

HAND-SOLDERING PROCEDURES

- 1) Clean the metal surfaces of areas to be joined – surfaces should be free of dirt & oils
- 2) Brush / apply liquid or paste flux onto areas to be assembled – only apply where you want the solder to flow.
- 3) Clamp, fixture or hold parts to be joined together
- 4) Hold hot soldering iron as close to location of area where solder joint is desired making good contact with the tip on one of the pieces being joined. The hot iron tip should be making contact on part of the wet flux that was pre-applied.
- 5) As soon as the flux is bubbling hot - touch the solder wire to the joint area, feeding the solder wire into the joint as it melts and flows into the joint.
- 6) Do not move or disturb the solder joint while it is cooling.