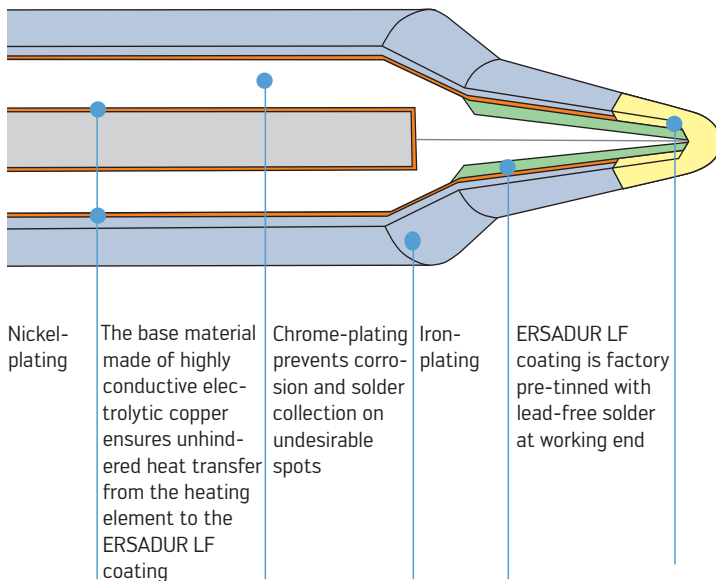


# ERSADUR soldering tips



Cross-section of an ERSADUR tip, non-scale representation



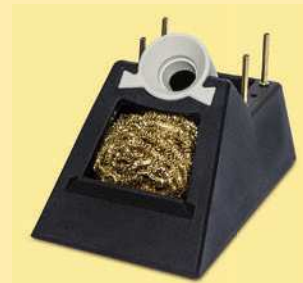
## Special care for soldering tips

### Important facts:

1. When a soldering tip remains hot for a long period of time, the tip will oxidize or blacken. An oxidized tip will no longer "wet" or melt solder properly.
2. The higher the **working temperature** of the soldering tip, the faster this oxidation will take place and tip lifetime will be shorter.
3. Soldering irons that automatically go into a lower "standby" temperature increase tip life.
4. **The oxidation of the tip will be very rapid** if the tip is left "cooking" without molten solder covering the tip end. It happens, for example, if the tip is not wetted with solder right after cleaning it.
5. Excessive **mechanical force** during soldering will shorten the tip life.
6. Proper care of the tip will greatly **increase tip life**.
7. **Lead-free soldering** requires **higher temperatures**, is more aggressive to the tip and will always lead to shorter tip life.

### Special care:

1. Always clean the tip by wiping on a slightly wet sponge after each use. Alternatively, tips can be dry cleaned using the Erska dry sponge.
2. Always put fresh solder onto the end of the tip **BEFORE** putting the tip back into the tool holder.
3. Always use lowest working temperature possible.
4. Never leave an iron "cooking" unattended for some time. Always set iron into automatic standby if possible or turn off when not in use.
5. Never use excessive mechanical force when soldering.
6. Soldering tip oxidation can be easily removed if detected early. Early detection and removal will greatly increase tip life.
7. Tip oxidation removal or tip refurbishing is accomplished in 4 consecutive steps:
  - Clean on damp sponge,
  - Clean with wire brush,
  - Use of a TIP-REACTIVATOR chemical,
  - Retinning using proper flux cored solder wire.



### Ersa Dry Sponge

The Erska Dry Sponge (order no. 0008M) is an alternative to the wet sponge and can be beneficial, especially in lead-free soldering.



**Youtube:**  
Ersa explains  
#2 - X-TOOL  
VARIO



### Service Tool X-TOOL VARIO

Service tool for tip exchange and cleaning of the X-TOOL VARIO desoldering iron (order no. E074600).



### Cleaning kit for tip series 742 (X-TOOL VARIO)

The cleaning kit includes the fitting drill bits for the tips of the 742 series to remove residues in the suction channel of the tip (order no. E074700).



### Cleaning brush

Brush with brass bristles for gentle tip cleaning (order no. 3ZT00051). It can also be used to clean heating elements.

In the field of hand soldering a long tip lifetime with continuously good soldering results is essential for the users. Oxidized soldering tips can only slowly melt the solder, which decreases productivity. A soldering tip needs care in order to ensure an efficient process.

Dry cleaning of soldering tips offers substantial advantages. The soldering tips are not cooled abruptly and contaminated tips resulting from dirty sponges are avoided. Due to the slightly abrasive properties of the special wire mesh, passive layers that accumulated on the tip can easily be removed. Tip life is thus increased considerably in lead-free hand soldering.

# ERSADUR longlife soldering tip series 102



■ All i-CON soldering stations with soldering irons i-TOOL, i-TOOL NANO, i-TOOL PICO

<p><b>0102PDLF01</b></p> <p>pencil point, recessed, 0.1 mm <math>\varnothing</math></p>	<p><b>0102PDLF02</b></p> <p>pencil point, 0.2 mm <math>\varnothing</math></p>	<p><b>0102PDLF03L</b></p> <p>pencil point, extended, 0.3 mm <math>\varnothing</math></p>	<p><b>0102PDLF04</b></p> <p>pencil point, 0.4 mm <math>\varnothing</math></p>
<p><b>0102PDLF04L</b></p> <p>pencil point, extended, 0.4 mm <math>\varnothing</math></p>	<p><b>0102PDLF05L</b></p> <p>pencil point, extended, 0.5 mm <math>\varnothing</math></p>	<p><b>0102PDLF06</b></p> <p>pencil point, 0.6 mm <math>\varnothing</math></p>	<p><b>0102PDLF06L</b></p> <p>pencil point, extended, 0.6 mm <math>\varnothing</math></p>
<p><b>0102PDLF07</b></p> <p>pencil point, 0.7 mm <math>\varnothing</math></p>	<p><b>0102PDLF08L</b></p> <p>pencil point, extended, 0.8 mm <math>\varnothing</math></p>	<p><b>0102PDLF10</b></p> <p>pencil point, 1.0 mm <math>\varnothing</math></p>	<p><b>0102CDLF04</b></p> <p>chisel-shaped, 0.4 mm</p>
<p><b>0102CDLF12</b></p> <p>chisel-shaped, 1.2 mm</p>	<p><b>0102CDLF16</b></p> <p>chisel-shaped, 1.6 mm</p>	<p><b>0102CDLF18L</b></p> <p>chisel-shaped, extended, 1.8 mm</p>	<p><b>0102CDLF20</b></p> <p>chisel-shaped, 2.0 mm</p>
<p><b>0102CDLF24</b></p> <p>chisel-shaped, 2.4 mm</p>	<p><b>0102CDLF24L</b></p> <p>chisel-shaped, extended, 2.4 mm</p>	<p><b>0102CDLF32</b></p> <p>chisel-shaped, 3.2 mm</p>	<p><b>0102CDLF50</b></p> <p>chisel-shaped, 5.0 mm</p>
<p><b>0102CDLF65</b></p> <p>chisel-shaped, 5.0 mm</p>	<p><b>0102CDLF080C</b></p> <p>chisel-shaped, conical, 8.0 mm</p>	<p><b>0102CDLF100</b></p> <p>chisel-shaped, 10.0 mm</p>	<p><b>0102CDLF100C</b></p> <p>chisel-shaped, conical, 10.0 mm</p>