

N₂ System

N₂ System



N₂ gas and preheating effect improves the solderability greatly!

- The preheating effect is achieved by passing Nitrogen gas along the heating element in the hand piece. Soldering can be done on multilayer PWB and high density PWB sensitive to heat without raising the temperature of the tip excessively, even when the melting point of lead-free solder is high.
- Improvement of wettability and spreadability.
- Preventing oxidation.
- Space saving:-

In case of setting with HAKKO FX-951, the dimensions are 163(W) x 280(H) x 110(D)mm
 In case of setting with FM-203, the dimensions are 201(W) x 280(H) x 190(D)mm

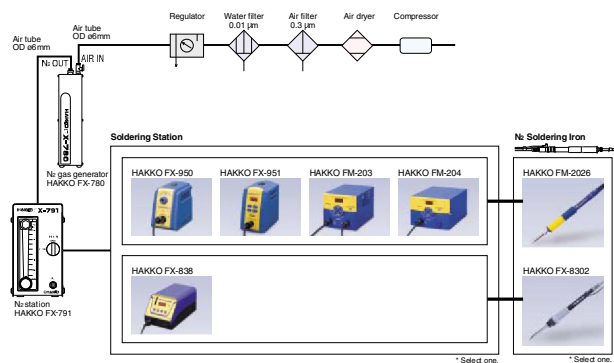
Setting example with the FX-951
 * HAKKO FX-951, HAKKO FM-2026
 HAKKO FX-780, HAKKO FX-791

Comparison of wettability and spreadability



Less bridge is generated even for components susceptible to bridging.

Connection method



Compact High-Performance N₂ Generator



HAKKO FX-780

- HAKKO FX-780 generate Nitrogen gas at a maximum concentration of 99.9%. It is very compact and can be installed in a minimal space. Moreover, it can be placed perpendicularly or horizontally.

Compact N₂ Flow Meter



HAKKO FX-791

- This meter is very compact and can be installed in a minimal space next to the soldering station. The flow meter has a range between 0.25~2.5 l/min, allowing easy control. (Recommended flow rate is 0.5 l/min. to 1.5 l/min. Adjust the flow rate depending on the tip shape.)

N₂ Soldering Iron

Nitrogen gas passes between the tip and nozzle assembly uniformly and the soldering tip is entirely covered with Nitrogen gas, which intercepts oxygen to prevent the soldering tip and solder from being oxidized and increases the preheating effect. It allows more stable and uniform soldering.



HAKKO FM-2026

- N₂ Soldering iron with high-out 70W
 FM-2026 Conversion Kit (No.FM2026-04)



Iron holder (No.FH200-01) is included.

● Sleep Function

Conversion Kit	FX-950		FX-951		FX-952*		FM-203	FM-204	FM-312*
	Former	Latest	Former	Latest	Former	Latest			
FM-2026 Conversion Kit (No.FM2026-04)	○	×	○	×	○	○	○	○	×

○ - Equipped with the sleep function X - Not equipped with the sleep function

* Discontinued Product



HAKKO FX-8302

- Heavy-duty soldering iron 150W
- Easy tip replacement
- A cartridge type soldering tip can be replaced easily and quickly.

N₂ System

Specifications

FX-780	
Model No.	FX-780
Air Supply Pressure	0.3-0.7MPa
Concentration of Soldered N ₂	99.9% (Max.)
Amount of Generated N ₂	1.5L/min. (When compressed air of 0.5MPa is supplied at 25°C, the concentration of generated nitrogen is 98%.)
Dimensions (w/o sockets & valve)	73(W) x 282(H) x 71(D)mm
Weight (w/o racks)	1.5kg
FX-791	
Model No.	FX-791
Dimensions	70(W) x 121(H) x 134(D)mm
Weight	600g
Pressure (w/o rack) / Gas flow	0.2MPa (2.0kgf/cm ²) 0.25-2.5l/min

FM-2026	
Model No.	FM-2026
Power Consumption	70W (24V)
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Cord	1.2m
Total Length (w/o cord)	205mm with 2.4D tip
Weight (w/o cord)	45g w/nozzle assembly C & 2.4D tip

FX-8302	
Model No.	FX-8302
Power Consumption	150W
Tip to Ground Resistance	< 2Ω
Tip to Ground Potential	< 2mV
Cord	1.2m
Total Length (w/o cord)	195mm with 2.4D tip
Weight (w/o cord)	41g w/nozzle assembly D & 2.4D tip

Packing List

Model Name	Contents
HAKKO FX-780	N ₂ generator1 Racks for station2
HAKKO FX-791	N ₂ station1
HAKKO FM-2026 (Conversion kit)	N ₂ soldering iron (FM-2026)1 Iron holder with 599B tip cleaner (No. FH200-01)1 Connecting cable1 Heat resistant pad1 * This unit does not include a soldering tip or nozzle assembly. When purchasing this unit, please buy your desired soldering tip and nozzle assembly together.
HAKKO FX-8302	N ₂ soldering iron (FX-8302)1 * This unit does not include a soldering tip or nozzle assembly. When purchasing this unit, please buy your desired soldering tip and nozzle assembly together.

Replacement and Optional Parts

Part No.	Name/Description
FM2026-02	HAKKO FM-2026/24V-70W
B2974	Sleeve cover
B2765D	Sleeve assembly, yellow
B2768D	Sleeve assembly, orange
B2769D	Sleeve assembly, blue
B2998*	Nitrogen guard

* When using the soldering iron holder cover, install it into your soldering iron holder.

Sleeve Assemblies

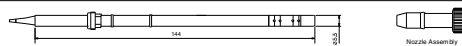


No. B2765D (Yellow) No. B2768D (Orange) No. B2769D (Blue)

Optional Tips and Nozzle Assemblies

Unit: mm

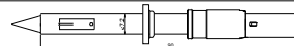
For FM-2026



Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly
T13-B2 Shape-0.5B	B2708 Nozzle assembly C	T13-BL Shape-BL	B2988 Nozzle assembly E	T13-BC1 T13-BCF ¹⁾ Shape-1BC	B2899 Nozzle assembly F
T13-BC2 T13-BCF ²⁾ Shape-2BC	B2708 Nozzle assembly A	T13-BC3 T13-BCF ³⁾ Shape-3BC	B2900 Nozzle assembly G	T13-D08 Shape-0.8D	B2709 Nozzle assembly D
T13-D16 Shape-1.6D	B2708 Nozzle assembly C	T13-D24 Shape-2.4D	B2708 Nozzle assembly C	T13-J02 Shape-0.2J	B2707 Nozzle assembly B
T13-KF Shape-KF	B2923 Nozzle assembly J	T13-KR Shape-KR	B2902 Nozzle assembly I	T13-KU Shape-KU	B2901 Nozzle assembly H
T13-BCM2 Bevel with indent ⁴⁾ Shape-2BC	B2706 Nozzle assembly A	T13-BCM3 Bevel with indent ⁴⁾ Shape-3BC	B2900 Nozzle assembly G		

¹⁾ These tips are limited on the soldering surface only.
²⁾ T13-BCM2 and T13-BCM3 are not available for sale or use in the U.S.A.

For FX-8302



Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly	Tip	Applicable Nozzle Assembly
T20-BC T20-BCF ¹⁾ Shape-1BC	B3121 Nozzle assembly A	T20-BC2 T20-BCF ²⁾ Shape-2BC	B3124 Nozzle assembly D	T20-BC3 T20-BCF ³⁾ Shape-3BC	B3124 Nozzle assembly D
T20-BC4 T20-BCF ⁴⁾ Shape-4BC	B3124 Nozzle assembly D	T20-C5 Shape-0.5C	B3124 Nozzle assembly D	T20-C6 Shape-0.6C	B3124 Nozzle assembly D
T20-D16 Shape-1.6D	B3123 Nozzle assembly C	T20-D24 Shape-2.4D	B3124 Nozzle assembly D	T20-D32 Shape-0.32D	B3124 Nozzle assembly D
T20-D6 Shape-0.6D	B3561 Nozzle assembly E	T20-J02 Shape-0.2J	B3122 Nozzle assembly B	T20-K Shape-K	B3123 Nozzle assembly C
T20-KU Shape-KU	B3122 Nozzle assembly B	T20-BL Shape-BL	B3121 Nozzle assembly A	T20-BL2 Shape-BL2	B3121 Nozzle assembly A
T20-BL3 Shape-BL3	B3123 Nozzle assembly C	T20-BCM ²⁾ Shape-3BC	B3124 Nozzle assembly D		

¹⁾ Tipped on the soldering surface only.
²⁾ The part number T20-BCM2 is not available for sale or use in the U.S.A.