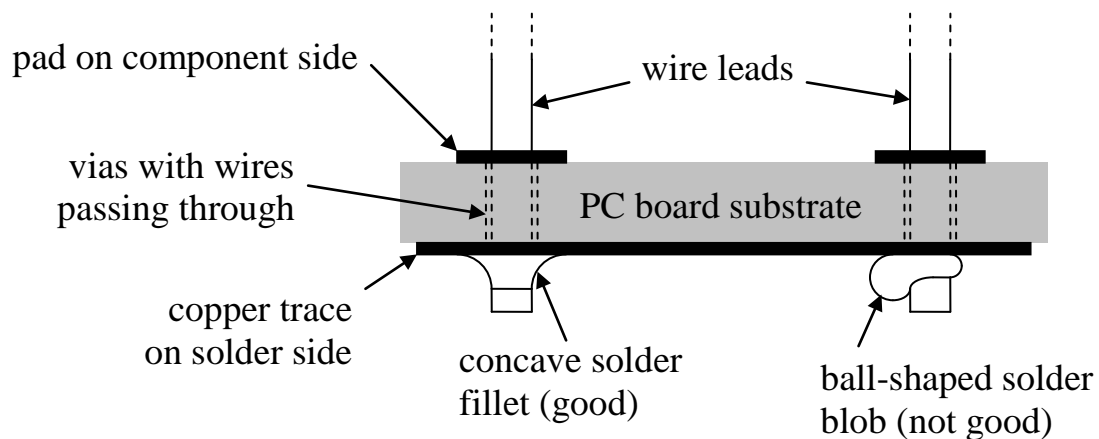


Soldering Basics

- Before starting, wet the soldering station sponge.
- Use a temperature of ~ 750 °F for lead-free solder.
- The solder should be melted by the trace and the part, not by the iron. The finished joint should be a concave “fillet” as shown below, not a ball-shaped “blob.”



- Use as little solder as possible. Avoid solder bridges.
- **CLEAN THE TIP OFTEN!**
- Do not leave the iron set to high temperatures for long periods of time (more than 10 minutes or so).
- Before turning off the iron, clean the tip and coat the tip with fresh solder. A cool, coated tip does not oxidize.