

## Process Guide R-TSO-03

# TSOP Removal Flux Application



### Equipment Required

PACE Intelliheat® Power Supply  
 TD-100 Thermo-Drive Soldering Iron  
 TSOP Removal Tip (See Chart on Back)  
 Tip Tool  
 Tip Maintenance Station

### Optional Equipment

Tweezers

### Materials

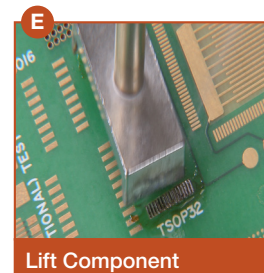
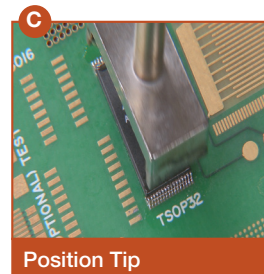
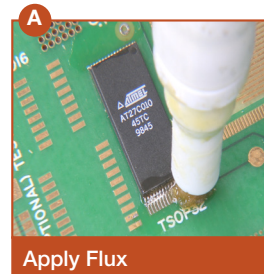
Flux-cored Solder  
 Flux  
 Cleaner



TD-100

### Procedure

1. Remove conformal coating (if any) and clean work of any contamination, oxides or residues.
2. Set a tip temperature of 343°C (650°F) for lead-free or 316°C (600°F) for leaded alloys and adjust as necessary.
3. Install TSOP removal tip into the TD-100 using Tip Tool.
4. Apply flux to all lead/land areas. **A**
5. Remove old solder from tip with Fiber Tool from Tip Maintenance Station.
6. Thermal shock tip with damp Sponge Tool from Tip Maintenance Station.
7. Tin bottom and inside edges of tip with solder. **B**
8. Lower tip over component contacting ALL leads with tip. **C**
9. Confirm solder melt of ALL joints and lift component from PCB. **D** & **E** (Surface tension of the tip should lift the component from the board. If this does not occur, use of tweezers to lift the component is optional)
10. Release component from tip by wiping on a heat resistant surface.
11. Re-tin tip with solder and return the TD-100 to its Tip & Tool Stand.
12. Prepare lands for component replacement.



**PAGE**  
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# TD-100 Tips

