



QA Technology Company, Inc.

<p>A p p l i c a t i o n s N o t e</p> <p>Making Solder Connections on Soldered Sockets</p> <p>Document# D10038 Rev A ECN# 1892 Page 1 of 1</p>		
---	--	--

Solder connections are normally made, of course, on solder cup sockets. But in some cases it is desirable to make solder connections on the tail pin (round or square) of QA's soldered sockets. This can be done safely. Here are a few specifics on the subject:

Q: If the tube is heated to the point where the solder in the joint flows, will the tail pin (round or square) move?	A: No. The pin is press-fit into the tube, so even without solder holding the pin, it takes a minimum of about 10 pounds (of axial force) to move the square pin and about 1 pound to move the round pin.
Q: At what temperature does the solder melt?	A: The solder melts at about 350 degrees Fahrenheit (177° C).
Q: If the socket is upside down or sideways when heated, will the solder in the joint flow to the area where the probe tube seats?	A: No. There is not enough solder in the joint for this to happen.
Q: If the socket tube is heated, and solder is <i>fed</i> into the joint, is it possible to solder a probe in the socket or introduce enough solder into an empty socket that probes cannot be completely installed?	A: Yes. But this possibility can be eliminated by not feeding solder into the joint. Keep added solder away from the tail pin/tube junction.