

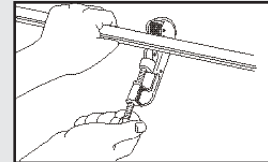
COPPER TUBE AND SOLDER TYPE FITTINGS

HOW TO MAKE PERFECT SOLDER JOINTS

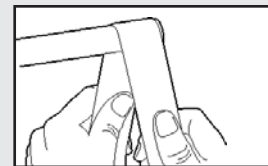
1. Cut tube square with the cutter or fine hack saw (32 tooth blade is recommended). Remove Burr.
2. Clean outside end of copper tube thoroughly with sandcloth or sandpaper equal to cup depth of fitting. Leave no dark spots.
3. Clean inside of fitting carefully to tube stop with wire brush. Note: Sandcloth or sandpaper may also be used.
4. Using a brush, apply light uniform coat of soldering flux to the outside of the tube and inside of the fitting.
5. Slip tube into fitting to tube stop. Turn tube back and forth once or twice to distribute flux evenly.
6. Apply heat uniformly around the fitting with torch. When solder melts upon contact with heated fitting, the proper soldering temperature has been reached. Remove flame and feed solder slightly off center at the bottom of the joint. Proceed across the bottom of the fitting and up to the top center position. Return to the starting point, and then proceed up the incompleated side to the top, again, overlapping the solder metal. Wipe off surplus solder with a piece of cloth.

CAUTION: Do not overheat the joint or direct the flame into the face of the fitting cup. Overheating could burn the flux, which will destroy its effectiveness and the solder will not enter the joint properly.

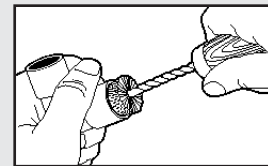
1. Cut tube to length and remove burr with file or scraper.



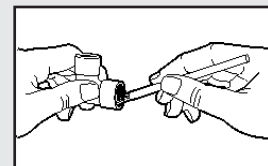
2. Clean outside of tube with sandpaper or sandcloth.



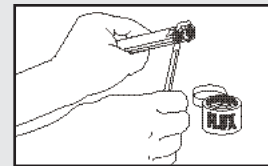
3. Clean inside of fitting with wire brush, sandcloth or sandpaper.



4. Apply flux thoroughly to inside of fitting.



5. Apply flux thoroughly to outside of tube—assemble tube and fitting.



6. Apply heat with torch. When solder melts upon contact with heated fitting, the proper temperature for soldering has been reached. Remove flame and feed solder to the joint at one or two points until a ring of solder appears at the end of the fitting.

