

HAKKO FR-873

PREHEATER

Preheater

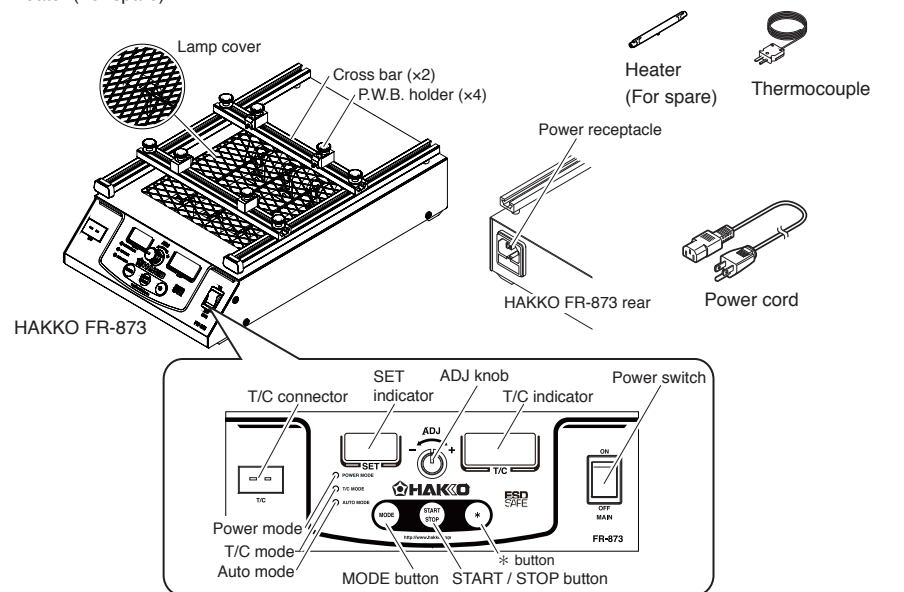
Instruction Manual

Thank you for purchasing the HAKKO FR-873 Preheater.
Please read this manual before operating the HAKKO FR-873.
Keep this manual readily accessible for reference.

1. PACKING LIST AND PART NAMES

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

HAKKO FR-873	1	Power cord	1
Thermocouple	1	Instruction Manual	1
Heater (For spare)	1		



2. SPECIFICATIONS

Power consumption	120V-370W
Effective heated area	80(W) × 80(D) mm (3.2 × 3.2 in.)
Heater area dimensions	133(W) × 140(D) mm (5.2 × 5.5 in.)
Dimensions	190(W) × 100(H) × 311(D) mm (7.5 × 3.9 × 12.2 in.)
Weight (w/o cord)	2.2 kg (4.9 lb.)
Mode	Power mode 0 - 100%
	T/C mode 50 - 200°C (122~392°F)
Temperature stability	T/C mode ±5°C (±9°F)

* This product is protected against electrostatic discharge.
* Specifications and design are subject to change without notice.

中國RoHS: 產品中有毒有害物質或元素的名稱及含量

部件名稱	有毒有害物質或元素					
	鉛(Pb)	汞(Hg)	鎘(Cd)	六價鉻(Cr(VI))	多溴聯苯(PBB)	多溴二苯醚(PBDE)
電路板	×	○	○	○	○	○
水平支架	×	○	○	○	○	○
連接器	×	○	○	○	○	○
插座	×	○	○	○	○	○

○ : 表示該有毒有害物質在該部件所有均質材料中的含量均在SJ/T 11363-2006標準規定的限量要求以下。
× : 表示該有毒有害物質至少在該部件的某一均質材料中的含量超出SJ/T 11363-2006標準規定的限量要求。

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CAUTION

This product includes such features as electrically conductive plastic parts and grounding of the handpiece and station as measures to protect the device to be soldered from the effects of static electricity. Be sure to observe the following instructions:
1. The handle and other plastic parts are not insulators, they are conductors. When making repairs or replacing parts, take sufficient care not to expose live electrical parts or damage insulation materials.
2. Be sure to ground the unit during use.

3. WARNINGS, CAUTIONS AND NOTES

Warnings, cautions and notes are placed at critical points in this manual to direct the operator's attention to significant items. They are defined as follows:

⚠ **WARNING:** Failure to comply with a WARNING may result in serious injury or death.

⚠ **CAUTION:** Failure to comply with a CAUTION may result in injury to the operator, or damage to the items involved. Two examples are given below.

NOTE: A NOTE indicates a procedure or point that is important to the process being described.

WARNING

When powered, the preheater unit will become extremely hot, possibly reaching temperatures above 200°C (392°F). Be sure of the following to avoid possible burns/fires resulting from the failure to observe them.

- Do not touch the lamp cover. Also, do not place a metal object around the lamp cover.
- Do not use the product near an object that may readily catch fire.
- Inform all individuals nearby that the "product can be extremely hot and can pose a hazard."
- Turn off the product and check to be sure it has sufficiently cooled before replacing a part or storing the product.
- The unit is for a counter or workbench use only.
- This appliance can be used by children aged from 8 years and above and persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge if they have been given supervision or instruction concerning use of the appliance in safe way and understand the hazards involved.
- Children shall not play with the appliance.
- Cleaning and user maintenance shall not be made by children without supervision.

● To prevent accidents or damage to the HAKKO FR-873, be sure to observe the following:

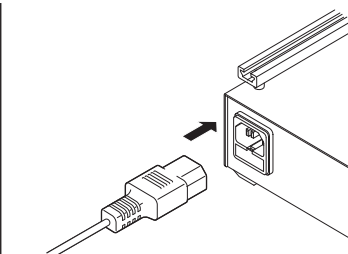
CAUTION

- Turn off the product when suspending/terminating its operation or before leaving it unattended.
- Do not use the product for purposes other than preheating.
- Do not subject the product to excessive impact.
- Do not expose the heater unit to Hot Air directly from above.
- Be sure that the product is properly grounded before use.
- Do not modify the product.
- Be sure to use genuine HAKKO parts for replacement.
- Be sure the product does not wet. Do not handle it with wet hands.
- Be sure to hold the plug whenever connecting/disconnecting the cord.
- Avoid any use or actions acts that could pose a hazard.

4. INITIAL SETUP

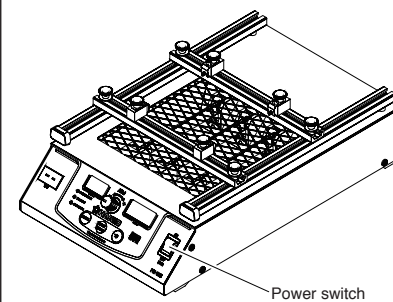
A. Making connections and turning on the power

1. Connect the power cord to the power receptacle found on the rear of the preheater body.



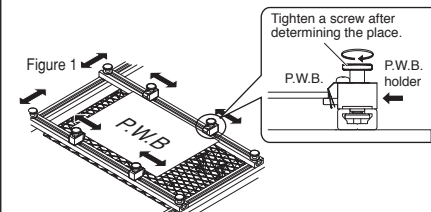
2. Connect the power plug to the power outlet.

3. Turn on the power switch.



B. Mounting the P.W.B.

Fit the P.W.B. to the HAKKO FR-873. (Figure 1)



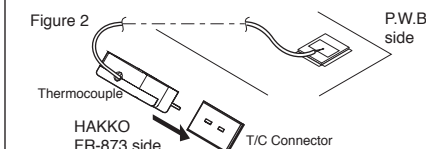
Ensure the front cross bar is secure. Place one edge of the P.W.B. against the holder clips. Bring the rear cross bar into contact with the opposite edge of the P.W.B. so that the holder clips secure the P.W.B..

4. INITIAL SETUP

C. Attaching the thermocouple in (auto) T/C mode
Insert the thermocouple in the thermocouple connector; then, bring the tip of the thermocouple into contact with any location where you want to take measurements or a part you want to heat. (Figure 2)

CAUTION

S-E is indicated when the thermocouple is not properly connected to the preheater body or has an open circuit. If you receive an error, insert the thermocouple properly in the thermocouple connector, then, turn on the power switch again.



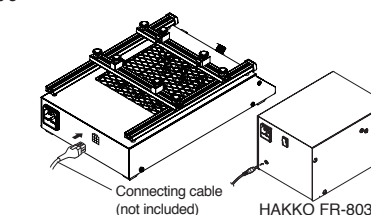
Connection with the HAKKO FR-803B/FM-206 (Optional)

The HAKKO FR-803B and FM-206 can be connected to the HAKKO FR-873 with a connecting cable, which permits the HAKKO FR-803B / FM-206 to start/stop the HAKKO FR-873.

CAUTION

Connect the HAKKO FR-873 and FR-803B / FM-206 by the connecting cable before turning on the power switch.

Figure 3



1. HAKKO FR-803B

START

When pressing the Hot Air button of the HAKKO FR-803B handpiece, the HAKKO FR-873 will work in conjunction with the HAKKO FR-803B. The HAKKO FR-873 and FR-803B will be operated by the setting and mode of each unit.

NOTE:

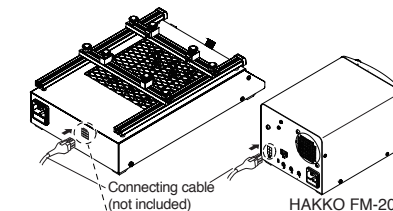
When pressing the START/STOP button of the HAKKO FR-873, Only the HAKKO FR-873 will be activated.

STOP

Press the Hot Air button of the HAKKO FR-803B handpiece or turn off the power when the profile is finished in auto mode.

CAUTION

Be sure that both the HAKKO FR-873 and FR-803B are starting from the STOP state. If the HAKKO FR-873 is running and the HAKKO FR-803B is not, starting the HAKKO FR-803B will effectively stop the HAKKO FR-873.



Please refer to the HAKKO FR-803B instruction manual for its use.

2. HAKKO FM-206

START

When pressing the Hot Air button of the HAKKO FM-2029 handpiece with the HAKKO FM-2029 connected to the HAKKO FM-206, or pressing the START/ STOP button of the HAKKO FR-873, the HAKKO FR-873 will work in conjunction with the HAKKO FM-206. The HAKKO FR-873 and FM-206 will be operated by the profile of each unit.

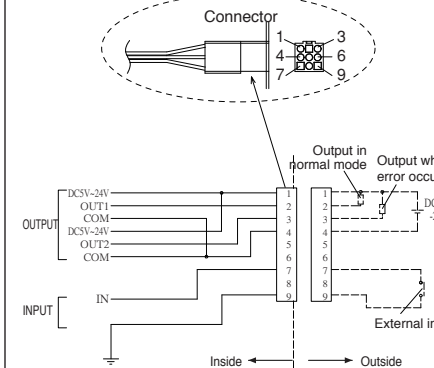
STOP

Press the Hot Air button of the HAKKO FM-2029 handpiece while the HAKKO FM-2029 is connected to the HAKKO FM-206, or press the START/ STOP button of the HAKKO FR-873. If the HAKKO FM-206 is in AUTO mode, the HAKKO FR-873 will stop automatically when the HAKKO FM-206 reaches the end of the programmed profile.

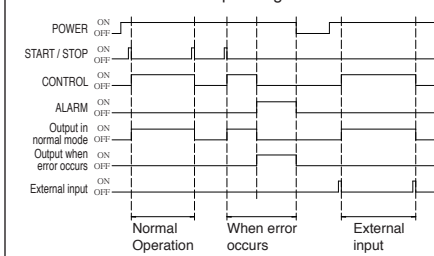
CAUTION

When using the HAKKO FR-873 in Auto Mode, it is necessary to ensure that each stage of the profile has the same time setting as the profile on the HAKKO FR-803B or FM-206. It is also necessary to set the HAKKO FR-803B or FM-206 to use CLOSED timing.

Please refer to the HAKKO FM-206 / FM-2029 instruction manual for its use.



Operating chart



5. OPERATION

A. Selecting the desired mode

Use the MODE button to select the desired mode. (Normal or Auto mode)
 Each mode (Normal or Auto) is divided into the following control modes:
 Power mode: The preheater is controlled by setting the output.
 T/C mode: The preheater is controlled by setting the temperature.

CAUTION

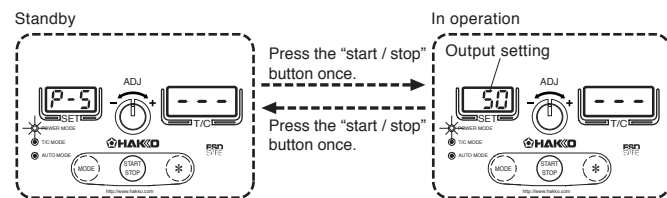
If the preheater is used in combination with a hot air rework station, be sure the heater is not exposed directly to the hot air.

Normal modes

● Power mode

The unit is controlled according to the setting output during operation.

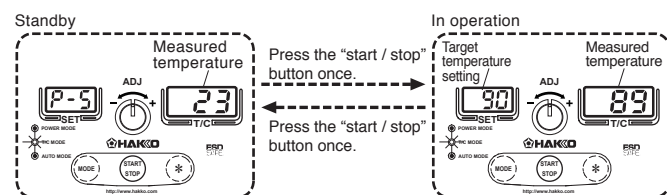
LED lamp :
POWER MODE



● T/C mode

The unit is controlled so that measurement temperature by the thermocouple becomes the setting temperature during operation.

LED lamp :
T/C MODE

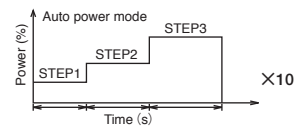


Auto modes

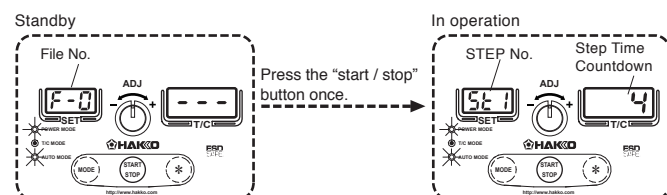
In auto modes, the preheater automatically returns to its previous state when all associated operations are completed. The unit will return to standby even when pressing the START/STOP button during operation.

● Auto power mode

The output (%) and time (sec) are controlled according to the profile set in 3 steps.
 It's possible to store ten profiles.

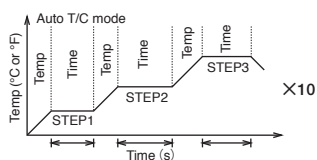


LED lamp :
POWER MODE
AUTO MODE

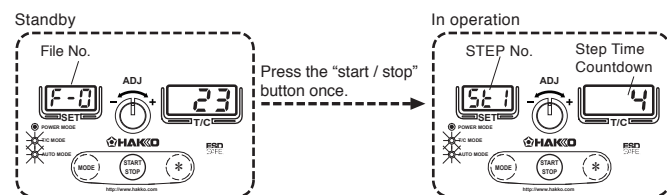


● Auto T/C Mode

The thermocouple is used to control the temperature of a specific location of measurement for a specific length of time according to the profile set in 3 steps.
 It's possible to store ten profiles.



LED lamp :
T/C MODE
AUTO MODE



If the thermocouple is attached to the T/C connector while the preheater is in power mode/auto power mode, temperature readings are indicated on the T/C indicator for monitoring; otherwise, the display will read " - - - ".

Detailed information on the parameters and how to change them can be found in manuals available at the HAKKO Document Portal. Please download and make use of them.

➔ <https://doc.hakko.com>

5. OPERATION

● Changing the settings used in normal mode

Example: Changing the settings used in power mode

Be sure that the setting in power mode is between 0% and 100%.

● Initially, the setting is 50%.

EX: To change from 25% to 50%,

1. Hold down the (*) button found on the front panel for at least one second.
 The SET indicator flashes to indicate the current setting.

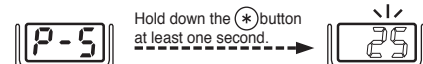
2. Changing the Setting

Turn the ADJ knob until the desired setting is indicated. When the desired setting is indicated, press the (*) button to complete the task.

* It's possible to change the setting temperature in the same procedure when in T/C mode.

CAUTION

Although it's possible to change the setting value during operation, note that the output can fluctuate.



Turn the ADJ knob.



● Changing the file used in auto modes

Each file (indicated as F-0 through F-9) used in auto modes permits the specification of 10 profile settings. Before selecting a different file, be sure that the preheater is in auto mode (i.e., the AUTO MODE lamp is on).

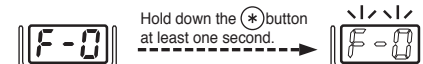
1. Hold down the (*) button found on the front panel for at least one second.
 The SET indicator flashes to indicate the current setting.

2. Changing the Setting

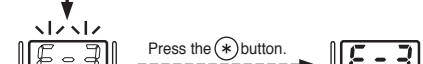
Turn the ADJ knob until the desired setting is indicated. When the desired setting is indicated, press the (*) button to complete the task.

* Detailed information on the parameters and how to change them can be found in manuals available at the HAKKO Document Portal. Please download and make use of them.

EX: To switch from file No. 0 to file No. 3,



Turn the ADJ knob.



6. INSPECTION

In order for you to use the preheater in optimum condition for a long time, it is important that you perform maintenance work on a regular basis. The degree of wear and tear the preheater may incur varies depending on the temperatures it is used at and the environment it is used in. Provide appropriate care according to the conditions of its use.

WARNING

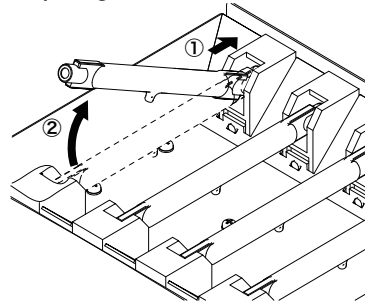
When replacing the heater:
 • Make sure the heater and lamp cover have sufficiently cooled.
 • Be careful for any injuries which may be caused by sharp edges on the lamp cover.

■ Burned-out heater



Measure the resistance value between the terminals.

■ Replacing the heater



Measure the resistance of the heater. If the heater has an open circuit, replace the heater.

1. Remove the screws from the both sides of the unit and detach the cover.

2. Lift and move the lamp cover out of the way of the lamps.

CAUTION
 Do not remove the nuts securing the grounding strap to the lamp cover.

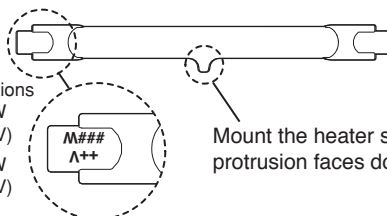
3. Replace the heater.

CAUTION
 • Do not subject the heater to excessive impact.
 • Do not hold the heater by its glass portion at the center with bare hands.
 • For replacement, hold the end of the heater, and detach it from the socket at an angle.

4. Replace the lamp cover and re-install the cover of the unit.

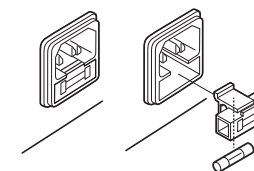
CAUTION
 • Mount the heater so that the sealing at the center faces downward (on the reflector side).
 • Be sure that the grounding wire of the lamp cover is properly connected.

Specifications
 40V 120W
 (100-120V)
 80V 250W
 (220-240V)



Mount the heater so that the protrusion faces downward.

6. INSPECTION



1. Disconnect the power cord from the power receptacle.
2. Pull the fuse out of the fuse holder.
3. Replace the fuse with a new one.
4. Put the fuse holder back in place.

7. TROUBLESHOOTING

WARNING

Be sure to disconnect the power plug before inspecting the inside of the preheater or replacing its part to avoid electric shocks.

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

CHECK: Is the power cord or the power plug disconnected?
ACTION: Connect the cord or the plug.
CHECK: Has the fuse blown?
ACTION: Find out why the fuse has blown; then, replace the fuse. If the fuse blows once again, ship the preheater body together with the fuse for necessary repairs.

● The heater is not powered.

CAUTION
 A single block has a set of 3 heaters. Keep in mind that an open circuit in one heater deprives the other heaters in the same block of power.

CHECK: Has the START/STOP button been pressed?
ACTION: Press the START/STOP button.
CHECK: Is the selector switch off?
ACTION: Turn on the selector switch.
CHECK: Is the heater out of the socket?
ACTION: Fit the heater properly in the socket.
CHECK: Is the heater burned out?
ACTION: If the result indicates that the heater has burned out, replace it.

● S-E is indicated.
 (in T/C mode, auto T/C mode)

CHECK: Is the thermocouple connected to the preheater body?
ACTION: Connect the thermocouple to the preheater body.
CHECK: Does the thermocouple have an open circuit?
ACTION: If feasible, correct the open circuit; otherwise, replace the thermocouple.

● H-E is indicated.
 (in T/C mode, auto T/C mode)

CHECK: Is the selector switch off?
ACTION: Turn on the selector switch.
CHECK: Is the heater burned out or out of place?
ACTION: See "● The heater is not powered."
CHECK: Is the setting for the heater power alert too low (set to too short a time)?
ACTION: Change the heater power alert to an appropriate setting.
CHECK: Is the location of measurement for the thermocouple inappropriate or is the thermocouple mounted improperly?
ACTION: Mount the thermocouple to an appropriate location of measurement.

● O-E is indicated
 (in T/C mode, auto T/C mode)

CHECK: Is the setting for the temperature upper limit too low?
ACTION: Change the temperature upper limit to an appropriate setting.

● U-E is indicated.
 (in T/C mode, auto T/C mode)

CHECK: Is the setting for the temperature lower limit too high?
ACTION: Change the temperature lower limit to an appropriate setting.

● The heater fails to exert control, the control mechanism is not normal, or the temperature indication remains unchanged.

CHECK: Is the thermocouple displaced from the location of measurement or is it mounted improperly?
ACTION: Mount the thermocouple in an appropriate location of measurement.

● Settings cannot be edited. The mode cannot be changed.

CHECK: Is the protection level C-2 or higher?
ACTION: By referring to "● Editing the Parameters", change the protect level to one that permits changing of the settings.

● The unit turns off suddenly while running.

CHECK: Is the Auto power shutoff set?
ACTION: Turn OFF the power switch and then back ON. By referring to "● Editing the Parameters", change the Auto shutoff time.

※ 各言語 (日本語、英語、中国語、フランス語、ドイツ語、韓国語) の取扱説明書は以下のURL、HAKKO Document Portalからダウンロードしてご覧いただけます。
 (商品によっては設定の無い言語がありますが、ご了承ください)
 * 各言語 (日本語、英語、中文、法語、ドイツ語、韓国語) 的使用説明書は以下のURL、HAKKO Document Portal 下欄参照。
 (有一部分的产品没有设定外语对应, 请见谅)
 * Instruction manual for the language, Japanese, English, Chinese, French, German and Korean can be downloaded from the following URL, HAKKO Document Portal.
 (Please note that some language may not be available depending on the product.)

➔ <https://doc.hakko.com>