



**WORK INSTRUCTION**

**Typical Soft Solder Operations**

REVISION: 00

PROCEDURE NO.: WI-8.2.4.40

DATE EFFECTIVE: 06/22/11

**Pre-Tinning of stranded lead wire using a crucible of solder or “solder pot” or “solder bath”:**

1. Apply a small amount of flux to the stripped end of the lead wire and then dip it into the “solder pot”.
2. Visually inspect to make sure there is ample solder on the lead end. If not fully coated, repeat previous step.
3. If excess flux is present, remove flux with water, alcohol or other solvent compatible with the process.

**Soldering electrical components**

1. If the components to be joined lack ample solder, additional solder can be added with the aid of a soldering iron and a spool of solder. Depending on the application, additional flux may or may not be needed.
2. When joining components, using a soldering iron, be sure to have a uniform flow of solder across the surfaces to be joined. After removing the heat source and while the solder is still wet, do not move the components until the solder solidifies.
3. If excess flux is present, remove flux with water, alcohol or other solvent compatible with the process.

**REVISION HISTORY**

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	06/22/11	All	Initial release



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**AUTHORIZATION**

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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