How To Collect a Solder Sample From a Solder Pot For Testing

Items needed:

- Safety equipment required to protect operator
  - Face shield
  - Long gloves properly rated for handling hot solder
  - Long apron rated for hot processes
  - Face mask to prevent breathing in dross fumes and dust
  - Any other safety devices required by local safety department

Tools

- Stainless steel spoon or metal tool to collect a sample about 1" (25mm) diameter
- Scrappers and hand tools to remove dross from the solder pot and chimney of the solder pot

Process for Wave Solder Machine:

1. Insure solder pot is up to working temperatures.
2. De-dross the solder pot and add solder to fill the solder pot to the correct level.
3. Turn the solder pumps on and allow to run for 15 minutes.
4. After turning the pumps off, de-dross the small amount of dross from the top of the pot
5. Extract a sample of solder from near the top of the pot using a clean spoon. This sample simulates the solder that will come in contact with the circuit board during the soldering process.
6. Allow the sample to cool then remove it from the spoon and place it in a clean bag and ship it off to be tested for alloy content.

Process for Selective Solder Machine:

1. Insure the system is up to temperature.
2. Check and remove and excessive dross that might be in the tank as needed, and insure that the tank at the proper tank level.
3. Manually turn the pump on to allow the solder to flow up and out of the nozzle for 3 - 5 minutes. After that time period collect a solder sample in a spoon to be sampled.

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