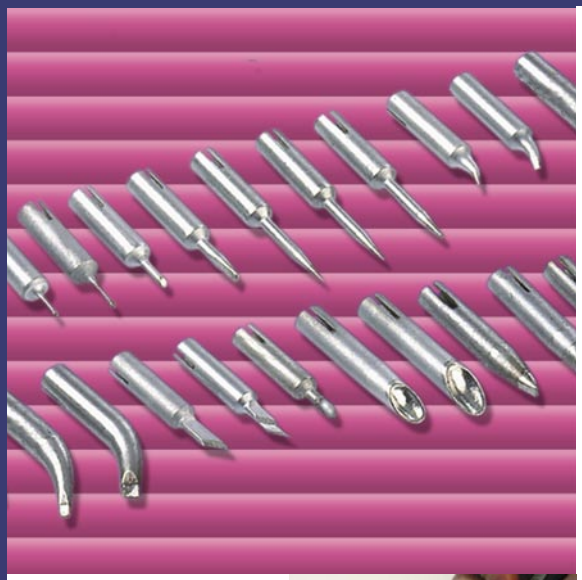
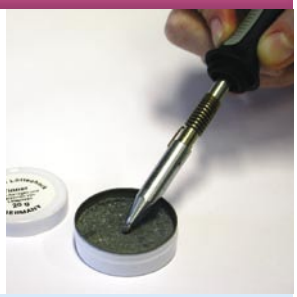
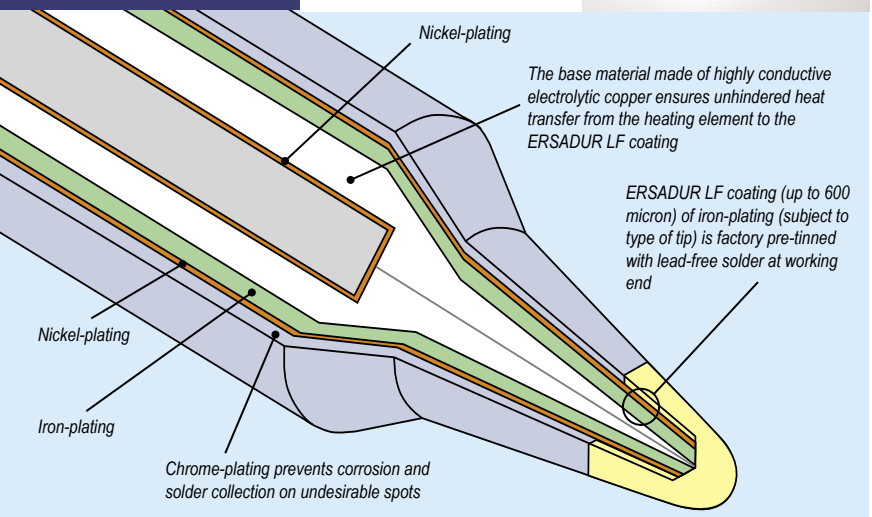
Soldering and Desoldering Tips



The ERSA **Tip-Reactivator** allows the regeneration of oxidized soldering tips. It is environmentally safe, free of lead and halogens and func-tions even at low soldering tip temperatures. For this purpose the heated soldering tip is wiped on the surface of the regeneration compound.





Cross-section of an ERSADUR soldering tip, non-scale representation

Important notice: special care for soldering tips!

Hand soldering operators are happy when their soldering tips last a long time and continue to solder well. Soldering tips that do not allow the solder to melt rapidly due to excess oxidation clearly disrupt productivity! Special care of the soldering tip should be taken in order to solder efficiently.

Important Facts:

1. When a soldering tip remains hot for a long period of time, the tip will oxidize or blacken. An oxidized tip will no longer „wet“ or melt solder properly.
2. The higher the working temperature of the soldering tip, the faster this oxidation will take place and tip lifetime will be shorter.
3. Soldering irons that automatically go into a lower “stand-by” temperature increase tip life.
4. The oxidation of the tip will be very rapid if the tip is left “cooking” without molten solder covering the tip end. It happens, for example, if the tip is not wettned with solder right after cleaning it.
5. Excessive mechanical force during soldering will shorten the tip life.
6. Proper care of the tip will greatly increase tip life.
7. Lead-free soldering requires higher temperatures, is more aggressive to the tip and will always lead to shorter tip life.

Special Care:

1. Always clean the tip by wiping on a slightly wet sponge after each use. Alternatively, tips can be dry cleaned using wire mesh.
2. Always put fresh solder onto the end of the tip BEFORE putting the tip back into the iron holder.
3. Always use lowest working temperature possible.
4. Never leave an iron “cooking” unattended for some time. Always set iron into automatic stand-by if possible or turn-off when not in use.
5. Never use excessive mechanical force when soldering.
6. Soldering tip oxidation can be easily removed if detected early. Early detection and removal will greatly increase tip life.
7. Tip oxidation removal or tip refurbishing is accomplished in 4 consecutive steps: a. clean on damp sponge, b. clean with wire brush, c. using a Tip re-activator chemical, and d. re-tinning using proper flux cored solder wire.

ERSADUR LF soldering tips to process lead-free solders

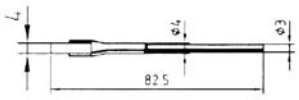
Conventional soldering tips can also be used for lead-free solders. Since lead-free soldering requires higher process temperatures, and due to the fact that lead-free solder is more aggressive to the soldering tip, the tip’s service life is shorter. ERSADUR LF soldering tips have an increased layer of iron, which increases tip life. Consequently they are especially suitable for lead-free soldering.

422 ERSADUR Desoldering Tip Series

For:

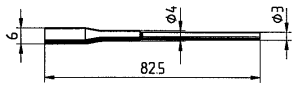
- **DIGITAL 2000 A**
  with Chip tool
- **MICRO-CON 60 iA**
  SMD Desoldering Pincette 40
- **REWORK 80**
- **SMD 8000**
- **SMT UNIT 60 AC / A**
  with Chip tool /
  SMD Desoldering Pincette 40

0422FD10



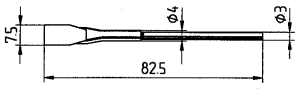
4 mm, for e.g. SO 8 GT/14 GT/16GT

0422ED



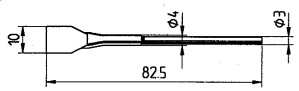
6 mm, for e.g. SOIC 8

0422FD3



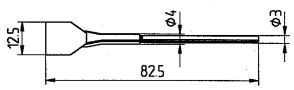
7,5 mm, for e.g. SOIC 12 / SOT 23

0422FD1



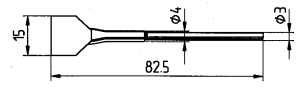
10 mm, for e.g. SOIC 16

0422FD4



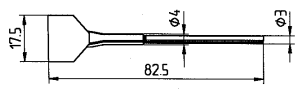
12.5 mm, for e.g. SOIC 20

0422FD2



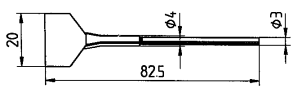
15 mm, for e.g. SOIC 24

0422FD5



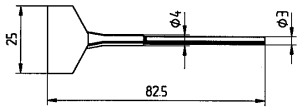
17.5 mm, for e.g. SOIC 28

0422FD6



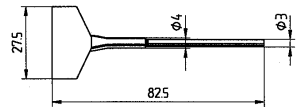
20 mm, for e.g. SOIC 32

0422FD7



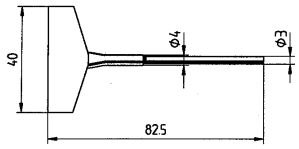
25 mm, for e.g. SOIC 40

0422FD8



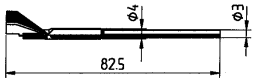
27.5 mm, for components of 27.5 mm side length

0422FD9



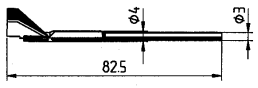
40 mm, for components of 40 mm side length

0422QD5



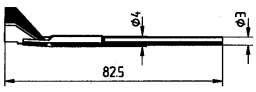
90°, length 10 mm, for e.g. PLCC 20

0422QD1



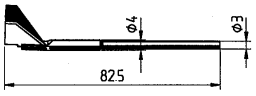
90°, length 12.5 mm, for e.g. PLCC 28

0422QD6



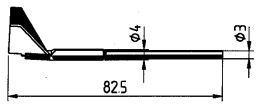
90°, length 15 mm, for e.g. QFP, TQFP and TQFP 0T25

0422QD3



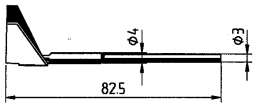
90°, length 17.5 mm, for e.g. PLCC 44

0422QD4



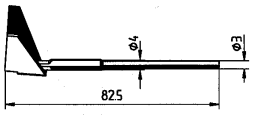
90°, length 20 mm, for e.g. PLCC 52

0422QD2



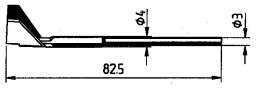
90°, length 25 mm, for e.g. PLCC 68

0422QD7



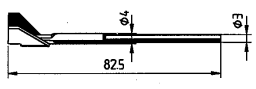
90°, length 30 mm, for e.g. PLCC 84

0422RD1



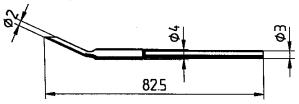
length 22.5 x 16.5 mm, for e.g. QFP 100

0422RD2



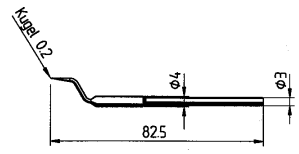
length 15 x 12.5 mm, for e.g. PLCC 32

0422MD



ellipse, for MELF and MINIMELF

0422SD*



for MICROMELF

***Please note:**

The desoldering tips 0422SD must be used in combination with the tip turn protection set (see page 24) to ensure good results.
Tip turn protection set for TC 40 desoldering pincette and Desoldering Pincette 40 on request.

Leadfree Bleifrei
DESIGNED FOR
ERSA