Checklist to Maximize Tip Life

Please use the following table below as a quick reference to help you maximize your soldering iron tip life.

Process Variable	Key to Maximize Tip Life	DO NOT
Tip Maintenance	Keep the tip working surface free from deposits Use the Hakko FS-100 Tip Polish as a supplement to regular cleaning Use clean, damp sponges for regular cleaning Use a non-abrasive tip cleaner as an alternative to a damp sponge (Hakko 599B Tip Cleaner) Flood the tip with solder after cleaning to cover the entire working surface of the tip. Use only distilled (or de-ionized) water for cleaning sponges	Use commercial tip tinners Use regular tap water on the cleaning sponge Use dirty or contaminated sponges Drop or hit the tip against hard surfaces or objects
Tip Temperature	Use lower operating temperatures Turn down the temperature when at idle Turn off the soldering station if not in use for an extended period.	Increase tip temperatures Leave the iron idling at high temperatures Leave the soldering iron on continuously without use
Solder	Use lower Tin (Sn) content solders if possible Use wire solder that has a milder flux core Be aware of solder composition and changes	
Flux	Use mildly active fluxes where possible (RMA flux preferred) MINIMIZE the use of organic, water soluble, or highly active fluxes	
Operator Technique	Select the proper tip size and shape for the application Apply solder to the connection and not directly to the tip If solder must be applied directly to the tip, vary the contact point.	Try to make one tip work for all connections Press the tip against the component pad or lead Rub the tip against a surface with force Use the tip as a pick or small screwdriver Use excessive flux Apply flux directly to the soldering iron tip
Application	Take into consideration the application differences besides number of connections	