




# CATALOG

# TIP



Rev 2000-04



Hakko prides itself in the consistently high quality of the materials and workmanship that go into its products, which include our various soldering and desoldering tips. Hakko tips are designed and manufactured for maximum heat conductivity, performance, and life.

## TIP MAINTENANCE AND CLEANING PROCEDURES

### SELECTING THE PROPER TIP FOR THE JOB.

- Short tips with larger dimensions will provide better heat transfer and performance than longer, thinner tips.
- One common problem is not matching the tip size to the job. This can cause a drop in the performance of your soldering irons and affect the reliability of your work.
- Matching the tip size and configuration to the job is as important as any other aspect of soldering, and in many cases is more important. Always use a tip as wide and thick as possible, making sure that it does not interfere with components or overlap the pad and touch the board.

### KEEP TIPS 'WET'.

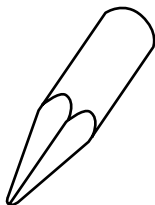
- Applying solder to the working surface of the tip will prevent oxidation and impurities from building up. This promotes long tip life.

### KEEP TIPS CLEAN.

- Stroking the tip surface across a clean and properly damp cellulose sponge will keep flux residues, solder impurities, and oxidation from forming on the surface of the tip. Immediately re-wet the tip with solder after wiping, or before any extended period when the iron will not be used.

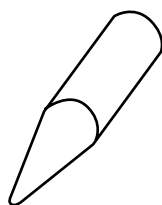
### BASIC STYLE OF "HAKKO" SOLDERING IRON TIPS

SHAPE 'A'



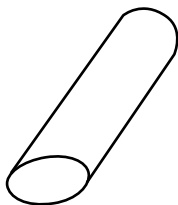
Pyramid  
Type

SHAPE 'B'



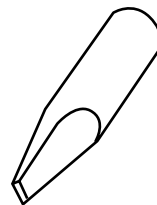
Conical  
Type

SHAPE 'C'

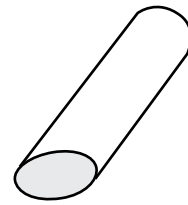


Bevel  
Type

SHAPE 'D'



Chisel  
Type



\* These tips are tinned  
on the flat only.

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Note: dimensions in ( ) = inches



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pgs. 6, 8, 9 & 18



pgs. 6, 8, 9 & 18



pg. 10 & 18



pg. 13



pgs. 14 & 15



pgs. 16 & 17



pg. 20



pg. 20



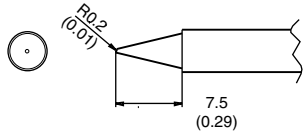
pgs. 6, 8, 9, 18 & 20



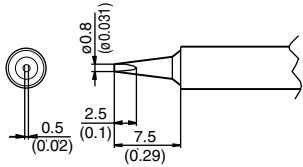
pg. 18

# 911 Series

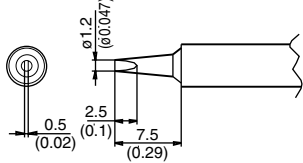
T1-B Shape-B Conical



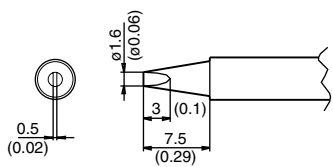
T1-08D Shape-0.8D Chisel



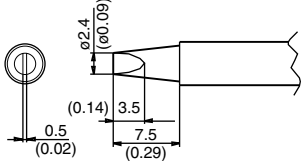
T1-12D Shape-1.2D Chisel



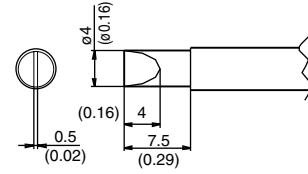
T1-16D Shape-1.6D Chisel



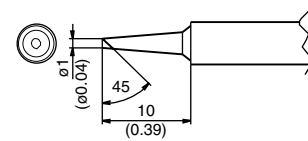
T1-24D Shape-2.4D Chisel



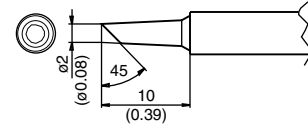
T1-4D Shape-4D Chisel



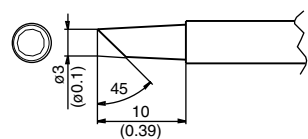
T1-1BC Shape-1BC Bevel



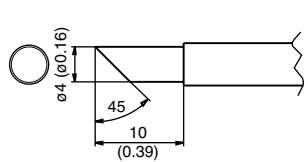
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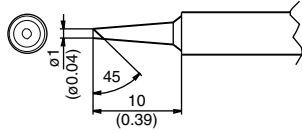
T1-3BC Shape-3BC Bevel



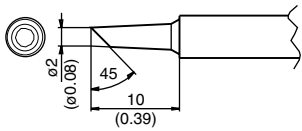
T1-4C Shape-4C Bevel



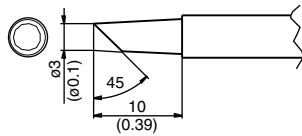
**T1-1BCF Shape-1BC Bevel**  
(Tinned on soldering surface only.)



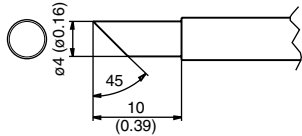
**T1-2BCF Shape-2BC Bevel**  
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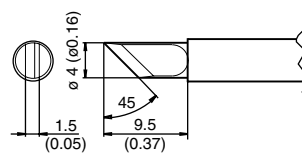
**T1-3BCF Shape-3BC Bevel**  
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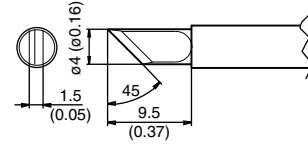
**T1-4BCF Shape-4C Bevel**  
(Tinned on soldering surface only.)



**T1-K Shape-K Knife**

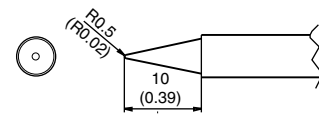


**T1-KL Shape-KL Knife**

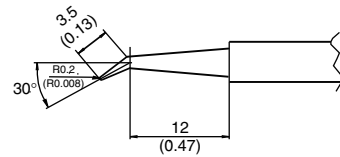


left handed knife tip

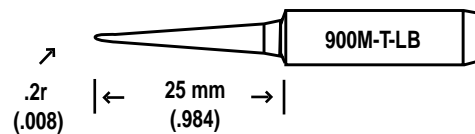
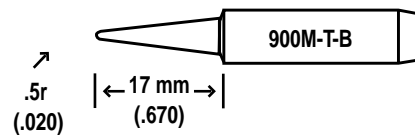
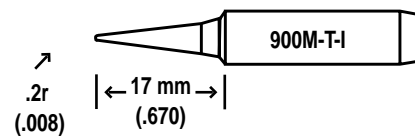
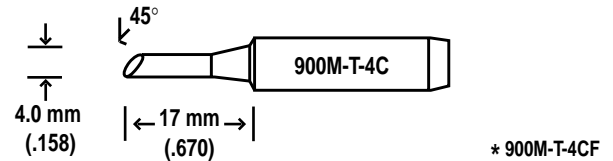
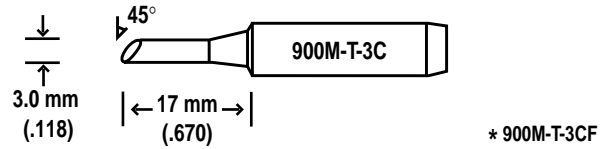
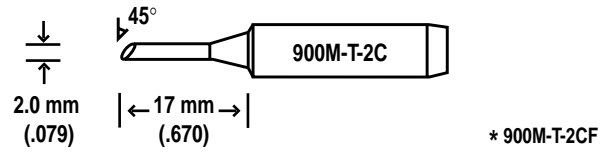
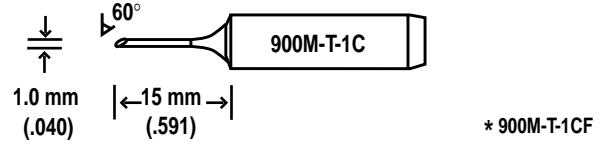
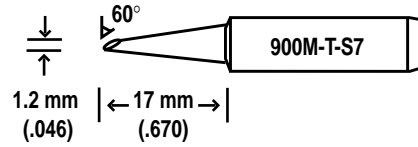
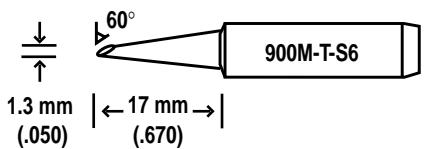
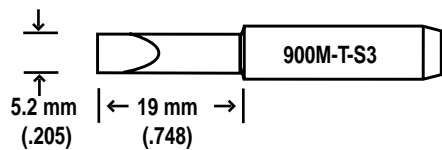
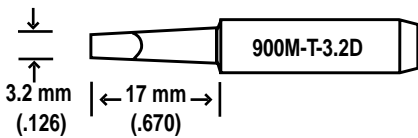
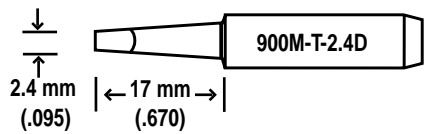
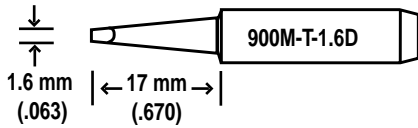
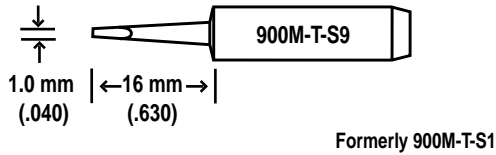
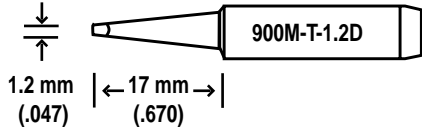
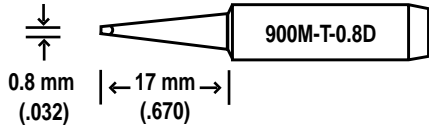
**T1-2B Shape-2B Conical**

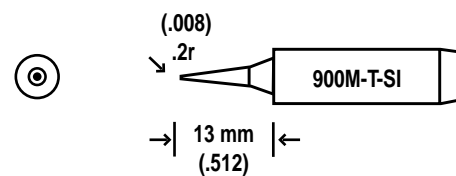
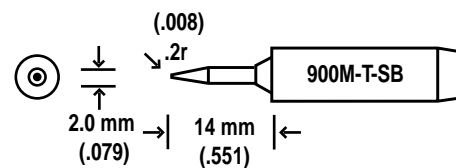
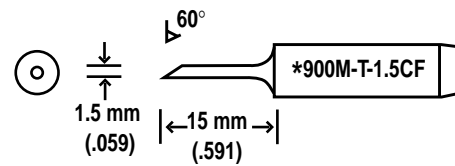
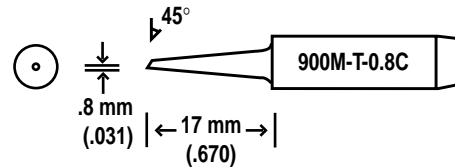
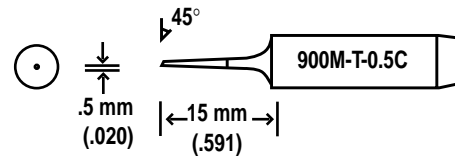
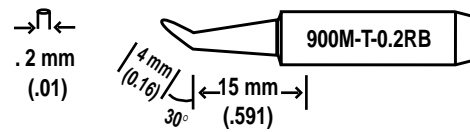
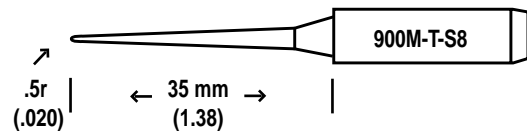
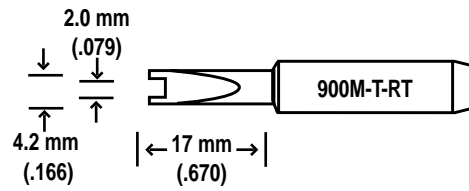
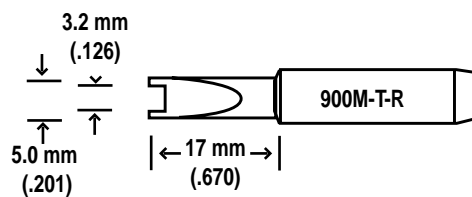
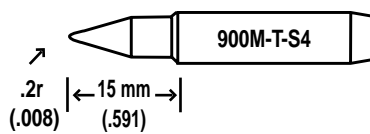
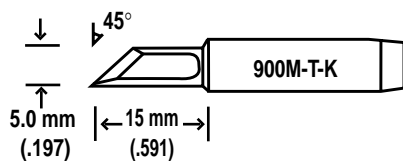
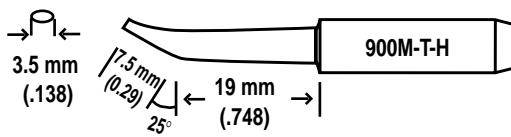
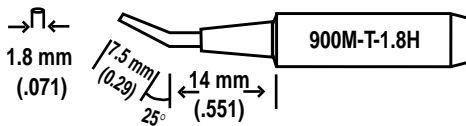
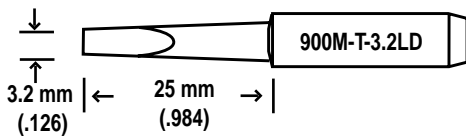
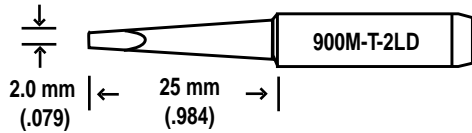
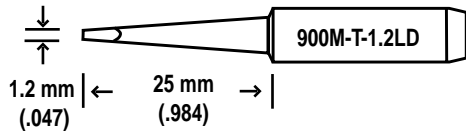


**T1-02JL Shape-02RLB Bent**

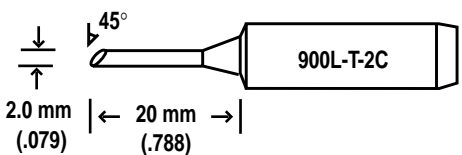
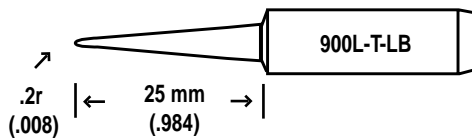
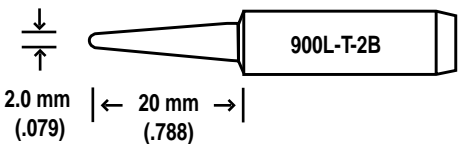
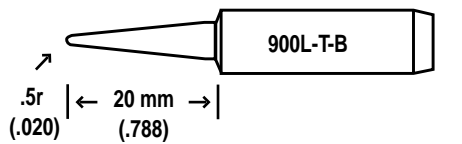
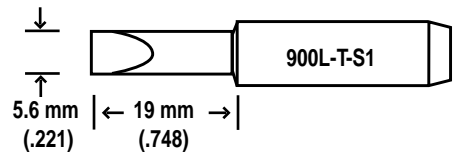
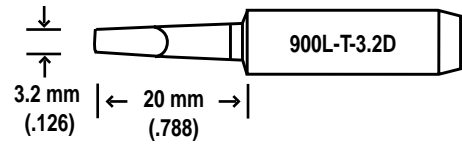
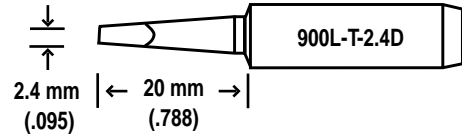
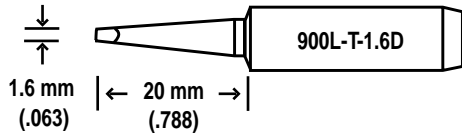


# 900M/907/913 Series

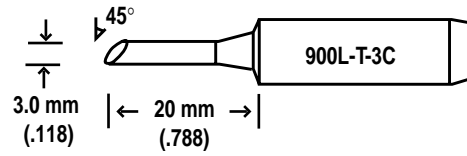




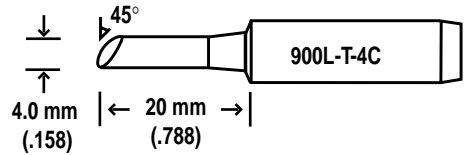
# 900L/908/914 Series



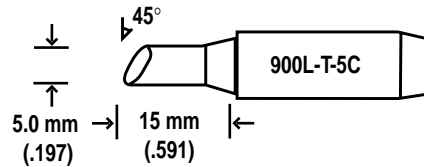
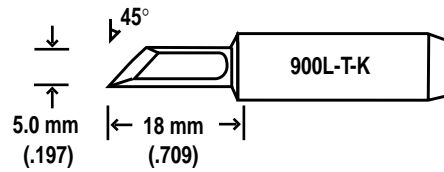
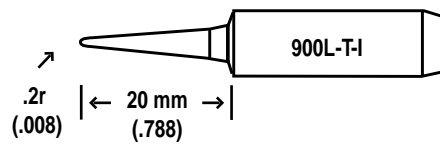
\* 900L-T-2CF



\* 900L-T-3CF

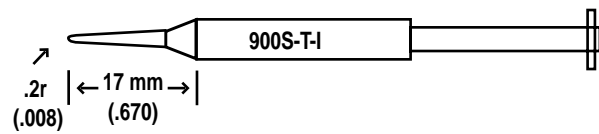
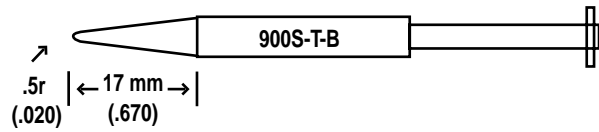
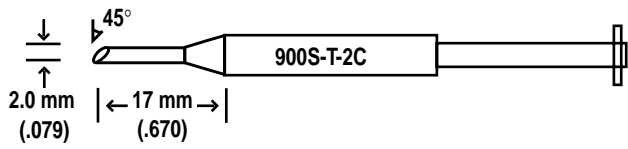
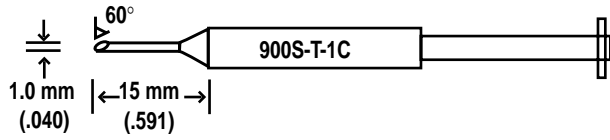
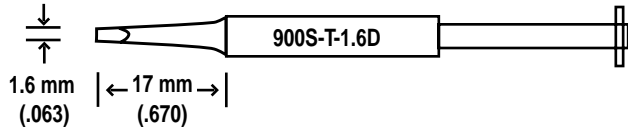
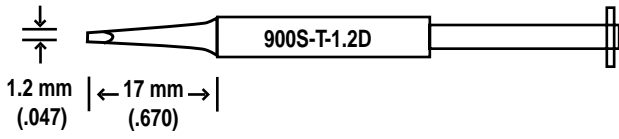


\* 900L-T-4CF



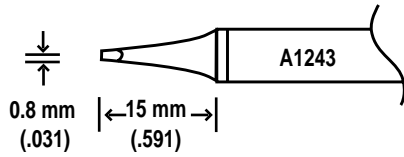
\* 900L-T-5CF



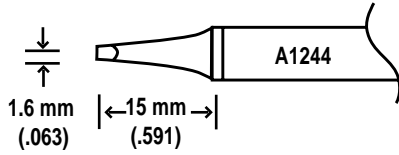


# 903 Series

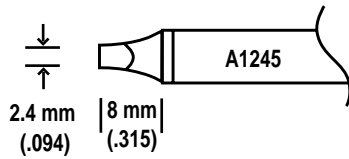
SHAPE: 0.8D



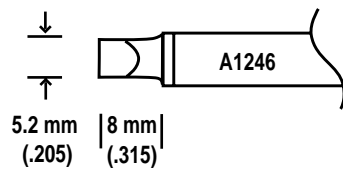
SHAPE: 1.6D



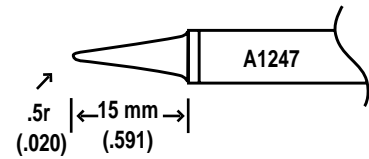
SHAPE: 2.4D



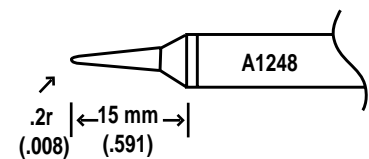
SHAPE: 5.2D



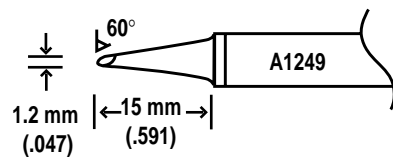
SHAPE: B



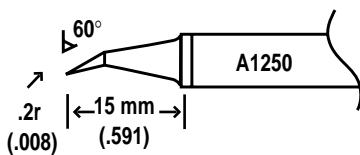
SHAPE: I



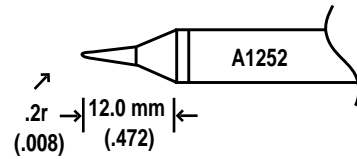
SHAPE: 1.2C



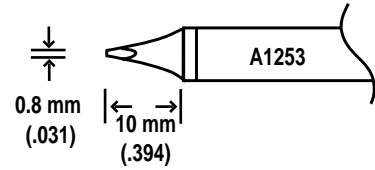
SHAPE: 0.2RB



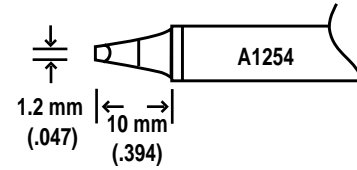
SHAPE: SI



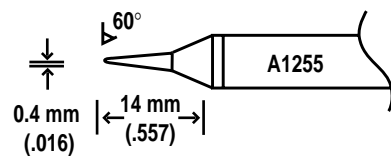
SHAPE: 0.8SD



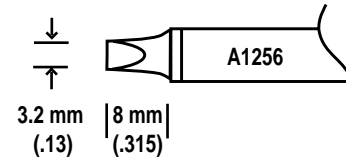
SHAPE: 1.2SD



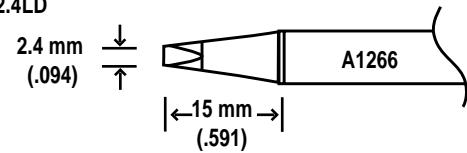
SHAPE: .04SC



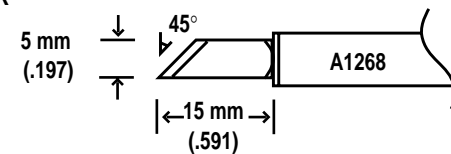
SHAPE: 3.2D



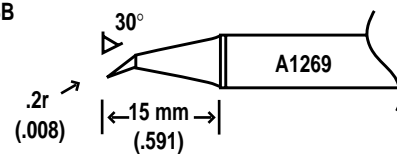
SHAPE: 2.4LD



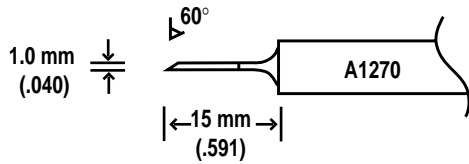
SHAPE: K



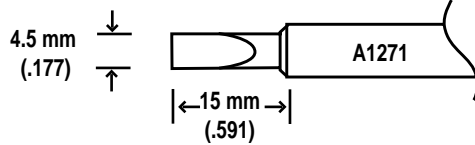
SHAPE: 0.2RSB



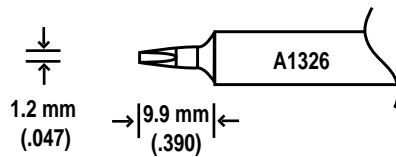
SHAPE: 1C



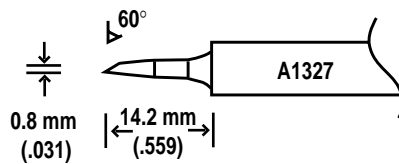
SHAPE: 4.5D



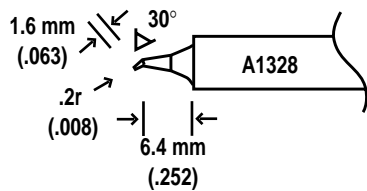
SHAPE: 1.2D



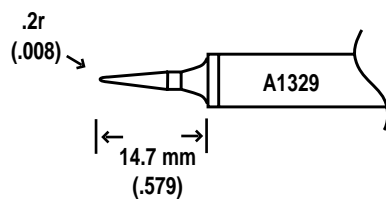
SHAPE: 0.8SC



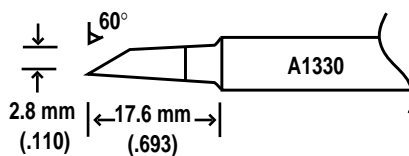
SHAPE: 0.2RSSB



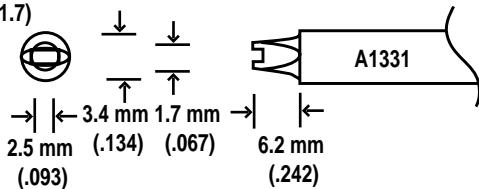
SHAPE: IS



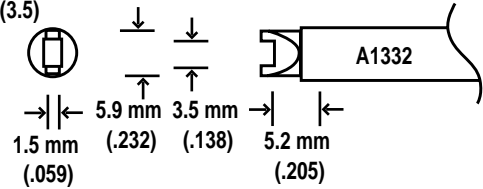
SHAPE: 2.8C



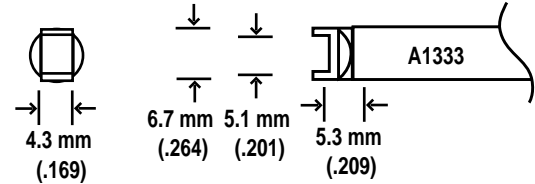
SHAPE: R1 (1.7)



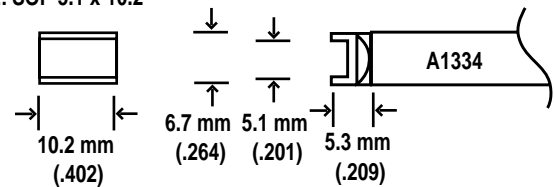
SHAPE: R2 (3.5)



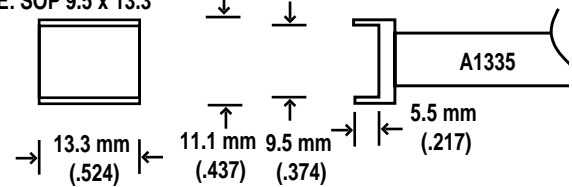
SHAPE: SOP 5.1 X 4.3



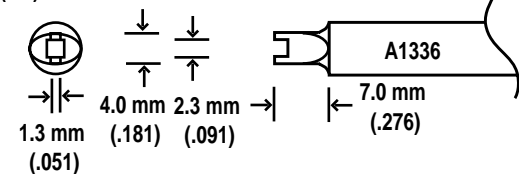
SHAPE: SOP 5.1 x 10.2



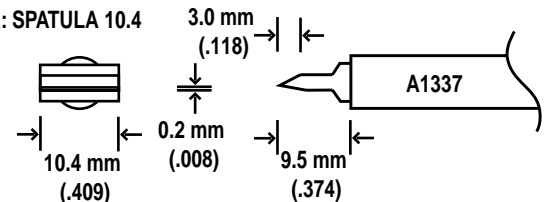
SHAPE: SOP 9.5 x 13.3



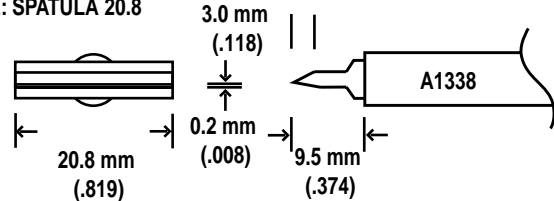
SHAPE: R3 (2.3)



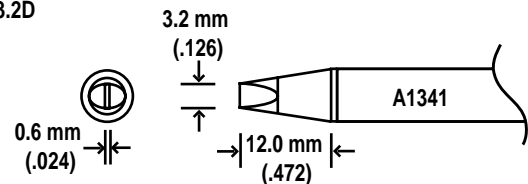
SHAPE: SPATULA 10.4



SHAPE: SPATULA 20.8

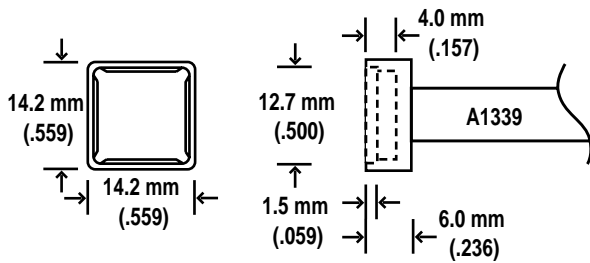


SHAPE: 3.2D

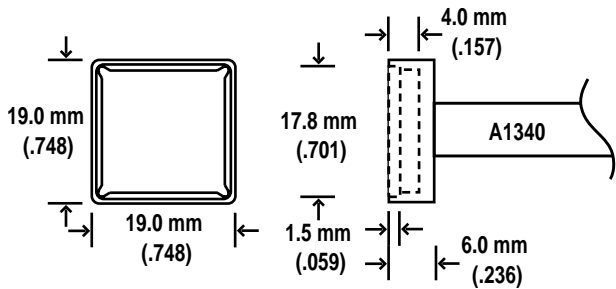


# 903 Series

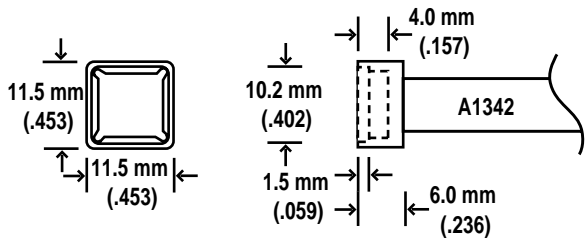
SHAPE: PLCC 12.7 x 12.7



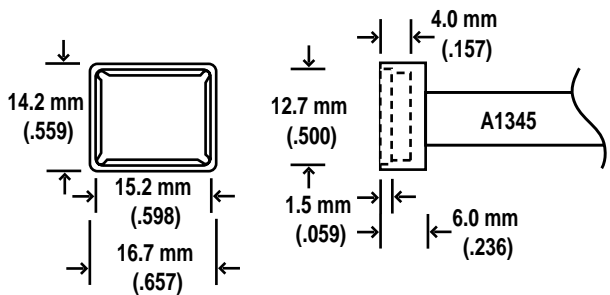
SHAPE: PLCC 17.8 x 17.8



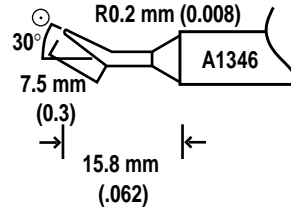
SHAPE: PLCC 10.2 x 10.2



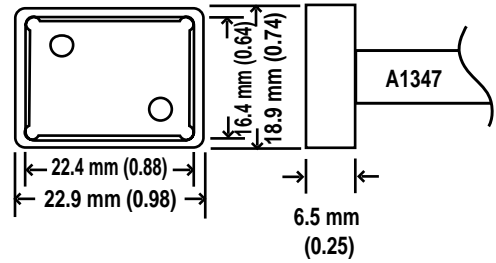
SHAPE: PLCC 15.2 x 12.7



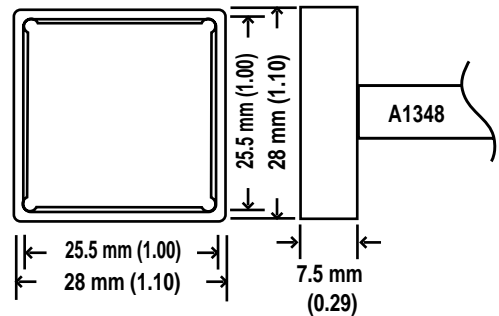
SHAPE: 0.2RLB Bent



SHAPE: PLCC 16.4 x 22.4

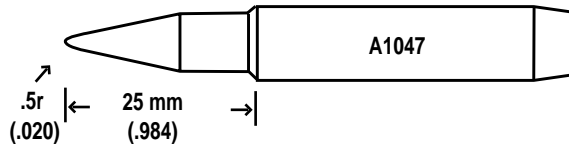


SHAPE: PLCC 25.5 x 25.5

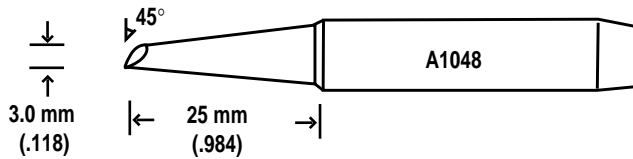


## 455 Series

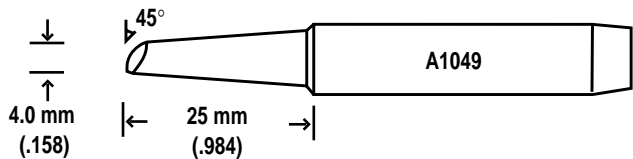
SHAPE: B



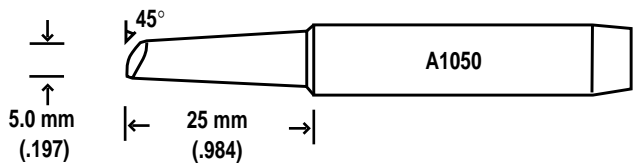
SHAPE: 3C



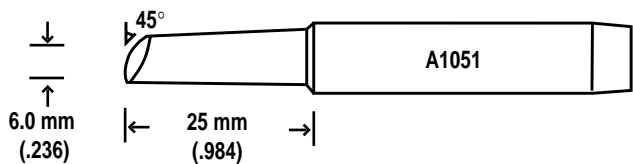
SHAPE: 4C



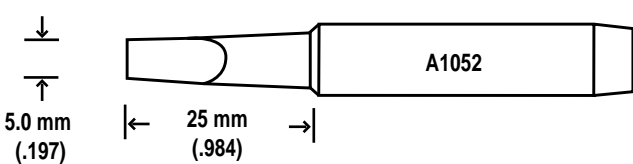
SHAPE: 5C



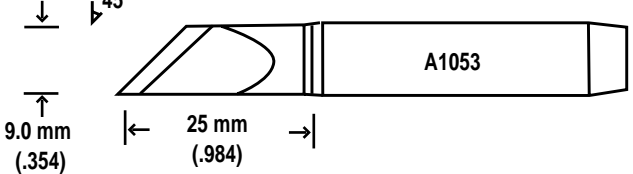
SHAPE: 6C



SHAPE: SD

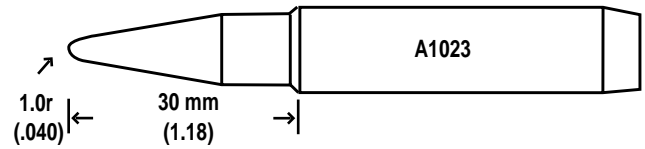


SHAPE: K

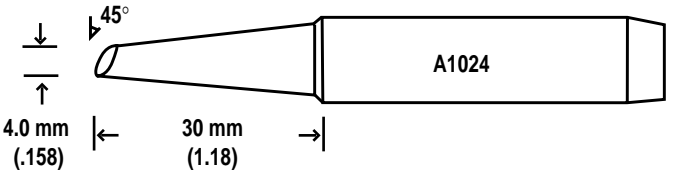


## 456 Series

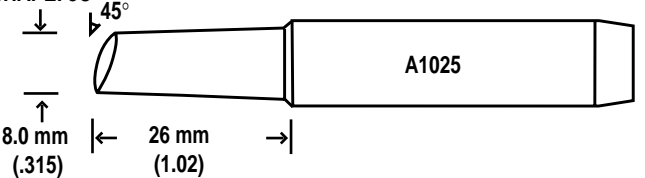
SHAPE: 2B



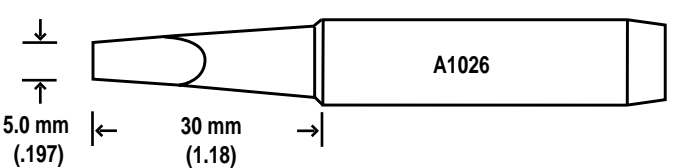
SHAPE: 4C



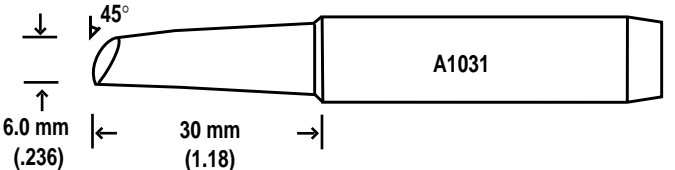
SHAPE: 8C



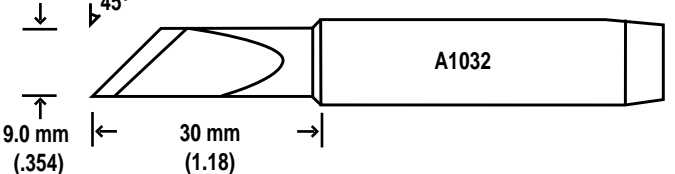
SHAPE: SD



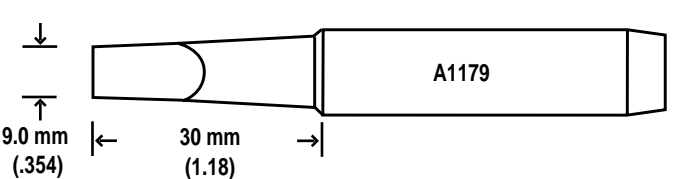
SHAPE: 6C



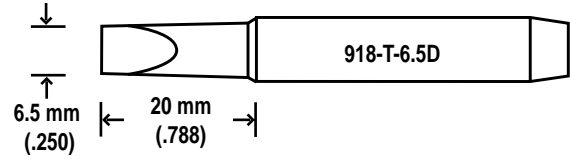
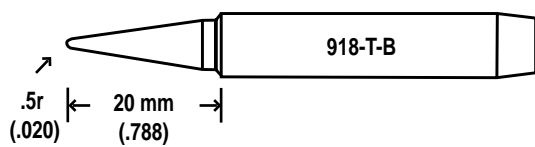
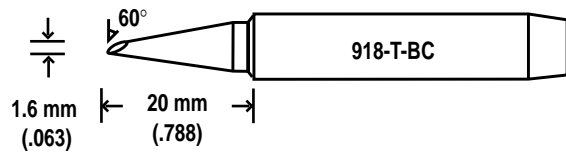
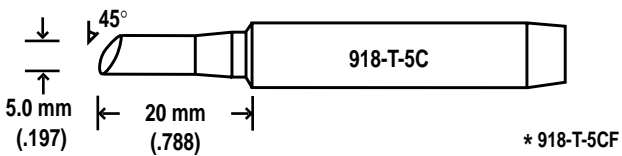
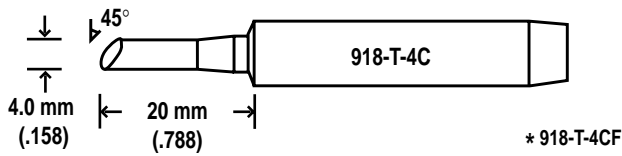
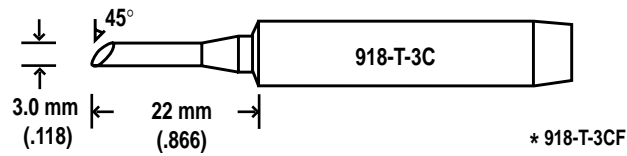
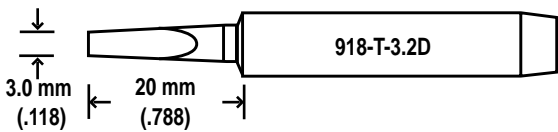
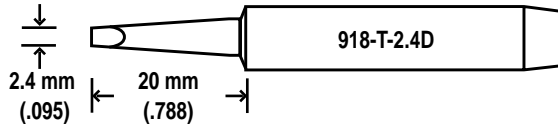
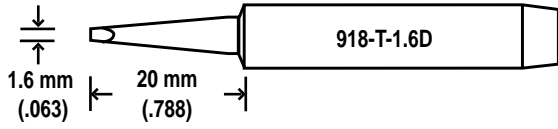
SHAPE: K

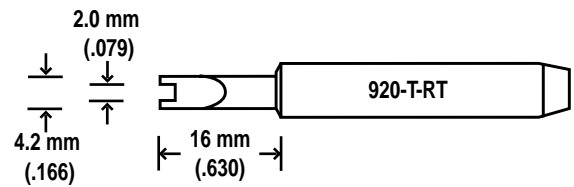
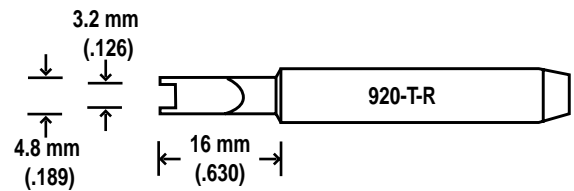
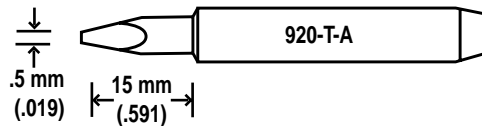
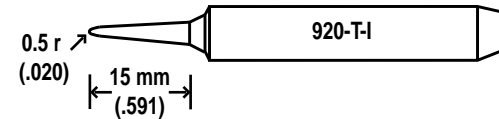
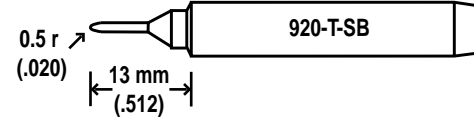
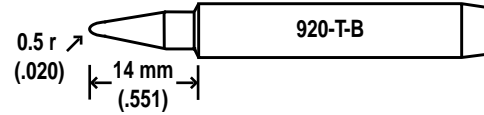
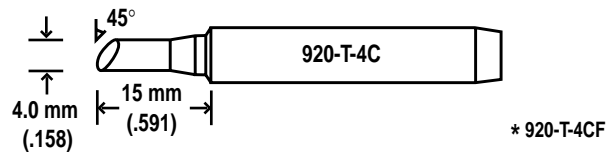
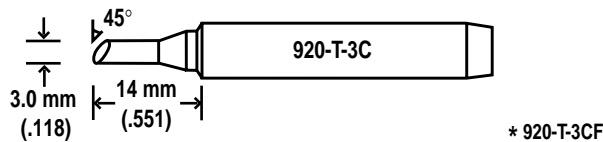
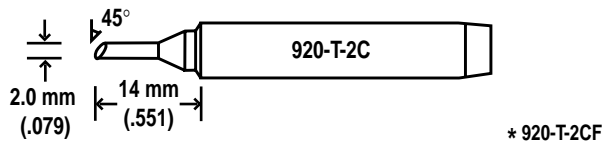
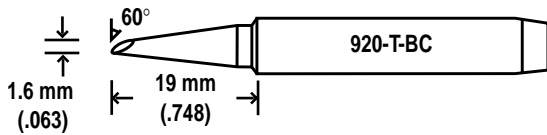
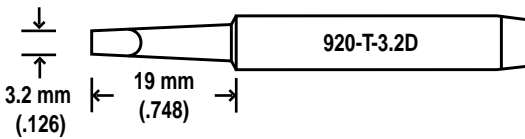
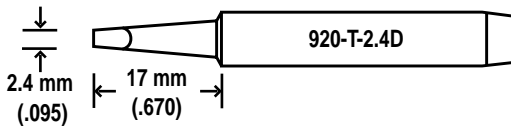
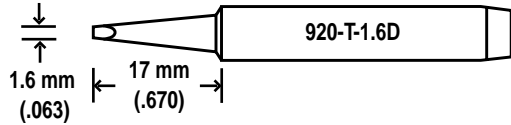
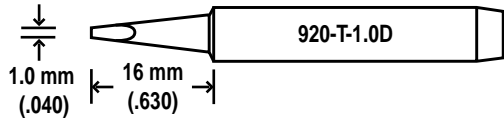


SHAPE: 9D

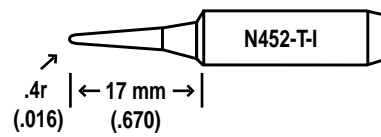
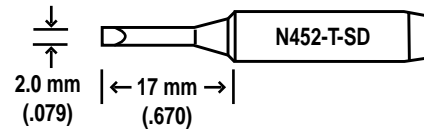
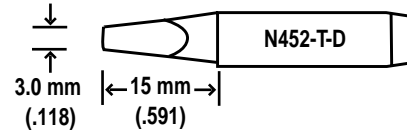
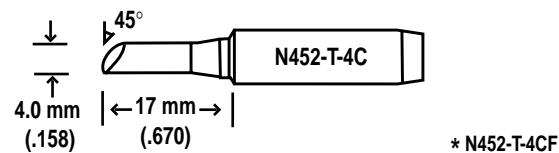
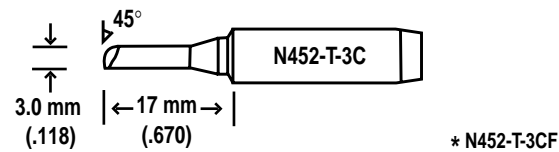
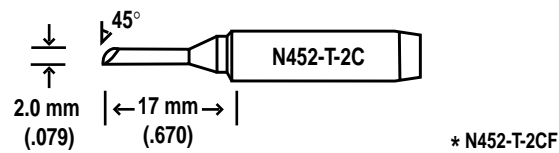
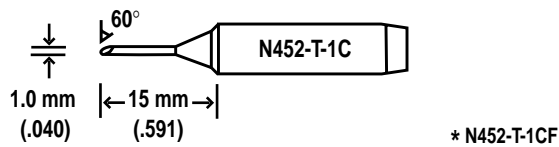
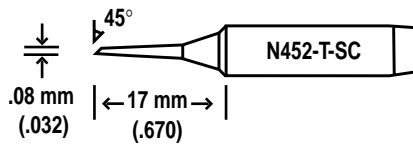
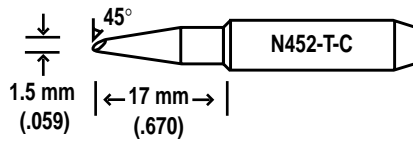
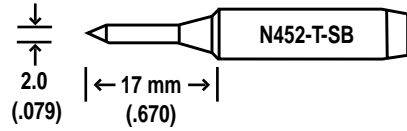
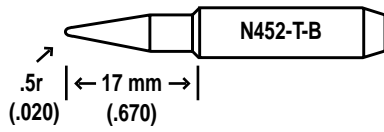


# 918 Series

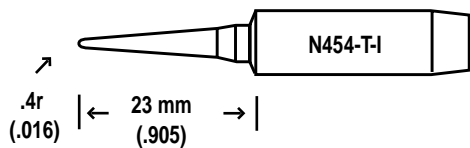
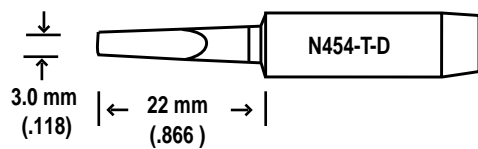
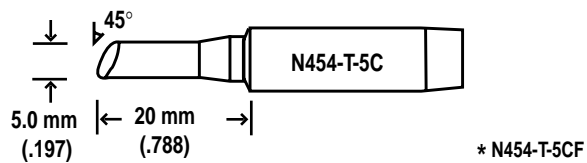
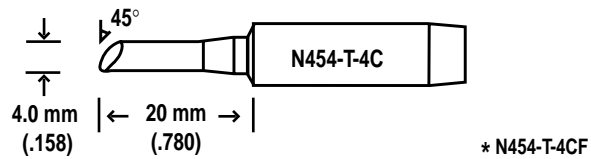
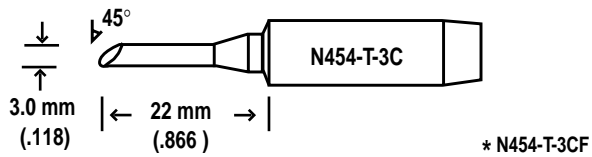
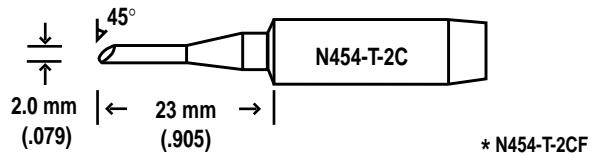
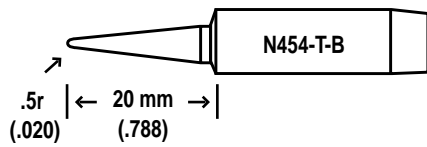




# N452 Series



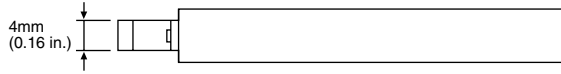




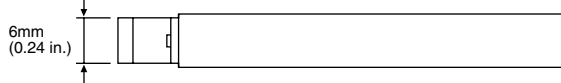
# 950 Series

SOP

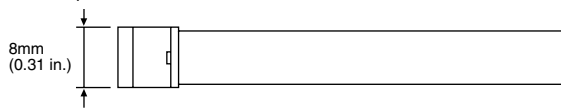
**A1390** Tip/SOP 4L



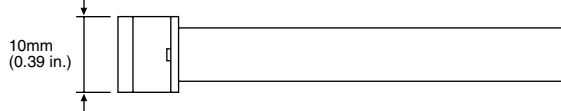
**A1391** Tip/SOP 6L



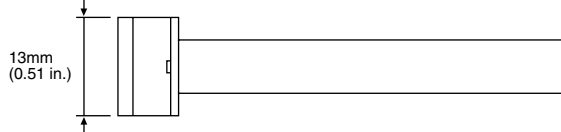
**A1380** Tip/SOP 8L



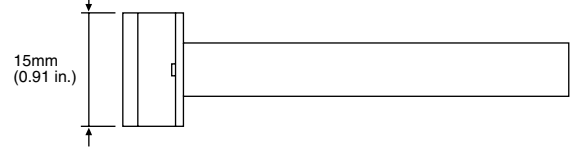
**A1381** Tip/SOP 10L



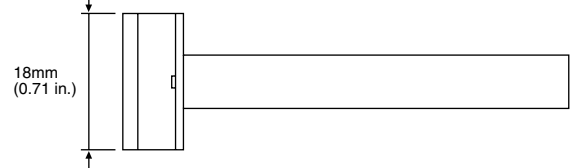
**A1382** Tip/SOP 13L



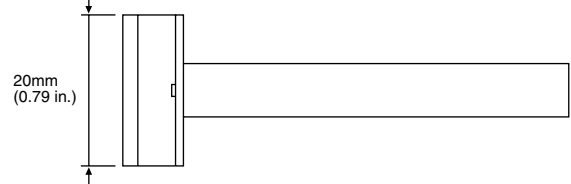
**A1392** Tip/SOP 15L



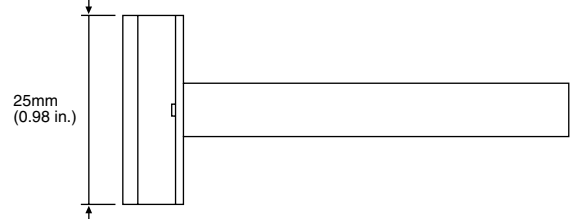
**A1383** Tip/SOP 18L

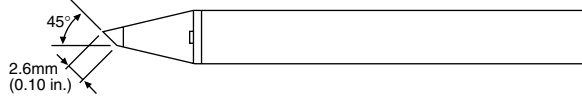


**A1384** Tip/SOP 20L

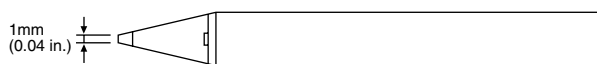


**A1385** Tip/SOP 25L

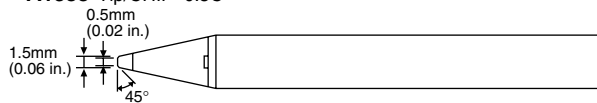
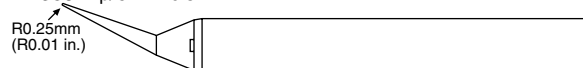


**888-079** Tip/CHIP 2.6C**888-080** Tip/CHIP 0.7T

CHIP

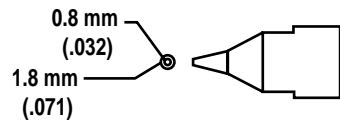
**A1379** Tip/CHIP 1L**A1378** Tip/CHIP 2L

CHIP

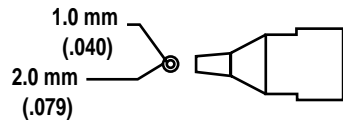
**A1388** Tip/CHIP 0.5C**A1389** Tip/CHIP 0.5I

# 802/807/808 Series

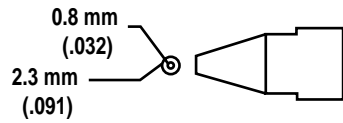
A1002



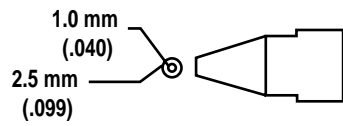
A1003



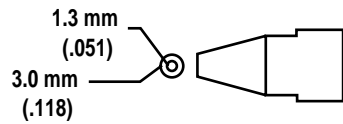
A1004



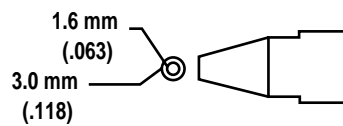
A1005



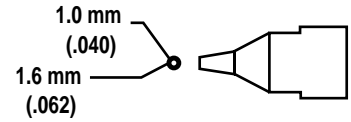
A1006



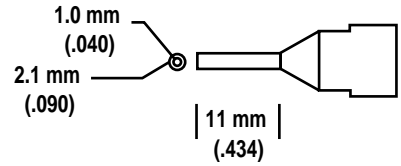
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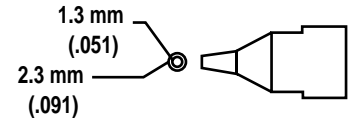
A1393



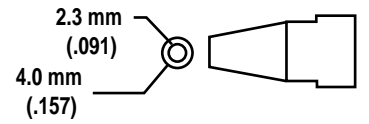
A1394



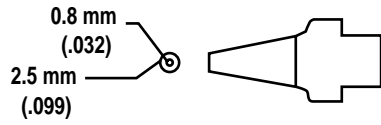
A1395



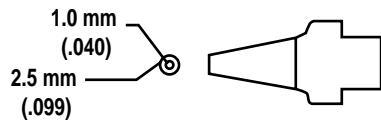
A1396



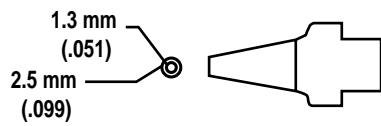
481-T-0.8



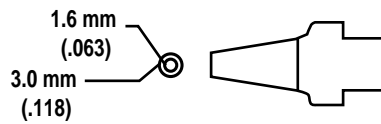
481-T-1.0



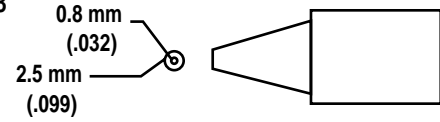
481-T-1.3



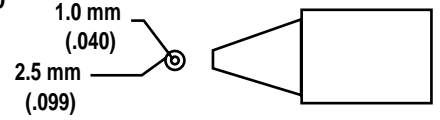
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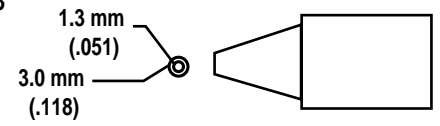
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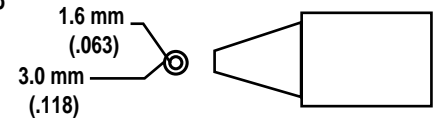
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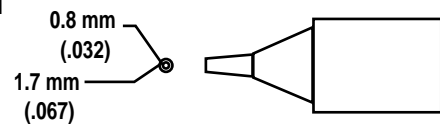
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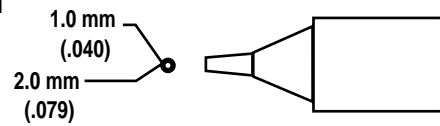
483-T-1.6



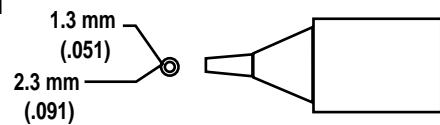
483-T-0.8T



483-T-1.0T



483-T-1.3T


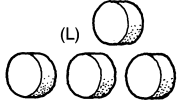

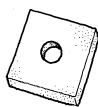
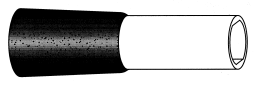
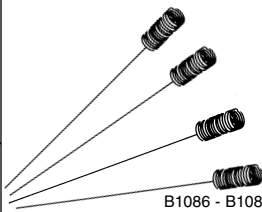

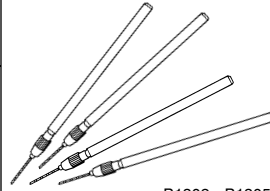






# For long lasting use of your desoldering tools, Keep Hakko's "Desoldering Maintenance Kit" by your side!



## Desoldering Maintenance Kit

P/N HJ2002-01

|  |  |   |  |
|--|--|---|--|
| <br>777-090 | <b>Part No. 777-090<br/>Maintenance Brush</b><br>Cleans oxides and flux residue from heater core. Do not use on nozzles as brush will damage the plating.                              | <br>A1033         | <b>Part No. A1033<br/>Ceramic Paper Filter (L) (Set of 10)</b><br>Protects the pump by filtering flux vapors at the handpiece. Replace when face of filter is coated with flux.  |
| <br>888-001 | <b>Part No. 888-001<br/>Drill for Heating Element</b><br>Cleans solder and flux from the heating element core. Use once a day.   | <br>A1042          | <b>Part No. A1042<br/>Cleaning Sponge</b><br>Cleans nozzle of excess solder and oxides. Rinse with water only. Replace sponge when contaminated.   |
| <br>888-075 | <b>Part No. 888-075<br/>Wrench</b><br>Removes and replaces enclosure nut, enclosure and nozzle from heating element.   | <br>B1086 - B1089 | <b>Part No. B1087<br/>Nozzle Cleaning Pin (1.0mm)</b><br>B1086: 0.8mm, B1088: 1.3mm, B1089: 1.6mm<br>Used to clean accumulated solder from the nozzle, preventing clogging. Match cleaning pin diameter to nozzle hole diameter. Use approximately every two hours of operation. |
| <br>A1009   | <b>Part No. A1009<br/>Ceramic Paper Filter (S) (Set of 10)</b><br>Protects the pump by filtering flux vapors at the desolder station. Replace when face of filter is coated with flux. | <br>B1302 - B1305 | <b>Part No. B1303<br/>Nozzle Cleaning Drill (1.0mm) with holder<br/>Drill bit only: B1308; 0.8mm, B1310;<br/>1.3mm, B1311; 1.6mm</b><br>Used to remove heavy accumulation of solder from the nozzle. Use if cleaning pin can not clean nozzle.                                   |
| <br>A1011   | <b>Part No. A1011<br/>Filter Holder for 802</b><br>Holds spring filter (A1030) in filter pipe (B1128). For use with 802 handpiece only. Replace if holder becomes stiff or cracked.    | <br>A1030          | <b>Part No. B1915<br/>Filter Holder for 807</b><br>Holds spring filter (A1030) in filter pipe (B1916). For use with 807 handpiece only. Replace if holder becomes stiff or cracked.  |
| <br>A1030   | <b>Part No. A1030<br/>Spring Filter (Set of 10)</b><br>Captures solder in the handpiece. Replace when filter is 1/2 to 1/3 full of solder.   | <br>B1915          | <b>Part No. B1915<br/>Filter Holder for 807</b><br>Holds spring filter (A1030) in filter pipe (B1916). For use with 807 handpiece only. Replace if holder becomes stiff or cracked.  |

## **PROBABLE CAUSES OF EARLY TIP FAILURE**

### **HIGH LINE VOLTAGE.**

- Even though Hakko irons and stations are designed to maintain temperature with slightly varying supply voltages, a consistently high line voltage will cause the iron to run hot. This will reduce tip life.

### **LOW TIN ALLOY SOLDER.**

- The lower the tin content of your solder, the more difficult it will be to keep the tip from ‘dewetting’ (losing its protective coat of solder). Keep a roll of large diameter 63-37 solder on hand to periodically flush and re-tin the tips.

### **SMALL DIAMETER SOLDER.**

- In many cases, the diameter of the solder being used is too small for effective wetting of the tips. A periodic flooding with a larger diameter solder, as mentioned above, will do the trick.

### **DIFFERENCES IN FLUX ACTIONS.**

(RA, RMA, water soluble, ‘No Clean’ etc.)...

- The more active the flux, the more frequently the tip needs to be cleaned. Oxidation forms at a much higher rate with highly active fluxes. Please check with the solder or flux manufacturer as to the relative activity of the flux you are using.

### **EXCESSIVE PRESSURE, OR THE ‘PUSHING IN’ OF HEAT.**

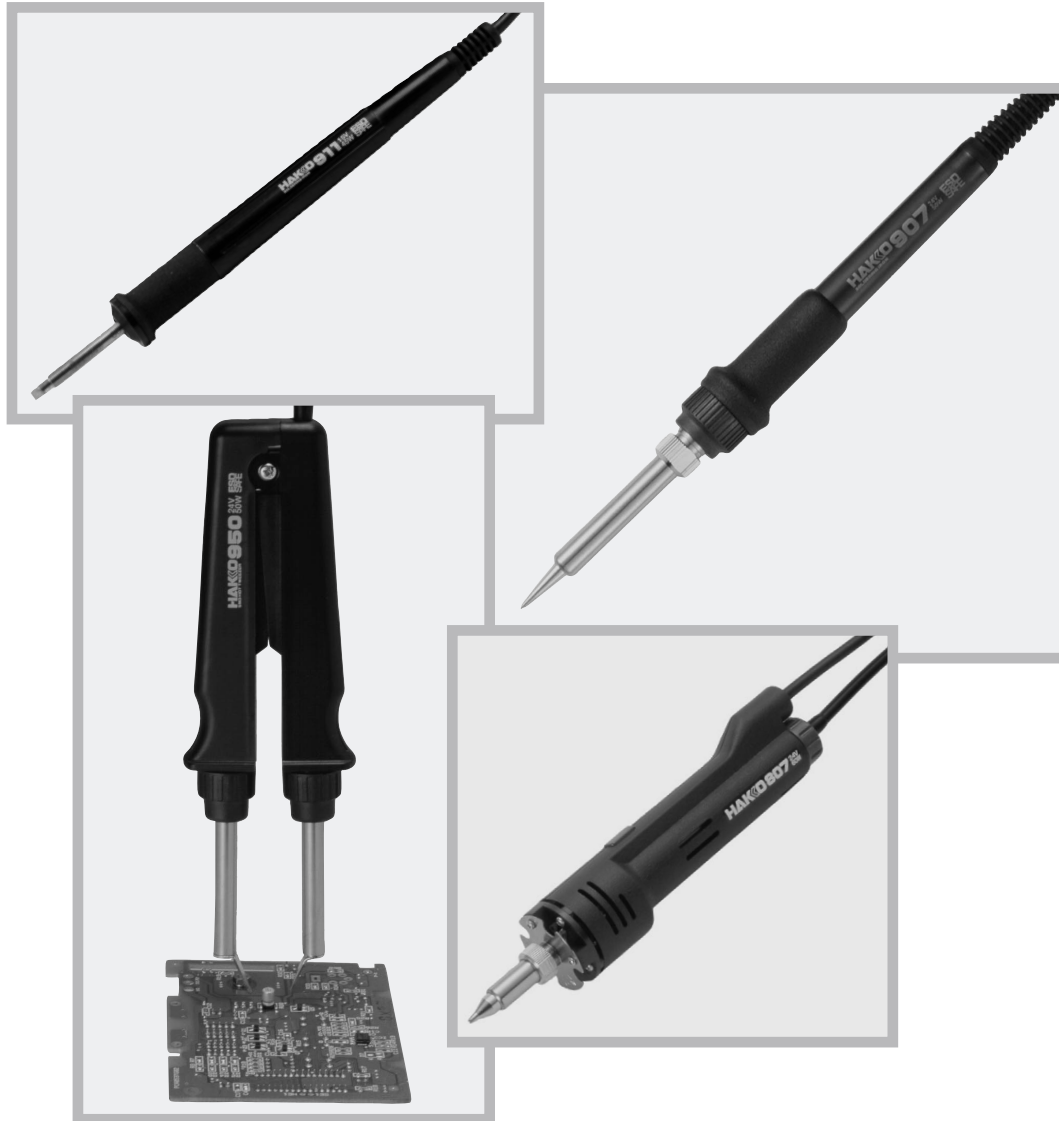
- Applying excessive pressure, or rubbing the tip against the joint to ‘force’ heat in, will destroy the tip faster than normal contact soldering.

### **TIP TEMPERATURE.**

- The higher the tip temperature, the faster oxidation will form. At temperatures exceeding 875 deg. F, the speed of oxidation is just about twice that at 700 deg. F.

### **– NOTE –**

Tips subjected to proper maintenance and cleaning procedures should last between two to four weeks, depending upon the temperature, tip configuration, and the job or jobs being performed.



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