

Installation Instructions: Probe Blade Spare Tip

1. Remove the old tip and completely remove the remaining solder from the original tip installation.
2. Thoroughly clean the blade, preferably in an ultrasonic cleaner using de-ionized water, then rinse with isopropyl alcohol.
3. Use Kester® no clean solder (containing Sn96.5Ag3.0Cu0.5 alloy) or equivalent and Kester® flux pen 2331-ZX or equivalent.
4. Hold the tip to the bottom of the blade, allowing the excess length of the tip to extend off the back of the blade.
5. Using the flux pen, apply the flux to the bottom of the blade and to the portion of the tip contacting the blade; do not contact the sharpened tip. Flux should pool around the base of the tip on the blade.
6. Solder the tip to the blade using a steady swipe of solder from the iron. Do not rest the iron on the blade; the solder should flow instantly.
7. Wet a swab with isopropyl alcohol and lightly clean the flux off the blade around the soldered area. Do not use the swab on the tip portion extending past the blade.
8. Trim excess length off the back of the blade.
9. Place bend to the end of the tip for probing at approximately 0.75 mm from sharp end of tip at a 60° angle.