

## 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.

