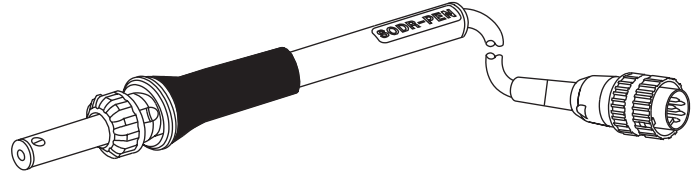


1/16" Chisel Tip

Sodr-Pen
Handpiece



EQUIPMENT REQUIRED

PACE SensaTemp® Power Supply
 SP-2A Sodr-Pen®
 SP-2A Tip & Tool Stand
 1/16" Chisel Tip
 HP-65 HandiPik®
 Tip Tool

PAGE PART NUMBER

 6025-0014-P1
 6019-0043
 1121-0414
 7028-0001-P1
 1100-0206-P1

OPTIONAL EQUIPMENT

Tweezers

Locally obtained

MATERIALS (approved by your organization)

Flux-cored Solder

Locally obtained

Flux

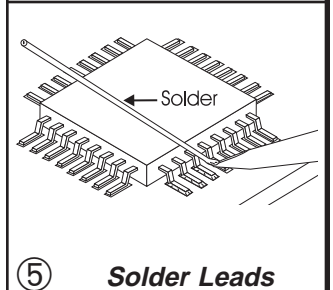
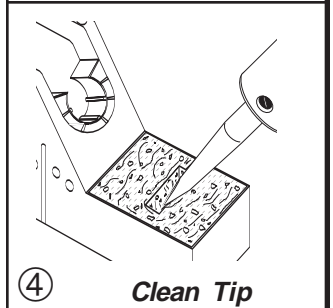
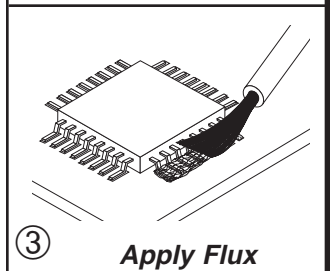
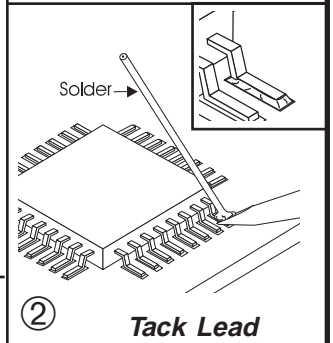
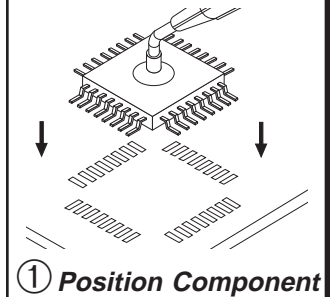
Locally obtained

Cleaner

Locally obtained

PROCEDURE

1. Start with a tip temperature of 315°C (600°F) and adjust as necessary.
2. Install 1/16" Chisel Tip into Sodr-Pen using Tip Tool.
3. Position component ensuring proper lead-to-land alignment. Hold 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 of the row to be soldered. ③
6. Clean tip using Tip & Tool Stand sponge. ④
7. Position Chisel Tip on lead. Apply solder to side of lead/land area to form proper solder fillet. ⑤
8. Repeat step 7 on remaining leads of component. Clean tip as necessary.
9. Re-tin tip with solder. Return handpiece to its Tip & Tool Stand.
10. Clean, if required, and inspect.



I-QFP-01-A