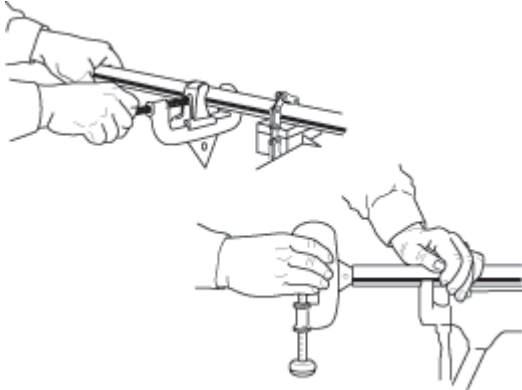


# The Fine Art of Soldering

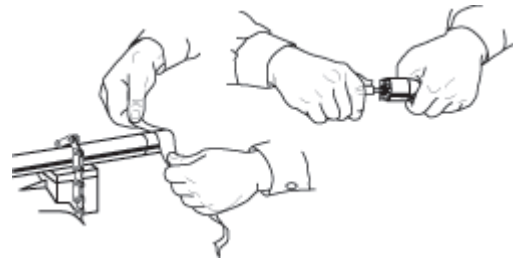
When adjoining surfaces of copper and copper alloys meet under proper conditions of cleanliness and temperature, solder will make a perfect adhesion. The strength of joint is equal to or even greater than the strength of tube alone. Surface tension seals the joint. Capillary attraction draws solder into, around, and all about the joint. It's easy to learn to make a perfect solder joint when you use NIBCO® Fittings.

## WITH 95-5 SOLDER AND INTERMEDIATELY CORROSIVE FLUX

1. Cut tube end square, ream, burr and size.



2. Use sand cloth or steel wire brush to clean tube and cup to a bright metal finish.



3. Apply solder flux to outside of tube and inside of cup of fitting carefully so that surfaces to be joined are completely covered. **Use flux sparingly.**



4. Apply flame to the fitting to heat tube and solder cup of fitting until solder melts when placed at joint of tube and fitting.



5. Remove flame and feed solder into the joint at one or two points until a ring of solder appears at the end of the fitting. The correct amount of solder is approximately equal to  $1\frac{1}{2}$  the diameter of the fitting...  $\frac{3}{4}$ " (20mm) solder for  $\frac{1}{2}$ " fitting, etc.



6. Remove excess solder with a small brush or wiping cloth while the solder is plastic.



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