

HOW TO SOLDER

1. Clean the parts to be joined.
2. Clean soldering iron tip and "tin" all faces of tip with a coating of solder.
3. Heat parts(not solder) to be joined.
4. Apply flux-core solder to heated parts, not the soldering tip, and heat it till solder melts and flows freely.

CAUTION

1. When the soldering iron is plugged in for the first time. There comes out a smoke from the tip end. The smoke stops in a short while and a smoke never comes out again.
2. Use soldering stand and other aids to avoid burning fingers.
3. Don't pull the soldering iron tip outward and use it, it will shorten the heating element life.
4. After finish the works, cool it down naturally.
5. Don't file the tip face.
6. Don't apply too much solder unnecessarily
7. Clean soldering tip.

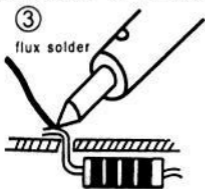
Soldering Work

①



Clean the tip and place the solder on it slightly

③



Place the flux solder as illustrated.

②



Place the tip end on the joint to be soldered. and heat it.

④



A soldering finish must be as above picture.