

Nordson *SELECT*

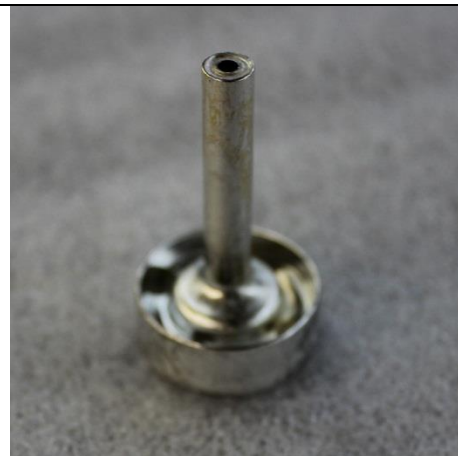
MRT-1066.1 (05/05/14) Nitrogen Quality Test

Tool List:

High Temp Gloves
Safety Glasses
Spatula
Dross Pan
Acid Brush
Superior #75 or #23 Flux
Nozzle
Proper Chimney & Cap

Document List:

Refer to MRT-1036.1
Refer to MRT-1053
Refer to MRT-1054.1



For testing purposes the nozzle must be properly cleaned and tinned.

Refer to ATD-1036.1



Make sure to have a clean riser on the pump inside and out. The above picture shows a cleaned riser.

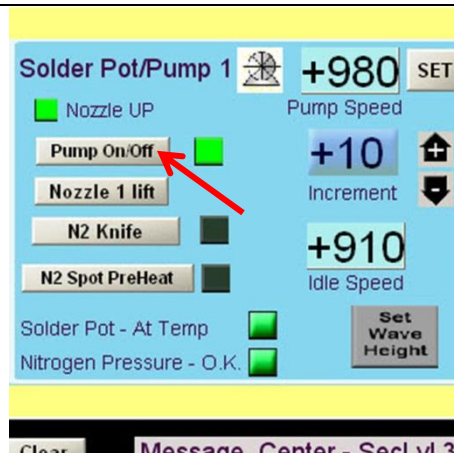
Refer to ATD-1053



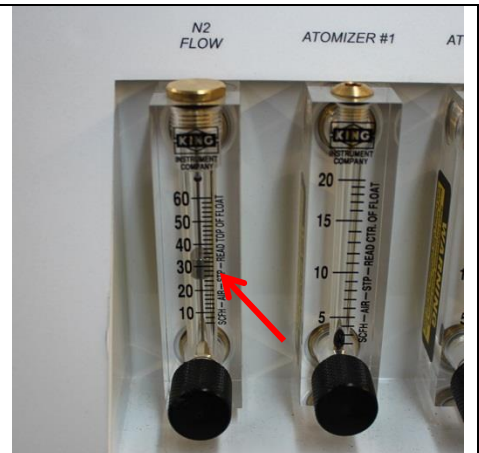
Make sure to clean the solder pot of all dross and debris. Using a spatula and dross pan.



Properly set-up the pump with nozzle, chimney & cap, as seen above.
Refer to ATD-1054.1



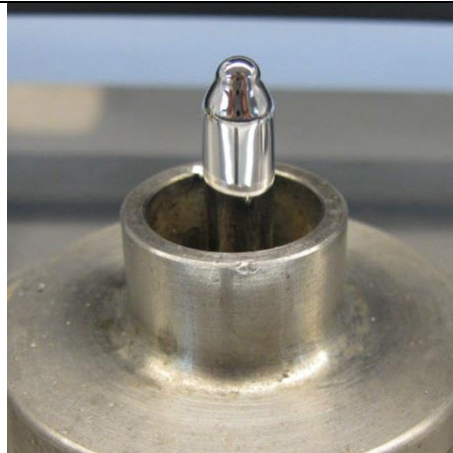
Turn pump ON at the process speed.
Speeds may vary!



Make sure **nitrogen flow** meter is on **30-40 CFH**.



Dress (tin) the nozzle using an acid brush and **Superior #75** flux to assure Good even solder flow.
Refer to ATD-1053



Do NOT Disturb or touch the solder during the test!
Watch the solder as it flows. Observe over 15 minutes that the solder at the top of the wave remains **clean and shiny**.

If discoloration (oxide) is observed the N2 quality is compromised. It should be 99.999% purity which is 10ppm O2. This must be fixed at the source.

Customer Service
Nordson SELECT, Inc.
22425 East Appleway Ave
Suite 1
Liberty Lake, WA 99019
Office: +1.509.924.4898
Fax: +1.509.533.1299