



# **HAKKO 485**

**SOLDERING SYSTEM**

## **INSTRUCTION MANUAL**

Please read this instruction manual thoroughly  
before operating the HAKKO 485

# 1 Construction & Accessories

## AIR UNIT (No.486)

### Body (No.485-1)

\*Other air hoods and solder nozzles are available for special requirements.

Fig1

Anti-oxidizer (No.485-026)

42 pin air hood (No.485-31)

28 pin air hood (No.485-30)

18/20 pin air hood (No.485-29)

14/16 pin air hood (No.485-28)

42pin nozzle (No.485-N-04)

28pin nozzle (No.485-N-03)

18/20 pin nozzle (No.485-N-02)

14/16 pin nozzle (No.485-N-01)

Lamp (No.485-10)

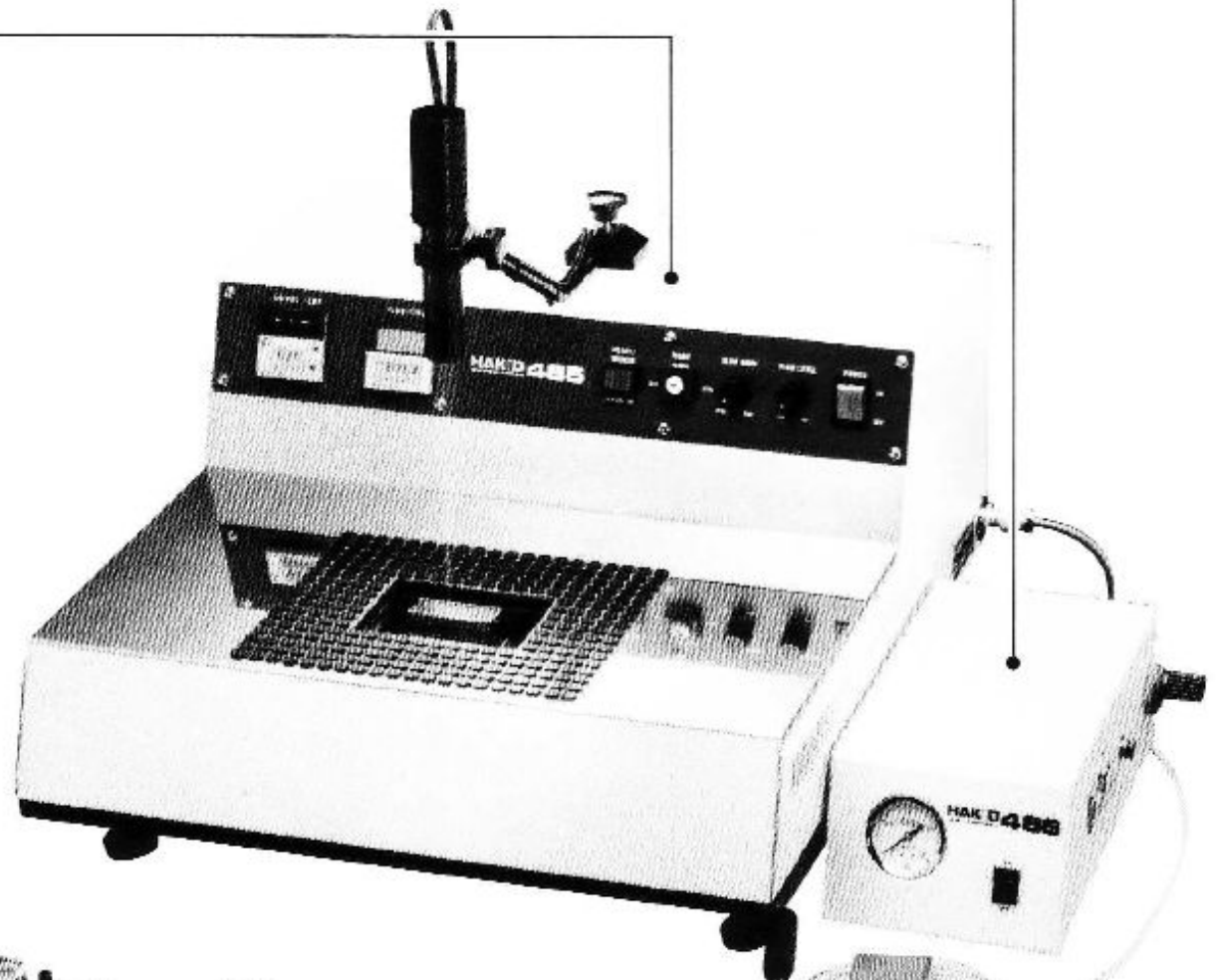
Horizontal gauge (No.485-22)

Spatula (No.485-09)

IC tweezers (No.485-07)

Waste collector (No.485-23)

Positioning board (No.485-20)



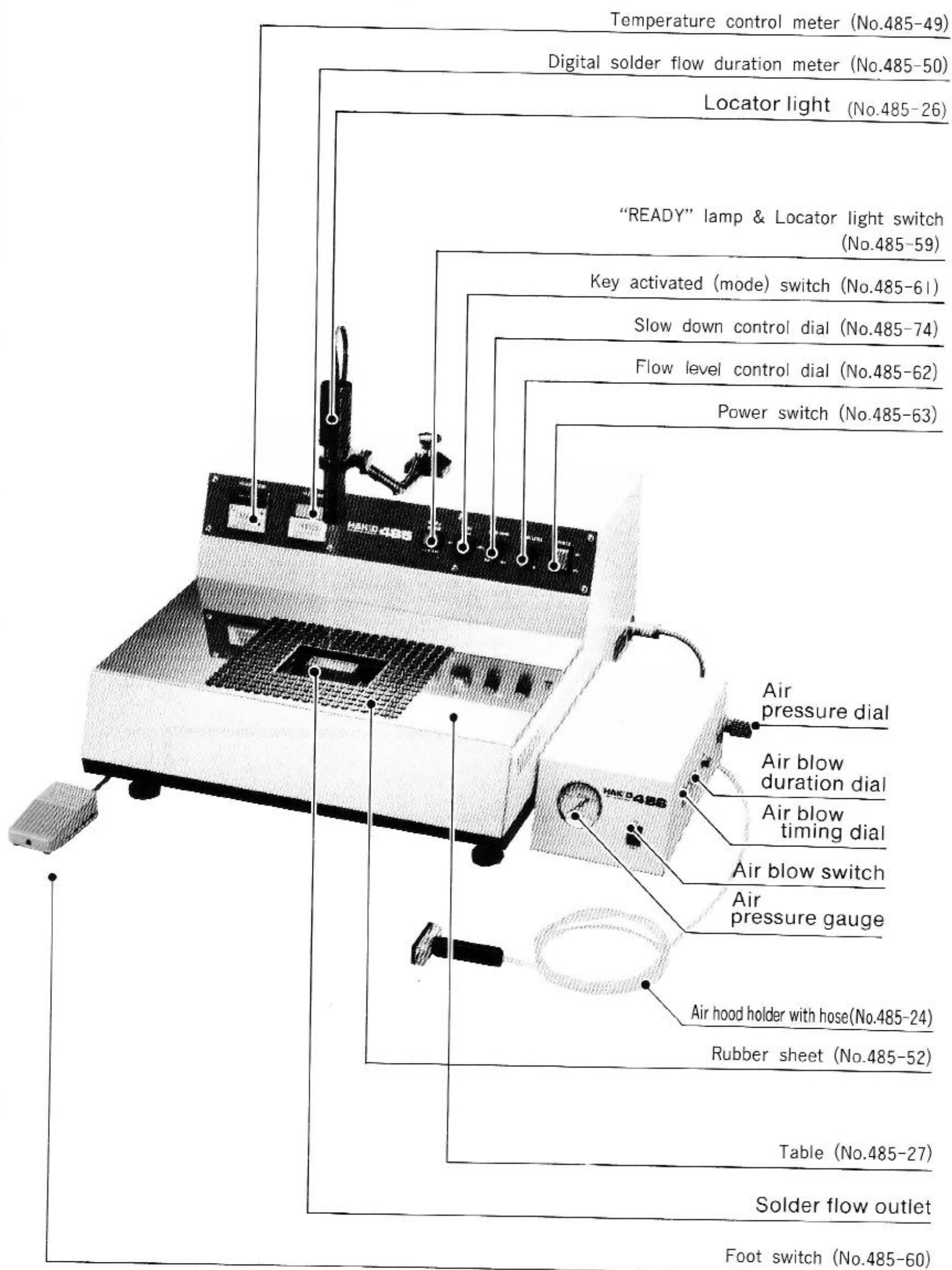
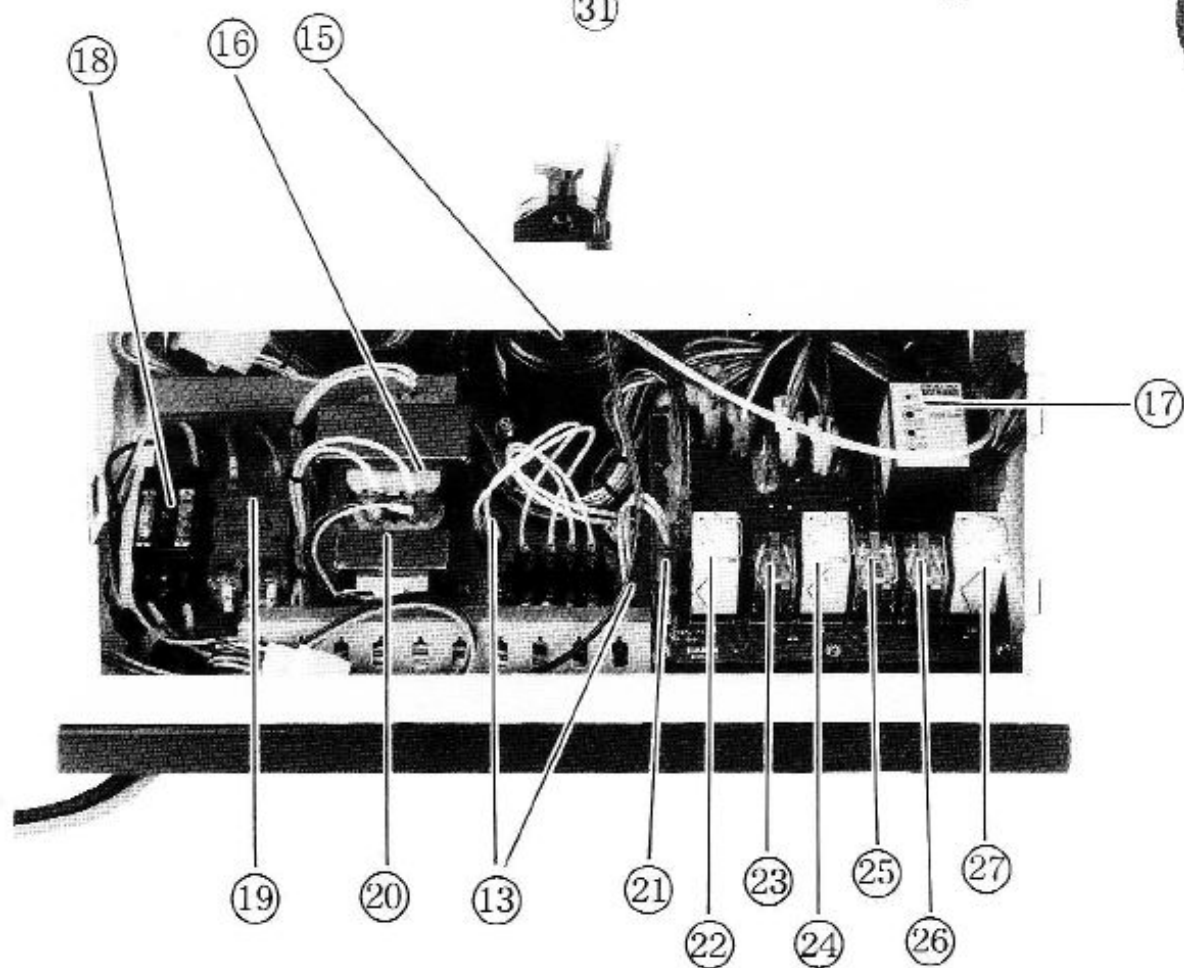
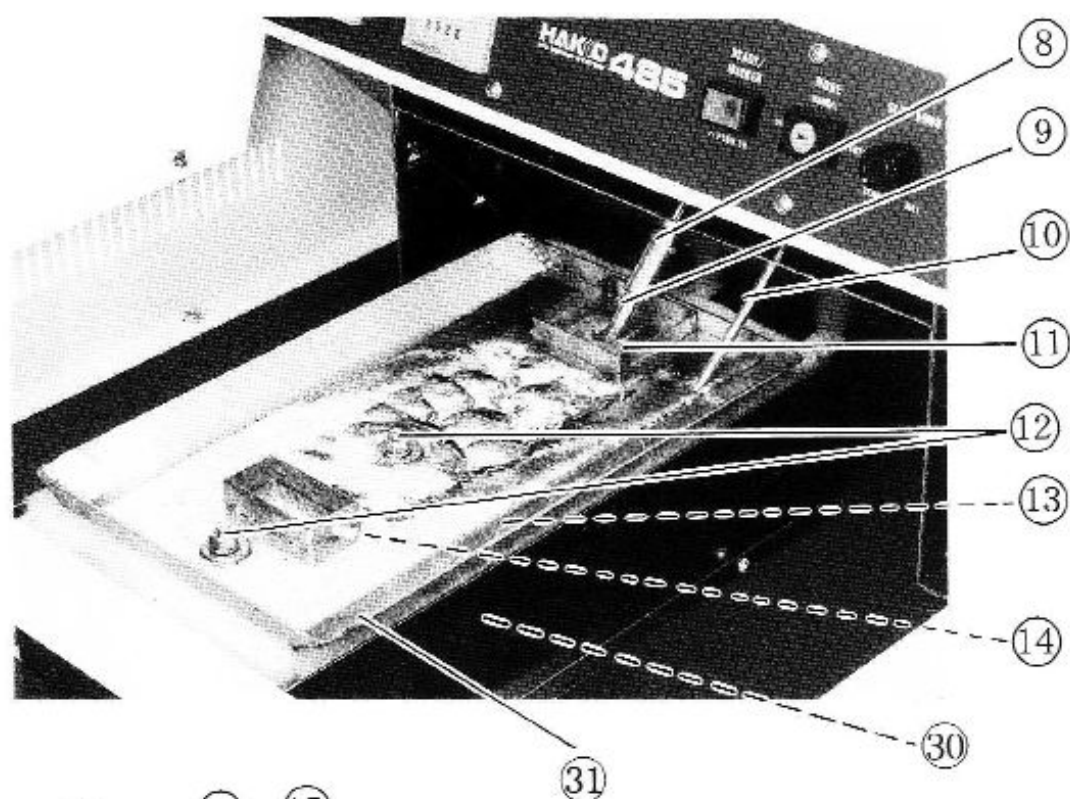
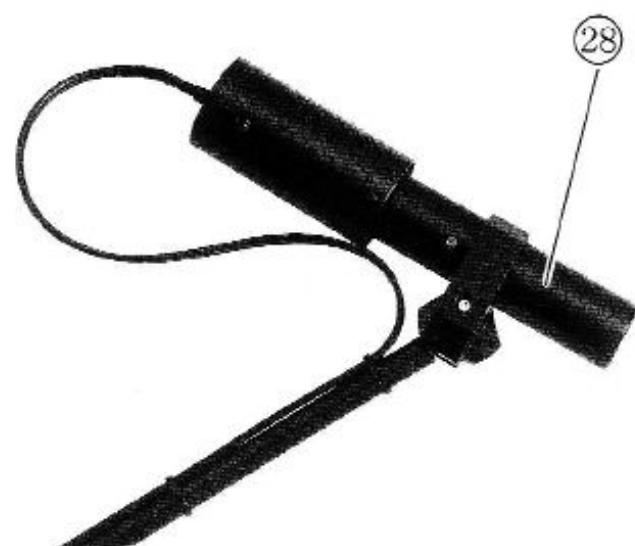
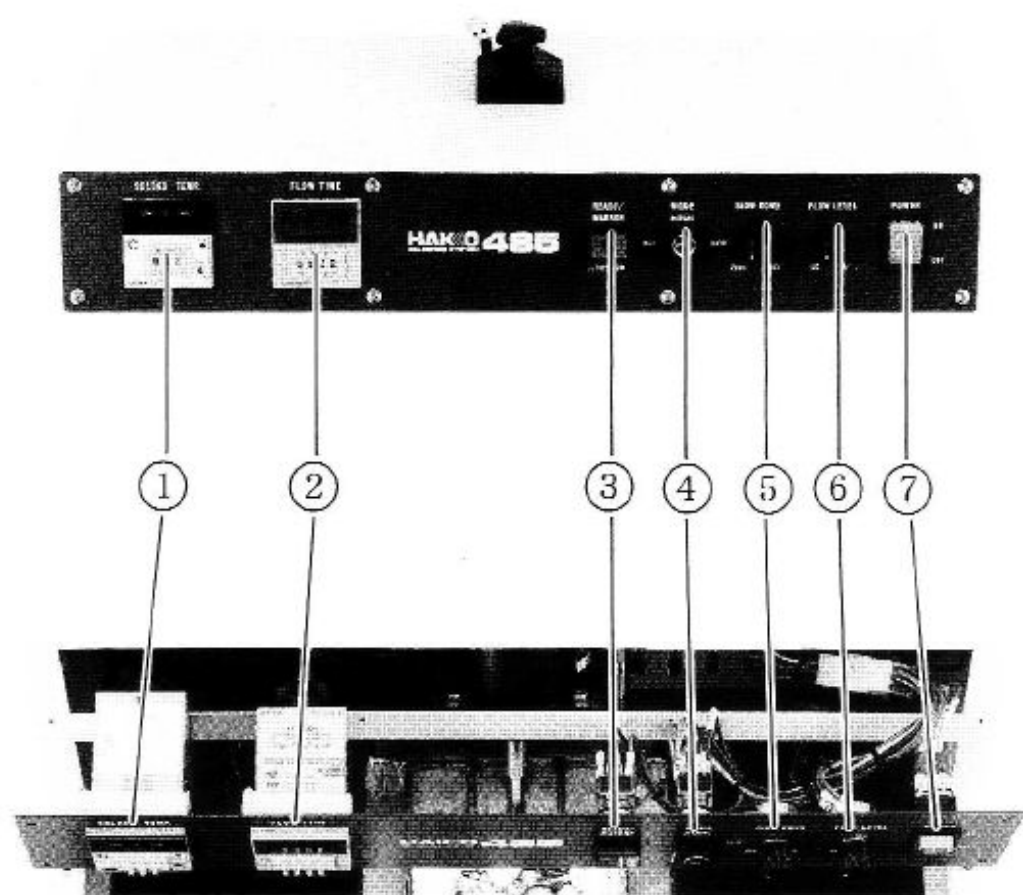


Fig2





No.	Part No.	Part Name	Description
1	485-49	Temperature Control Meter	
2	485-50	Digital Solder Flow Duration Meter(T-1 Timer)	
3	485-59	Locator Light Switch ("READY" Lamp)	
4	485-61	Key Activated Switch	
5	485-74	Slow Down Control Dial	
6	485-62	Flow Level Control Dial	
7	485-63	Power Switch	
8	485-64	Joint	w/hexagon 2 screws (2.0mm/0.079in.)
9	485-53	Impeller	w/shaft
10	485-06	CA Sensor	
11	485-65	Anti-oxidizer Plate	
12	485-66	Nut (M6)	w/washer
13	485-H	Heating Element	100V
	485-H-V12	Heating Element *	120V
14	485-67	Chamber	
15	485-46	Motor	
16	485-68	Transformer *	120V
17	485-57	Motor Control Unit	
18	485-69	Current Leakage Breaker	
19	485-70	S.S.R	
20	485-71	Transformer/for Locator Light	
21	485-72	Fuse/3A	
22	485-73	T4 Timer	
23	485-51	Control Relay (RX Relay)	
24	485-55	' T.D' Timer	
25	485-51	Control Relay (FX Relay)	
26	485-51	Control Relay (AX Relay)	
27	485-54	' T.O ' Timer	
28	485-26	Locator Light	
29	485-10	Lamp (6V/10W)	
30	485-58	Insulation Set	
31	485-47	Solder Bath	

\* Used for 120V model only.

## 2 The Internal Parts of the Body

Motor

Motor control unit

Trans

S.S.R.

Current leakage breaker

Timer

RX relay

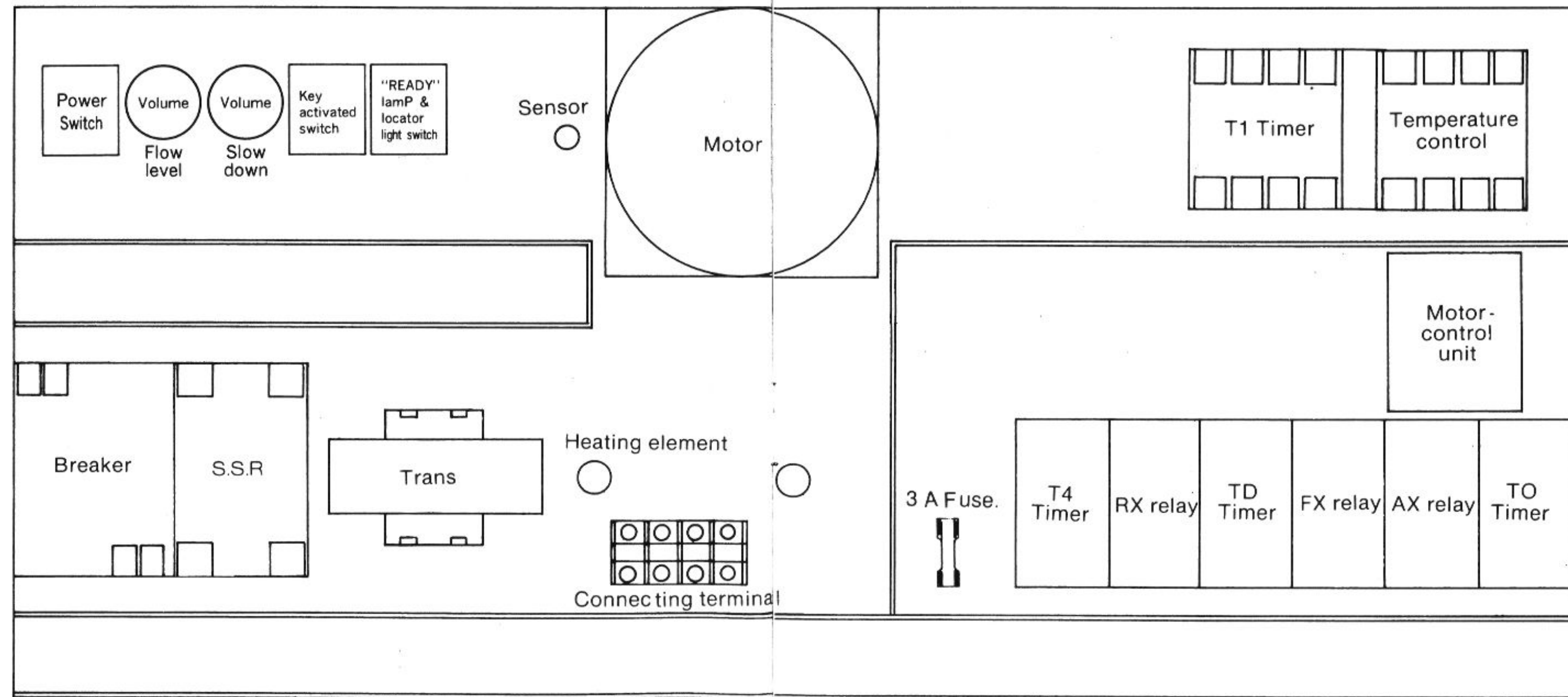
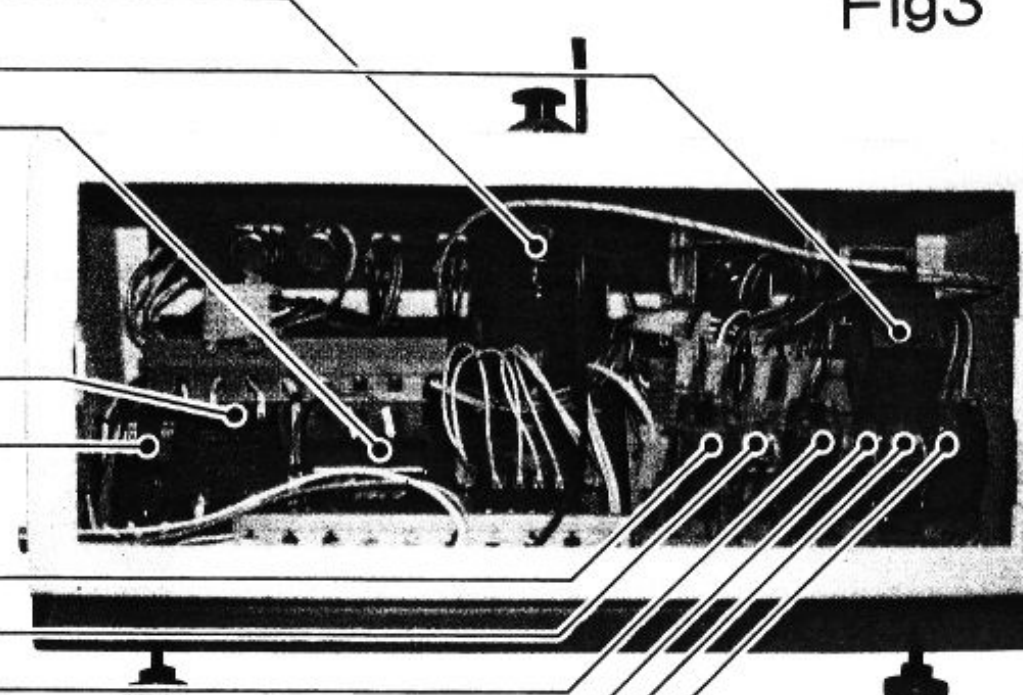
Timer

FX relay

AX relay

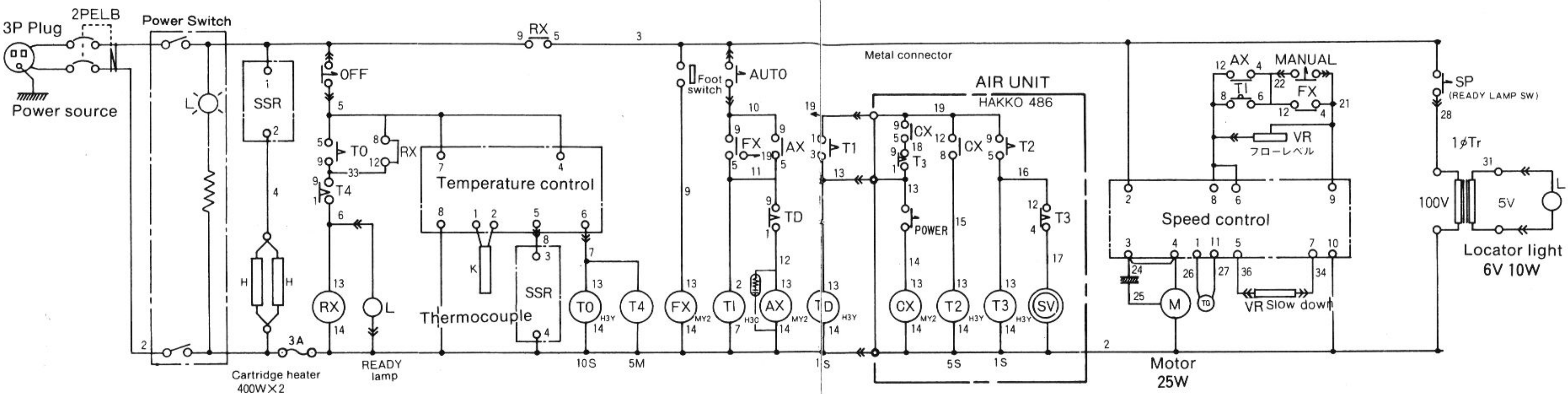
Timer

Fig3





# 3 Wiring Diagram / Safety Precautions / Setting Up



## Safety Precautions



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/570°F.  
**Mishandling may result in burns or fire.** Please make sure to comply with the following rules.

- 1. Use this 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.

## Setting Up

1	2	3	4	5	6
Remove packing material and check enclosed accessories with Fig. 1. (Some accessory parts will be found in the body.)	Put the locator light into the upper holder of the body (485), and secure it. Connect the plug to a power source.	Connect a compressor to AIR UNIT (486).	Plug AIR UNIT into 3p metal connector of the body.	Plug the air hose into the side (Fig. 2) of AIR UNIT.	Adjust the feet on the body (485) so that it is stable and level. Place the Anti-oxidizer.

## 4 How to Use

**⚠ CAUTION :** For safety reasons, be sure to ground the unit by connecting

the ground wire to a grounded terminal.

First, plug the power supply cord into a power source, then open the rear panel of the body and turn on the Current Leakage Breaker. (Push the black switch to the up position.) Check the breaker switch (red button to right of Current Leakage Breaker switch) by depressing the red button, approximately once a month.

Turn on the power switch on the front panel, and set key activated switch to MANUAL or AUTO. Heating Element gets electricity.

Adjust temperature (0-299°C, 32-570°F) with the digital temperature control meter (located on the front panel).

When operating in AUTO, adjust the Digital solder flow duration meter (standard setting: 250°C, 482°F 4 sec.).

When temperature reaches the pre-set one, the temperature control lamp turns from ◀ (red) to |||| (the center). Shortly after, the "READY" lamp will light. The unit is then ready to use. Select the appropriate flow nozzle for your IC and fix it to the solder flow outlet. Turn the locator light on and set it to the center of the IC.

NOTE: As a safety feature, the locator light will not operate until the temperature reaches the pre-set one, regardless if the switch is turned on.

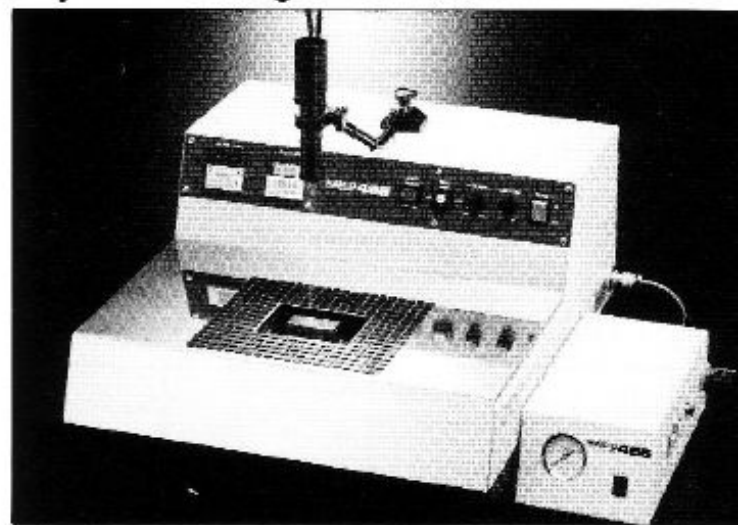
### Mode - AUTO

Before changing to AUTO mode, depress the foot switch and adjust the solder flow precisely as desired while still in MANUAL mode. Then change to AUTO mode. Set the solder flow duration according to your needs. Put a printed circuit board on the table, then set the locator light to the center of the IC.

Lightly depress the foot switch. Observe closely to see when the solder comes from the IC holes. At that time remove IC. Should it not remove easily, depress the foot switch once more. The solder will flow only for the duration set on the flow timer.

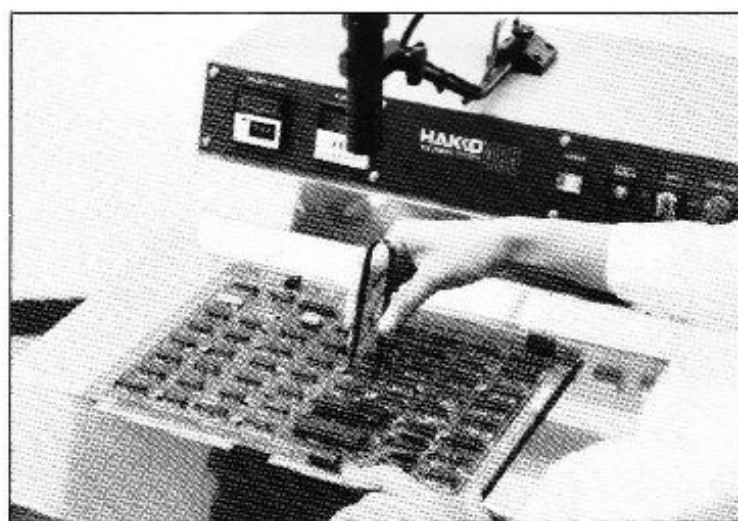
### Mode - MANUAL

Change to MANUAL. Adjust the solder flow precisely with Solder flow dial to the desired setting by depressing

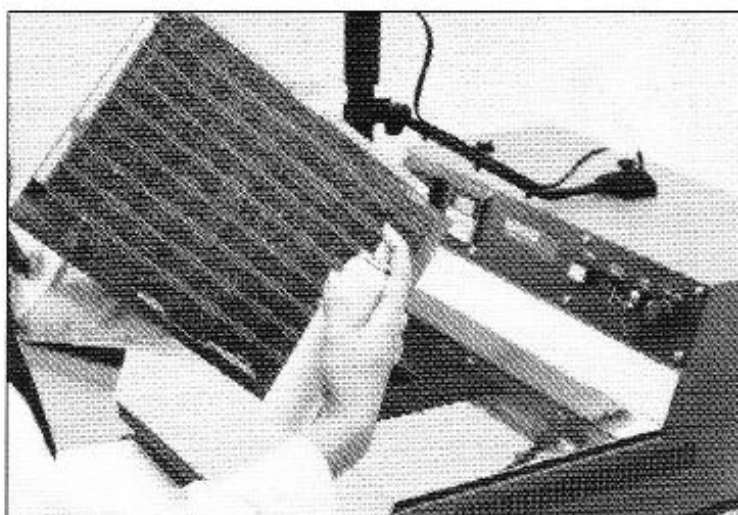


①

NOTE : Without setting the key activated switch to MANUAL or AUTO, Heating Element does not get electricity.



③



⑤



the foot switch. Put a printed circuit board on the table, and set the locator light to the center of IC.

Lightly depress the foot switch. Observe closely to see when the solder comes from the IC holes. At that time remove IC.

NOTE: As solder continues to flow while the foot switch is depressed, remove your foot from switch just before removing IC from the table. An inter-locking device prevents the motor, the foot switch, and the locator lamp from operating until the "READY" lamp is lit.



②

#### **Compressed Air Cleaning - after removal of IC**

Connect AIR UNIT (486) to the body (485) with 3P metal connector. Turn the AIR UNIT switch to ON in order to prepare for cleaning. Next, switch the MODE key on the body to AUTO, then, using a printed circuit board to test, set the solder flow duration according to your needs.

Adjust Slow down dial, Air pressure dial, Air blow duration dial and Air blow timing dial. (Refer to 7)

Put a printed circuit board on the table and set the locator light where the IC had been.

Then place the hood of the air cleaning hose over the section to be cleaned and lightly depress the foot switch. Be especially careful not to press the printed circuit board too much with your hands, as the solder will overflow through the holes. After the solder has run out, compressed air from the air hood cleans IC holes for the pre-set time period.

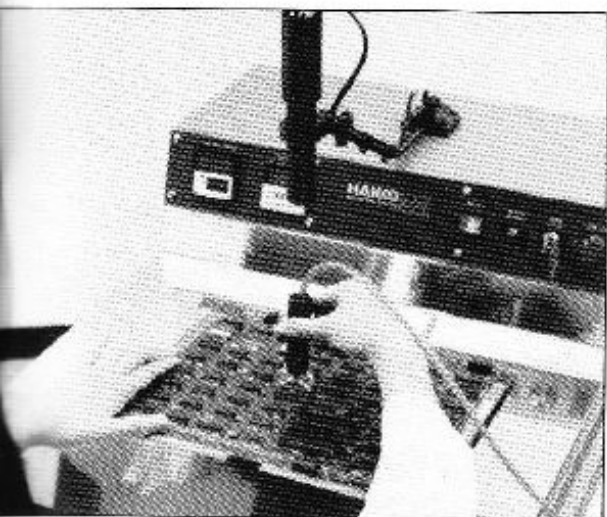
#### **Other Uses**

If an IC is defective or does not operate properly, it may be replaced with a new IC. Remove defective IC, spray flux on backside of board, and attach new IC using the same procedure as above.

Excessive solder on the leads of the IC or other components can be removed easily. Depress the foot switch and briefly dip the leads into the solder bath.

It is also possible to attach various sized connects by special ordering separate nozzle attachments from us.

NOTE: After finishing the work, turn off the power switch.



④

## 5 Trouble Shooting

- If the "POWER" lamp should fail to light, yet the solder bath has reached the desired temperature, check whether the bulb needs to be replaced.
- Should the solder bath not heat to the desired temperature, although the ◀ (red) lamp lights, the cause is likely one or more of the following:
  1. The heating elements have worn out.
  2. The SSR semiconductor switch has gone bad.
  3. The thermocouple has gone bad.
  4. The temperature control itself has gone bad.

If the thermocouple goes bad, the right arrow (▶) on the solder temperature gauge will light after the unit is switched on.

- If the solder does not flow after the foot switch is depressed, or if the ◀▶ lamp fails to light but the "READY" light does come on, then the "To timer RX relay" has gone bad.
- If the "READY" lamp fails to light, yet the solder flows, check to see if the bulb needs to be replaced.
- If the locator light fails to light after turning on the switch, but the "READY" lamp lights, then replace the locator light.

### **Mode - MANUAL**

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If the solder does not flow when foot switch is depressed, examine the following:

- **Foot Switch**

Open the rear panel of the body, depress the foot switch, and determine whether the FX relay is working or not. If it is not working properly, then replace the foot switch. (Normally, when the foot switch is depressed, the relay will make a rattling sound.)

- **The Solder Flow Dial, the Motor, the Speed Control**

If the FX relay is working properly but the solder still does not flow, then the contact of the FX relay is likely bad or components related to the speed control are bad. Remove the work table and depress the foot switch.

1. If the motor fails to work, then (1) the FX relay, or (2) the motor, the control, the motor control, the condenser, or the flow level dial has gone bad.
2. If the motor does operate, then the impeller in the solder bath has gone bad.

### **Mode - AUTO**

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If the solder does not flow when foot switch is depressed:

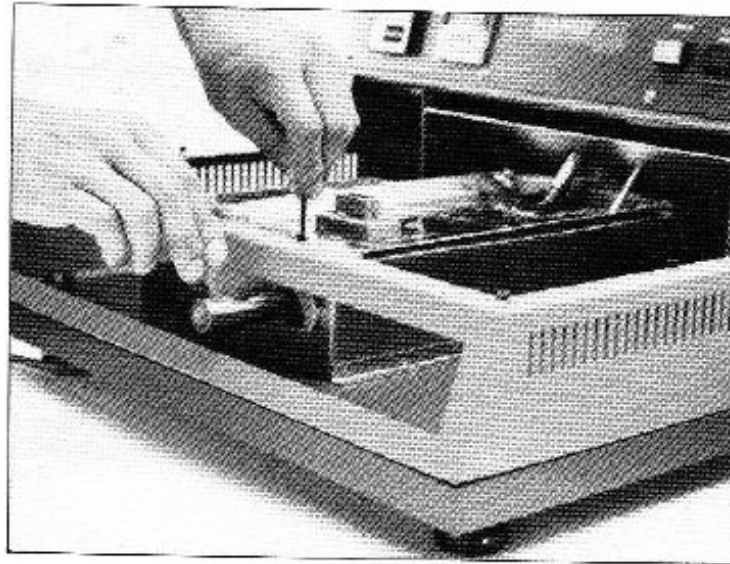
- The causes are almost identical to those of the MANUAL mode, with the exception that the time setting circuit may have gone bad.
- If the solder continues to flow in spite of the timer setting, then T1 Timer or AX relay has gone bad.



## **Replacing the Heating Element**

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- ① Open the rear panel of the body.  
Remove the four white wires from the connecting terminal.
- ② Remove the work table and pull out heat insulating material from the front of the solder bath. Unscrew the two securing nuts with a hex key wrench.
- ③ Push the heating elements forward and replace them.



## **Replacing the Sensor**

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Loosen the temperature control terminals ① and ② in the rear portion of the body. Pull the sensor out and replace it.

- ① = red (+) terminal
- ② = black (-) terminal

※ Replace the sensor when the solder in the solder bath is melted.

## **Replacing the Locator Light**

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Unscrew the securing nut through the locator light cover hole. Pulling the light up, remove it and then replace it.

## **Trouble Shooting the AIR UNIT**

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If compressed air is not forced out after the solder has ceased flowing, the problem is one or more of the following:

1. The key-activated switch has gone bad.
2. The air compressor is bad or one of the connections needs attention.
3. The dial has been improperly adjusted.
4. The T1 timer contact has gone bad.
5. The terminal connector joint cable is improperly connected.
6. The timer for the air control unit has gone bad.
7. The valve has gone bad.

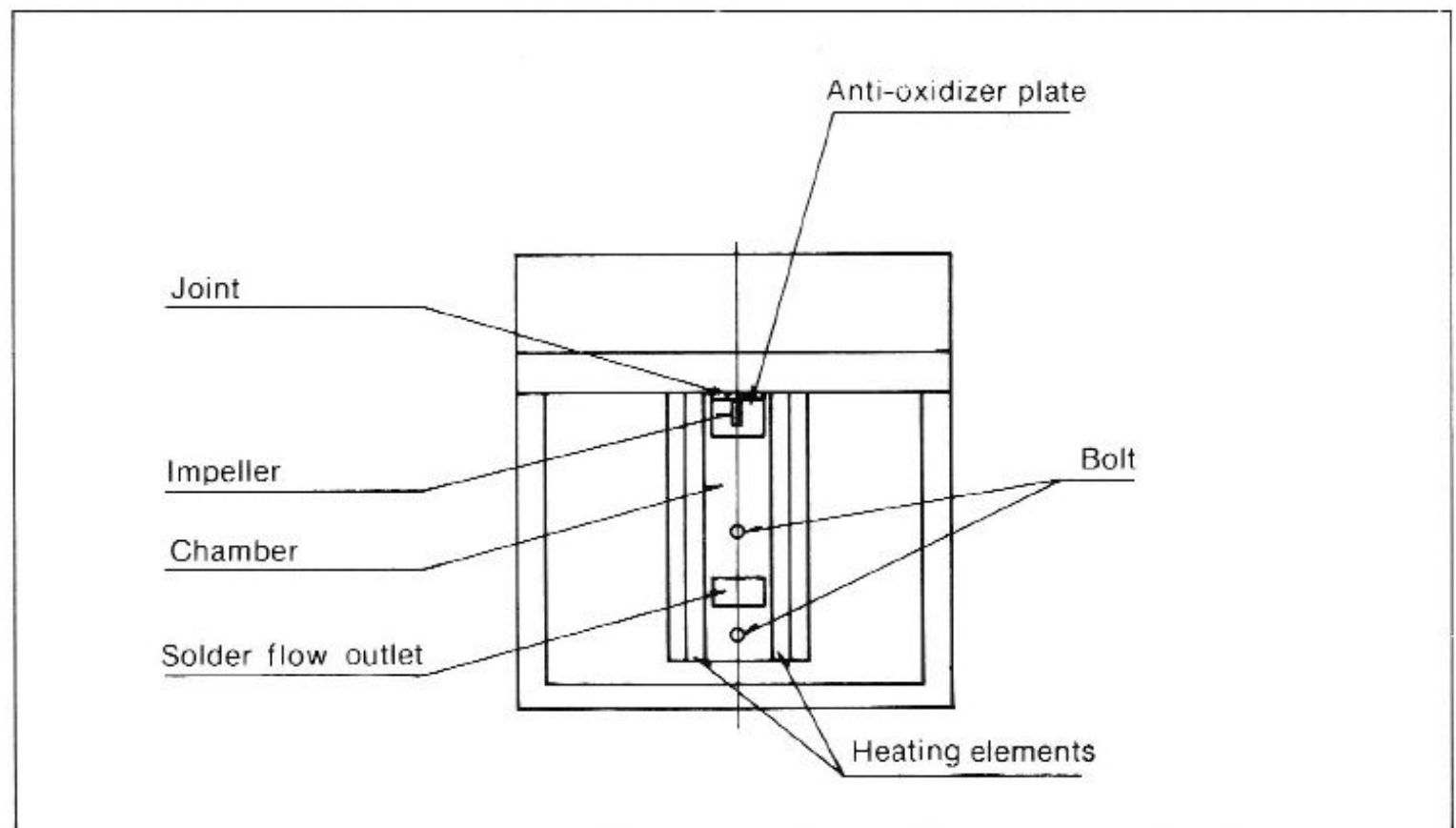


# 6 How To Clean The Inside of The Solder Bath

## A. Daily Cleaning

Clean before or after every use.

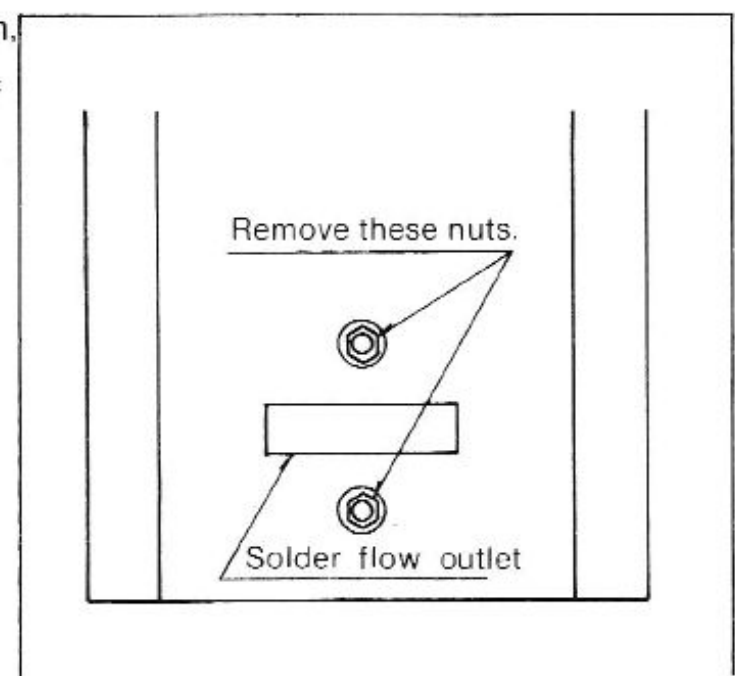
- Remove the table.
- Remove any and all oxide inside the bath using the provided spatula.
- Replace the anti-oxidizer on the anti-oxidizer plate.



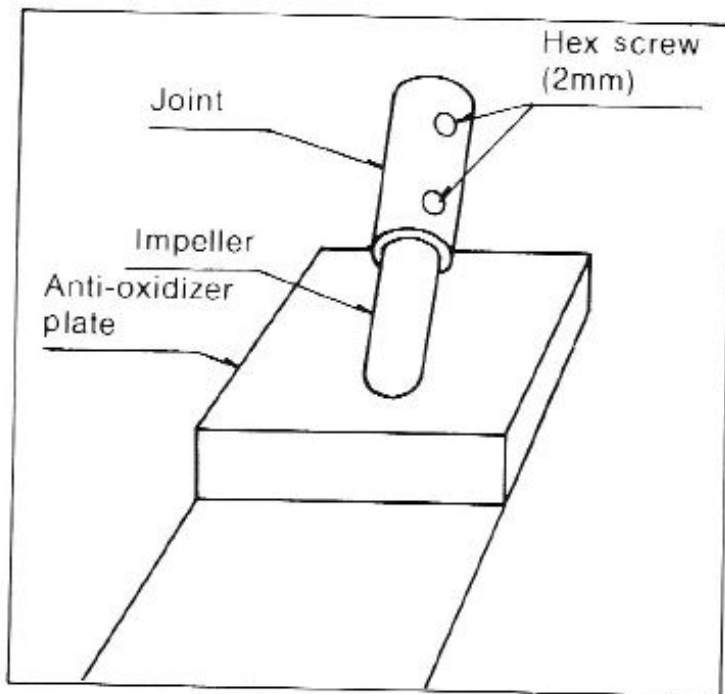
## B. Monthly Disassembly and Cleaning

To keep the unit in good working condition, clean the unit once a month following the procedure described below.

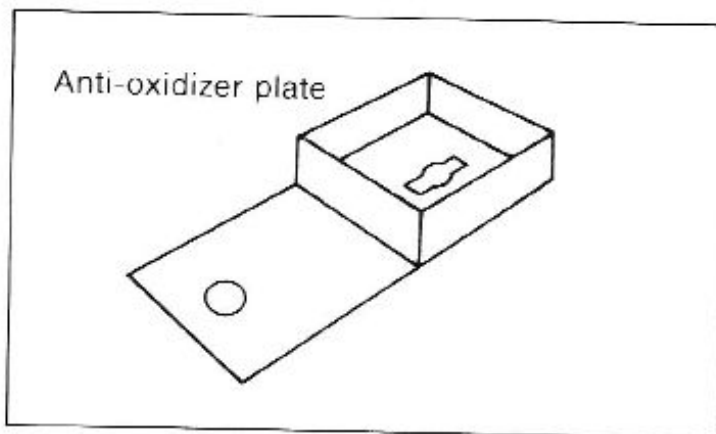
- 1) With the Power switch in the OFF position, remove the 2 nuts located at the top of the solder bath.



2) Turn the Power switch on and wait 30-40 minutes for the solder in the bath to melt.



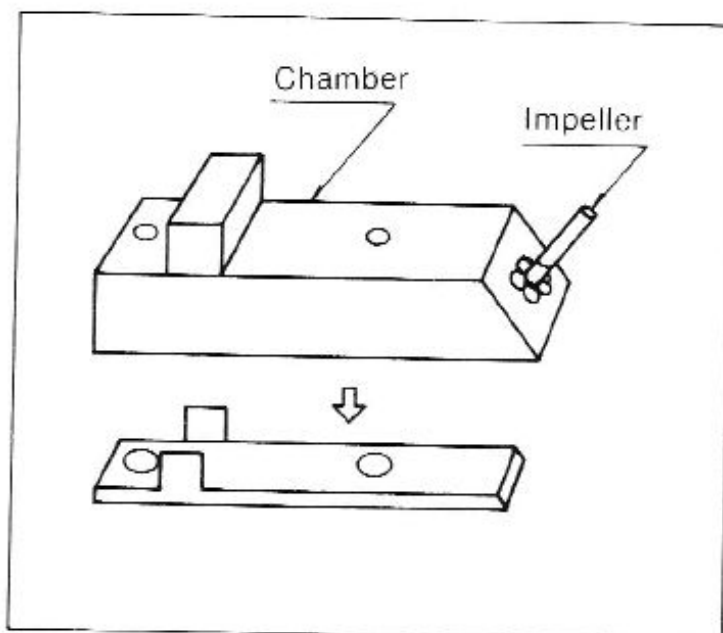
3) Using a 2.0mm hex wrench, remove the 2 screws securing the joint to the impeller and let the impeller drop down.



4) Remove the anti-oxidizer plate.

5) Grasp the Impeller and the Chamber with two pairs of pliers and gently pull the Chamber away from the bottom plate.

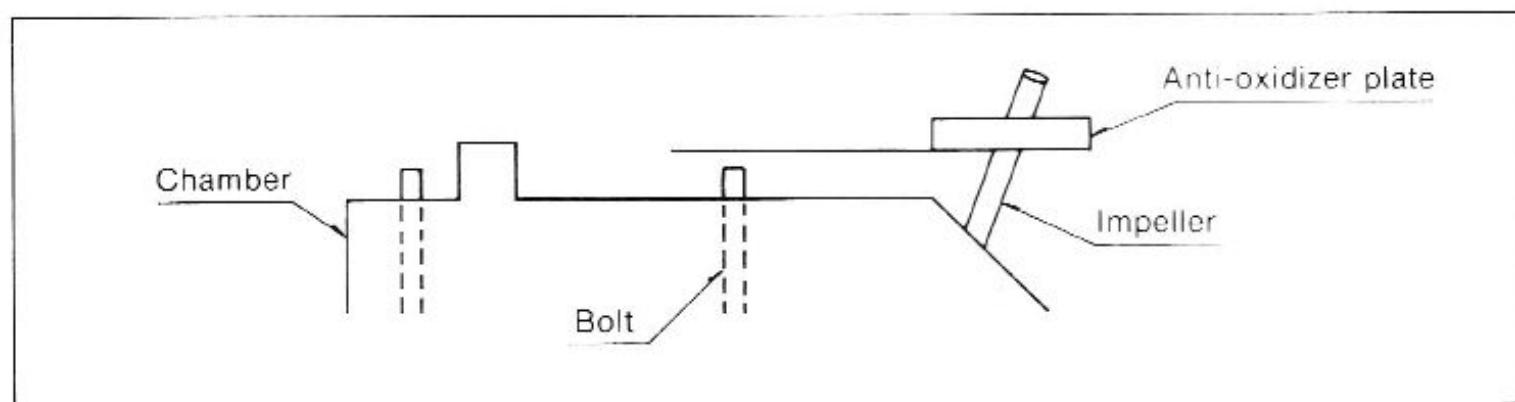
Caution: Be sure not to spill or touch the melted solder in the bath while removing the chamber.



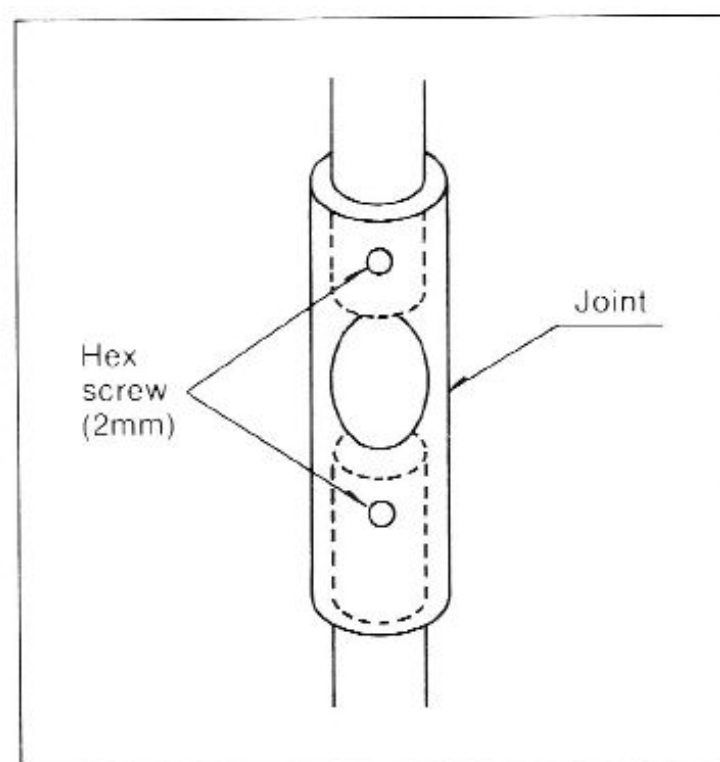
6) Remove any and all oxide from the bottom plate using the provided spatula.

7) Place the Impeller into the Chamber and secure the Chamber to the bottom plate.  
Place the Chamber into the bath over the 2 bolts.

8) Insert the Anti-oxidizer plate over the Impeller and the nearest bath bolt.



9) Align the D-shaped cuts on the impeller and the motor shaft through the hole in the joint and secure them with the 2 hex screws.



10) Turn on the motor. If the Impeller touches the bottom plate, adjust the Impeller so that it doesn't.

11) Place the Anti-oxidizer.



# 7 Setting up the Hakko No.485/486 System

## SAMPLE OF ADJUSTMENT

No. 485 Body and No. 486 Air Unit

### A. Through-hole P.C. Board on both side.

	485 Body			Air Unit (486)		
	Nozzle	Temperature Control	Flow Time	Air Pressure	Delay	Time
Slow Down Dial Scale=Max.	14/16P	250°C (482°F)	5 sec.	0.4kg/cm <sup>2</sup>	2.2 sec.	0.1 sec.
	18/20P	250°C (482°F)	5 sec.	0.4kg/cm <sup>2</sup>	2.2 sec.	0.1 sec.
	28P	250°C (482°F)	5 sec.	0.5kg/cm <sup>2</sup>	2.2 sec.	0.1 sec.
	42P	250°C (482°F)	5 sec.	0.5kg/cm <sup>2</sup>	2.2 sec.	0.1 sec.
Slow Down Dial Scale=0	14/16P	250°C (482°F)	5 sec.	0.4kg/cm <sup>2</sup>	0.6 sec.	0.1 sec.
	18/20P	250°C (482°F)	5 sec.	0.4kg/cm <sup>2</sup>	0.6 sec.	0.1 sec.
	28P	250°C (482°F)	5 sec.	0.5kg/cm <sup>2</sup>	0.6 sec.	0.1 sec.
	42P	250°C (482°F)	5 sec.	0.5kg/cm <sup>2</sup>	0.6 sec.	0.1 sec.

- Set the "Flow Level" as the solder just begins to flow from the nozzle.
- When using a special-order nozzle (for connectors, etc.), set the "Delay Timer" on the Air Unit. Set the "Timer" while the air is blowing and just when there is 2-3mm of solder under the top of the nozzle.

### B. Multi Layers P.C. Board

For printed circuit boards with more than 4 layers, preheat the board but don't increase the soldering temperature.

### Specifications

Dimensions	485 (Body) 486 (Air Unit)	500mm (19.7in) (W) × 245mm (9.6in) (H) × 550mm (21.7in) (D) 150mm (5.9in) (W) × 100mm (3.9in) (H) × 300mm (11.8in) (D)
Weight	485 (Body) 486 (Air Unit)	35kg (77lbs.) without solder 3.5kg (7.7lbs.)
Power Consumption	850W	
Room Temperature	Between -5°C (23°F) and 40°C (104°F)	
Temperature Control	Normal Temperature ~ 299°C (570°F)	
Solder	10kg (22lbs.)	
Heating Element	800W (400W × 2)	
Air Pressure	2kg/cm <sup>2</sup> (4.4lbs.) ~ 7kg/cm <sup>2</sup> (15.4lbs.)	

\* The specifications written here may be subject to change without notice.



#### OVERSEAS AFFILIATES

**U.S.A.: AMERICAN HAKKO PRODUCTS, INC.**  
25072 ANZA DR. SANTA CLARITA, CA 91355, U.S.A.  
TEL: (661) 294-0090 FAX: (661) 294-0095  
Toll Free (800)88-HAKKO

<http://www.hakkousa.com>

**HONG KONG: HAKKO DEVELOPMENT CO., LTD.**  
ROOM 1504, EASTERN HARBOR CENTRE  
26 Hoi Chak Street, Quarry Bay, HONG KONG.  
TEL: (2811-5588 FAX: 2590-0217  
<http://www.hakko.com.hk/>

**CHINA: HAKKO DEVELOPMENT CO., LTD.**  
ROOM 1112 1115, 11 FLOOR, INTERNATIONAL BANK  
TOWER 191 DONGTING ROAD WEST, GUANGZHOU  
510180, CHINA.  
TEL: (020)8135-0112, 8135-0113 FAX: (020)8135-0181

#### HEAD OFFICE

4-5, SHIOKUSA 2-CHOME, NANIWA KU, OSAKA, 556-0024 JAPAN  
TEL: +81-6-6561-3225 FAX: +81-6-6561-8466  
<http://www.hakko.com>

**TAIWAN: HAKKO DEVELOPMENT CO., LTD.**  
3F., NO 110, CHUNG HSIN RD., SEC 3, SANCHUNG, TAIPEI  
HSIEN, TAIWAN.  
TEL: (02)2975-2600 FAX: (02)2973-9565

**S'PORE: HAKKO PRODUCTS PTE., LTD.**  
1, GENTING LINK #02-04, PERFECT INDUSTRIAL  
BUILDING, SINGAPORE 349518  
TEL: 748-2277 FAX: 744-0033

**MALAYSIA: HAKKO PRODUCTS SDN BHD**  
**MALAYSIA HEAD OFFICE**  
NO.22, JALAN PEMBERITA U1/M9, SEKSYEN U1,  
TEMASIA INDUSTRIAL PARK 40150 GLENMARIE,  
SHAH ALAM, SELANGOR DARUL FUJIAN, WEST MALAYSIA.  
TEL: (03)519-5223 FAX: (03)519-5221

**PENANG BRANCH:** TEL: (04)507-0888 FAX: (04)507-0999  
**JOHORE BAHRU BRANCH:** TEL: (07)236-7766 FAX: (07)237-4666

**PHILIPPINES: HAKKO PHILS TRADING CO., INC.**  
NO. 415 WINDSOR TOWER CONDOMINIUM,  
163 LEGASPI ST., LEGASPI VILLAGE MAKATI,  
METRO MANILA, PHILIPPINES  
TEL: (02)817-0712, 815-4993 FAX: (02)810-7649

**INDONESIA: P.T. HAKKO PRODUCTSTAMA INDONESIA**  
COMP BUMI INDAH BLOK IV NO. 40 NAGOYA BATAM, INDONESIA.  
TEL: (778)457-459 FAX: (778)452-777  
**P.T. HAKKO PRODUCTSTAMA INDONESIA**  
KEBON JERUK PLAZA, BLOK D NO. 6, JALAN RAYA PERJUANGAN,  
JAKARTA BARAT, JAKARTA 11530, INDONESIA.  
TEL: (21)532-4083 FAX: (21)532-4082