Replacing the Heating Element

1. Checking the heating element
   1. Remove the nut, tip enclosure, tip and nipple.
   2. Turn the power switch on and wait until the L.E.D. heater comes on and off.
   3. Using a straight-edge (CAUTION: Be sure to remove the nut before removing the nipple).
   4. Turn the temperature calibrator clockwise to increase the temperature and counterclockwise to reduce the temperature.

2. Replacing the heating element
   1. Desolder the heating element leads and sensor leads.
   2. Remove the old heating element and replace it with a new one.
   3. Bend the leads at right angle.
   4. Pass the leads through the terminal, push the lead down inside the terminal board, then solder it. Be sure that the leads are not twisted and that the grounding spring is properly connected.

3. Inspection after replacement and reassemble
   1. After replacing the heating element, measure the resistance value between pins 4 & 1 and 4 & 2, and pins 5 & 1 and 5 & 2. If it is not infinite, the heating element and sensor are touching. Be sure that the insulation covering the lead is long enough to leave NO exposed wire. Cut the wire to leave no more than 1 to 2mm from the solder joint. Move the tube back to its original position for ESD safe type.

4. Recalibrate the temperature
   To ensure accurate soldering temperatures, always recalibrate the temperature after replacing the heating element.
   1. Connect your iron to the station for calibration.
   2. For HAKKO 927 * 937 928 * 938 929 * 939 927 * 427 729 * 928 * 929 729
      1. Set the temperature control knob to 400°C (750°F).
      2. Turn the power switch on and wait until the L.E.D. heater lamp comes on and off.
      3. Using a straight-edge (+) or small cross point screwdriver, adjust the temperature calibrator (marked “CAL”) so that the tip temperature is 400°C (750°F).
   * Turn the temperature calibrator clockwise to increase the temperature and counterclockwise to reduce the temperature.
   * Using the supplied hex wrench, remove the screw (Mx-screw) labeled “CAL” on the bottom of the station, and then turn the power on (HAKKO 937).
   * Remove the CAL pot before recalibrating HAKKO 935/937.
   * We recommend the HAKKO 951/952 thermometer for measuring the tip temperature.

5. Inspection after replacement and reassemble
   After replacing the heating element, measure the resistance value between pins 4 & 1 and 4 & 2, and pins 5 & 1 and 5 & 2. If it is not infinite, the heating element and sensor are touching. Be sure that the leads are not twisted and that the grounding spring is properly connected.

6. Recalibrate the temperature
   1. Turn the power switch on and insert the card. Set the temperature to 400°C (750°F).
   2. Wait until the digital display indicates a tip temperature of 400°C (750°F).
   3. Using a straight-edge (+) or small cross point screwdriver, adjust the temperature calibrator (marked “CAL”) so that the tip temperature is 400°C (750°F).

* Specifications subject to change without notice.

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