



MRT-1036 Nozzle Tinning

Tool List:

Safety Glasses
 Scotch Brite
 High Temp Gloves
 Small Container of Superior #75 Flux
 Needle Nose Pliers



**Always wear safety glasses when working on your selective soldering machine.*

**Also, read through these instructions in its entirety before starting the procedure.*

**Be careful even with the use of high temp gloves, the nozzle can burn you through the glove.*

Step 1:

Submerge the nozzle in solder to heat it and then using scotch brite, thoroughly scrub the nozzle.

DANGER: Dip nozzle very slowly into solder to prevent outgassing or solder splatter!



<p>This nozzle needs to be re-tinned as the solder flows down one side of the nozzle during use.</p>	<p>Submerge the nozzle in your solder tank using the needle nose pliers to heat the nozzle.</p>	<p>Using the scotch Brite Scrub the nozzle.</p>

Step 2:

Now while the nozzle is still hot, submerge it into a small container of Superior #75 flux taking care to wear safety glasses and high temp gloves. **(BE CAREFUL to dip into flux slowly to prevent splatter!)**


Then SLOWLY submerge the nozzle into the solder tank once again.

DANGER: Dip nozzle very slowly into solder to prevent outgassing or solder splatter!

		<p>You should repeat the previous steps until the nozzle is free of black residues and oxidation. Scrubbing the nozzle with scotch brite while hot will eliminate the extra work it would take to remove the solder when it is cold and greatly reduces the time to tin the nozzle. Again, take care in the time you handle the hot nozzle as it can still burn you through the high temp gloves if held to long.</p>
<p>Submerge the hot nozzle into Superior #75 flux. Also, you can soak the nozzle in the flux for a while. (5-20 min)</p>	<p>Submerge the nozzle into the solder tank.</p>	

Step 3:

This is a properly tinned nozzle and free of black residues and oxidation.

	<p>Notice how there is no black substances or oxidation on this nozzle now. Also, you will see that ring is clean along with the inside ring is free of flux residue. This nozzle should now perform like new.</p>
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