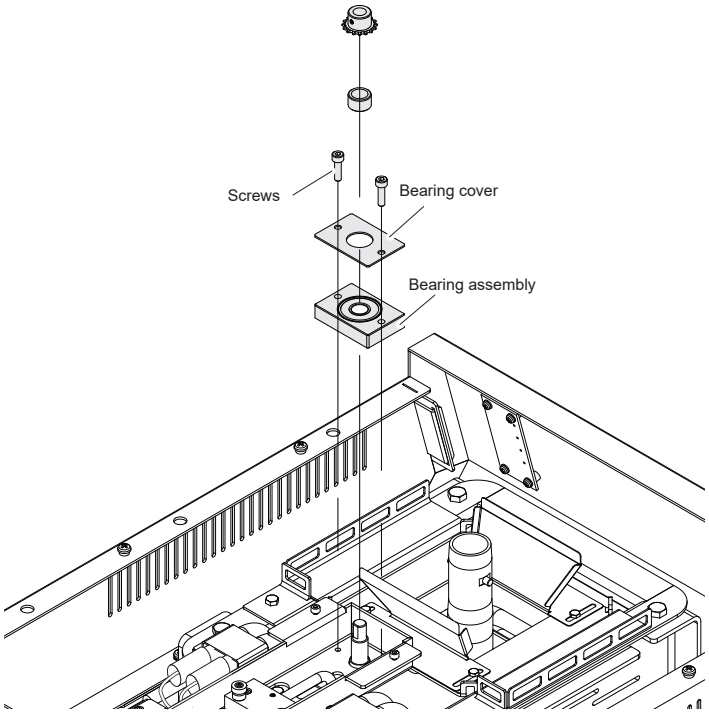
9-3-3-2.Replacing the bearing assembly

(1) Loosen the screws on the impeller-side sprocket with a hex wrench (size 1.5 mm), and remove the sprocket.

(2) Remove the screws on the bearing cover using a hex wrench (size 3 mm) and replace the bearing assembly.

NOTE Pay attention to the installation direction of the sprocket.

(3) After replacement is complete, reassemble in reverse order.



9-3-3-3.Motor replacement

(1) Remove the driving unit assembly.
(See "9-3-2. Disassembly and cleaning" (p.18))

(2) Remove the chain.

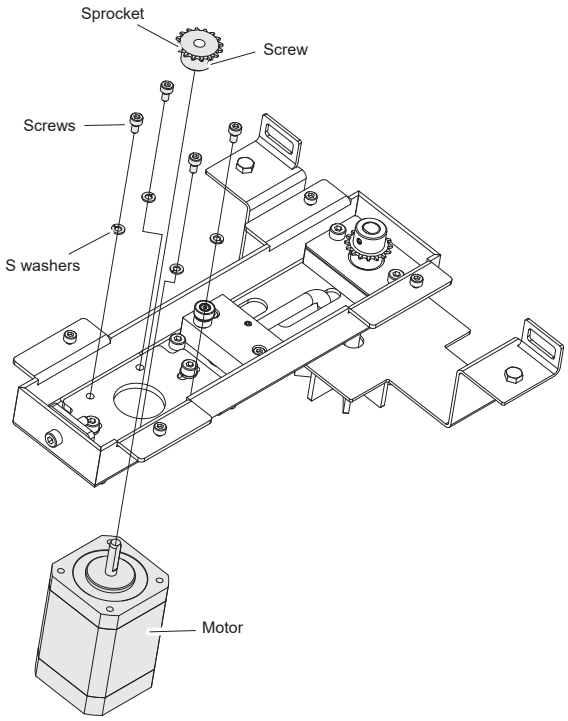
(3) Loosen the screw on the motor-side sprocket with a hex wrench (size 1.5 mm), and remove the sprocket.

(4) Remove the motor screws using a hex wrench (size 2.5 mm) and replace the motor.

NOTE Use caution to prevent the spring washer from falling off.

NOTE Pay attention to the installation direction of the sprocket.

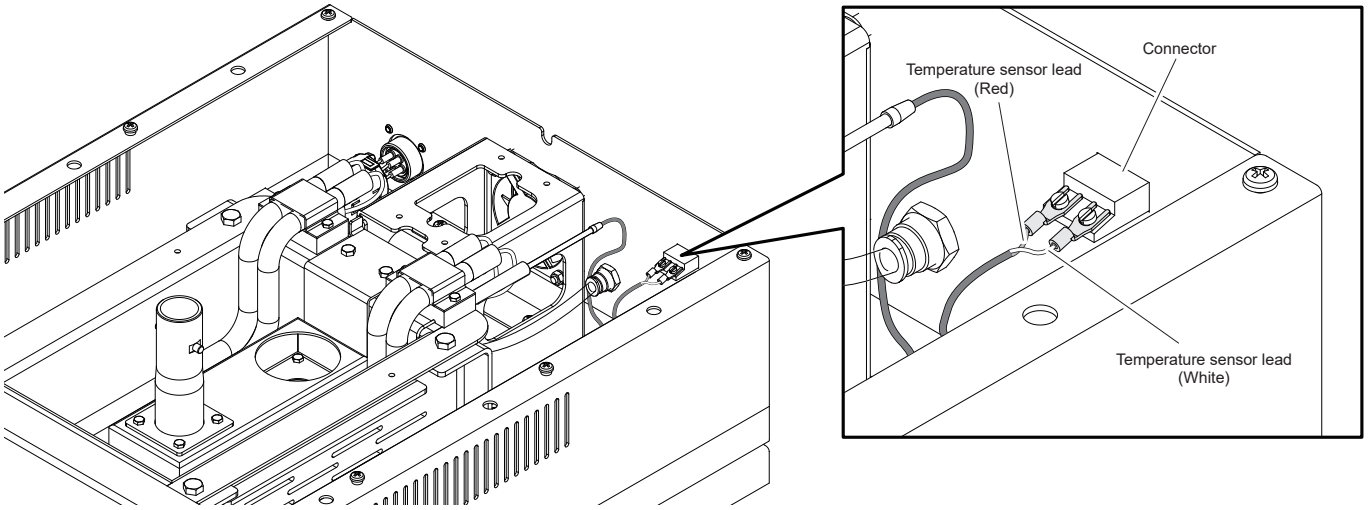
(5) After replacement is complete, reassemble in reverse order.



9-3-3-4.Replacing the temperature sensor

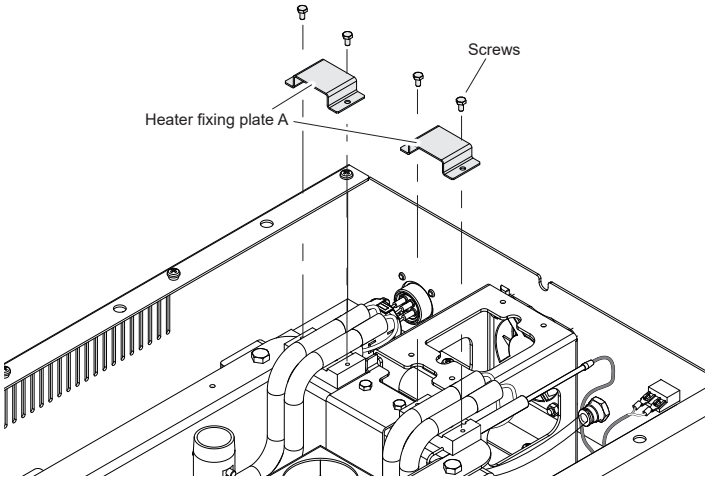
(1) Remove the driving unit assembly. (See "9-3-2. Disassembly and cleaning" (p.18))

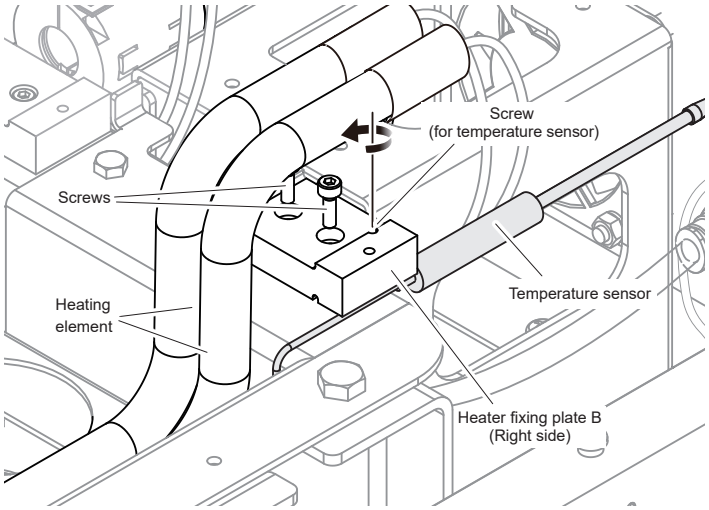
(2) Loosen the connector screw with a flathead screwdriver (slot width 0.7 mm) and remove the temperature sensor terminals.



(3) Remove the screws from both heater fixing plate A using a box driver (size 5.5 mm).

(4) Lift the heater, loosen the temperature sensor screw with a hex wrench (size 1.5 mm), then remove the heater fixing plate B (right side) screws with a hex wrench (size 3 mm) and replace the temperature sensor.





(5) After replacement is complete, reassemble in reverse order.

NOTE The temperature sensor needs to be installed in the correct orientation (sensor lead wire colors).

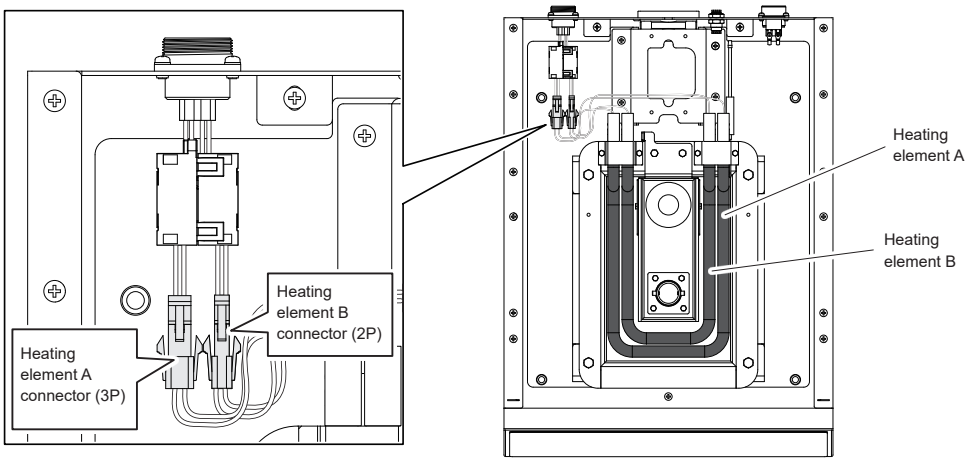
NOTE Be caution not to deform the temperature sensor.

9-3-3-5.Replacing the heating element

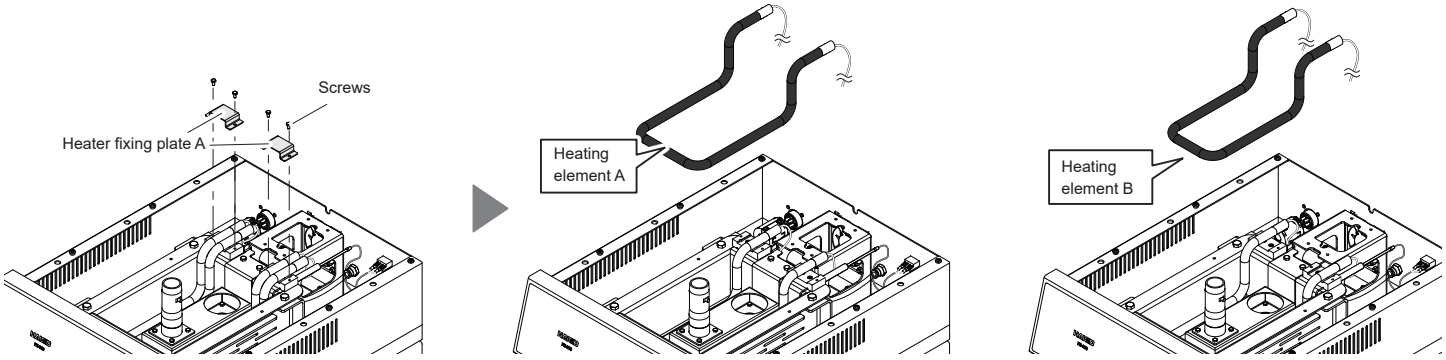
(1) Remove the driving unit assembly. (See "9-3-2. Disassembly and cleaning" (p.18))

(2) Disconnect the connector of heating element to be replaced.

* Heating element A uses a 3-pin connector, and heating element B uses a 2-pin connector.



(3) Remove the screws from both heater fixing plate A using a box driver (size 5.5 mm), and replace heating element A (outer) or heating element B (inner).



(4) After replacement is complete, reassemble in reverse order.

9-3-3-6.Solder replacement

(1) Remove the flow outlet assembly, the chamber base. (See "9-3-2. Disassembly and cleaning" (p.18))

(2) Use a stainless-steel ladle to scoop out the solder.

(3) Reinstall the flow outlet assembly, the chamber base, and the driving unit assembly. (See "9-3-2. Disassembly and cleaning" (p.18))

(4) Refill the solder pot with fresh solder. (See "5-3. Preparations" (p.5))

10. Troubleshooting

⚠ CAUTION
Turn the power off and unplug the power cord before inspecting or replacing any internal components.

No operation even if power switch is turned ON.	Has the power cord plug been removed?	▶ Plug unit into outlet.
	Is the fuse blown?	▶ Replace the fuse. If the fuse blows again, send the entire product set back for service.
[Connection Error] is displayed.	Is the plug on the connection cable (for control) disconnected?	▶ Be sure the connecting cables is securely connected.
[Heater A Error] is displayed.	Is the plug on the connection cable (for power) disconnected?	▶ Be sure the connecting cables is securely connected.
	Is heating element A electrically open?	▶ Replace heating element A. (See "9-3-3-5. Replacing the heating element" (p.23))
[Heater B Error] is displayed.	Is heating element B electrically open?	▶ Replace heating element B. (See "9-3-3-5. Replacing the heating element" (p.23))
[Sensor Error] is displayed.	Is the temperature sensor cable disconnected?	▶ Insert the Connector. If the indication does not disappear, replace the temperature sensor. (See "9-3-3-4. Replacing the temperature sensor" (p.22))
[Solder Leak Error] is displayed.	Is there any hole in the solder pot and has solder leaked into the interior of the main unit?	▶ If the soldering pot is damaged, send the entire unit set back for service.
Solder is difficult to melt or does not melt.	Is the temperature set to a value lower than the melting point of the solder?	▶ Set an appropriate set temperature. If the solder still does not melt, replace the solder. (See "9-3-3-6. Solder replacement" (p.23))
The solder does not flow, or the flow is weak.	Is the solder level insufficient?	▶ Check the solder level. (See "9-1-4. Inspection of the solder level" (p.17)) If the solder level is insufficient, add more solder.
	Is the temperature set to a value lower than the melting point of the solder?	▶ Set an appropriate set temperature.
	Is the chain slack or disengaged?	▶ Adjust the chain tension. Replace the chain if it is damaged. (See "9-3-3-1. Replacing the chain , idler and sprocket" (p.21))
	Has the motor stopped rotating?	▶ Replace the motor. (See "9-3-3-3. Motor replacement" (p.21))
	Are impurities or debris adhering to the impeller?	▶ Clean the impeller. (See "9-3-2. Disassembly and cleaning" (p.18))
	Is dross accumulating?	▶ Remove the dross from the chamber. (See "9-3-2. Disassembly and cleaning" (p.18))

If you cannot find a solution in this manual, or if another problem occurs, please contact the distributors where you purchased the product.

HAKKO

HAKKO CORPORATION

HEAD OFFICE
4-5, Shiokusa 2-chome, Naniwa-ku, Osaka 556-0024 JAPAN
TEL: +81-6-6561-3225 FAX: +81-6-6561-8466
https://www.hakko.com E-mail: sales@hakko.com

OVERSEAS AFFILIATES

U.S.A.: AMERICAN HAKKO PRODUCTS, INC.
TEL: (661) 294-0090 FAX: (661) 294-0096
Toll Free (800) 88-HAKKO
4 2 5 5 6
https://www.HakkoUSA.com E-mail: Support@HakkoUSA.com

CHINA: HAKKO DEVELOPMENT CO., LTD.
TEL: (020) 8135-0112, 8135-0113, 8135-1086 FAX: (020) 8135-0181
https://www.hakko.com.cn E-mail: sales@hakko.gz.cn

SINGAPORE: HAKKO PRODUCTS PTE., LTD.
TEL: 6748-2277 FAX: 6744-0033
https://www.hakko.com.sg E-mail: sales@hakko.com.sg

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