

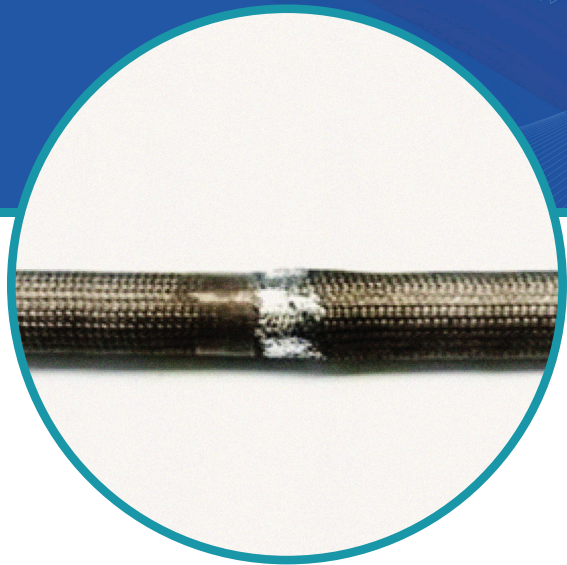
GUIDELINES

Soldering Instructions for Silver ARACON[®] Conductive Fiber & EMI Shielding

The same techniques used for soldering silver plated copper can be applied to soldering silver ARACON conductive fiber and EMI shielding.

For best results, the additional following guidelines are recommended:

- ARACON may be cut easily with titanium-bonded or ceramic scissors. Plated steel or stainless steel scissors will wear quickly and are not recommended.
- If soldering ARACON braided EMI shield over a metal contact, it is recommended that a PTFE or Kapton tape be applied around the braid end to hold the loose fiber ends in place while soldering.
- Apply flux, Kester No Clean 951 or equivalent, on the area to be soldered. Only apply enough flux to



achieve an acceptable solder joint. Too much flux can degrade the product performance over time.

- Using SN63 or equivalent solder with the appropriate wire diameter for the application, form a heat bridge between components being soldered with a soldering iron or resistance tweezer. Feed solder into the conductive fiber until the desired fill or coverage is satisfied, being careful not to overheat and reflowing the fiber plating. Remove the heat source quickly and take care not to disturb solder joint as it cools.
- Thoroughly clean the solder joint while still warm to aid in the process using isopropyl alcohol and dry with compressed air.
- Inspect solder joint for good wetting.