

melts the rest of the joint will be hot enough for the solder to "take", (i.e., form a capillary film).

- (5) Apply solder for a second or two, then remove the solder and keep the iron tip on the joint. The rosin will bubble out. Allow about three or four bubbles, but don't keep the tip applied for more than ten seconds.
- (6) Solder should follow the contours of the original joint. A blob or lump may well be a solder bridge, where enough solder has been built upon one conductor to overflow and "take" on the adjacent conductor. Due to capillary action, these solder bridges look very neat, but they are a constant source of trouble when boards of a high trace density are being soldered. Inspect each integrated circuit and component after soldering for bridges.
- (7) To remove solder bridges, it is best to use a vacuum "solder puller" if one is available. If not, the bridge can be reheated with the iron and the excess solder "pulled" with the tip along the printed circuit traces until the lump of solder becomes thin enough to break the bridge. Braid-type solder remover, which causes the solder to "wick up" away from the joint when applied to melted solder, may also be used.

INSTALLING AUGAT PINS

Augat pins are normally supplied on carriers (e.g., 8-pin and 16-pin carriers). In many cases the PC board layout permits Augat pins to be installed while still attached to the carrier or a portion of the carrier. In other cases the pins must be installed singly.

To install two or more pins that are still attached to the carrier, proceed as follows:

NOTE

It is perfectly alright to appropriately cut a carrier to accommodate the installation. For example, an 8-pin carrier can be cut in half (4 pins each) across the short dimension to fit a 4-pin, 4-corner layout. It may also be cut in half along the long dimension to fit a 4-pin, inline layout.

- (1) Insert pins in the mounting holes from the front (component) side of board. (The carrier will hold the pins perpendicular to the board.)
- (2) Solder all pins from back (solder) side of board so the solder "wicks up" to the front side.