

JUMPER SOLDERING

Set iron from 600 to 700 degrees. Depending on the controller, the amount of heat varies. Preferably use the lowest setting possible.

Soldering Start Pins:

Working from layer 1 add flux at the pad of the jumper. Holding the tip of the iron to one side of the pad, being careful not to touch the board. Heat and add solder when flux begins to bubble. The solder must run through to layer 6 making a good solder connection between the pin and pad. You do not want excess solder at the base of pin or solder running along the length of the pin. These would be rejects and would require changing.

Soldering Pass-thru Pins:

Working from layer 1 first check for high jumpers. All boardstops of the jumpers must be flush onto the pads. Use a hand insertion tool or a tweezer to seat jumpers that are high. Turning board over and working on layer 6 they then get soldered. On one side of the pin there is a small opening which is where you place the tip of your iron when soldering. Adding flux to pad at jumper you heat with tip in proper location. When the flux begins to bubble add enough solder to give a good solder connection between the pin and the pad. You do not want excess solder at the base of pin or solder running along the length of the pin. These would be rejects and require changing.

Soldering Terminator Pins:

Working from layer 1 first check for high jumpers. All boardstops of jumpers must be flush onto the pads. Use a hand insertion tool or a tweezer to seat jumpers that are high. Turning board over and working from layer 6 they are soldered. Adding flux at the pad of the terminator and placing the iron tip to one side of pad (not touching the board), heat and when flux begins to bubble add a small amount of solder giving you a good connection between the terminator and the pad. You do not want solder to run down through the barrel and into the cage on layer 1. This would be a reject and require changing.