

# SOLDERING

To solder a component onto the printed circuit board, follow these step-by-step instructions.

- Insert the leads of the component (sometimes called legs) through the correct holes in the PCB. The leads will stick out on the copper track side of the PCB.
- Some components can be held in place by gently bending their legs. Hold the component's legs with small pliers to prevent heat from the soldering iron damaging the component.
- The tip (bit) of the soldering iron should be clean and hot. Hold the tip against the copper track and the component lead to heat both through.
- After a few seconds, hold the solder wire against the joint and allow a small amount of solder to melt onto the track.
- Molten solder should flow around the lead at the point where it goes through the track forming a neat shiny joint.
- Electronics solder contains thin cores of **flux**. This melts onto the joint and prevents oxidation. Without flux, the solder will not flow.



