ArmorLite[®] Suggested Soldering Procedure for Pull-On Braid Over Multiple Breakout Legs

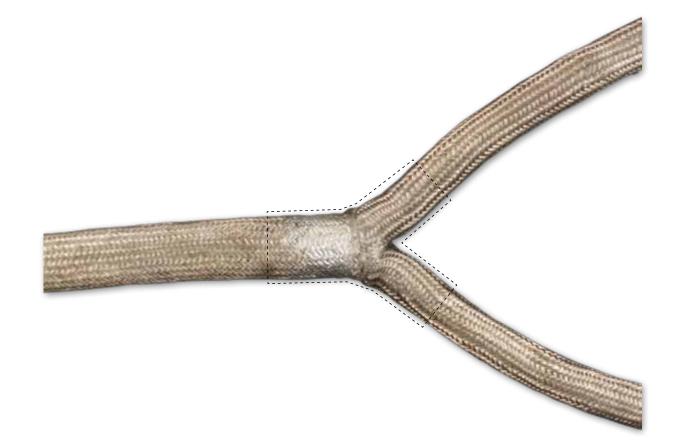


For the following instructions, refer to image at bottom of page

- 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, gong back and forth per leg.



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