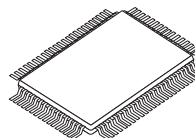


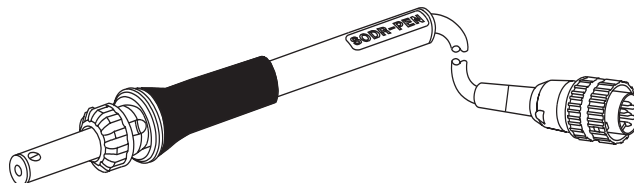
QFP Installation

Mini-Wave



MINI-WAVE TIP

**Sodr-Pen
Handpiece**



EQUIPMENT REQUIRED

PACE SensaTemp[®] Power Supply
 SP-2A Sodr-Pen[®]
 SP-2A Tip & Tool Stand
 Mini-Wave[®] Tip
 Tip Tool
 HP-65 HandiPik[®]

PAGE PART NUMBER

 6025-0014-P1
 6019-0043
 See chart on back
 1100-0296-P1
 7028-0001-P1

OPTIONAL EQUIPMENT

Tweezers

Locally obtained

MATERIALS (approved by your organization)

Flux-cored Solder

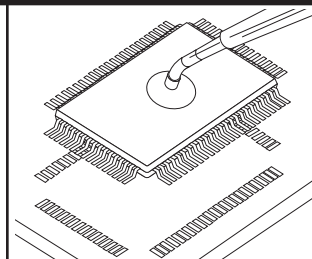
Locally obtained

Flux

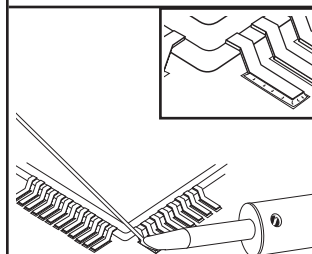
Locally obtained

Cleaner

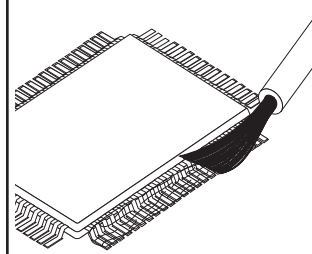
Locally obtained



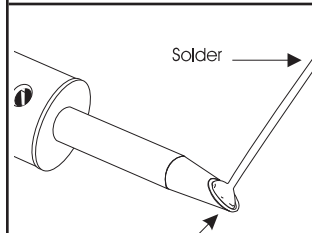
① **Position Component**



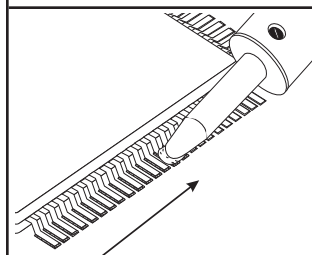
② **Tack Lead**



③ **Flux Leads**




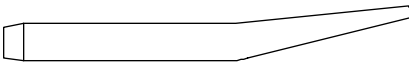
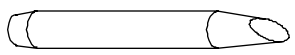

④ **Fill Tip**



⑤ **Solder Component**

PROCEDURE

1. Start with a tip temperature of 315°C (600°F) and adjust as necessary.
2. Install selected Mini-Wave Tip into the Sodr-Pen using Tip Tool.
3. Position the component ensuring proper lead-to-land alignment. Hold the component in place using the HandiPik or tweezers. ①
4. Apply flux and tack solder opposing corner leads. ②
5. Apply flux to ALL lead/land areas. ③
6. Clean tip on Tip & Tool Stand Sponge.
7. Apply solder to the cupped portion of tip to create a convex bead of molten solder. ④
8. Position Mini-Wave Tip so the solder bead contacts the top portion of leads. Slowly move tip over one row of leads to form proper solder fillets at each joint. ⑤
9. Repeat steps 6 through 8 on remaining sides of component.
10. Re-tin Mini-Wave Tip with solder. Return handpiece to its Tip & Tool Stand.
11. Clean, if required, and inspect.

| SURFACE MOUNT INSTALLATION TIP | DESCRIPTION | TIP SIZE A | PART NUMBER |
|---|---|----------------------|-------------|
|  | Angled Single Sided Chisel Tip (for Fine Pitch) | A = 1.5mm (0.06") | 1121-0563 |
|  | Angled Mini-Wave Tip (for Fine Pitch) | A = 1.8mm (0.07") | 1121-0564 |
|  | Single Sided Chisel Tip | A = 3.3mm (0.13") | 1121-0406 |
|  | Mini-Wave Tip | A = 3.3mm (0.13") | 1121-0490 |