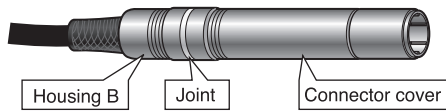
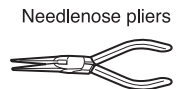
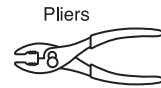
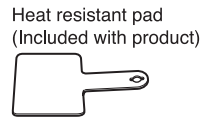


# Part Replacement for FM-2021/2025 Version Upgrade

## 1 Part Names

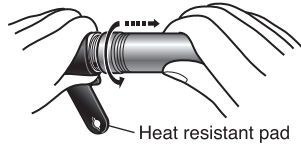


## Required Tools



## 2 How to Replace

### (1) Detach the connector cover.



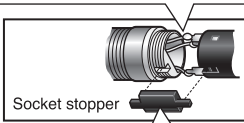
The connector cover is screwed onto the joint. While firmly press the heat resistant pad against the joint, turn the connector cover until detached.

\* If housing B comes off the joint before the connector cover does, reattach it as before and then detach the connector cover. If the connector cover cannot be detached by hand, anchor the joint from over the heat resistant pad with a pair of pliers and try detaching the cover.

**CAUTION**  
Directly holding the joint with pliers or using excessive force to hold the joint can damage the joint. Use caution.

### (2) Detach the ring and spring.

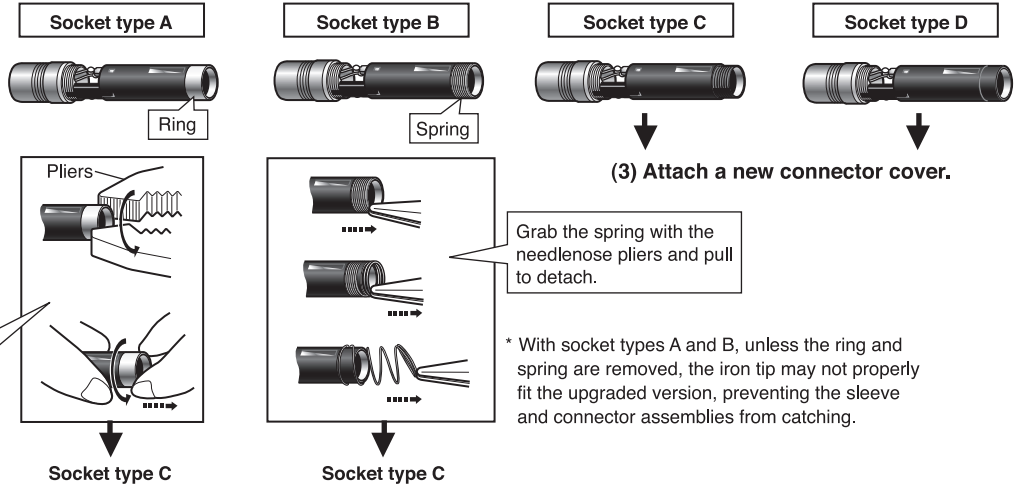
\* Be careful not to cut the lead wire while working.



Check the socket stopper is attached. If it comes off while working, put it back securely between the socket and joint

The ring is screwed onto the socket. Grab the ring with a pair of pliers and make about 2 turns to loosen. Then, turn the ring by hand until detached.

There are 4 types of sockets that become visible once the connector cover has been detached.



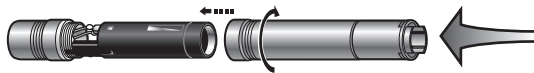
### (3) Attach a new connector cover.

Grab the spring with the needlenose pliers and pull to detach.

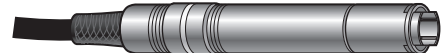
\* With socket types A and B, unless the ring and spring are removed, the iron tip may not properly fit the upgraded version, preventing the sleeve and connector assemblies from catching.

### (3) Attach a new connector cover.

From FM-2021 to FM-2027 ... From FM-2025 to FM-2028



### (4) Completed upgrade



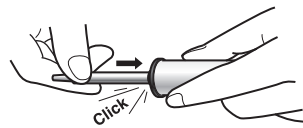
# FM-2027/FM-2028 Iron Tip Replacement

## CAUTION

The tip can be very HOT. Be carefule in replacing hot tip. Use the heat-resistant pad for handling hot tip, but do not hold the hot tip, even with the pad, for a long time.

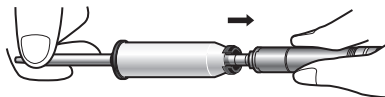
### ● Inserting the tip:

(1) When inserting the tip into a new sleeve assembly, hold the tip by the front end and insert it into the sleeve assembly.



Insert the iron tip until you hear it clicks.

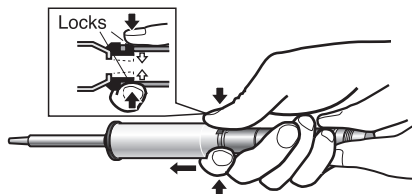
(2) When inserting the sleeve assembly into the connector assembly, align the lock positions and snap the sleeve assembly into the sleeve assembly.



Align the lock positions to snap the sleeve assembly and connector assembly together.

### ● Removing the tip

(1) To detach the sleeve assembly, press on both locks of the sleeve assembly and pull the sleeve assembly off.



Attempting to pull the sleeve assembly off without pressing on the locks can damage the product.

(2) Use the heat resistant pad to pull the tip from the sleeve assembly.

