⬟ HAKKO

HAKKO 487
SOLDERING FLOW POT

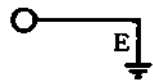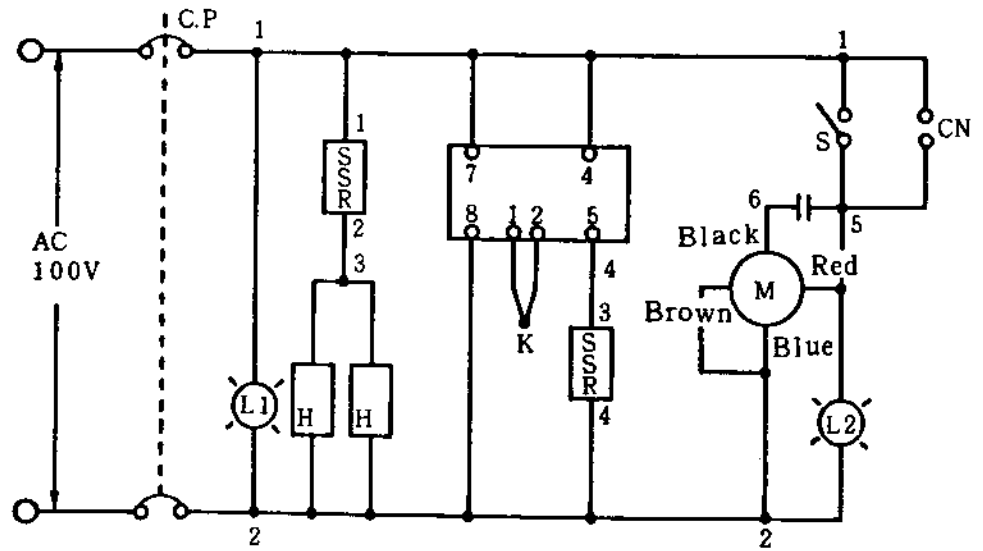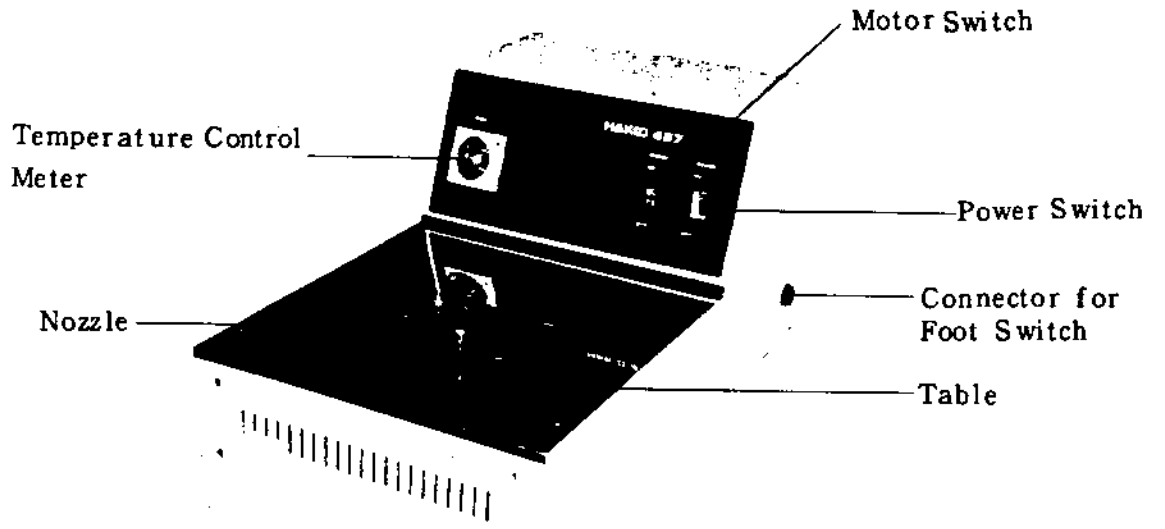
INSTRUCTION MANUAL

Please read this instruction manual thoroughly
before operating the HAKKO 487.

1. Construction

Temperature Control Meter

Motor Switch

Nozzle

Power Switch

Connector for Foot Switch

Table

C.P

AC 100V

SSR

SSR

L1

H

H

K

L2

Black

Red

Brown

Blue

M

S

CN

E

2. Operating Instructions

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 0°C, 32°F and 299°C, 570°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.

   Notes ; 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.

   Caution; 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. Troubleshooting Guide

1) <u>Replacing the heating element</u>

   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. Replace it with an identical heating element.

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(−) termonal.
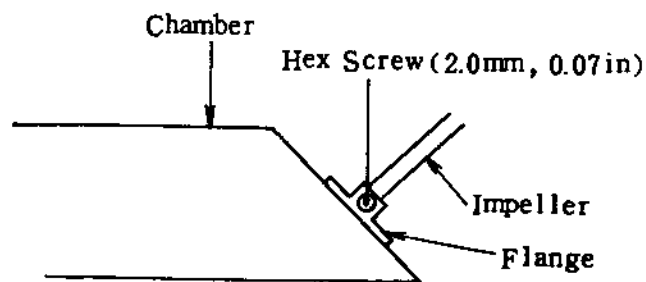
4. Cleaning the Inside of the Solder Bath

1. Removing oxidation

To remove the oxidation from the solder bath, first melt solder in the bath and stir thoroughly, then scrape the oxidation on the surface of the solder.
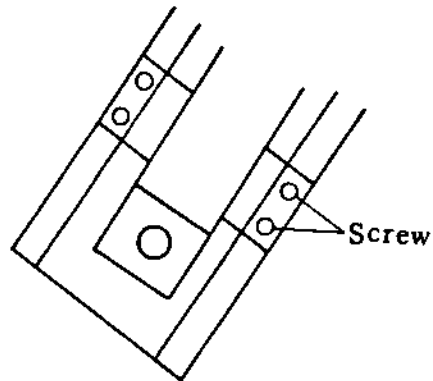
2. Disassembling and cleaning the chamber

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

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 screw securing the flange.

3. Loose the joint screw with a 2.0mm(0.07in) hex wrench and pull down the impeller.

Chamber

Hex Screw (2.0mm, 0.07in)

Impeller

Flange

4. Remove the 4 screws securing the chamber to the unit and remove the chamber.

Screw

5. Remove any oxidation in the chamber by patting the side and bottom of the chamber and clean up.
6. Place the chamber into the bath. Secure the impeller and the joint with the appropriate screws.

Secure 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.