

# TD-100 STANDARD SOLDERING TIPS

## TIP SPECIFICATIONS

TIPS	DESCRIPTION	TIP SIZE - L	SIZE - D	PART NUMBER
	1/32" Conical Sharp Extended	13.4mm (0.530")	0.80mm (0.031")	1124-0001-P1
	1/64" Conical Sharp	7.8mm (0.310")	0.40mm (0.016")	1124-0002-P1
	1/64" Conical Sharp Bent 30 Degrees	7.8mm (0.310")	0.40mm (0.016")	1124-0003-P1
	1/64" Conical Sharp Extended	13.5mm (0.535")	0.40mm (0.016")	1124-0004-P1
	13/64" Conical Sharp Extended	4.7mm (0.188")	0.80mm (0.031")	1124-0005-P1
	3/128" Conical	4.6mm (0.184")	0.58mm (0.023")	1124-0006-P1
	1/16" 90 Degree Chisel	10.9mm (0.430")	2.03mm (0.080")	1124-0007-P1
	3/64" 30 Degree Chisel	9.7mm (0.380")	1.20mm (0.047")	1124-0008-P1
	3/64" 30 Degree Bevel	3.6mm (0.140")	1.20mm (0.047")	1124-0009-P1
	13/64" Extra Large Chisel	7.62mm (0.300")	5.15mm (0.203")	1124-0010-P1
	1/64" 60 Degree Bevel	14.7mm (0.580")	0.40mm (0.016")	1124-0011-P1
	1/32" 30 Degree Chisel	9.1mm (0.360")	0.80mm (0.031")	1124-0012-P1
	3/32" 30 Degree Chisel	9.9mm (0.390")	2.40mm (0.094")	1124-0013-P1
	5/64" 60 Degree Chisel	4.7mm (0.185")	2.00mm (0.078")	1124-0014-P1
	1/64" Conical, Sharp, Bent 30 Degrees, Extended	15.1mm (0.595")	0.40mm (0.016")	1124-0015-P1
	3/64" Chisel Bent 30 Degrees	11.7mm (0.460")	1.20mm (0.047")	1124-0016-P1
	1/16" 60 Degree Chisel	15.8mm (0.620")	1.60mm (0.063")	1124-0017-P1
	1/32" Conical Sharp Extended	16.7mm (0.660")	0.80mm (0.031")	1124-0018-P1
	1/16" 30 Degree Chisel	9.9mm (0.390")	1.60mm (0.063")	1124-0019-P1
	1/8" 90 Degree Chisel	4.8mm (0.190")	3.20mm (0.125")	1124-0020-P1

### MAXIMIZING TIP LIFE...

PACE recommends the following practices to maximize tip life.

1. Always use the lowest possible temperatures while soldering. High temperatures cause tips to oxidize faster, which reduces heat transfer and damages the protective iron plating.
2. Avoid aggressive fluxes whenever possible. Aggressive fluxes erode tips faster, shortening their useful life.
3. Always use a properly sized tip for the work. Tips, that are too small, will wear out faster and tips that are too large will wear unevenly which, in turn, will change the tip geometry rendering it useless, possibly damaging pads.
4. Always tin tips when not in use and after cleaning on a damp sponge. A coating of solder will prevent oxidation from forming which causes tips to lose their tinning or wetting capability.
5. Always feed solder wire into the heated work, not the tip. Feeding solder directly into the tip will cause pin-holes in the tip and will cause the flux in the solder wire to be burned off before it can activate and prepare the surfaces being soldered.

Should tips lose their tinning or wetting capability, a tip cleaner such as Sodr-Tek's Tip-Brite may be used to restore them.

