FACTORS LIMITING LIFE OF TIPS

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WORKING TEMPERATURE

The higher the temperature,
the greater the oxidation and corrosion.
Work with the lowest possible temperature.
Use thermal efficient tools and keep tips clean of oxidation.

FLUX AND SOLDER ALLOY

Too much active Flux can cause corrosion.
IPC recommends: ROL, REL and ORL.
The internal flux from small Ø solder reels might not be enough.
Provide compatible external Flux if necessary.

CORRECT TECHNIQUES

Too much pressure on the surface to solder
can cause tip or plate breakage.
Do not use as a pointed object or a screwdriver.
Choose the biggest tip possible for each application and work at the lowest possible temperature.

OXIDIZATION

Iron oxide does not wet nor transfer temperature well (dewetting).The higher the temperature, the greater the risk of oxidation
Keep tips always tinned while not in use.
Use flux on your solder joints.
Take advantage of *SLEEP & HIBERNATION functions*.

IRON PLATING THICKNESS

Plate wear shortens tip life (hollowed-out).
Do not use mechanical or chemical means to clean the tip. Use the cleaning methods provided by the manufacturer.
Do not apply too much pressure to the tip.