



Keep this manual readily accessible for reference.

Please check to make sure that all items listed below are included in the package.

Diagram illustrating the components and tools for the 240V PX-5012 soldering station:

- Hexagon wrench
- Power cord
- Display
- Control buttons
- Solder pot
- Solder pot mounting screws (both sides)
- Power switch
- Fuse
- Spatula
- J-shaped waste collector

	50 × 50 Square	75 × 75 Square
Power consumption	100V - 200W, 110V - 260W, 120V - 290W, 220V - 240W, 230V - 260W, 240V - 280W	
Temperature range	200 - 450°C (400 ~ 840°F)	200 - 380°C (400 ~ 720°F)
Solder pot dimensions	50 (W) × 50 (D) × 43.5 (H) mm (2.0 × 2.0 × 1.7 in.)	75 (W) × 75 (D) × 52.5 (H) mm (3.0 × 3.0 × 2.1 in.)
Molten solder capacity	0.85 kg (1.87 lb.)	1.2 kg (2.64 lb.)
Weight	1.7 kg (3.74 lb.)	
(w/o solder and cord)		
Outer dimensions	143 (W) × 100 (H) × 220 (D) mm (5.6 × 4.0 × 6.7 in.)	

[illegible]

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°C or °F temperature display selection	1 C	°C
Setting a solder type	2 1	Sn-Pb (Tin an lead)
Setting the solder pot type	3 1	50 × 50 square
Setting the timer	4 0	OFF or disabled

The solder types are listed for only rough classification. Select the closest one to your solder type.

6. PARAMETER SETTINGS

3. Setting the solder pot type

In the HAKKO FX-301B package, the size of the solder pot is 50 × 50 square. The 75 × 75 square solder pot is available to order for the requirement of your work.

4. Setting the timer

It will be able to check the present addition time by pressing the button.

● How to change and reset

Set the size of the solder pot that you will use.

- 50 × 50 Square: Setting range of temperatures 200 - 450°C/400 - 840°F
- 75 × 75 Square: Setting range of temperatures 200 - 380°C /400 - 720°F

Press the or to select the number corresponding to your solder pot size as shown above. After checking the displayed selection, press the button.

- for OFF or disabled
- for a value between 10 and 9990 hours

Select the displayed and then press the button. You will proceed to enter the time to set. Enter a desired time value. Time can be set in units of 10 hours in a range between and (10 and 9,990 hours). After entering the time value, press the button.

NOTE:
After the set time has passed, will be displayed, the alarm will start sounding, and then the heater for the solder pot will be turned OFF. To reset the alarm and others, turn OFF the power switch and then immediately turn it ON again. The timer will be reset to the above time setting. After the set time has passed, the heater for the solder pot will be turned OFF.

- Changing the time Enter the value between 001 - 999.
- Resetting the time In case of resetting the time (in the middle of setting the time.), please change to the different value once, and enter the desired value.

7. CHANGING THE TEMPERATURE SETTING

● Changing the temperature setting

The HAKKO FX-301B is preset at 350°C at the factory.

Example: 350°C to 400°C

1. Check that the displayed value is 350°C.
Press the button for one second or more. The hundreds digit will start blinking, indicating the unit is in the temperature setting mode.
2. Entering the hundreds digit
Press the or button to set the desired figure. When the desired figure is displayed, press the button to enter. The tens digit will begin to blink.
3. Entering the tens digit
Press the or button to set the desired figure. When the desired figure is displayed, press the button to enter. The unit's digit will begin to blink.
4. Entering the unit's digit
Press the or button to set the desired figure. When the desired figure is displayed, press the button to enter. Now the setting has been completed.

After the setting has been completed, the displayed temperature starts blinking and the temperature in the solder pot starts rising. The current temperature will be displayed in a short time.

8. IN CASE THE DISPLAY AND THE ACTUAL TEMPERATURE IS DEFFERENT

● Entering offset value

The offset value was set to 0°C at factory.

Example:

When the set temperature is 400°C and the actual solder temperature in the solder pot is 350°C; The difference between the two is +50°C. Therefore, enter 050 instead of the current offset value.

1. Press the button on the front panel.
This will set the station to offset value entry mode.
2. Enter the offset value
The allowable ranges for offset values are from -70 to +70°C (In °F mode from -158 to +158°F).

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- a. Entering the hundreds digit
• Press the or button to set the desired figure. In °C mode, 0 (plus) or - (minus) can be selected. (In °F mode, 0, 1 (plus) or -, -1 (minus) can be selected.) When the desired figure is displayed, press the button to enter. The tens digit will begin to flash.
- b. Entering the tens digit
• Press the or button to set the desired figure. Any value from 0 to 7 (In °C mode, 0 to 9) can be selected. When the desired figure is displayed, press the button to enter. The units digit will begin to flash.
- c. Entering the units digit
• Press the or button to set the desired figure. Any value from 0 to 9 (In °F mode, same value can be selected.) When the desired figure is displayed, press the button to enter.

Once you can check the display and the measured temperature, all the settings are finished.

When the temperature of solder reaches the set value, the buzzer sounds. About 5 to 10 minutes later, measure the temperature of solder. If the measured value is different from the displayed temperature, match them with each other by entering an offset.

9. MAINTENANCE

WARNING
Unless otherwise directed, carry out these procedures after turning the power switch OFF, unplugging the power plug and waiting for both the unit and the solder to sufficiently cool down.

Changing the solder pot

CAUTION
After changing the solder pot, measure the temperature again. If the measured value is different from the displayed temperature, enter an offset.

WARNING
When the power is ON, the temperature of the melted solder in the solder pot is approximately 450°C/842°F. Before changing the solder pot, be sure to unplug the power cord and let the solder and the unit cool to room temperature.

Replacing the heating element

Fig. 1
Fig. 2
Fig. 3
Fig. 4
Fig. 5

10. ERROR MESSAGES

● Sensor Error



Press the button and hold for one second.

Press the button

Press the or button.

Press the button

Press the button

Press the button

NOTE:
When measure the temperature of the solder, be sure to measure at the same position.

1. Using the hexagon wrench (provided with the HAKKO FX-301B) to loosen the screws on both sides of the unit.
- NOTE:**
Removal is unnecessary.
2. Pull out the solder pot.
3. Insert a new solder pot and then tighten the screws on both sides.
- CAUTION**
Check that the solder pot has been locked now. Otherwise, the temperature may not increase properly.
1. Loosen the screws on both sides of the unit. (Fig. 1)
- NOTE:**
Removal is unnecessary.
2. Pull out the solder pot. (Fig. 2)
3. Remove the setscrews (6 pieces) on the unit. (Fig. 3)
4. Slide the front panel forward, disconnect the two connectors (Fig. 4) from the connector circuit board, and then pull out the units of the heating elements (Fig. 5).
5. Insert the right and left heating elements in the reverse procedure to removing the heating elements.

After finishing the maintenance, measure the temperature of solder. If the measured value is different from the display temperature, enter an offset.

CAUTION
The heating element is a discrete type.
The right heating element is equipped with a sensor.

11. TROUBLE SHOOTING GUIDE

WARNING
• Before checking the inside of the FX-301B or replacing parts, be sure to disconnect the power plug.
• If the power cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified person in order to avoid personal injury or damage to the unit.

● The unit does not operate when the power switch is turned on.

CHECK : Is the power cord and/or the connection plug disconnected?
ACTION : Connect it.
CHECK : Is the fuse blown?
ACTION : Investigate why the fuse blew and then replace the fuse. If the cause can not be determined, replace the fuse. If the fuse blows again, send the unit in for repair.

12. PARTS LIST

● FX-301B Soldering pot			
Item No.	Part No.	Part Name	Specifications
①	B2917	Cover	
②	B2918	Overflow tray	
③	B2916	Heat insulator	
④	B3377	Front panel	With membrane sheet
⑤	B3376	P.W.B.	For temperature control, connector
⑥	B2705	Fuse/125V-5A	100 - 110V
	B2468	Fuse/125V-5A	120V
	B2922	Fuse/250V-5A	220 - 240V
	B3045	Fuse/250V-5A	230V CE, KTL for SG, MY, ID, PH
	B2924	Transformer	100 - 120V
	B2925	Transformer	220 - 240V
⑦	B2926	Chassis	With rubber feet
⑧	B2927	Solder pot support	
⑨	B2928	Solder pot tray	
⑩	B1084	Power switch	
⑪	B1134	Fuse holder	
⑬	B1795	Power cord, 3 wired cord & American plug	
	B1796	Power cord, 3 wired cord but no plug	
	B2913	Power cord, 3 wired cord & BS plug	230V India
	B2914	Power cord, 3 wired cord & Chinese plug	220V China
	B1797	Power cord, 3 wired cord & European plug	KTL, CE

Item No.	Part No.	Part Name	Specifications
⑬	B1798	Power cord, 3 wired cord & Australian plug	230V - 240V
	B3046	Power cord, 3 wired cord & BS plug	230V UK

● Replacement parts			
Item No.	Part No.	Part Name	Specifications
⑭	A1548	Heating element/Right Equipped with a sensor	100 - 120V
	A1550	Heating element/Right Equipped with a sensor	220 - 240V
⑮	A1552	Heating element/Left	100 - 110V
	A1554	Heating element/Left	120V
	A1555	Heating element/Left	220 - 240V
⑯	A1539	Solder pot	Special coating 50 × 50 × 43.5(mm) /1.97 × 1.97 × 1.7(in.)
⑰	B2919	J-shaped waste collector	
⑱	B2932	Spatula	
⑲	B1417	Hexagon wrench	2.5mm

● Optional parts		
Part No.	Part Name	Specifications
A1540	Solder pot	Special coating 75 × 75 × 52.5(mm)/3.0 × 3.0 × 2.1(in.)