

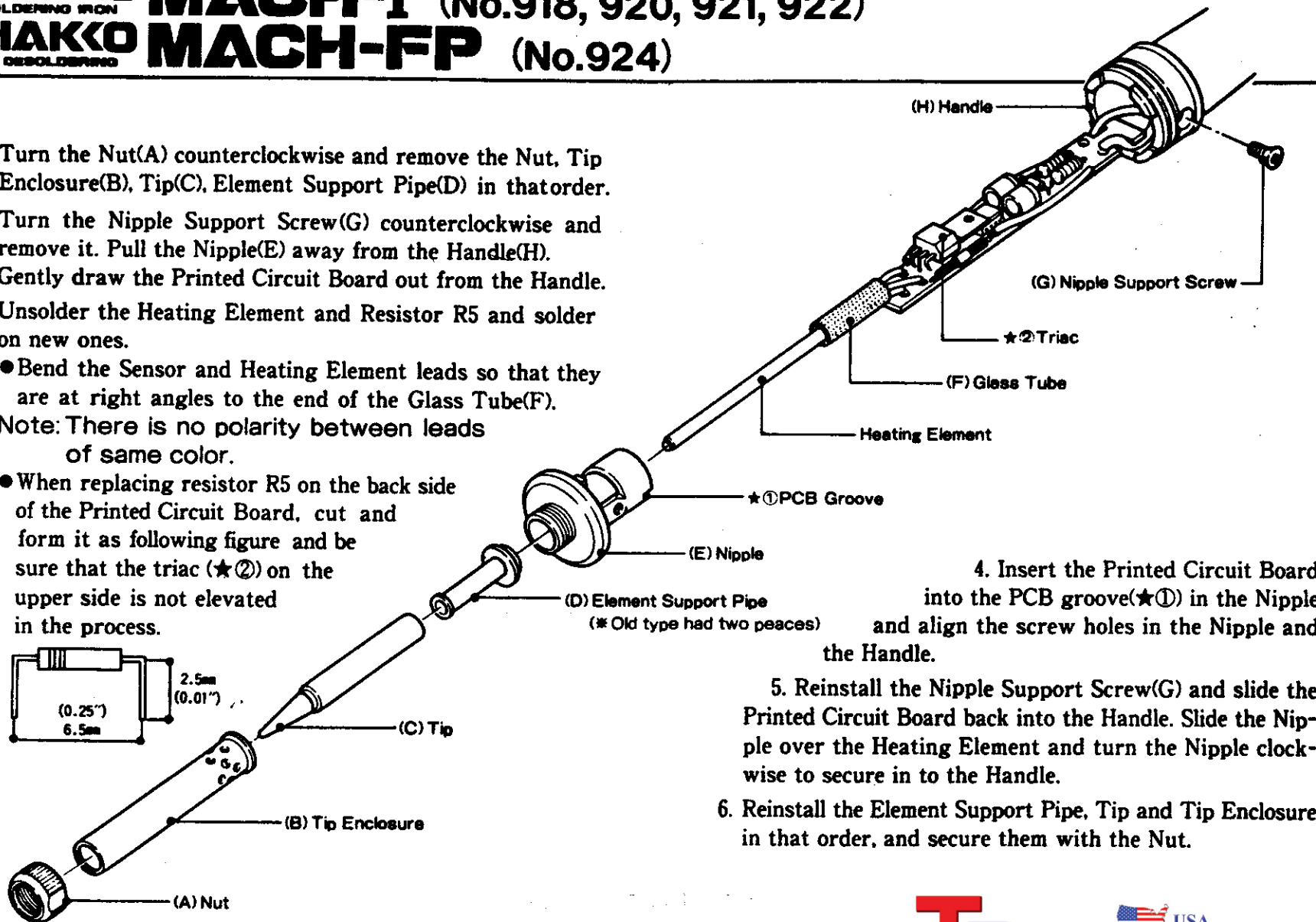
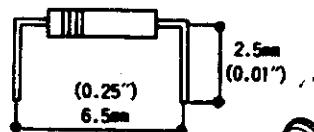
HAKKO MACH-I (No.918, 920, 921, 922)
 SOLDERSM IRON
HAKKO MACH-FP (No.924)
 FP DESOLDERSM

1. Turn the Nut(A) counterclockwise and remove the Nut, Tip Enclosure(B), Tip(C), Element Support Pipe(D) in that order.
2. Turn the Nipple Support Screw(G) counterclockwise and remove it. Pull the Nipple(E) away from the Handle(H). Gently draw the Printed Circuit Board out from the Handle.
3. Unsolder the Heating Element and Resistor R5 and solder on new ones.

- Bend the Sensor and Heating Element leads so that they are at right angles to the end of the Glass Tube(F).

Note: There is no polarity between leads of same color.

- When replacing resistor R5 on the back side of the Printed Circuit Board, cut and form it as following figure and be sure that the triac (★②) on the upper side is not elevated in the process.



4. Insert the Printed Circuit Board into the PCB groove(★①) in the Nipple and align the screw holes in the Nipple and the Handle.

5. Reinstall the Nipple Support Screw(G) and slide the Printed Circuit Board back into the Handle. Slide the Nipple over the Heating Element and turn the Nipple clockwise to secure in to the Handle.

6. Reinstall the Element Support Pipe, Tip and Tip Enclosure in that order, and secure them with the Nut.