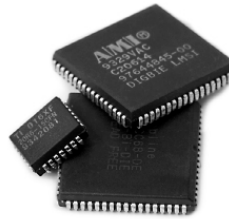


Process Guide I-PLC-05 PLCC Installation Point to Point



Equipment Required

- PACE Intelliheat® Power Supply
- TD-100 Thermo-Drive® Soldering Iron
- Chisel or Conical Tip (See Chart on Back)
- HP-65 HandiPik®
- Tip Tool

Optional Equipment

Tweezers

Materials

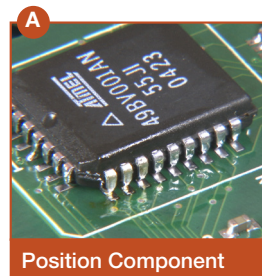
- Flux-cored Solder
- Flux
- Cleaner



TD-100

Procedure

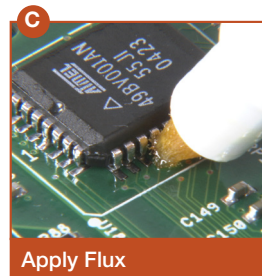
1. Set a tip temperature of 343°C (650°F) for lead-free or 316°C (600°F) for leaded alloys and adjust as necessary.
2. Install chisel or conical tip into the TD-100 using Tip Tool.
3. Position component ensuring proper lead-to-land alignment. Hold component in place using the HandiPik® or tweezers. **A**
4. Apply flux and tack solder opposing corner leads. **B**
5. Apply flux to ALL lead/land areas of the row to be soldered. **C**
6. Clean tip on Tip & Tool Stand sponge. **D**
7. Position chisel or conical tip at intersection of lead and land. Apply solder to side of lead/land area to form proper solder fillet. **E**
8. Repeat step 7 on remaining leads of component. Clean tip as necessary.
9. Re-tin tip with solder. Return TD-100 to its Tip & Tool Stand.
10. Clean, if required, and inspect.



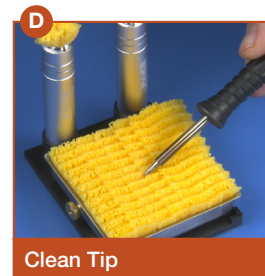
Position Component



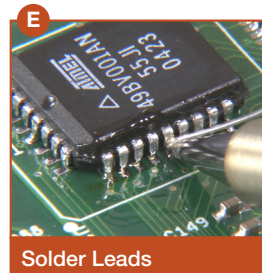
Tack Lead



Apply Flux



Clean Tip



Solder Leads



Process Guide I-PLC-05

TD-100 Tips



Tips	Description	Tip Size - L	Size - D	Part Number
	1/32" Conical Sharp Extended	13.4mm (0.530")	0.80mm (0.031")	1124-0001-P1
	1/64" Conical Sharp	7.8mm (0.310")	0.40mm (0.016")	1124-0002-P1
	1/64" Conical Sharp Bent 30 Degrees	7.8mm (0.310")	0.40mm (0.016")	1124-0003-P1
	1/64" Conical Sharp Extended	13.5mm (0.535")	0.40mm (0.016")	1124-0004-P1
	13/64" Conical Sharp Extended	4.7mm (0.188")	0.80mm (0.031")	1124-0005-P1
	3/128" Conical	4.6mm (0.184")	0.58mm (0.023")	1124-0006-P1
	1/16" 90 Degree Chisel	10.9mm (0.430")	2.03mm (0.080")	1124-0007-P1
	3/64" 30 Degree Chisel	9.7mm (0.380")	1.20mm (0.047")	1124-0008-P1
	3/64" 30 Degree Bevel	3.6mm (0.140")	1.20mm (0.047")	1124-0009-P1
	13/64" Extra Large Chisel	7.62mm (0.300")	5.15mm (0.203")	1124-0010-P1
	1/64" 60 Degree Bevel	14.7mm (0.580")	0.40mm (0.016")	1124-0011-P1
	1/32" 30 Degree Chisel	9.1mm (0.360")	0.80mm (0.031")	1124-0012-P1
	3/32" 30 Degree Chisel	9.9mm (0.390")	2.40mm (0.094")	1124-0013-P1
	5/64" 60 Degree Chisel	4.7mm (0.185")	2.00mm (0.078")	1124-0014-P1
	1/64" Conical, Sharp, Bent 30 Degrees, Extended	15.1mm (0.595")	0.40mm (0.016")	1124-0015-P1
	3/64" Chisel Bent 30 Degrees	11.7mm (0.460")	1.20mm (0.047")	1124-0016-P1
	1/16" 60 Degree Chisel	15.8mm (0.620")	1.60mm (0.063")	1124-0017-P1
	1/32" Conical Sharp Extended	16.7mm (0.660")	0.80mm (0.031")	1124-0018-P1
	1/16" 30 Degree Chisel	9.9mm (0.390")	1.60mm (0.063")	1124-0019-P1
	1/8" 90 Degree Chisel	4.8mm (0.190")	3.20mm (0.125")	1124-0020-P1
	3/128" Conical Sharp Bent 30 Degrees	14.4mm (0.570")	0.58mm (0.023")	1124-0021-P1
	1/16" Conical Sharp	9.9mm (0.390")	1.60mm (0.063")	1124-0022-P1
	1/8" 90 Degree Chisel Extended	8.6mm (0.340")	3.20mm (0.125")	1124-0023-P1
	1/16" 30 Degree Bevel	9.9mm (0.390")	1.60mm (0.063")	1124-0024-P1
	1/16" Conical Sharp Extended	12.1mm (0.478")	1.60mm (0.063")	1124-0025-P1
	1/16" Chisel Bent 30 Degrees	9.7mm (0.385")	1.60mm (0.063")	1124-0026-P1
	3/128" Conical Sharp	15.2mm (0.600")	0.58mm (0.023")	1124-0027-P1
	3/64" Chisel, Bent 30 Degrees, Extended	15.2mm (0.600")	0.91mm (0.36")	1124-0028-P1
	1/32" 30 Degree Bevel	9.1mm (0.360")	1.91mm (0.75")	1124-0029-P1
	1/32" Conical Sharp	9.9mm (0.390")	0.80mm (0.031")	1124-0030-P1
	1/128" Conical	N/A	0.20mm (0.008")	1124-0036-P1
	1/128" Conical, Special HA	N/A	2.40mm (0.09")	1124-0050-P1