



# FM-204

## DESOLDERING & SOLDERING STATION



The **HAKKO FM-204 Desoldering and Soldering Station** is a self-contained station with a built-in vacuum pump. This single port station has both the functionality for soldering and desoldering with a gun or pencil style desoldering handpiece. Utilizing N3 nozzles for a quick change process makes interchanging nozzles fast and convenient.

DESOLDERING

### FEATURES & BENEFITS

### SPECIFICATIONS For Part No. FM204-01 / FM204-CP

- Built in vacuum pump
- Meets or exceeds J-STD-001 requirements
- Placing the iron into the iron holder activates the sleep mode
- Can be used for soldering with the FM-2027 soldering iron (not included)
- Handpiece converts to either gun or pencil style

STATION	
Nozzle &/or Tips Series	N3 Nozzles <a href="#">see page 62</a> &/or T15 Tips <a href="#">see page 80</a> (Nozzles & Tips Sold Separately)
Power Consumption	120W
Temperature Range	400 °F - 840 °F / 200 °C - 450 °C *
Temperature Stability	±9 °F / ±5 °C at idle temperature
Station Output	24V
Vacuum Generator	Vacuum pump, double cylinder
Vacuum Pressure (Max.)	80 kPa (24 in. Hg / 600 mm Hg)
Suction Flow	15 L/min
Dimensions (W x H x D)	6.3 x 4.7 x 8.9 in. / 160 x 120 x 225 mm
Included Handpiece	FM-2024 (Part No. FM2024-02) <a href="#">see page 62</a>

### FM-204 DESOLDERING SET

P/N: FM204-01



**DESOLDERING HANDPIECE**  
P/N: FM2024-02

**FM-204 DESOLDERING STATION**

**IRON HOLDER w/ Brass Wire**  
P/N: FH200-05

### FM-204 DESOLDERING SET w/ SOLDERING IRON

P/N: FM204-CP



**IRON HOLDER w/ Brass Wire**  
P/N: FH200-05

**DESOLDERING HANDPIECE**  
P/N: FM2024-02

**FM-204 DESOLDERING STATION**

**FM-2027 CONVERSION KIT**  
P/N: FM2027-03

### CONTENTS For Part No. FM204-01 / FM204-CP

	Part No.	Description
FM204-01	--	FM-204 desoldering station
	<b>FM2024-02</b>	Desoldering handpiece
	<b>FH200-05</b>	Iron holder with 599B tip cleaner
	<b>B2873</b>	Cleaning drill
	<b>A1612</b>	Filter pipe assembly (1 piece)
	<b>A1613</b>	Ceramic paper filter (10 pcs)
	<b>B2972</b>	Control card
	<b>B2756</b>	Tip tray
	<b>B2872</b>	Handle (for gun configuration)
	<b>B3253</b>	Connecting cable
	<b>B2419</b>	Power cord
	<b>B2300</b>	Heat resistant pad
	<b>B2876</b>	Nozzle remover
--	--	Instruction manual
<b>FM204-CP</b> With Added Soldering Iron	<b>FM2027-03</b>	FM-2027 Soldering iron

\*Temperature range varies depending on handpiece model connected.  
 P/N: FM204-01 ships with one (1) FM-2024 desoldering handpiece.  
 P/N: FM204-CP ships with one (1) FM-2024 desoldering handpiece and one (1) FM-2027 soldering handpiece.  
 U.S. Patent Registered



# FM-205

## "SHOP AIR" DESOLDERING & SOLDERING STATION



The **HAKKO FM-205** is a "Shop-Air" Desoldering and Soldering Station. The shop-air feature provides for higher vacuum pressure and increased suction flow compared to the FM-204. The station also functions as a soldering station with a separately purchased FM-207 Conversion Kit.



### FEATURES & BENEFITS

- Requires shop air
- Digital temperature control
- Uses composite nozzles for improved thermal performance
- Uses low cost disposable filter cartridges
- Desoldering Handpiece converts to either gun or pencil style
- Functions as a soldering station with the FM-207 soldering iron conversion kit (not included)
- Includes low temperature alarm, sleep mode functionality and auto power off



### SPECIFICATIONS For Part No. FM205-01

STATION	
<b>Nozzle &amp; Tips Series</b>	N3 Nozzles <a href="#">see page 62</a> & T15 Tips <a href="#">see page 80</a> (Nozzles & Tips Sold Separately)
<b>Power Consumption</b>	80 W
<b>Temperature Range</b>	400 °F - 840 °F / 200 °C - 450 °C*
<b>Temperature Stability</b>	±9 °F / ±5 °C at idle temperature
<b>Vacuum Generator</b>	Ejector type
<b>Vacuum Pressure (max.)</b>	93 kPa 28 in. Hg / 700 mm Hg
<b>Suction Flow</b>	20 L/min
<b>Input Air Pressure (in use)</b>	490 kPa (71 psi) when in use (trigger or button is pressed)
<b>Comp. Air Consumption</b>	46 L/min
<b>Dimensions (W x H x D)</b>	6.3 x 4.7 x 8.9 in. / 160 x 120 x 225 mm

DESOLDERING

### FM-205 DESOLDERING SET

### FM-205 DESOLDERING STATION



### CONTENTS For Part No. FM205-01 (Complete Set w/ Desoldering Station, Handpiece & Iron Holder)

Part No.	Description
--	FM-205 desoldering station
FM2024-02	Desoldering handpiece
FH200-05	Iron holder with 599B tip cleaner
B2873	Cleaning drill
B2876	Nozzle remover
A1612	Filter pipe assembly (1 piece)
A1613	Ceramic paper filters (10 pcs)
B2972	Control card
B3253	Connecting cable
B2756	Tip tray
B2419	Power cord
B2300	Heat resistant pad
--	Instruction manual

\*Temperature range varies depending on handpiece model connected.  
P/N: FM205-01 ships with one (1) FM2024-02 desoldering tool.

U.S. Patent Registered

**NOTE:** This station requires shop air

### REQUIRED AIR CONNECTION KIT\* P/N: 999-216-01

Air pressure regulator package with filter  
\* Sold Separately.



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# FM-2024

## DESOLDERING TOOL HANDPIECE



For more information  
Scan QR Code.

The **HAKKO FM-2024 Desoldering Tool Handpiece** uses the N3 Series nozzles.  
Desoldering handpiece for use with FM-203 / FM-204 / FM-205 / FM-206 stations.



### FEATURES & BENEFITS

- Convertible Gun or Pencil Style Handpiece
- Disposable Solder Collection Filter
- Anti-Clogging Design



### SPECIFICATIONS For Part No. FM2024-02

<b>Nozzle Series</b>	N3 (Nozzles Sold Separately) <a href="#">see below</a>
<b>Station Compatibility</b>	FM-203, FM-204 <a href="#">see page 60</a> , FM-205 <a href="#">see page 61</a> & FM-206 <a href="#">see page 64</a>
<b>Power Consumption</b>	70W
<b>Temperature Range</b>	660 °F - 840 °F / 350 °C - 450 °C
<b>Tip-to-Ground Resistance</b>	< 2 Ω
<b>Tip-to-Ground Potential</b>	< 2 mV



### FILTERS AND REPLACEMENT PARTS

Part No.	Description
<b>A1612</b>	FM-2024 Filter pipe (set of 10)
<b>A1613</b>	Ceramic paper filter (set of 10) (For use with FM-203 / FM-204 / FM-205 / FM-206 stations / C1492 Desoldering Control Box)
<b>999-216</b>	Air hose kit (for use with FM-205 station <a href="#">see page 61</a> or with C1492 Desoldering Control Box)
<b>999-216-01</b>	Air hose kit with regulator

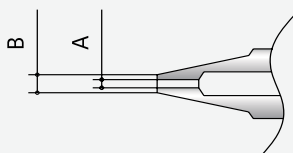
DESOLDERING

## N3 SERIES NOZZLES

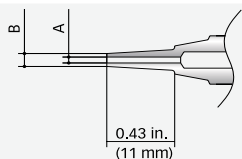


### N3 SERIES NOZZLES FOR USE WITH FM-2024

#### Type 1



#### Type 2



For more information on the  
N3 Nozzle Series [Scan QR Code.](#)



### REPLACEMENT NOZZLES

#### Nozzle Type 1

Part No.	Description	A	B
<b>N3-06</b>	Nozzle, 0.6 mm / 0.02 in.	0.6 mm / 0.02 in.	1.9 mm / 0.07 in.
<b>N3-08</b>	Nozzle, 0.8 mm / 0.03 in.	0.8 mm / 0.03 in.	2.0 mm / 0.08 in.
<b>N3-10</b>	Nozzle, 1.0 mm / 0.04 in.	1.0 mm / 0.04 in.	2.3 mm / 0.09 in.
<b>N3-13</b>	Nozzle, 1.3 mm / 0.05 in.	1.3 mm / 0.05 in.	2.6 mm / 0.10 in.
<b>N3-16</b>	Nozzle, 1.6 mm / 0.06 in.	1.6 mm / 0.06 in.	3.0 mm / 0.12 in.
<b>N3-20</b>	Nozzle, 2.0 mm / 0.08 in.	2.0 mm / 0.08 in.	3.4 mm / 0.13 in.
<b>N3-23</b>	Nozzle, 2.3 mm / 0.09 in.	2.3 mm / 0.09 in.	3.8 mm / 0.15 in.

#### Nozzle Type 2

Part No.	Description	A	B
<b>N3-L10</b>	Long Nozzle 1.0 mm / 0.04 in.	1.0 mm / 0.04 in.	2.3 mm / 0.09 in.