

ArmorLite™ Suggested Soldering Procedure for Pull-On Braid Over Multiple Breakout Legs



For the following instructions, refer to image at bottom of page

1. Apply Teflon tape over yoke areas overlapping onto individual legs (see dotted line areas). Pull ArmorLite™ braid onto the smaller legs first, then overlap with the large trunk.
2. Solder all open apertures providing 90%–100% optical coverage, meeting class 3 visual examination. Trim excess braid if required.
3. Suggested solder type:
SN63 WRMAP3, per QQ-S-571F/J-STD-004,
Solder diameter .062 flux-rosin mildly activated
Iron size: 175 watt: Suggested tip temperature 780°F to 800°F.
Dwell time on the braid should be **5-10** seconds total, going back and forth per leg.

