



ESICO-TRITON

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CARE AND USE OF ESICO VITACOTE SOLDERING TIPS

VITACOTE tips are furnished, factory tinned and ready for use. The tips will not become oxidized (de-tinned) if certain care is taken:

- 1.) Keep the working surface tinned at all times.
- 2.) Keep excess solder on the tip during prolonged idling periods.
- 3.) Keep the flux residues and plastic wire residues from accumulating on the tip.
- 4.) Keep solder impurities and wire solder containing flux voids from the process.

For re-tinning oxidized tips, the following steps are recommended:

- 1.) When re-tinning using the iron, heat tip hot enough to melt solder, and clean residue on a damp cellulose sponge
- 2.) Flux dip the clean tip and re-tin using a large diameter lead-free solder alloy
- 3.) If a solder pot is available, flux dip and clean tip, the re-tin by immersing in molten solder.

NOTE: Never file or break coating so copper is exposed. This would decrease considerably the life of the tip. To assure maximum life, remove tip from the iron frequently to prevent sticking, and when replacing make sure the tip is fully inserted in the iron at all times

DO'S and DONT'S about soldering tips:

DON'T

File to clean
Wipe tips dry
Wipe without re-tinning
Burn solder off tip
Try to tin oxidized tips
Overheat while cleaning
Overheat while re-tinning
Strike tip on holder, etc.
Forget to remove tip

DO'S

Wipe off with a wet sponge (cellulose)
Leave a thin layer of bright solder on tip
Re-tin immediately
Keep tip well tinned when idling
Clean tip while cool
Cool tip first
Re-tin just above the melt temp lead-free solder alloy
Protect tin coating
Remove at least daily, clean any oxide or foreign matter. Reinsert tip fully.

NOTE: When replacing tip or reinserting tip after cleaning, turn set screw to contact tip shaft, allow iron to heat up, then tighten screw fully.