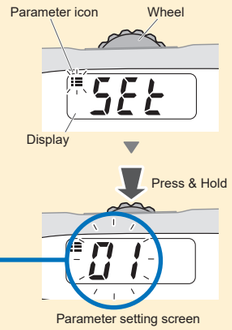
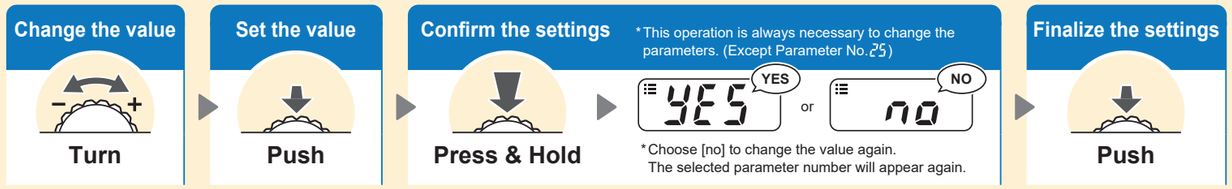
HAKKO FX-600D Parameter Settings / Troubleshooting

Parameter Settings



(1) Push the wheel.
(2) Press and hold the wheel within 1 second once the icon starts to blink.
(3) Enter the parameter setting mode, and then use the wheel to change the parameters.



* Changes will be lost if the power is turned off in the middle of setting. * The setting will time out and return to the normal screen if it is left idle for 10 seconds.

Parameter No.	Parameter name/summary	Setting value	Factory default settings (Value when implementing No. 25)
01	**Display temperature unit** Select from ºC or ºF. ● All set values are converted to the changed display temperature unit.	ºC/ºF	ºC (For USA: ºF)
02	**Sleep: Time setting** Set the time until the product transitions to sleep mode after the handpiece is placed on the iron holder. ● A shorter set time is more effective for preventing tip oxidation. ● This function is only activated if the temperature is set to 300ºC (570ºF) or higher. ● Push the wheel to return to the normal screen if the display shows [SLP].	1 to 29 min	06
03	**Low temp alarm** [H - E] will appear and blink to notify the user when the tip temperature drops by specified degrees during soldering.	30 to 150ºC 54 to 270ºF	150 ºC (ºF: 270)
07	**Sleep: [On]/[OFF] setting** Set whether or not to automatically transition to sleep mode once the time set in "Parameter No. 02" is reached.	On/OFF	OFF
13	**Sleep: Sleep mode temperature setting** Set the tip temperature during sleep configured in "Parameter No.02". ● A lower setting temperature is more effective for preventing tip oxidation. ● Push the wheel to return to the normal screen if the display shows [SLP].	200 to 300ºC 390 to 580ºF	200 ºC (ºF: 400)
25	**Initial reset** Reset the product to factory default settings.	ºC/ºF	ºC (When ºC is selected) ▶ Push ▶ no ºC ▶ Turn ▶ YES ºC ▶ Push ▶ 888 ºC/ºF ▶ 350 ºC (Set temperature) ▶ 350 ºC (Normal screen)
31	**Adjust mode: [On]/[OFF] setting** To correct the tip temperature, turn the adjust mode on. ● When the adjust mode is disabled, [ADJ] will disappear from the screen.	On/OFF	OFF

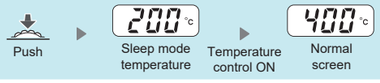
This function is convenient for when you want to work within a specified temperature range.
To solder between 320 and 350ºC at a set temperature of 350ºC, change the set value to [30] in No. 03 before beginning soldering. [H - E] will appear and blink to notify the user when the tip temperature drops below 320ºC during soldering.
The upper limit is restricted by the set temperature.

SLP Pausing the work Sleep mode

When the soldering iron is placed on the stand for a specified period of time (1 to 29 min.), it will automatically enter sleep mode and the tip temperature will drop to the set sleep temperature. This function can help to preserve tip life by reducing oxide buildup on the tip.
* To use this mode, enable "Parameter No. 07".

SLP on the display — Push the wheel to disable the sleep mode.
(Factory default Sleep mode temperature: 200ºC/400ºF
Set time: 6 min)

Disable the sleep mode.



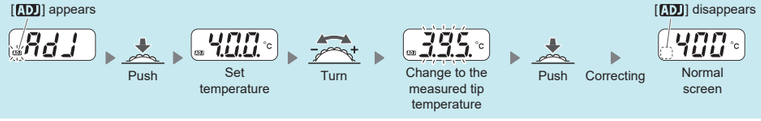
- The product will not transition to sleep mode in the following cases:
  - When the set temperature is below 300ºC (570ºF)
  - When the "Parameter No. 07" setting is disabled
  - When the soldering iron is placed on a flat surface
- To enable the sleep function, set "Parameter No. 07" to [On]. The sleep time (Parameter No. 02) and the sleep temperature (Parameter No. 13) can be changed as needed.

31 ADJ Tip temperature correction Adjust mode

The tip degradation can cause a deviation between "the set temperature" and "the measured tip temperature". This mode can minimize the deviation by entering "the measured tip temperature".
* To use this mode, enable "Parameter No. 31".

Press & Hold — Press and hold the wheel to correct the tip temperature.
(Correctable range: Set temperature ±150ºC/±270ºF)

Correct the tip temperature.
(Example: Set temperature 400ºC/measured temperature 395ºC)



- The setting will time out and return to the normal screen if it is left idle for 5 seconds.
- Correct the tip temperature only after the tip temperature has stabilized.
- Replacing or changing the tip may cause a deviation between the set temperature and the measured temperature. Correct the tip temperature frequently to match the measured tip temperature.

Troubleshooting

⚠ CAUTION
Unplug the power cord before inspecting or replacing any internal components.

The tip is not heating up.	Is the power cord securely plugged in?	Insert the plug into the outlet.
	Is the power cord broken or cut?	Send the main unit back for service.
	Is the heating element properly soldered?	Solder heating element once again. If the problem persists, send the main unit back for service.
[H - E] appears.	Is the heat capacity of the tip too small for the object to be soldered?	Use a tip with a larger heat capacity.
	Is the set value for the low temp alarm too small?	Increase the setting value. (See "Parameter No. 03")
	The heating element is not working.	Replace the heating element. If the problem persists, send the main unit back for service.
[S - E] appears.	The heating element/sensor is not working.	Replace the heating element.
	The P.W.B. is damaged.	Send the main unit back for service.
[- - -] appears.	The main unit is not working.	Send the main unit back for service.
The solder is not wetting on the tip.	Is the tip temperature too high or too low?	Set the appropriate temperature.
	Is the tip deformed or oxidized?	If the tip is deformed, replace it. If the tip is oxidized, remove the oxide. If the problem persists, replace the tip.
The tip temperature is too high/low.	Is the tip temperature corrected?	Measure and correct the value. (See "Tip temperature correction (Adjust mode)")

If you cannot find a solution in this manual, or if another problem occurs, please contact the retailer where you purchased the product.

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