



- Soldering station with two irons (Two-iron type of HAKKO FX-951)
- Two different soldering iron tips selected according to component sizes can be simultaneously used.
- Temperature on each station can be centrally controlled with one station
- Supports the N₂ system.

Specifications

Model No. FX952

Power consumption 140W

Temperature range 200-450°C

Temperature stability ±5°C at idle temperature

- Station

Output voltage 24V

Dimensions 113(W)×106(H)×206(D)mm

Weight 2.6kg

- Soldering Iron

Power consumption 70W (24V)

Tip to ground resistance <2Ω

Tip to ground potential <2mV

Heating element Composit heater

Length of cord 1.2m

Total length 188mm (with 2.4D tip)

Weight 30g (with 2.4D tip)

- Length and weight (w/o cord)

Packing List

Model No.	Packing List
No.FX-952	Station(HAKKO FX-952)(1), Soldering iron(HAKKO FM-2028)(2), Control card(1), Power cord(1), Heat resistant pad(1), Iron holder(1), Connecting cable(1), Instruction manual(1)

Note: A soldering tip is not included in this product. The tips of desired shape should be purchased separately.

[We apologize for the previous misdescription in the HAKKO FX-952](#)

Features

Standard Soldering Iron for Lead-free Soldering

- Uses lock-type Sleeve Assembly soldering iron.



[HAKKO FM-2028](#)

- Lock-type sleeve assembly attaches securely.
- Click sound ensures you easy and secure tip insertions.
- Four-color lineup of the sleeves
- Handy when using two different tips at the same time

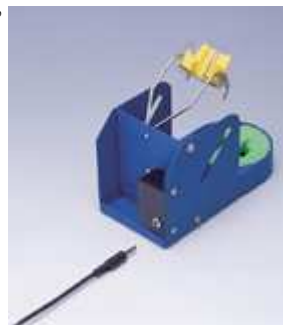
- Four Features of the Soldering Iron HAKKO FM-2028

- Interlock mechanism with the iron holder makes setting of the power-save setting easy.
- Power-save function allows minute-by-minute setting. (up to 30 minutes)
- (0-29mins. --- Sleep mode, 30 mins.--- Auto-power, Shutoff)
- Possible to set power-save function on two different irons.

* New FX-952 has the same updated features as the new FX-951.

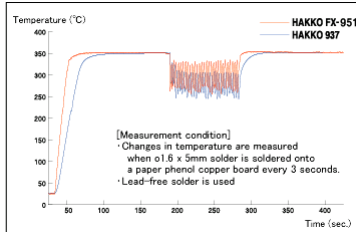
- Steady Performance Ensures Excellent Thermal Recovery.

- Never changing heater performance ensures excellent thermal recovery.(ref. Graph)

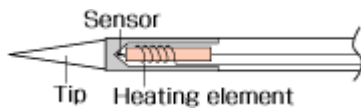


The excellent thermal recovery allows the soldering with lower preset temperature. It is also useful for Lead-free soldering which requires higher melting temperature

Thermal Recovery Graph (The comparison of HAKKO products)



- Compositetip



The composite tip is a ceramic soldering tip with integrated heating element and sensor. Despite its highly compact design, the tip offers superior thermal responsivity and greatly improved thermal recovery.

- 85 Variations of Tips



85 variations of HAKKO Tips accommodate various types of soldering from IC modifications to soldering to power sections. Tips for HAKKO FX-951 depend on the market.

[T15 Series for EU](#)

- Commitment to iron holders



Perfect for working when seated or standing

- Freely adjust iron holder angle.
- Two-stage height adjustment.
- Adjust height of left and right holders individually.

[Note] Be sure to tighten both screws firmly.
 (Failure to tighten the screws firmly may cause the sleep function to not work correctly)

A variety of height and angle settings are possible.



• Thermal Management



- Possible to lock the temperature with the control card.
- Digital offset makes temperature correction easy.
- Capable of lower limit temperature setting.



❖ Combination of optional handpiece (such as FM-2026) allows use of N₂ system.



N₂ system enhances solderability by Preventing Oxidation and Preheating Effect, featuring space-saving design.

190(W)×280(H)×206(D)mm

*Reference dimensions

Name	Figure	Remarks
HAKKO FX-952		With Iron holder, Control card, Heat resistant pad and Power cord
1 Station		(Not necessary to purchase this unit if you have it.)
<u>HAKKO</u> <u>FM-2026</u>		With Nitrogen guard(B2998)
2 N ₂ Soldering Iron	Tip and nozzle assemblies are optional parts.	*Attach it to only FH- 100(the previous iron holder).

3 Soldering Tip & Nozzle Assembly

HAKKO
FX-780



[T13 Series](#)



Select the soldering tip appropriate for work.

4 N₂ Generator



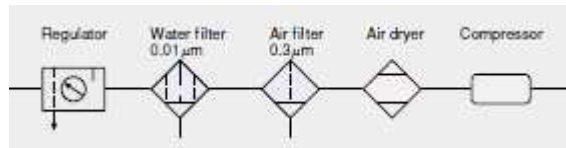
With Racks for Station
Air tube Outer diameter:
6mm It can be placed
perpendicularly or
horizontally.



5 HAKKO
FX-791
N₂ Flow Meter



6 The others



Air tube Outer diameter: 6mm

* The others are not provided by HAKKO

Used in combination with a smoke absorber
Can be used in combination with the HAKKO 490 smoke cleaner



[HAKKO 490](#)

Usage / Applications

Troubleshooting



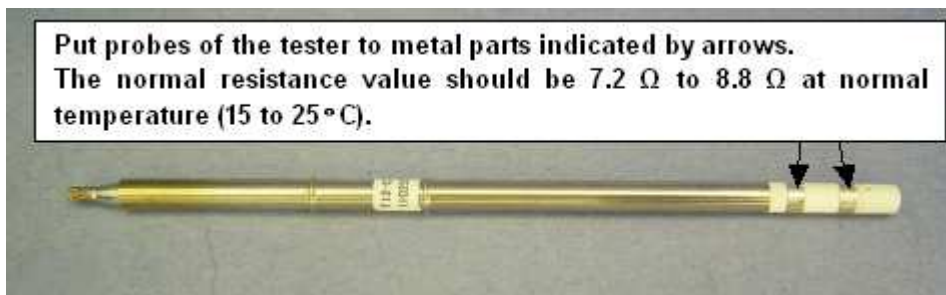
The soldering tip does not get hot. Why?

Case1 "S-E" appears on the display.



Causes : The heater or the sensor is switched off. Or the soldering iron is faulty.

Countermeasures : Measure the resistance value in the soldering tip to see if the heater or the sensor is switched off.

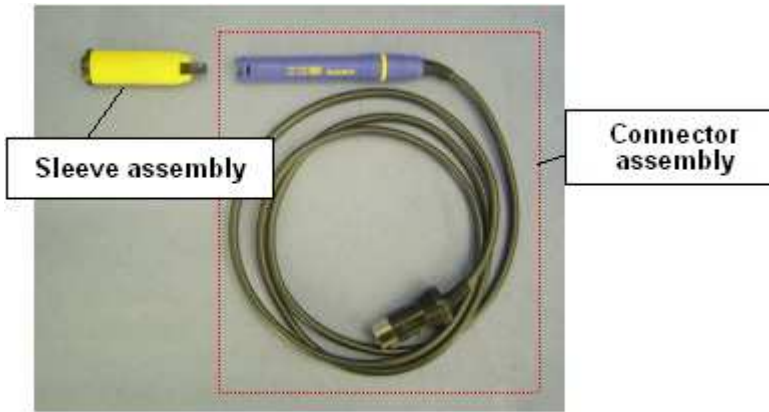


- When the resistance value is not normal
The heater or sensor is switched off. Replace a defective soldering tip with a new one.
- When the resistance value is normal
The sleeve assembly and the connector assembly might be faulty. Replace the faulty sleeve assembly and the connector assembly with new assemblies. Or have the faulty soldering station, the sleeve assembly, the connector assembly and the soldering tip repaired.



Contact the place of purchase near you and give them the part number below if you purchase a new connector assembly.

Part number: FM2028-03 Connector assembly



Submit the unit for repair.

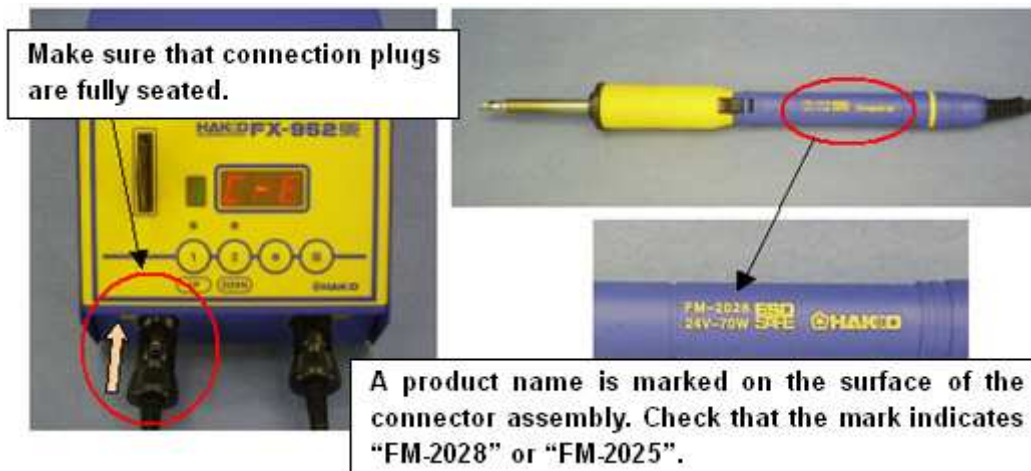
Please return the unit to the place of purchase for repair.

Case2 "C-E" appears on the display.

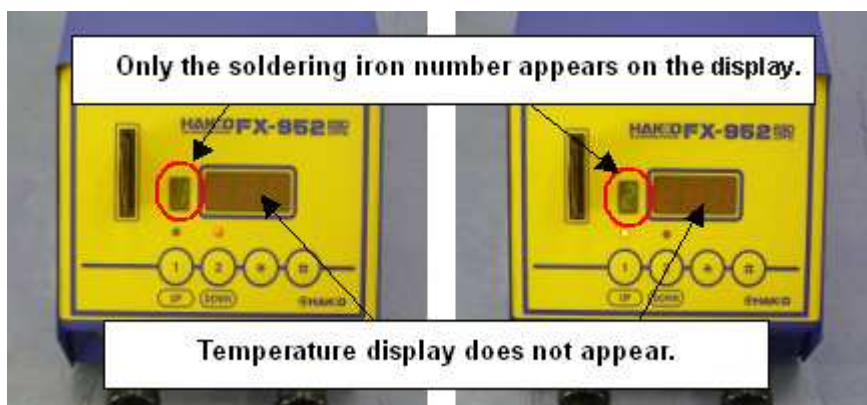


Causes : A soldering iron other than HAKKO FM-2025/2028 is used. Or a connection plug may not be fully seated.

Countermeasures : Check that a proper soldering iron is connected to the soldering station. Then remove and reconnect the connection plugs so they are fully seated.



Case3 Only the soldering iron number appears on the display.



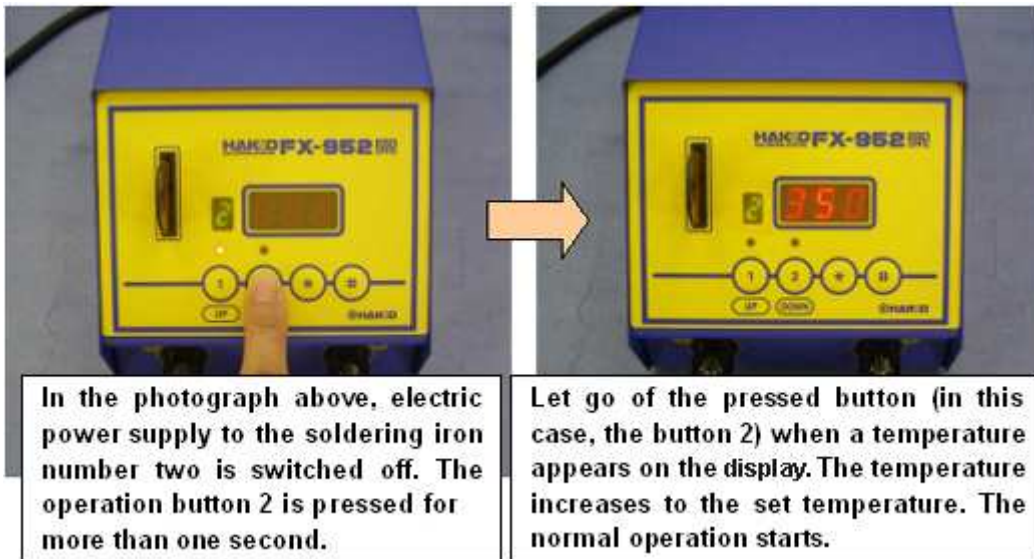
! Check the display after switching to the soldering iron number for the soldering iron that does not get hot. Only the soldering iron number appears as shown in the pictures above.

Causes : The operation button of the soldering iron number may be pressed for more than one second. Pressing the operation button of the soldering iron number for more than one second switches off the electric power to the soldering iron.



This function is available in order to protect an unused soldering iron from oxidation when only one of the two soldering irons is used. Press the operation button of the soldering iron number for more than one second again to cancel this function.

Countermeasures : Press the operation button of the soldering iron number for more than one second to cancel this function.



Case4 Nothing appears on the display.



Causes : A power cable may not be fully seated or a fuse in the power receptacle may be blown.

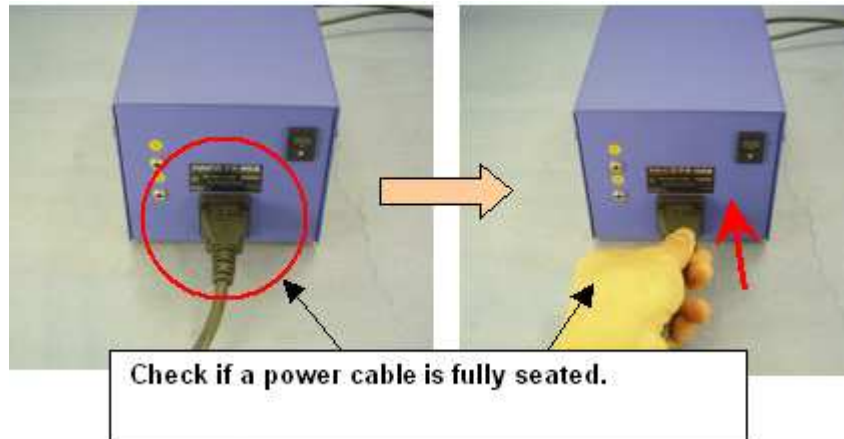
Countermeasures : Check the connection of the power cable and condition of the fuse in the power receptacle. If nothing appears on the display even if there are no problems with the power cable and the fuse have, a printed circuit board or a transformer may be faulty. Contact a HAKKO office, a service center or a distribution outlet near you to have the faulty soldering station, the sleeve assembly, the connector assembly and the soldering tip repaired. Two ways to have a faulty assembly repaired:



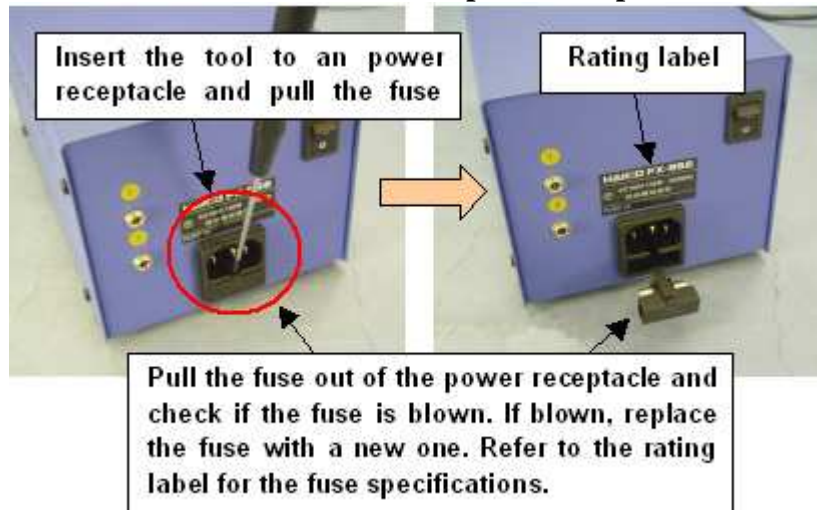
Submit the unit in a set of the station, soldering irons and tips for repair.

Please return the unit to the place of purchase for repair.

[Power cable check]



[Check on a fuse in a power receptacle]



Case5 "----" appears on the display.



Causes : The P.W.B may be faulty.

Countermeasures : Repair is necessary. Contact a HAKKO office, a service center or a distribution outlet near you to have the faulty soldering station, the sleeve assembly, the connector assembly and the soldering tip repaired.

Two ways to have a faulty assembly repaired:



Submit the unit in a set of the station, soldering irons and tips for repair.

Please return the unit to the place of purchase for repair.

Replacement Parts

	Part No.	Name	Specifications
	FH201-02	Iron holder	w/ power-save function
	FM2028-01	Soldering iron FM-2028	70W (24V)
	FM2028-02	Soldering iron FM-2028	70W (24V)
	B3253	Connecting cable	
	B2300	Heating resistant pad	
	B2388	Control card	
	B3216	Sleeve assembly	yellow
	B3218	Sleeve assembly	blue
	A1536	Cleaning sponge	green
	FM2028-03	Connector assembly	

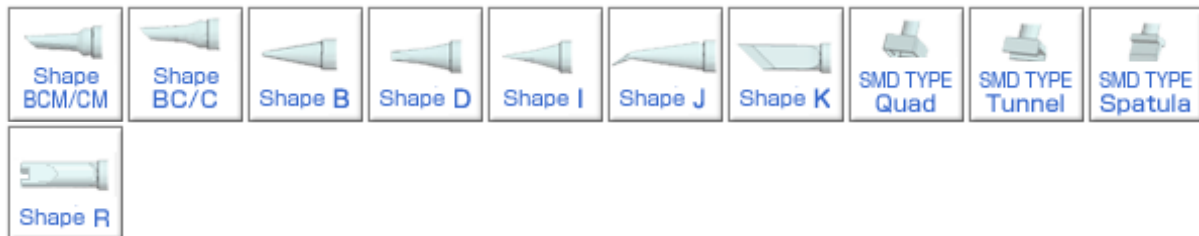
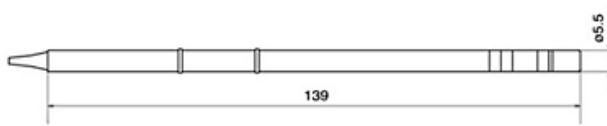


B3220 Connector cover

Option

	Part No.	Name	Specifications
	A1519	Cleaning sponge	yellow
	B3217	Sleeve assembly	orange
	B3219	Sleeve assembly	green
	599B-01	HAKKO 599B tip cleaner	
	B2756	Tip tray	

T15 széria

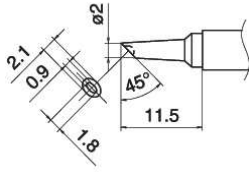


Shape BCM/CM

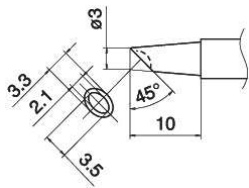
This type differs from Shape BC by the addition of a hollow to its cut face, providing high solder retention capability.

It is used for drag soldering and correction of bridging.

* Shape BCM/CM are not available for sale or use in the U.S.A.



T15-BCM2 Shape-2BC Bevel with indent

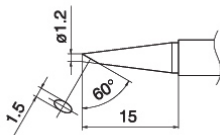


T15-BCM3 Shape-3BC Bevel with indent

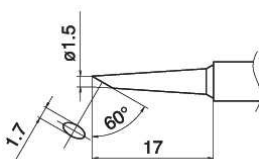
Shape BC/C

This type has a shape like a cone or column cut at a slant, which allows users to select the cut surface size depending on the workpiece.

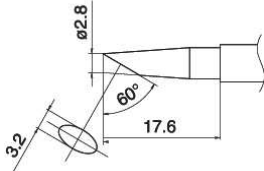
It is used for drag soldering and pre-tinning of lead wires.



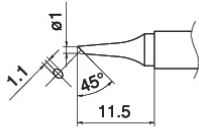
T15-BC12 Shape-1.2BC



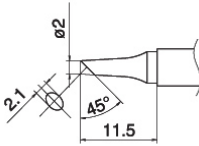
• T15-BC15 Shape-1.5BC



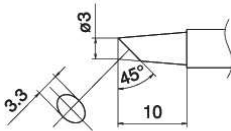
- T15-BC28 Shape-2.8BC



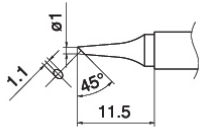
- T15-BC1 Shape-1BC



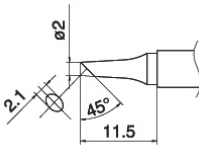
- T15-BC2 Shape-2BC



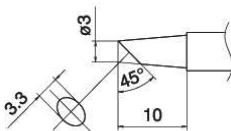
- T15-BC3 Shape-3BC



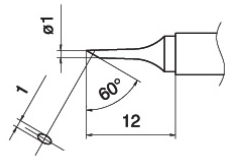
- T15-BCF1 Shape-1BC
Tinned cut surface only



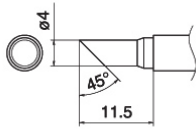
- T15-BCF2 Shape-2BC
Tinned cut surface only



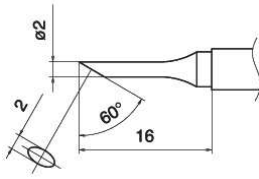
- T15-BCF3 Shape-3BC
Tinned cut surface only



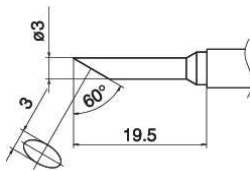
- T15-C1 Shape-1C



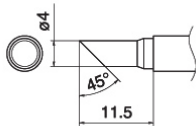
- T15-C4 Shape-4C



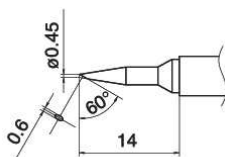
- T15-CF2 Shape-2C



- T15-CF3 Shape-3C



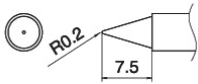
- T15-CF4 Shape-4C
Tinned cut surface only



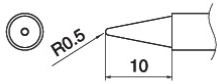
- T15-SBC04 Shape-0.4SBC

Shape B

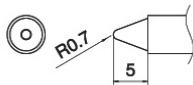
All-round type which can be used from any direction and is easy to hold at any position.
Possible to solder any surface from small to large.



T15-B Shape-B



- T15-B2 Shape-0.5B



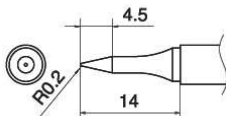
- T15-B3 Shape-0.7B



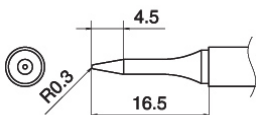
- T15-B4 Shape-0.4B



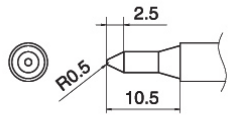
- T15-BLL Shape-BL Long



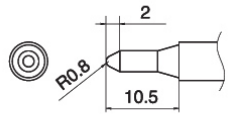
- T15-SB02 Shape-0.2SB



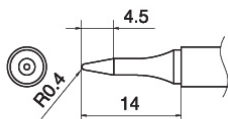
- T15-SB03 Shape-0.3SB



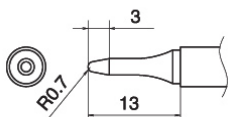
- T15-SB05 Shape-0.5SB



- T15-SB08 Shape-0.8SB



- T15-SBS04 Shape-0.4SBS

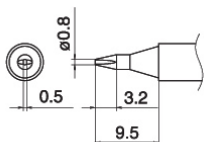


- T15-SBS07 Shape-0.7SBS

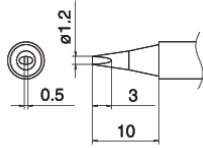
Shape D

This type has a shape like a flat-blade screwdriver and is capable of soldering by applying the tip in 2 ways: line and face.

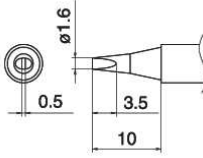
The width (size of tip) suitable for the workpiece can be selected, and it can be used for any soldering work.



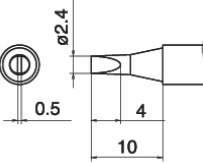
T15-D08 Shape-0.8D



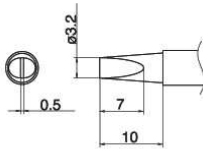
- T15-D12 Shape-1.2D



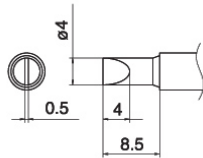
- T15-D16 Shape-1.6D



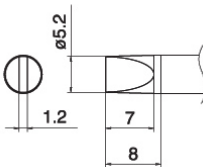
- T15-D24 Shape-2.4D



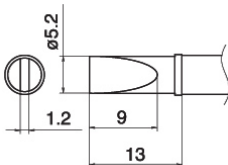
- T15-DL32 Shape-3.2D Long
Just joined as standard tip.



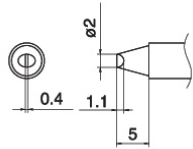
- T15-D4 Shape-4D



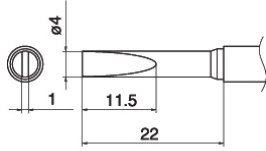
- T15-D52 Shape-5.2D



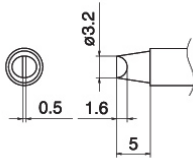
- T15-DL52 Shape-5.2D Long



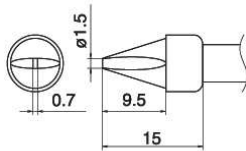
- T15-D2 Shape-2D



- T15-DL4 Shape-4D Long



- T15-D32 Shape-3.2D

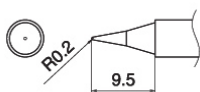


- T15-XD15 Shape-1.5XD

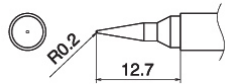
Shape I

This type has a thin conical end and is an ultrafine tip which is best suited for soldering at narrow pitches, etc.

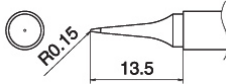
It is the best for soldering micro components such as 0603, etc. and for repairing high-density-mounting P.W.Bs. such as in cellular phones, etc.



T15-I Shape-I



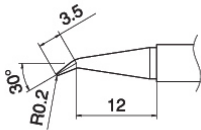
- T15-IL Shape-IL



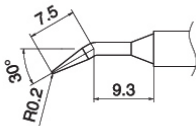
- T15-ILS Shape-ILS

Shape J

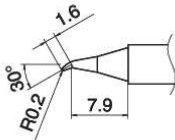
This type differs from Shape B and I by bending the tip end and is capable of soldering by applying the tip in 2 ways: face and point. It is used for drag soldering and correction of bridging.



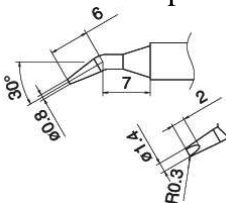
T15-J02 Shape-0.2J (Shape-0.2RSB)



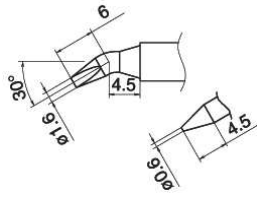
- T15-JL02 Shape-0.2JL (Shape-0.2RLB)



- T15-JS02 Shape-0.2JS (Shape-0.2RSSB)



- T15-JD14 Shape-1.4JD

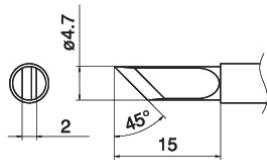


- T15-JD16 Shape-0.6JD

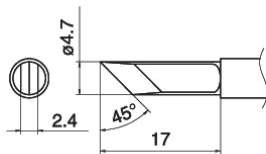
Shape K

This type has a shape like a knife and is capable of soldering by applying the tip in 3 ways: line, face and point.

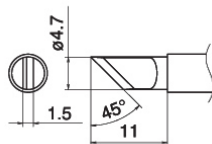
It is used for soldering at narrow pitches, correction of bridging and drag soldering.



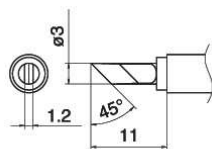
T15-K Shape-K



- T15-KF Shape-KF



- T15-KL Shape-KL
For drag soldering for left-handed.

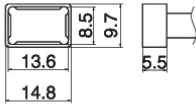


- T15-KU Shape-KU

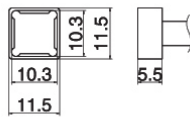
SMD Type : Shape Quad

This type is capable of heating plural pins or lead wires at once and is used for rework of SMDs.

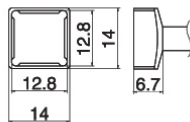
It is used for removal of QFP.



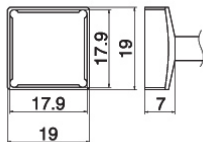
T15-1201 Quad
Size 13.6 x 8.5



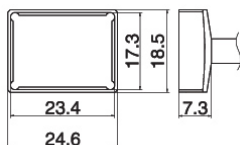
- T15-1202 Quad
Size 10.3 x 10.3



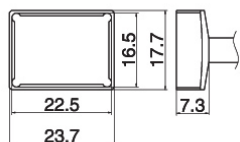
- T15-1203 Quad
Size 12.8 x 12.8



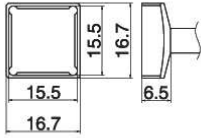
- T15-1204 Quad
Size 17.9 x 17.9



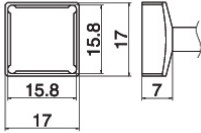
- T15-1205 Quad
Size 23.4 x 17.3



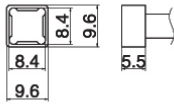
- T15-1206 Quad
Size 22.5 x 16.5



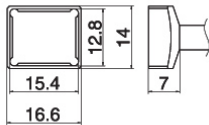
- T15-1207 Quad
Size 15.5 x 15.5



- T15-1208 Quad
Size 15.8 x 15.8



- T15-1209 Quad
Size 8.4 x 8.4

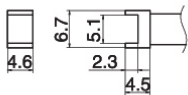


- T15-1210 Quad
Size 15.4 x 12.8

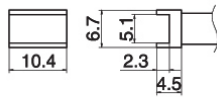
SMD Type : Shape Tunnel

This type is capable of heating plural pins or lead wires at once and is used for rework of SMDs.

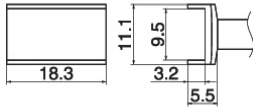
It is used for removal of SOP.



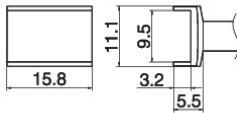
T15-1001 Tunnel
Size 5.1 x 4.6



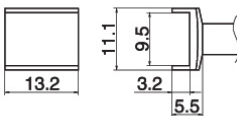
- T15-1002 Tunnel
Size 5.1 x 10.4



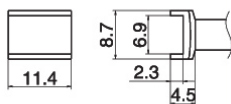
- T15-1003 Tunnel
Size 9.5 x 18.3



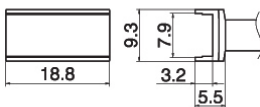
- T15-1004 Tunnel
Size 9.5 x 15.8



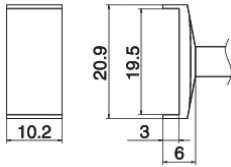
- T15-1005 Tunnel
Size 9.5 x 13.2



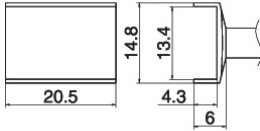
- T15-1006 Tunnel
Size 6.9 x 11.4



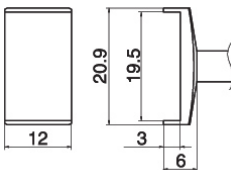
- T15-1007 Tunnel
Size 7.9 x 18.8



- T15-1008 Tunnel
Size 19.5 x 10.2



- T15-1009 Tunnel
Size 13.4 x 20.5

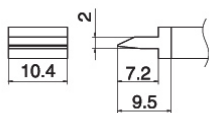


- T15-1010 Tunnel
Size 19.5 x 12

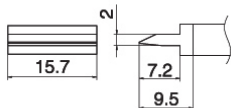
SMD Type : Shape Spatula

This type is capable of heating plural pins or lead wires at once and is used for rework of SMDs.

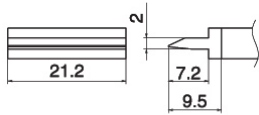
Soldering for thermal compression of flexible P.W.B., shield cases, connector, etc.



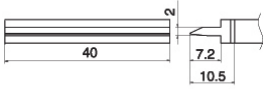
- T15-1401 Spatula
Size 10.4



- T15-1402 Spatula
Size 15.7



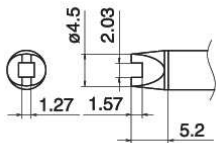
- T15-1403 Spatula
Size 21.2



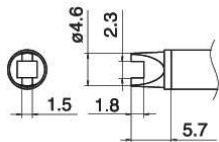
- T15-1406 Spatula
Size 40

Shape R

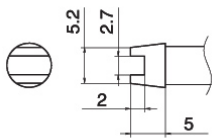
This type has a groove at the tip end.
It is suitable for removing ICs.



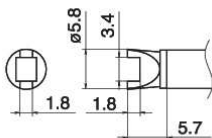
T15-R20 Shape-2.0R



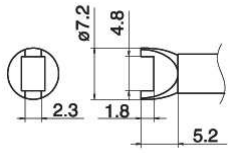
- T15-R23 Shape-2.3R



- T15-R27 Shape-2.7R



- T15-R34 Shape-3.4R



- T15-R48 Shape-4.8R