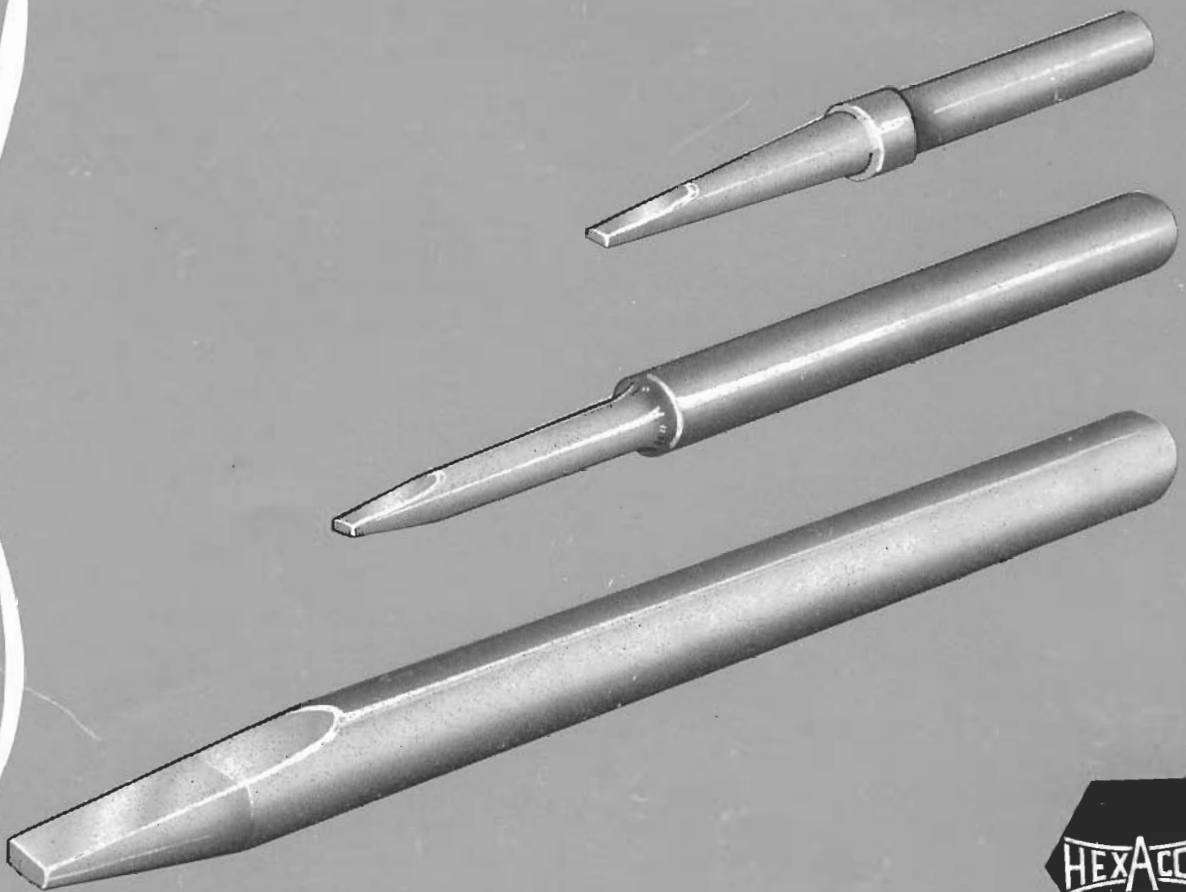


HEXAACON SOLDERING TIPS

famous **XTRADUR**
non-freezing **DUROTHERM**



FOR 55 YEARS
THE GREATEST NAME IN SOLDERING EQUIPMENT



The Greatest Name in Soldering Equipment serving industry for more than 55 years.

THIRTY-FIVE YEARS AGO

the Long-Life iron plated soldering tip industry was in its infancy. Hexacon Electric Company, with two decades of previous experience in producing soldering irons, developed and marketed the first complete line of "permanent" type soldering tips. Pioneering design features and plating techniques in our own laboratories, we introduced the XTRADUR brand tip. With its immunized shank and selective tinning it immediately became the accepted standard in the electronics industry. We also introduced the first tip catalog showing long-life tips in sizes from $\frac{1}{8}$ " to $1\frac{3}{4}$ " diameter featuring over 100 shapes and styles of tips.

Balanced thickness of electro-deposited iron alloy on shank of tip and working surface combined to give the tip maximum performance in modern high temperature, high speed soldering irons. The shank is coated to protect against scaling without loss of important thermal conductivity. The working surface is coated with a heavy thickness, carefully controlled to provide long maintenance-free service.

TWENTY-FIVE YEARS AGO

Hexacon introduced the exclusive DUROTHERM non-freezing tip. This, the only guaranteed non-freezing tip on the market, owes its popularity to a bonded Stainless Steel shank. This tip has become the most popular soldering tip in the industry because of its outstanding maintenance-free performance.

TWENTY YEARS AGO

Hexacon introduced the new process, LECTROTIN, developed to pretin tips. This exclusive technique assures a smooth, bright, wetted, working tip surface. It withstands the most difficult working conditions of high temperatures and long idle periods.

TODAY

XTRADUR and DUROTHERM Tips are the standard of excellence in worldwide markets. The uniform high quality has won the well recognized position of continued leadership.

1. HEXACON maintains the most modern and fully equipped laboratory and largest tip plating facility in the U.S.
2. HEXACON is the only soldering equipment manufacturer who makes a full-line of their own coated tips—combining 50 years of outstanding experience in the design, manufacture and control of both irons and tips.
3. HEXACON maintains local stock in thousands of authorized distributors for immediate delivery.
4. HEXACON also maintains a factory back-up stock of over a half-million tips ready to serve emergency requirements of industry. This includes Plug Tips and Screw Tips from .030" diameter to $1\frac{3}{4}$ " diameter in over 1500 special shapes and sizes.
5. HEXACON tips are made under the following patents: U.S. Patents 2,588,531, 3,109,231 and 3,245,599. Canada 739050, England 1,039,909.



Modern Manufacturing Facilities

Hexacon uses hard drawn Oxygen-Free high conductivity Tellurium alloy copper for the base material. This alloy selection provides inclusion-free base with best heat transfer. Tips are machined in our own modern, fully equipped, production department on precision automatic equipment to exacting dimensions as required. Machined tip blanks are then carefully milled, hot pressed or swaged, to insure no cracks or seams to blister under platings. All sharp edges are rounded to minimum .005 radius before plating.

Shank of XTRADUR tips, as well as back end of shank, entirely coated with protective iron alloy and heavy nickel chrome. No bare copper or large threaded holes to scale from oxidation to cause sticking or freezing. Shanks of XTRADUR and

DUROTHERM carefully ground to a precision surface with guaranteed tolerance of $\pm .001$ to insure proper fit in element of iron.

Hexacon maintains a full time Chemistry Department to continuously analyze plating solutions for maximum quality control.

Good quality iron alloy has a dense, stress-free structure with smooth, uniform surface, free from cracks or pits. This quality can only be attained by constant monitoring of plating process during entire coating cycle. To insure dense long-life coating on heavy tips the process takes up to 18 hours and cannot be hurried without compromising quality.

Microsections are examined daily to examine structure, thickness and quality of plating.



A



B



C



D



E



F

- A Stock
- B Milling
- C Machining
- D Inspection
- E Laboratory
- F Quality Control



Selecting the right tip

GRADES OF TIPS

DUROTHERM—Best grade long-life tip guaranteed not to freeze in HEXACON high heat irons even after many months of use. Best choice also for intermittent soldering where maintenance of other tips is costly or tips are left in irons for prolonged periods.

XTRADUR—Popular long-life design with all plated shank. Preferred for high speed, continuous heavy duty soldering. Entire tip surface protected against scaling.

COPPER TIPS—Economical copper alloy may be filed to redress or to form special shapes. Recommended for high lead or other special solders. Limited life on high speed production soldering.

TIP LENGTH

For maximum efficiency use shortest tip available. Tip temperature significantly reduced by using longer tips (always keep tip fully inserted in element bore).

TIP SHAPE

For quickest dwell time use broadest point with largest area of contact between tinned surface and terminal. Examples: Conical tips for eyelets, full chisel for flat terminals, radius groove tips for pin connectors.

TIP DIAMETER

Use largest diameter possible for better heat transfer, improved life and less maintenance. Oversize diameter tips (i.e. HT552X, HT409X and HT773X) give best efficiency.

OPTIONS AVAILABLE

SELECTIVE TINNING may be specified to prevent solder from spreading on tip surface or “bridging” between close adjacent terminals. (See also Page 16).

CUSTOM TIPS designed or plated to specifications. Furnish complete dimensions or sample copper tips.

DIELEX high strength dielectric coating over Xtradur or Durotherm long-life tips to prevent electrical shorting to adjacent terminals. (See also Page 16).

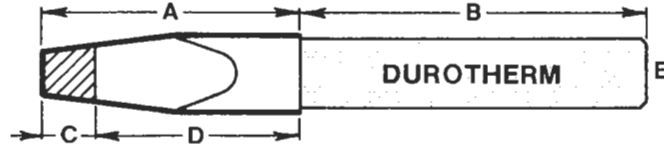


3 Grades of tips

ENGINEERING DATA

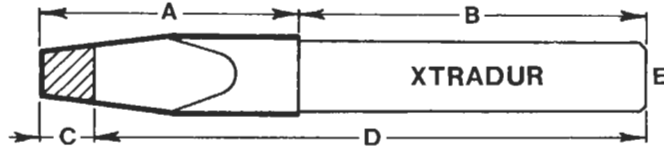
DUROTHERM Iron plated with patented stainless steel bonded to copper shank. Precision ground to tolerance of .001. Lectrotin on working surface and immunized over entire surface.

- A. Heavy Iron Coating
- B. Scale resistant Stainless Steel
- C. Pretinned Lectrotin
- D. Immunized Nickel and Chrome
- E. Iron, Nickel and Chrome coated



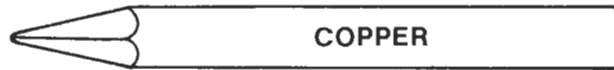
XTRADUR Heavy Iron plated over OFHC Copper alloy with shank precision ground to tolerance of .001. Pretinned with Lectrotin process and immunized with Nickel and Chrome.

- A. Heavy Iron Coating
- B. Iron, Nickel and Chrome
- C. Pretinned Lectrotin
- D. Immunized Nickel and Chrome
- E. Iron, Nickel and Chrome coated



COPPER TIPS Tellurium Copper alloy machined and carefully milled for precise point sizes, lightly plated with Nickel to reduce oxidation.

- A. High heat from OFHC Tellurium Copper
- B. Less scaling than ETP Copper
- C. Nickel plated to tin easier and reduce oxidation



HOW TO ORDER

All long-life tips carry prefix HT—

DUROTHERM add suffix D (Example: HT248D)

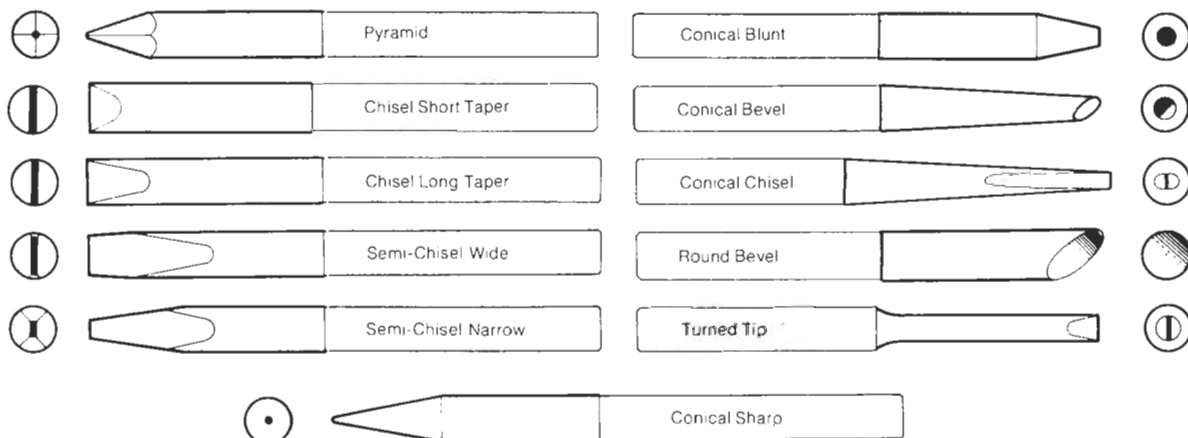
XTRADUR add suffix X (Example: HT248X)

Copper tips use only prefix T (Example: T248)

Note: XTRADUR and Copper tips available in plug type or screw type. DUROTHERM available in plug type only.

HEXACON TIPS are made under one or more of the following U.S. Patents 2,588,531, 3,109,231 and 3,245,599. Canada 739,050, England 1,039,909.

TIP SHAPES



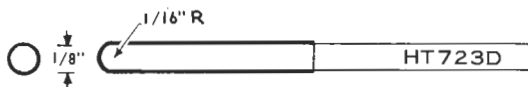
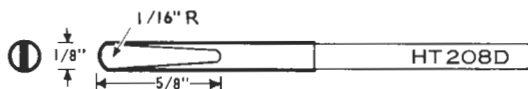
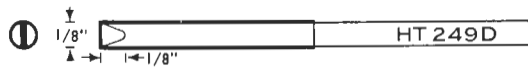


FITS NOS. 21A, 25S, P25, and 25H

POINT THICKNESS $\frac{1}{32}$ " EXCEPT AS SPECIFIED

TURNED DOWN TIPS DESIGNED FOR IRONS UP TO 25 WATTS.

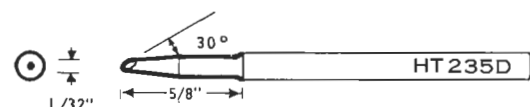
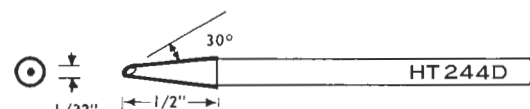
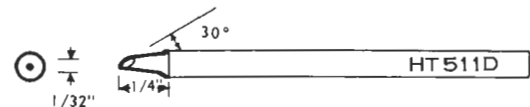
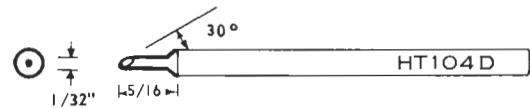
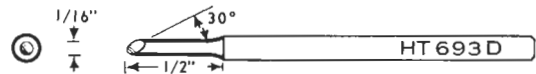
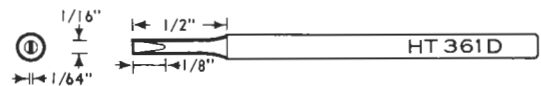
LENGTH $2\frac{1}{4}$ "



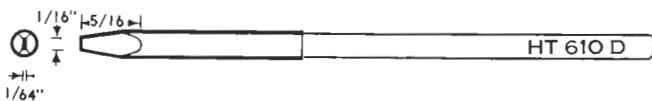
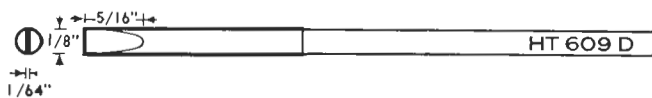
LENGTH $2\frac{1}{4}$ "



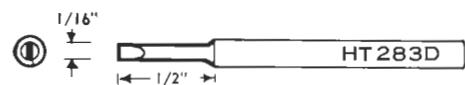
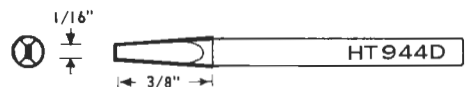
LENGTH $2\frac{1}{8}$ "



LENGTH 3"



LENGTH $1\frac{1}{8}$ "





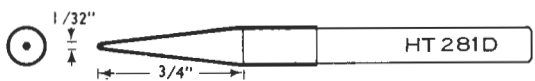
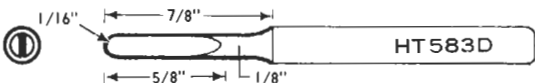
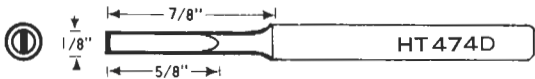
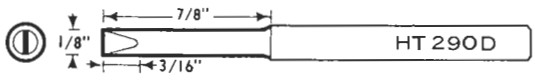
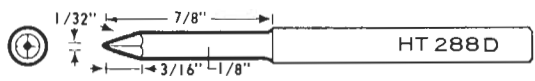
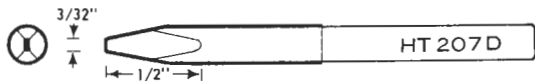
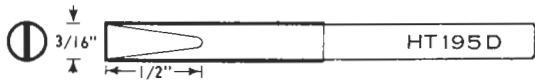
FITS NOS. 26S, P26, 26H, 22A and 22H

POINT THICKNESS 1/32" EXCEPT AS SPECIFIED

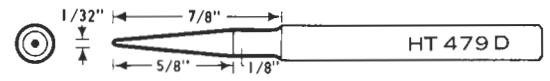
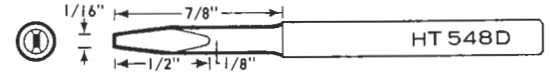
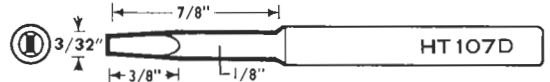
TURNED DOWN TIPS DESIGNED FOR IRONS UP TO 30 WATTS.

3/16"

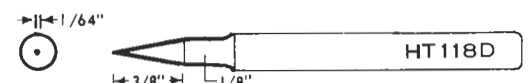
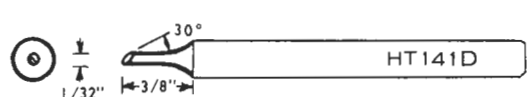
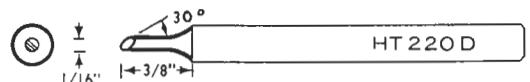
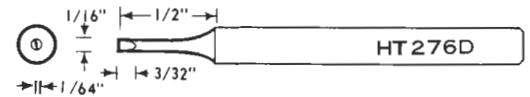
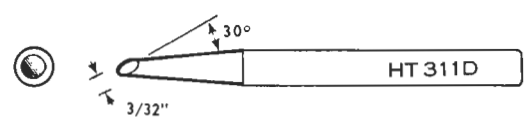
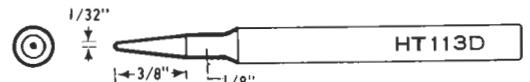
LENGTH 2 1/4"



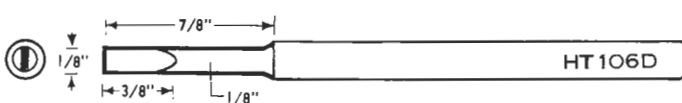
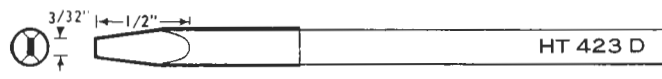
LENGTH 2 1/4"



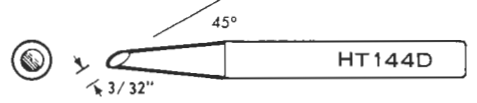
LENGTH 2 1/8"



LENGTH 3"



LENGTH 1 7/8"



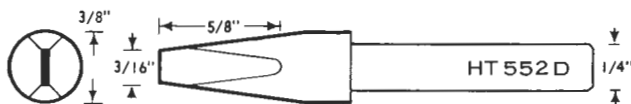
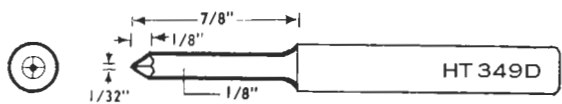
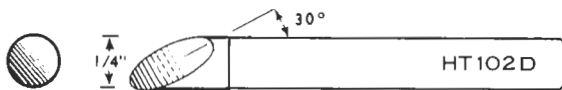
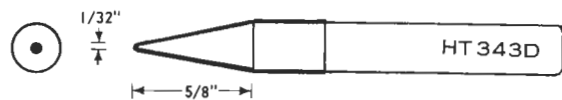
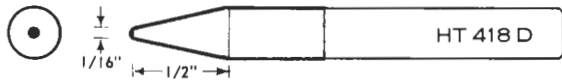
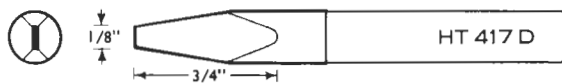
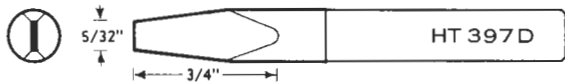
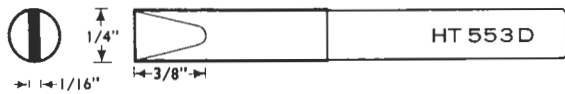
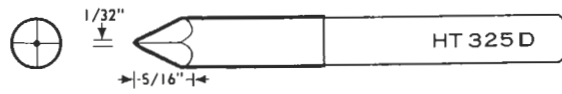
1/4"

FITS NOS. 23A, 24S, P24, and 24H

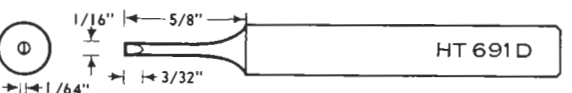
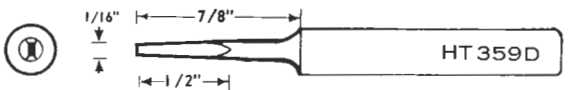
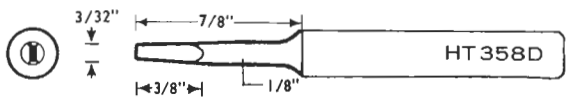
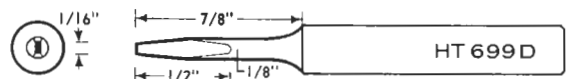
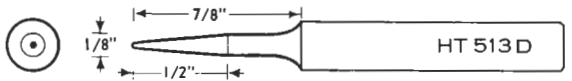
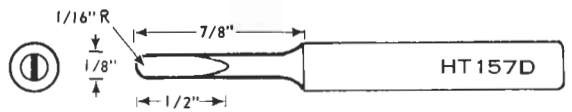
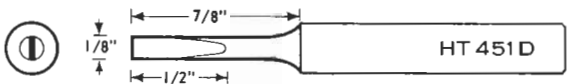
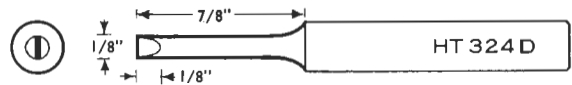
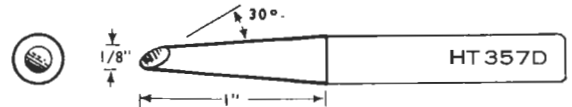
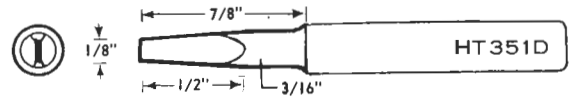
POINT THICKNESS 1/32" EXCEPT AS SPECIFIED

TURNED DOWN TIPS DESIGNED FOR IRONS UP TO 35 WATTS.

LENGTH 2 1/4"



LENGTH 2 1/4"

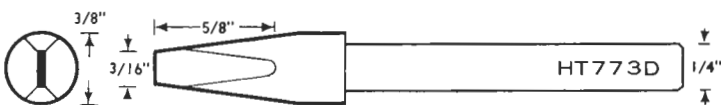
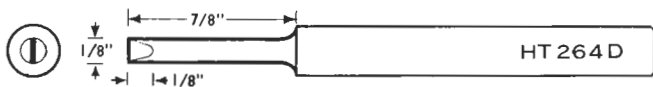
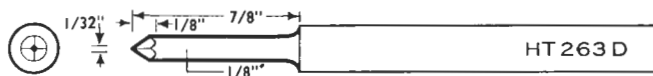
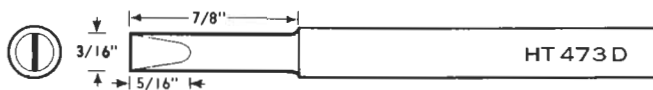
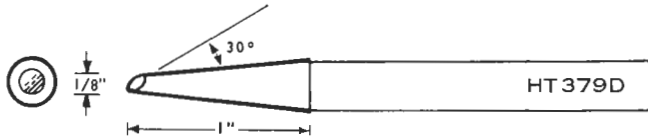
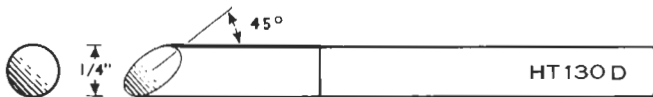
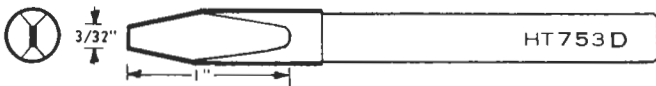
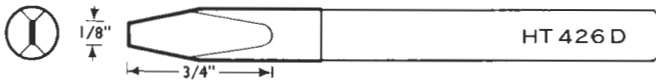
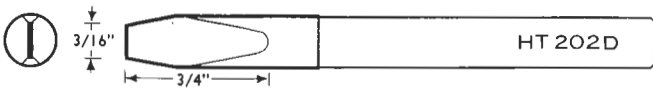
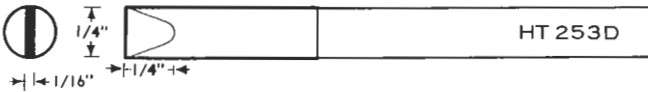
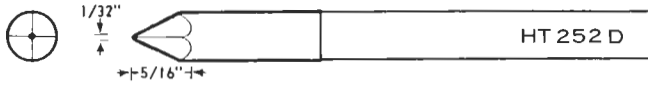




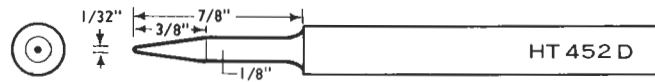
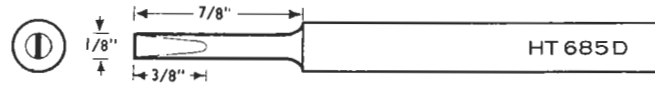
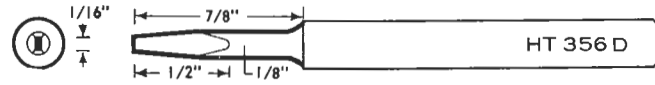
FITS NOS. P30, 30H, P34 and 34H
 POINT THICKNESS $\frac{1}{32}$ " EXCEPT AS SPECIFIED
 TURNED DOWN TIPS DESIGNED FOR IRONS UP TO 50 WATTS.

$\frac{1}{4}$ "

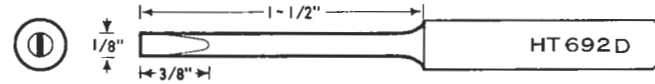
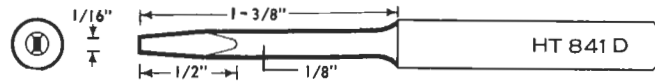
LENGTH $2\frac{3}{4}$ "



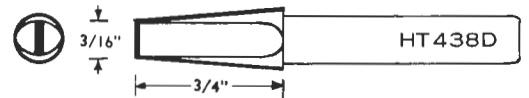
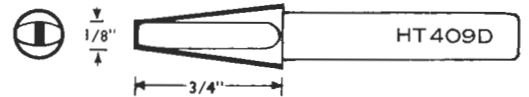
LENGTH $2\frac{3}{4}$ "



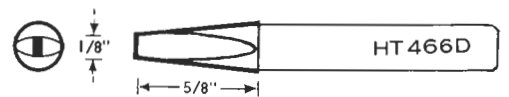
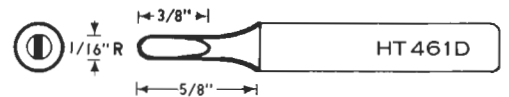
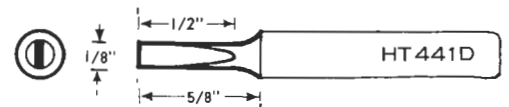
FITS IRONS 23A AND 24S



FOR IRONS UP TO 35 WATTS
 LENGTH 2"



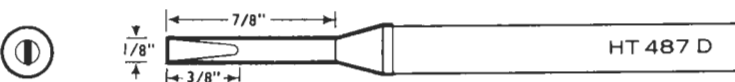
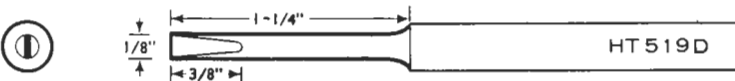
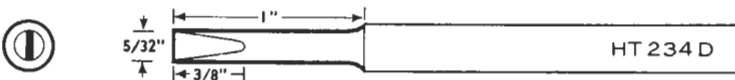
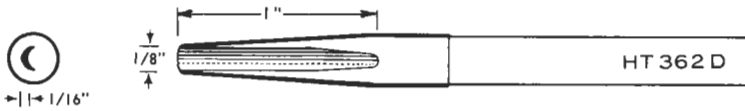
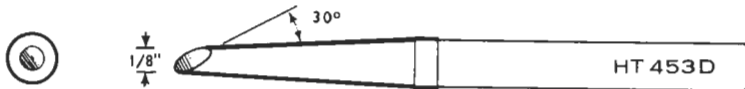
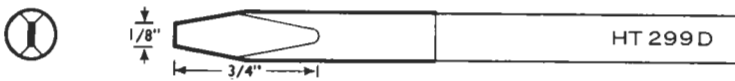
LENGTH $1\frac{7}{8}$ "



1/4"

FITS NOS. P30, 30H, P34 and 34H
POINT THICKNESS 1/32" EXCEPT AS SPECIFIED
TURNED DOWN TIPS DESIGNED FOR IRONS UP TO 50 WATTS.

LENGTH 3"

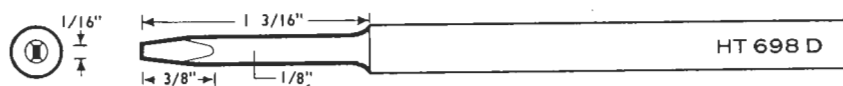
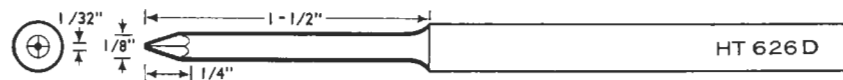
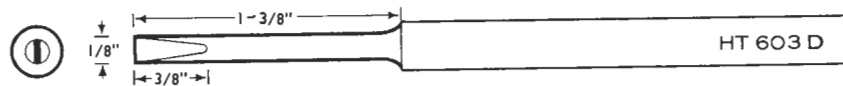
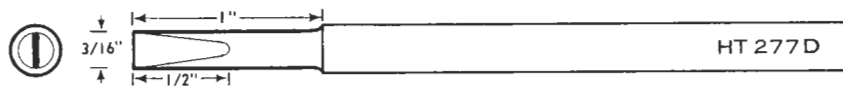
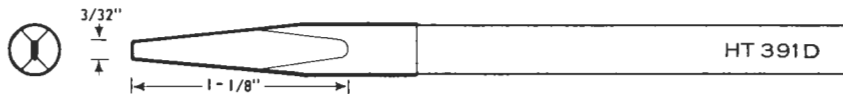
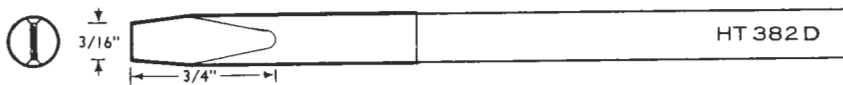
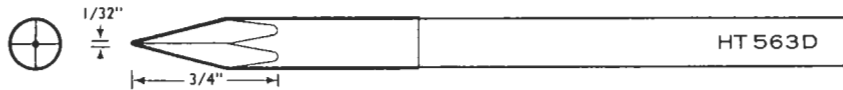




FITS NOS. P30, 30H, P34 and 34H
POINT THICKNESS $\frac{1}{32}$ " EXCEPT AS SPECIFIED
TURNED DOWN TIPS DESIGNED FOR IRONS UP TO 60 WATTS.

$\frac{1}{4}$ "

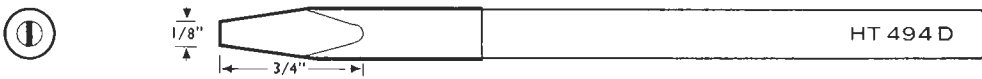
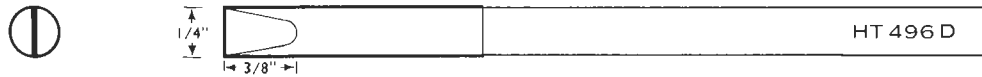
LENGTH $3\frac{3}{4}$ "



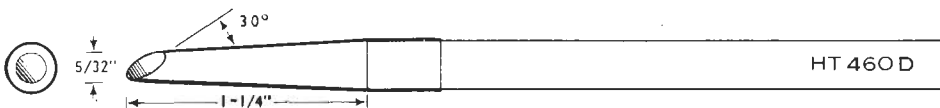
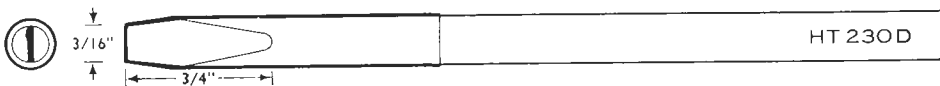
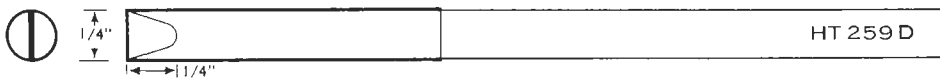
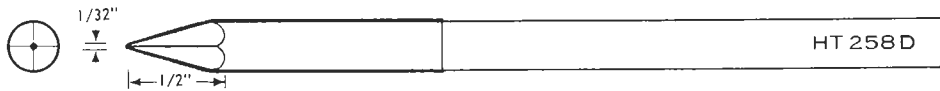
1/4"

FITS NOS. P114, P154 and P214
POINT THICKNESS 1/32" EXCEPT AS SPECIFIED

LENGTH 4"



LENGTH 4 1/4"

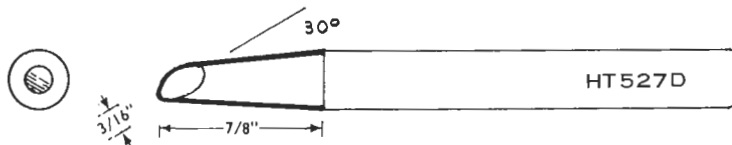
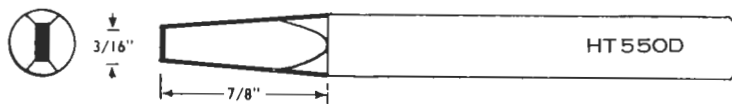
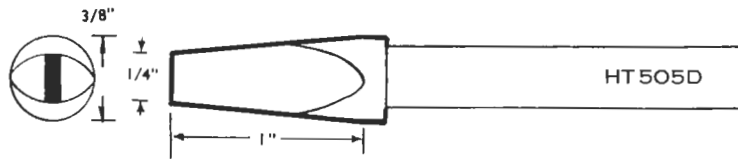




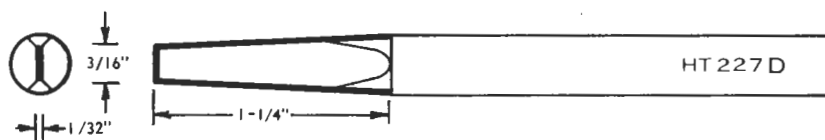
FITS NOS. P35 and 35H
POINT THICKNESS $1/16''$ EXCEPT AS SPECIFIED

$5/16''$

LENGTH 3"



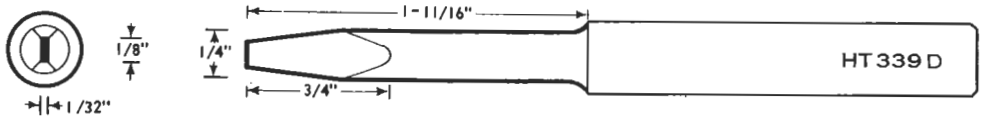
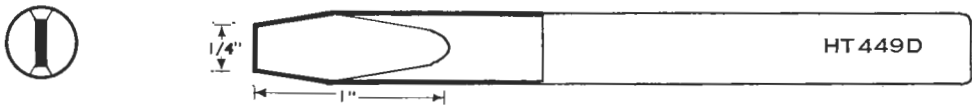
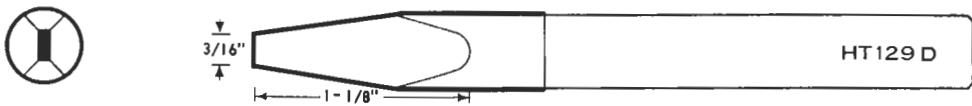
LENGTH 3 1/2"



3/8"

FITS NOS. P70, 70H, P100, 100H, P115, P116
 116H, P150, 150H, P153, 153H, P155, 155H, P238 P338
 POINT THICKNESS 1/16" EXCEPT AS SPECIFIED

LENGTH 3 3/4"

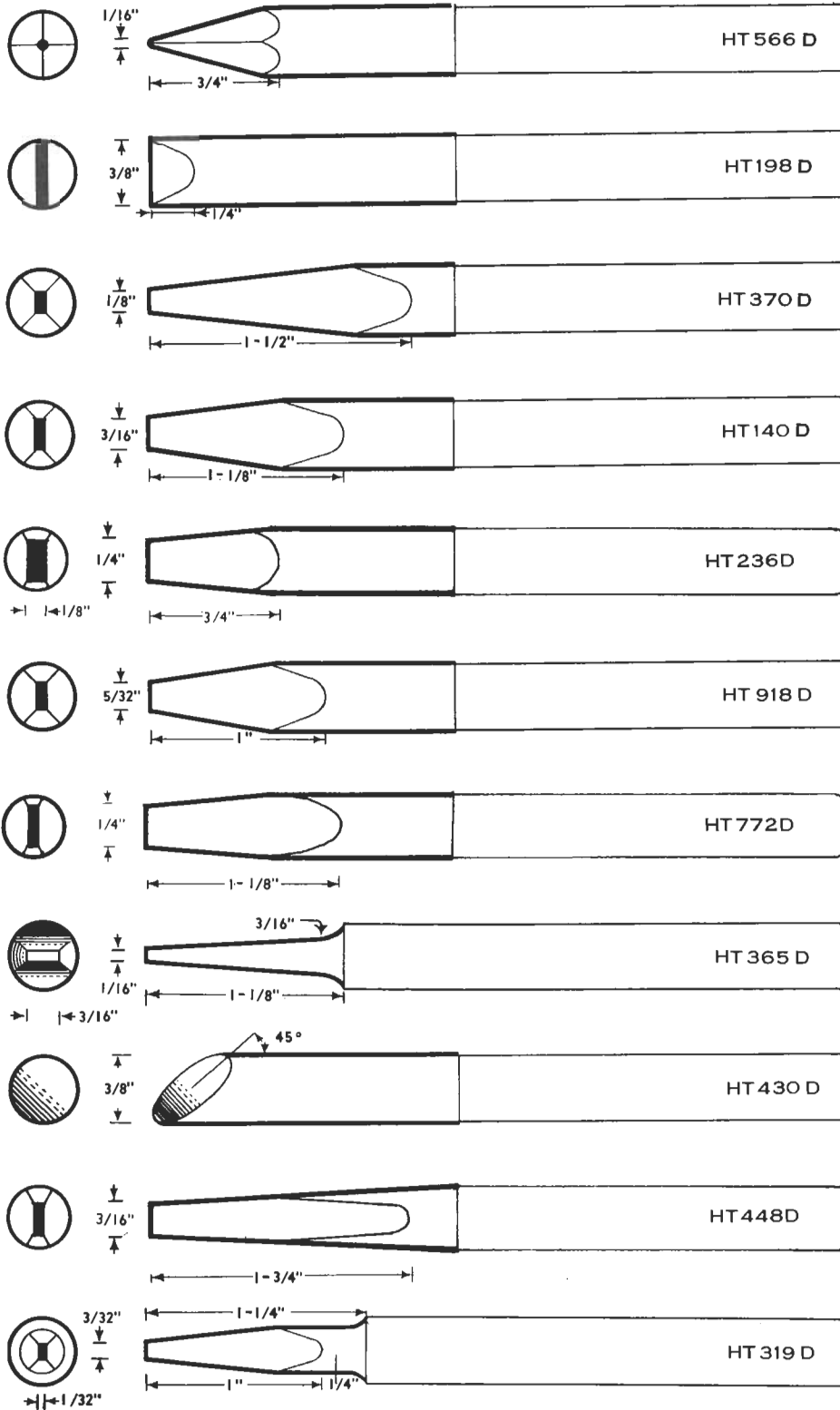




FITS NOS. P70, 70H, P100, 100H, P115, P116
116H, P150, 150H, P153, 153H, P155, 155H, P238, P338
POINT THICKNESS $\frac{1}{16}$ " EXCEPT AS SPECIFIED

$\frac{3}{8}$ "

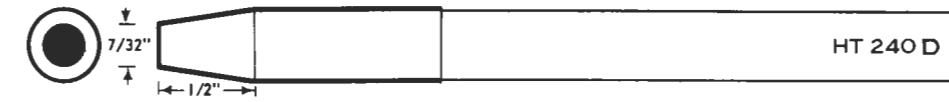
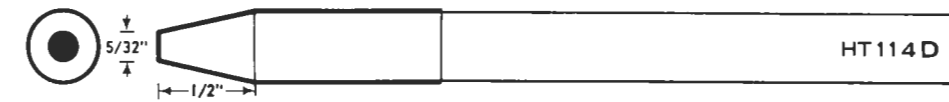
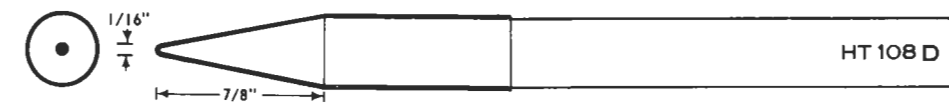
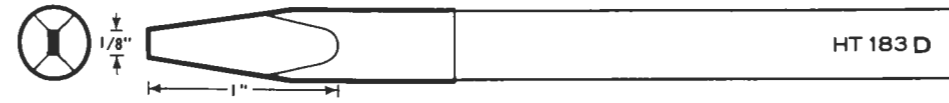
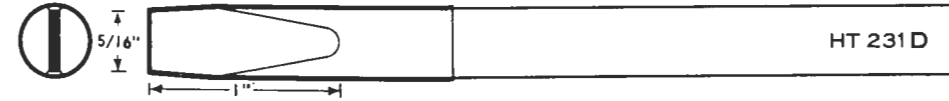
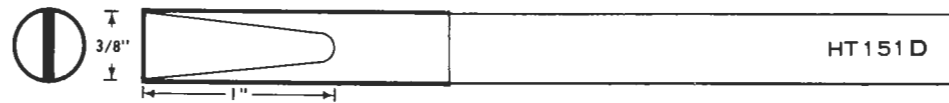
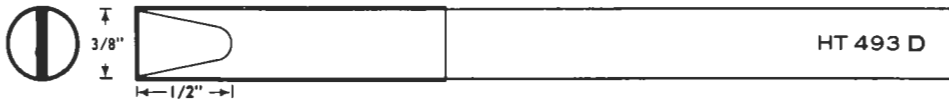
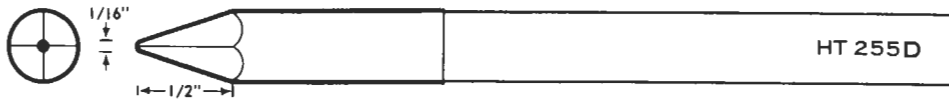
LENGTH 4"



3/8"

FITS NOS. P70, 70H, P100, 100H, P115, P116
116H, P150, 150H, P153, 153H, P155, 155H, P238 P338
POINT THICKNESS 1/16" EXCEPT AS SPECIFIED

LENGTH 4 1/4"

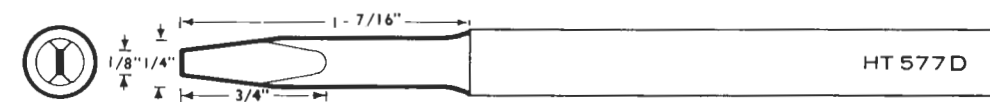
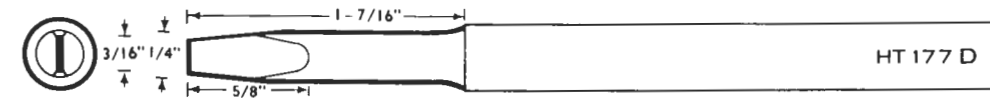
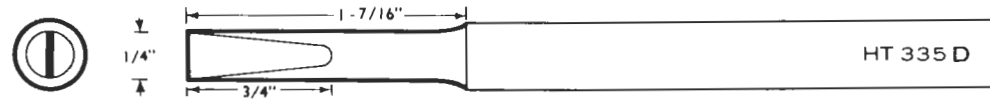
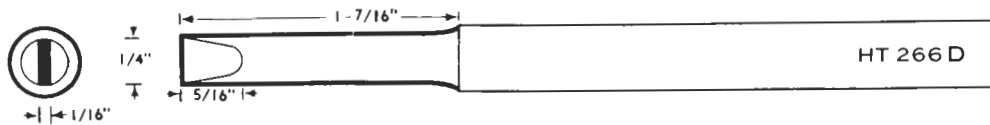
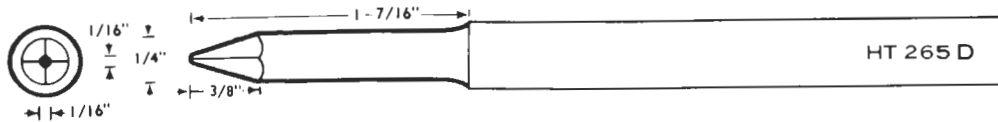
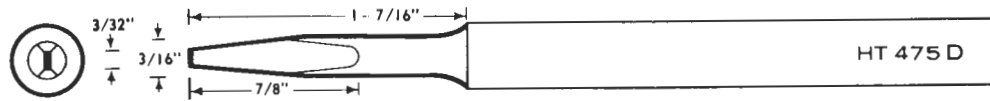
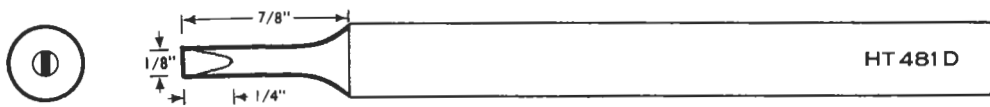
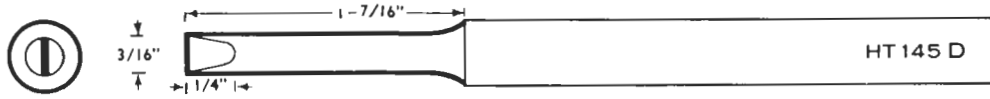




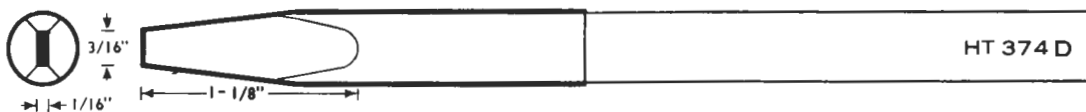
FITS NOS. P70, 70H, P100, 100H, P115, P116
 116H, P150, 150H, P153, 153H, P155, 155H, P238, P338
 POINT THICKNESS $\frac{1}{32}$ " EXCEPT AS SPECIFIED

$\frac{3}{8}$ "

LENGTH $4\frac{1}{4}$ "



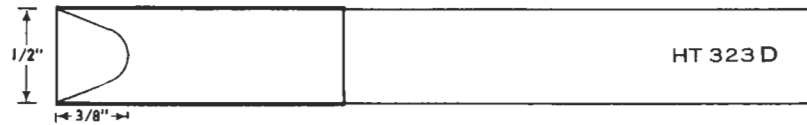
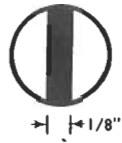
LENGTH 5"



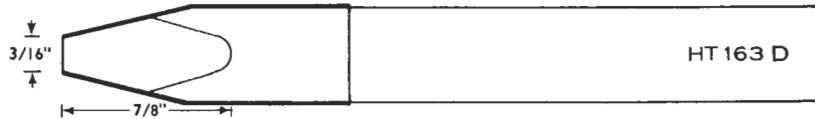
1/2"

FITS NOS. 151H, P151, P152 and P212
POINT THICKNESS 1/16" EXCEPT AS SPECIFIED

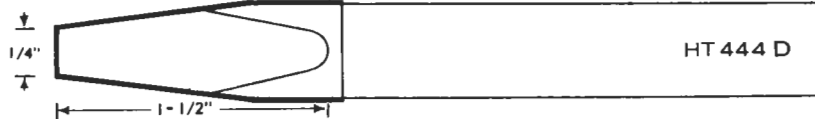
LENGTH 4"



HT 323 D



HT 163 D



HT 444 D



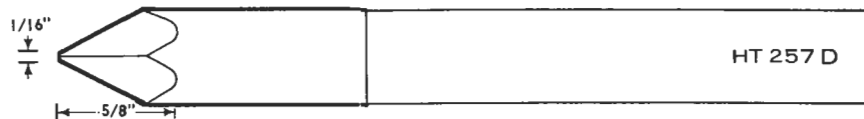
HT 203 D



HT 194 D

1/16" 3/16"

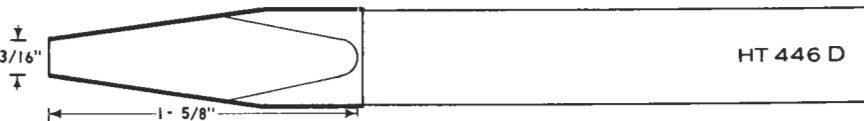
LENGTH 4 1/4"



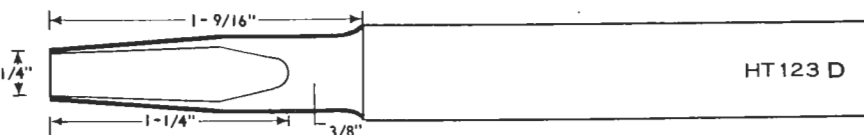
HT 257 D



HT 293 D



HT 446 D



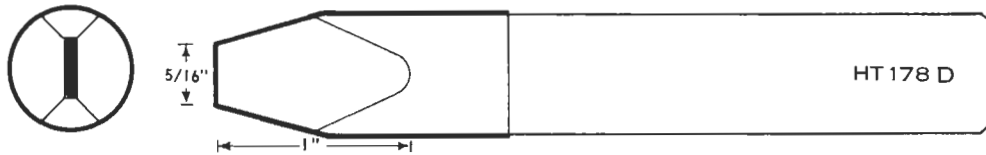
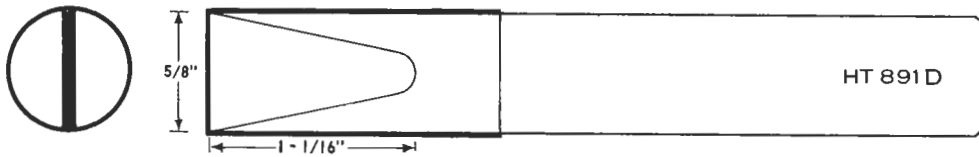
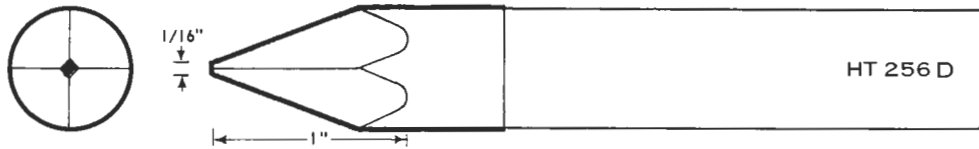
HT 123 D



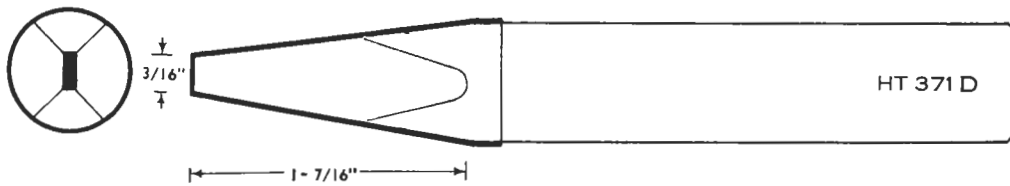
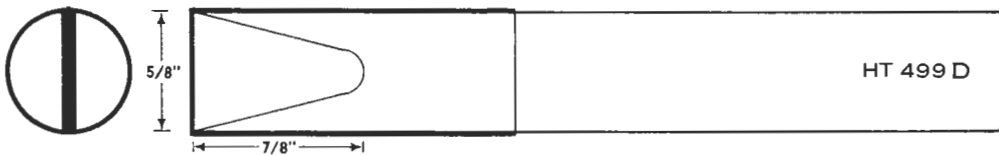
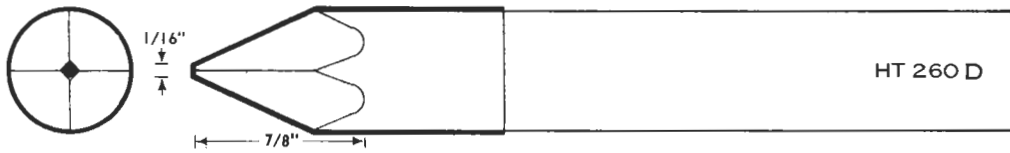
FITS NOS. P200, 200H and P250
POINT THICKNESS $\frac{1}{16}$ " EXCEPT AS SPECIFIED

$\frac{5}{8}$ "

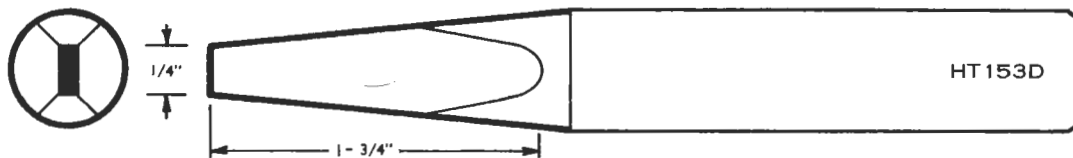
LENGTH 4"



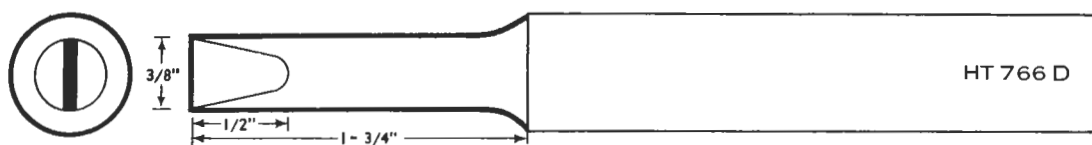
LENGTH 4 $\frac{1}{4}$ "



LENGTH 4 $\frac{1}{2}$ "



LENGTH 4 $\frac{3}{4}$ "



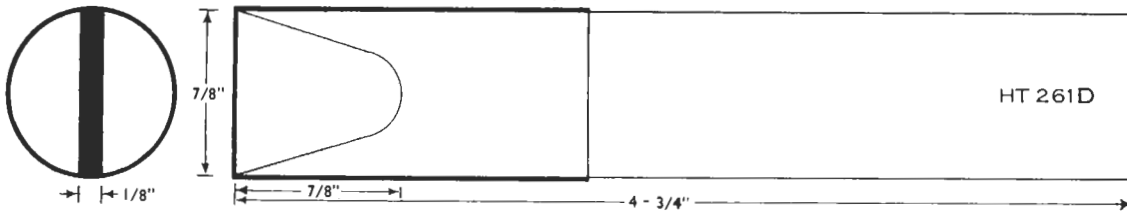
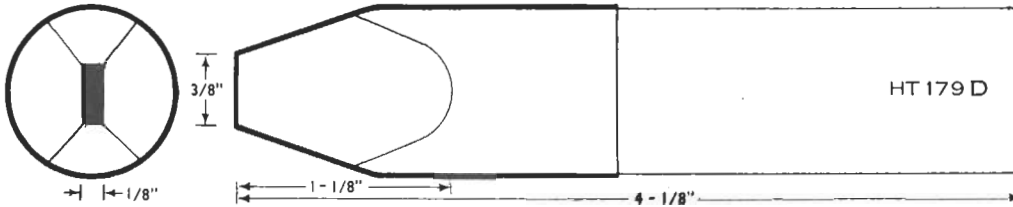
7/8"

FITS NOS. P300 and 300H

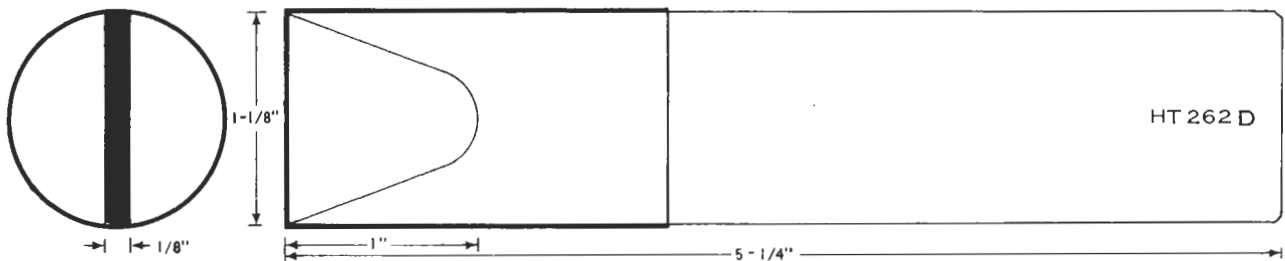
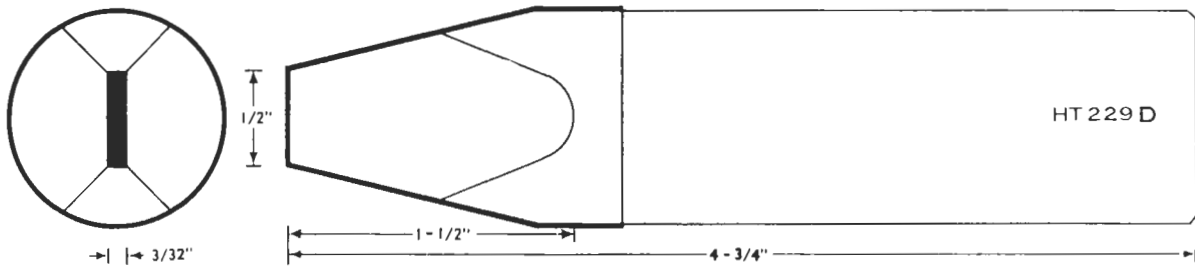
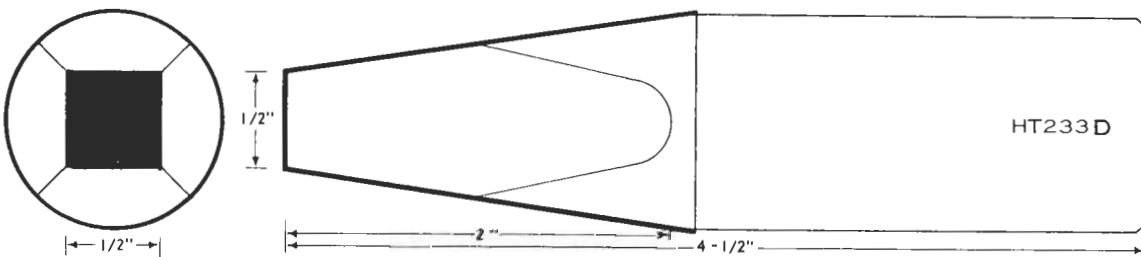
FITS NO P550

1 1/8"

7/8" TIPS



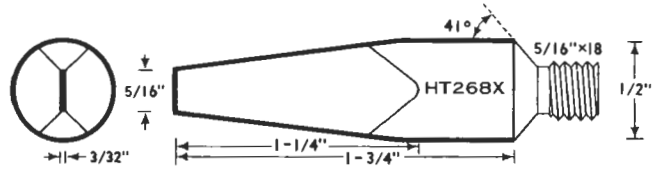
1-1/8" TIPS



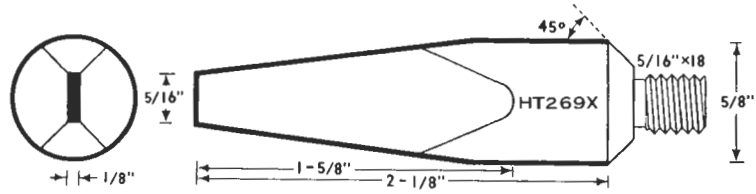


SCREW TYPE TIP

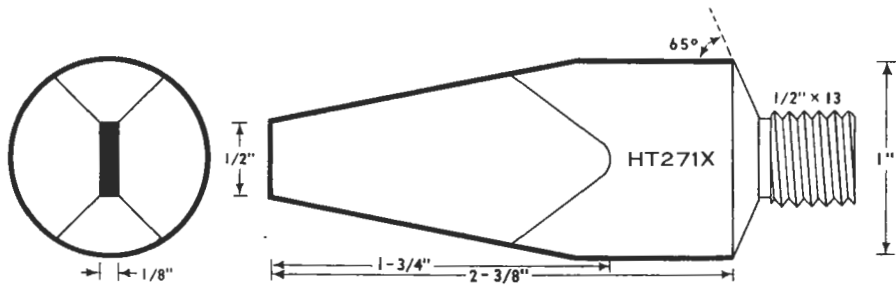
FITS NOS. 60, 85, 120, 170 and 225



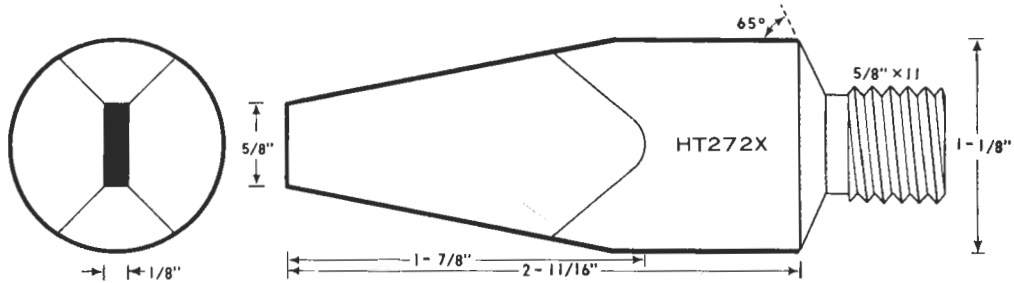
FOR IRONS 60 AND 85



FOR IRON 120



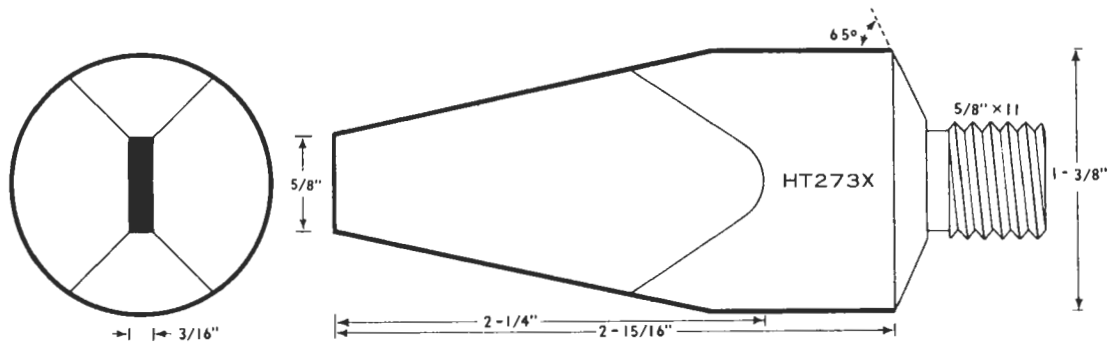
FOR IRON 170



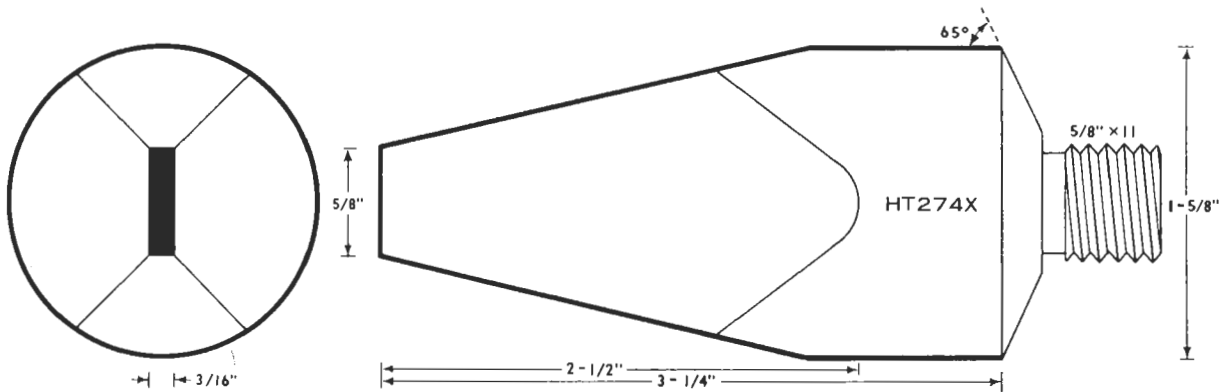
FOR IRON 225

SCREW TYPE TIP

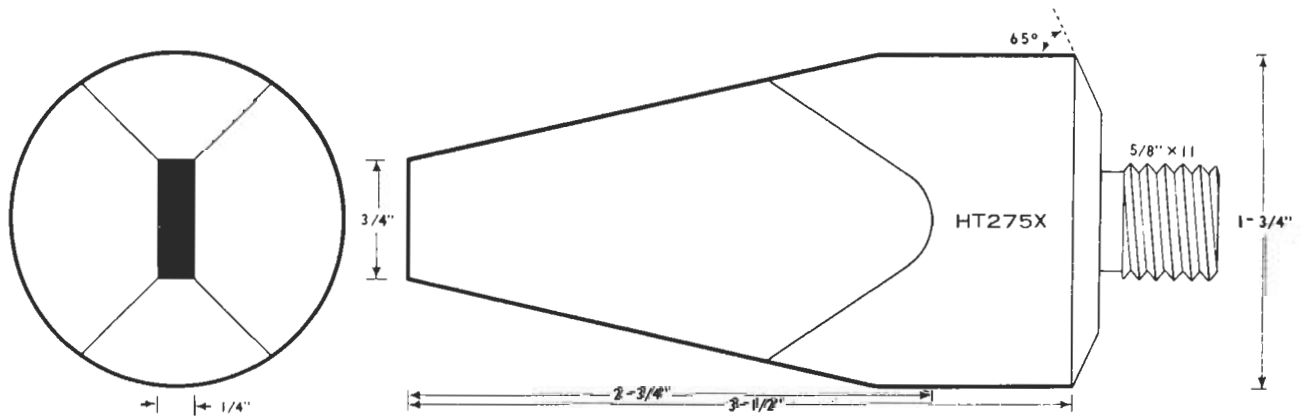
FITS NOS. 350, 500, 700 and 800



FOR IRON 350



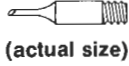
FOR IRON 500



FOR IRONS 700 AND 800



Drawings enlarged
twice actual size
to show detail.



Point thickness 1/32" except as specified.

HORNET TIPS

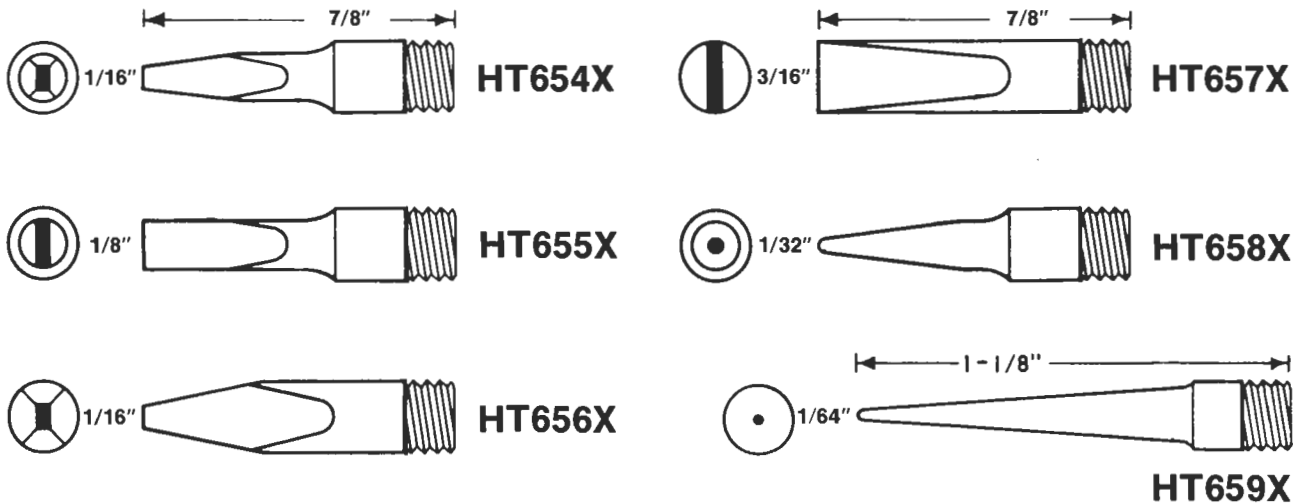
1/8" DIAMETER WITH 6-24 THREADS

FITS NUMBERS H10, H10K, H11, H11K



3/16" DIAMETER WITH 10-24 THREADS

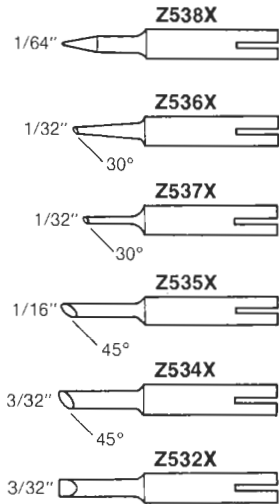
FITS NUMBERS H14, H14K



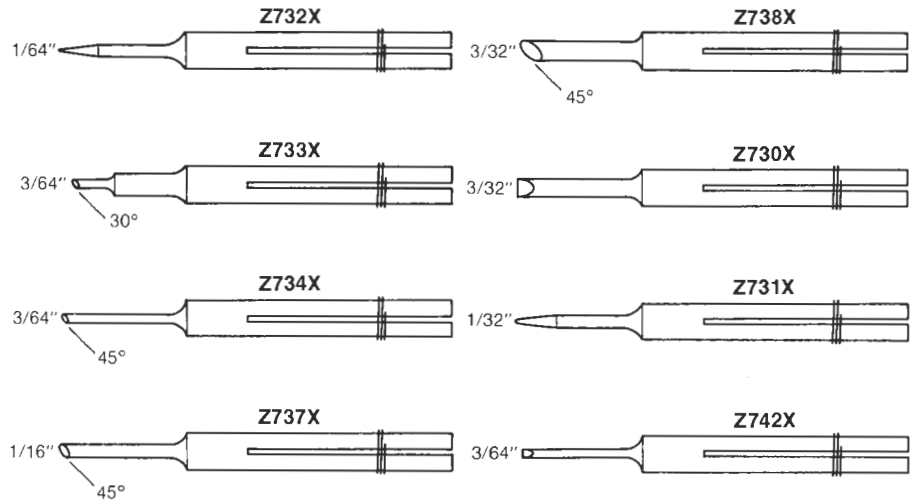
XTRADUR HORNET tips iron and silver plated to improve solderability and protect threads (specify suffix "X").
DUROTHERM tips iron, nickel/chrome plated and tinned to prevent solder from creeping and freezing of threads (specify suffix "D").

SLEEVE TYPE TIPS

5/32" DIAMETER FIT ORYX IRONS



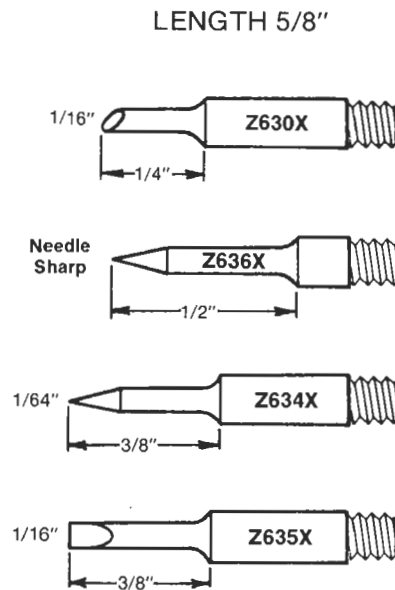
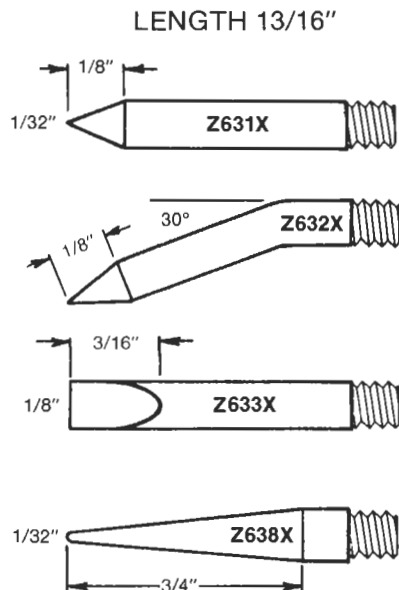
7/32" DIAMETER FIT ANTEX IRONS



5/32" and 7/32" tips also available in plain copper with nickel plating. Order by dropping suffix "X" (example Z731).

SCREW TYPE TIPS

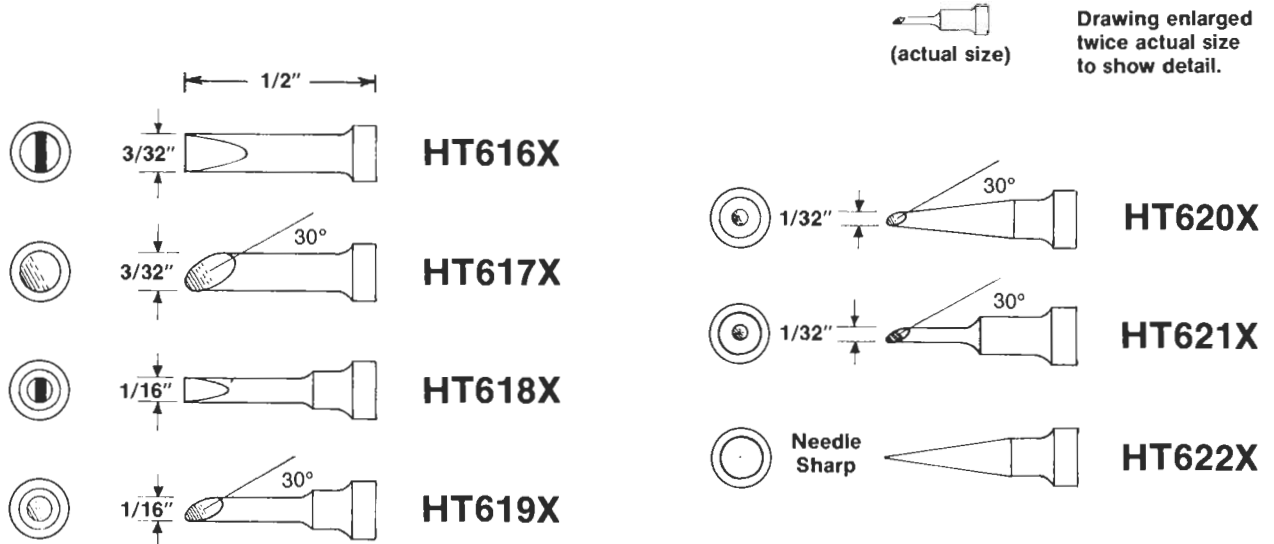
1/8" DIAMETER FIT AMERICAN BEAUTY B2000 AND UNGAR IRONS WITH 6-32 THREADS.





MICRO MINI TIPS

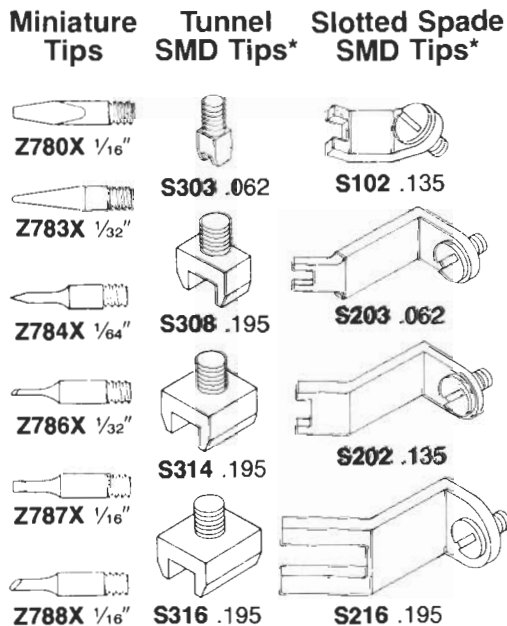
NEW MICRO-MINI IRON FITS NUMBERS M65, M70, M75, AND M85



XTRADUR MICRO-MINI tips iron plated over copper and pre-tinned for long life.
Also available in plain copper for special applications (specify prefix "T").

SMD AND MICRO-STEDI

Fits SMD10, SMDH10, MV15, and MF21

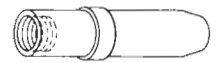


*Slot dimension shown after part number.

SMD Adapters



SS100
Fits Micro-Stedi Series
Adapters available for other irons



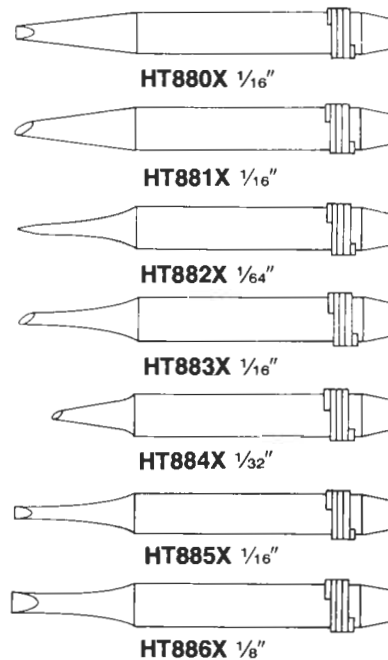
SJ100
Fits Therm-O-Trac



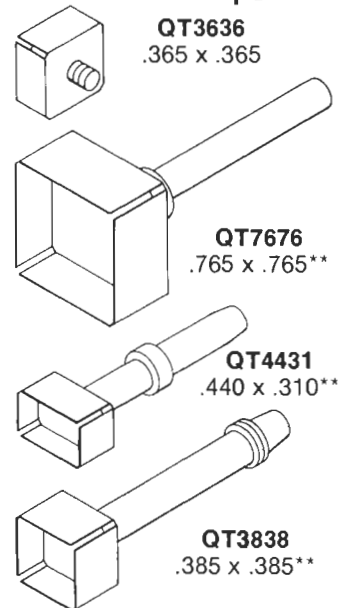
SP100
Fits 3/16" Mini Irons

Micro-Stedi Tips

Fits MS10, MS11, MS14, MS17, MV16, and MF21



Quad-Tips®

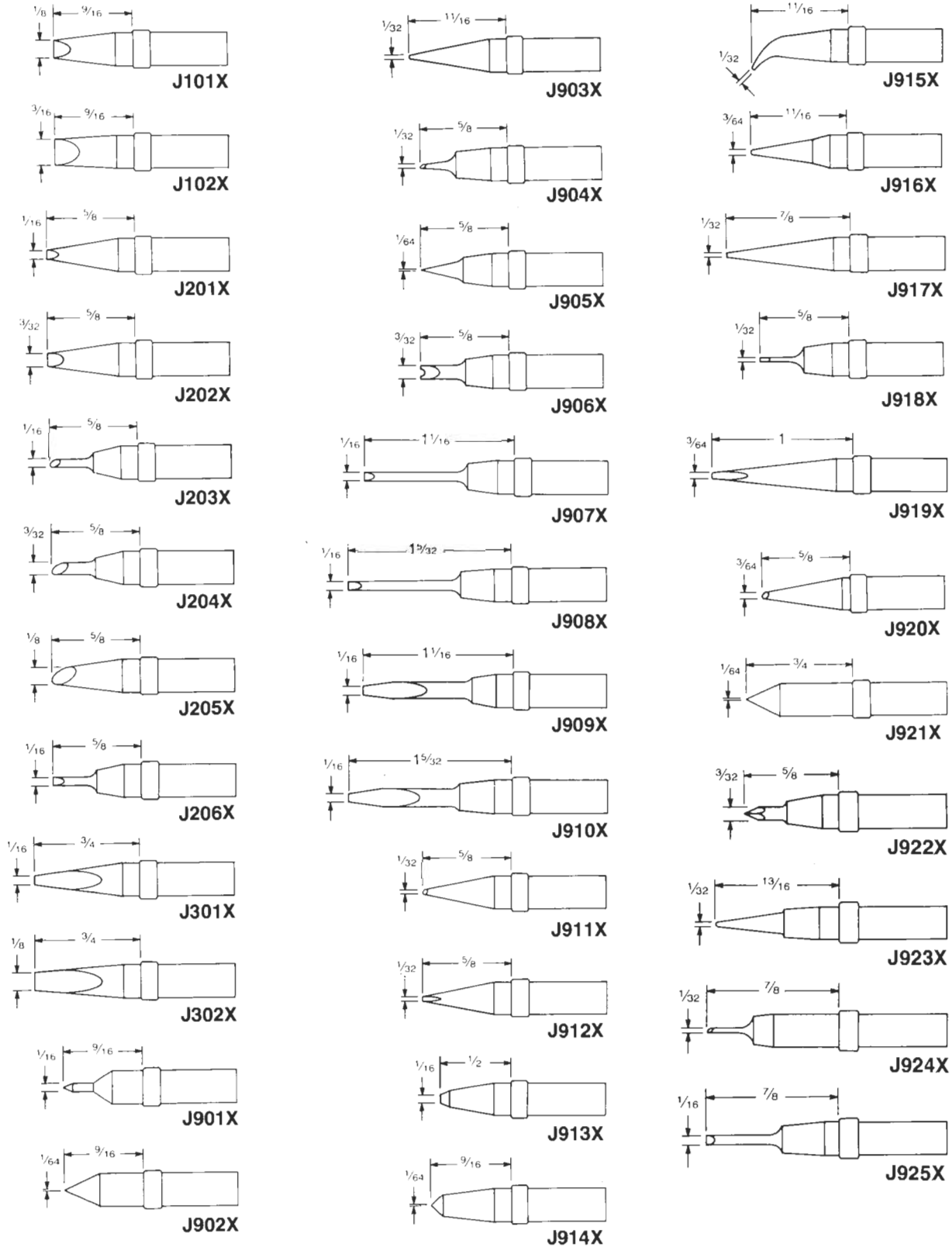


**Tips shown with adapters.
Other Quad -Tips® available to fit standard components.

THERM-O-TRAC TIPS

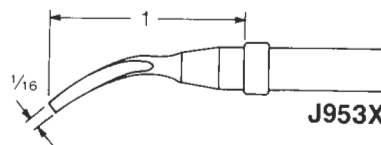
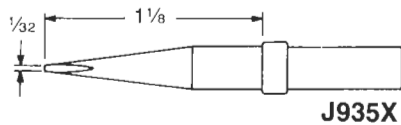
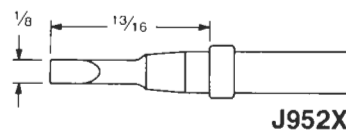
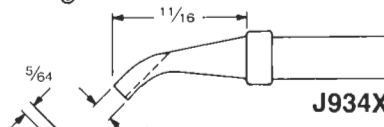
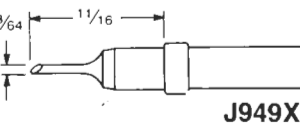
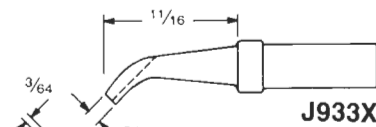
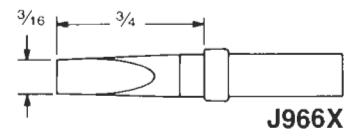
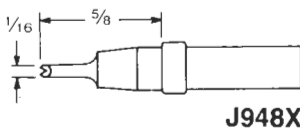
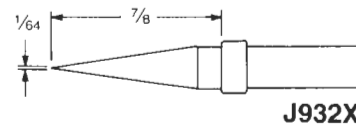
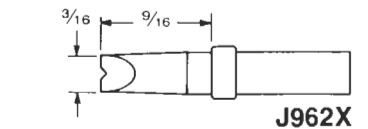
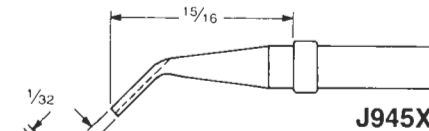
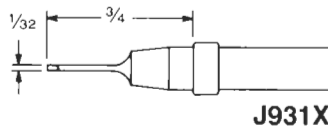
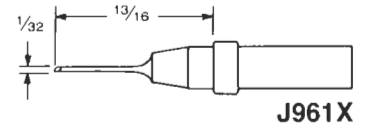
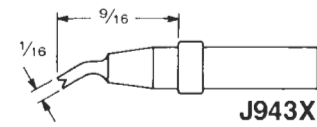
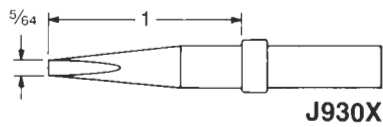
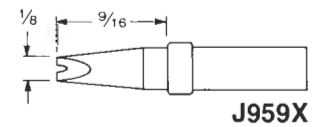
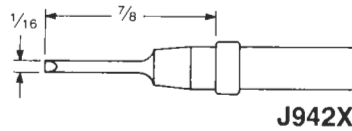
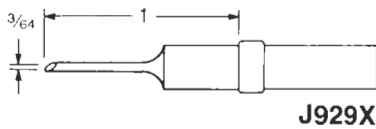
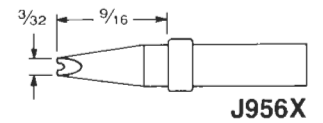
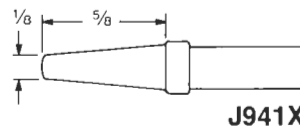
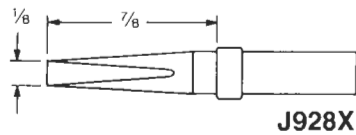
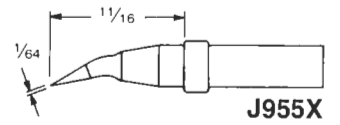
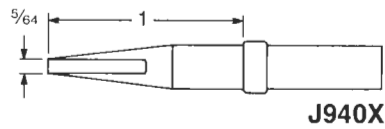
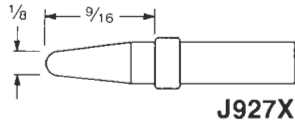
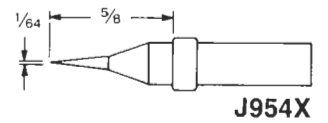
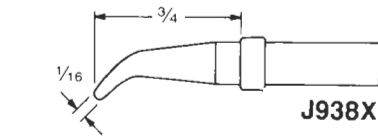
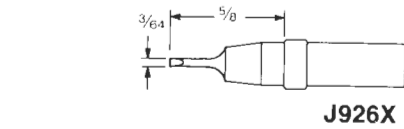
Fits Model 1001, 1002, 1002A, 1003A, 1003B, 1006A, and 1006B

Scale: actual size





THERM-O-TRAC TIPS



Over 80 J Tips Available

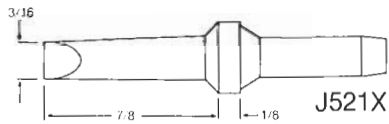
THERM-O-TRAC POWER BOOST TIPS

Fits Model 1002PBS

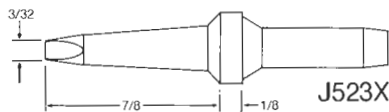
Power Boost Tips Must be Used with Proper Size Power Boost Case Assembly



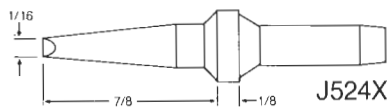
PB5 Case Assembly for J500 Series tips—2-1/2"
 PB6 Case Assembly for J600 Series tips—2-3/4"
 PB7 Case Assembly for J700 Series tips—2-7/8"
 (Standard 1001/1002 Case Assembly TT13 will not fit PB tips)



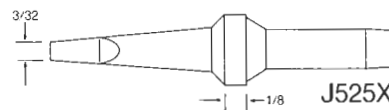
J521X



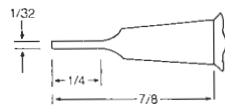
J523X



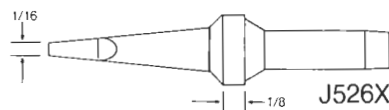
J524X



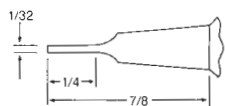
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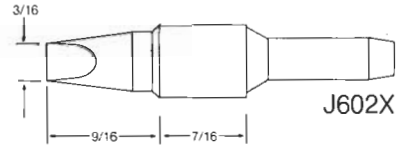
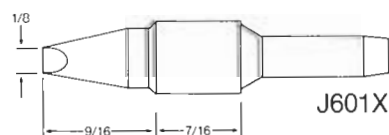
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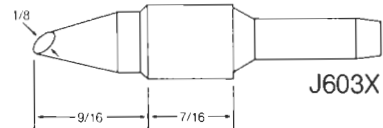
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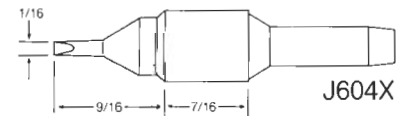
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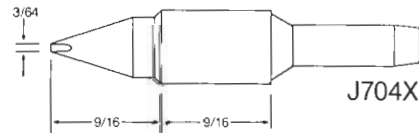
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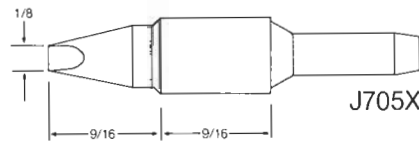
J603X



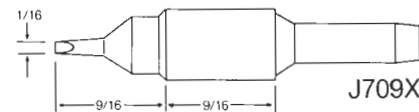
J604X



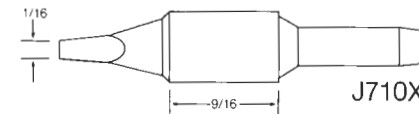
J704X



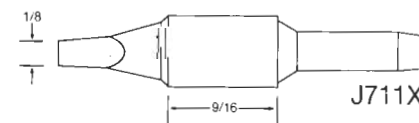
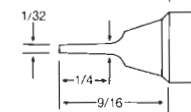
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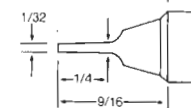
J709X



J710X



J711X





Index

Cat. No.	Dia.	Page	Cat. No.	Dia.	Page	Cat. No.	Dia.	Page	Cat. No.	Dia.	Page
PLUG TIPS											
HT102D	1/4	8	HT263D	1/4	9	HT468D	1/4	10	HT918D	3/8	15
HT104D	1/8	6	HT264D	1/4	9	HT470D	3/8	14	HT944D	1/8	6
HT105D	3/16	7	HT265D	3/8	17	HT472D	3/8	14	HT983D	3/16	7
HT106D	3/16	7	HT266D	3/8	17	HT473D	1/4	9	THREADED TIPS		
HT107D	3/16	7	HT276D	3/16	7	HT474D	3/16	7	HT268X	1/2	21
HT108D	3/8	16	HT277D	1/4	11	HT475D	3/8	17	HT269X	5/8	21
HT110D	3/16	7	HT281D	3/16	7	HT477D	1/8	6	HT271X	1	21
HT113D	3/16	7	HT283D	1/8	6	HT479D	3/16	7	HT272X	1-1/8	21
HT114D	3/8	16	HT288D	3/16	7	HT481D	3/8	17	HT273X	1-3/8	22
HT117D	3/8	14	HT290D	3/16	7	HT487D	1/4	10	HT274X	1-5/8	22
HT118D	3/16	7	HT291D	3/8	14	HT488D	3/8	14	HT275X	1-3/4	22
HT123D	1/2	18	HT293D	1/2	18	HT493D	3/8	16	HT654X	3/16	23
HT129D	3/8	14	HT294D	3/16	7	HT494D	1/4	12	HT655X	3/16	23
HT130D	1/4	9	HT299D	1/4	10	HT495D	1/4	12	HT656X	3/16	23
HT131D	1/4	9	HT311D	3/16	7	HT496D	1/4	12	HT657X	3/16	23
HT140D	3/8	15	HT313D	1/4	8	HT499D	5/8	19	HT658X	3/16	23
HT141D	3/16	7	HT319D	3/8	15	HT505D	5/16	13	HT659X	3/16	23
HT144D	3/16	7	HT323D	1/2	17	HT506D	5/16	13	HT864X	1/8	23
HT145D	3/8	17	HT324D	1/4	8	HT510D	3/8	14	HT866X	1/8	23
HT151D	3/8	16	HT325D	1/4	8	HT511D	1/8	6	HT867X	1/8	23
HT153D	5/8	19	HT327D	1/8	6	HT513D	1/4	8	HT868X	1/8	23
HT157D	1/4	8	HT328D	1/4	10	HT519D	1/4	10	HT869X	1/8	23
HT159D	1/4	8	HT331D	1/8	6	HT527D	5/16	13	HT870X	1/8	23
HT163D	1/2	18	HT335D	3/8	17	HT547D	5/16	13	HT871X	1/8	23
HT177D	3/8	17	HT339D	3/8	14	HT548D	3/16	7	HT873X	1/8	23
HT178D	5/8	19	HT343D	1/4	8	HT550D	5/16	13	Z630X	1/8	24
HT179D	7/8	20	HT349D	1/4	8	HT552D	1/4	8	Z631X	1/8	24
HT183D	3/8	16	HT351D	1/4	8	HT553D	1/4	8	Z632X	1/8	24
HT188D	1/4	11	HT356D	1/4	9	HT556D	5/16	13	Z633X	1/8	24
HT190D	3/16	7	HT357D	1/4	8	HT560D	1/8	6	Z634X	1/8	24
HT194D	1/2	18	HT358D	1/4	8	HT563D	1/4	11	Z635X	1/8	24
HT195D	3/16	7	HT359D	1/4	8	HT566D	3/8	15	Z636X	1/8	24
HT198D	3/8	15	HT361D	1/8	6	HT577D	3/8	17	Z638X	1/8	24
HT202D	1/4	9	HT362D	1/4	10	HT583D	3/16	7	Z780X	1/8	25
HT203D	1/2	18	HT365D	3/8	15	HT586D	1/4	8	Z783X	1/8	25
HT207D	3/16	7	HT370D	3/8	15	HT593D	3/8	16	Z784X	1/8	25
HT208D	1/8	6	HT371D	5/8	19	HT603D	1/4	11	Z786X	1/8	25
HT214D	3/16	7	HT374D	3/8	17	HT609D	1/8	6	Z787X	1/8	25
HT216D	1/8	6	HT376D	1/8	6	HT610D	1/8	6	Z788X	1/8	25
HT220D	3/16	7	HT379D	1/4	9	HT616X	3/32	25	SLEEVE TIPS		
HT222D	1/8	6	HT382D	1/4	11	HT617X	3/32	25	Z532X	5/32	24
HT227D	5/16	13	HT391D	1/4	11	HT618X	3/32	25	Z534X	5/32	24
HT229D	1-1/8	20	HT392D	3/16	7	HT619X	3/32	25	Z535X	5/32	24
HT230D	1/4	12	HT397D	1/4	8	HT620X	3/32	25	Z536X	5/32	24
HT231D	3/8	16	HT399D	1/4	8	HT621X	3/32	25	Z537X	5/32	24
HT233D	1-1/8	20	HT409D	1/4	9	HT622X	3/32	25	Z538X	5/32	24
HT234D	1/4	10	HT413D	1/4	10	HT626D	1/4	11	Z730X	7/32	24
HT235D	1/8	6	HT417D	1/4	8	HT638D	1/8	6	Z731X	7/32	24
HT236D	3/8	15	HT418D	1/4	8	HT667D	1/8	6	Z732X	7/32	24
HT240D	3/8	16	HT423D	3/16	7	HT685D	1/4	9	Z733X	7/32	24
HT244D	1/8	6	HT426D	1/4	9	HT691D	1/4	8	Z734X	7/32	24
HT248D	1/8	6	HT430D	3/8	15	HT692D	1/4	9	Z737X	7/32	24
HT249D	1/8	6	HT438D	1/4	9	HT693D	1/8	6	Z738X	7/32	24
HT251D	3/16	7	HT441D	1/4	9	HT698D	1/4	11	HT880X	7/32	25
HT252D	1/4	9	HT444D	1/2	18	HT699D	1/4	8	HT881X	7/32	25
HT253D	1/4	9	HT446D	1/2	18	HT708D	1/4	10	HT882X	7/32	25
HT254D	3/8	14	HT448D	3/8	15	HT723D	1/8	6	HT883X	7/32	25
HT255D	3/8	16	HT449D	3/8	14	HT753D	1/4	9	HT884X	7/32	25
HT256D	5/8	19	HT451D	1/4	8	HT766D	5/8	19	HT885X	7/32	25
HT257D	1/2	18	HT452D	1/4	9	HT772D	3/8	15	HT886X	7/32	25
HT258D	1/4	12	HT453D	1/4	10	HT773D	1/4	9			
HT259D	1/4	12	HT460D	1/4	12	HT841D	1/4	9			
HT260D	5/8	19	HT461D	1/4	9	HT891D	5/8	19			
HT261D	7/8	20	HT463D	1/4	8	HT892D	3/16	7			
HT262D	1-1/8	20	HT466D	1/4	9						

Index

(Continued)

Cat. No.	Slot Dim.	Page	Cat. No.	Slot Dim.	Page
SMD TIPS					
S102	.135	25	J907X	1/16	26
S202	.135	25	J908X	1/16	26
S203	.062	25	J909X	1/16	26
S216	.195	25	J910X	1/16	26
S303	.062	25	J911X	1/32	26
S308	.195	25	J912X	1/32	26
S314	.195	25	J913X	1/16	26
S316	.195	25	J914X	1/64	26
SJ100	Adapter	25	J915X	1/32	26
SP100	Adapter	25	J916X	3/64	26
SS100	Adapter	25	J917X	1/32	26
QUAD TIPS					
QT3636	.365 x .365	25	J918X	1/32	26
QT3838	.765 x .765	25	J919X	3/64	26
QT4431	.440 x .310	25	J920X	3/64	26
QT7676	.385 x .385	25	J921X	1/64	26
THERM-O-TRAC TIPS					
J101X	1/8	26	J922X	3/32	26
J102X	3/16	26	J923X	1/32	26
J201X	1/16	26	J924X	1/32	26
J202X	3/32	26	J925X	1/16	26
J203X	1/16	26	J926X	3/64	27
J204X	3/32	26	J927X	1/8	27
J205X	1/8	26	J928X	1/8	27
J206X	1/16	26	J929X	3/64	27
J301X	1/16	26	J930X	5/64	27
J302X	1/8	26	J931X	1/32	27
J521X	3/16	28	J932X	1/64	27
J523X	3/32	28	J933X	5/64	27
J524X	1/16	28	J934X	1/8	27
J525X	3/32	28	J935X	1/32	27
J526X	1/16	28	J938X	1/16	27
J601X	1/8	28	J940X	5/64	27
J602X	3/16	28	J941X	1/8	27
J603X	1/8	28	J942X	1/16	27
J604X	1/16	28	J943X	1/16	27
J704X	3/64	28	J945X	1/16	27
J705X	1/8	28	J948X	1/16	27
J709X	1/16	28	J949X	3/64	27
J710X	1/16	28	J952X	1/8	27
J711X	1/8	28	J953X	1/16	27
J901X	1/16	26	J954X	1/64	27
J902X	1/64	26	J955X	1/64	27
J903X	1/32	26	J956X	3/32	27
J904X	1/32	26	J959X	1/8	27
J905X	1/64	26	J961X	1/32	27
J906X	3/32	26	J962X	3/16	27
			J966X	3/16	27



Use and Care of Hexacon Soldering Tips

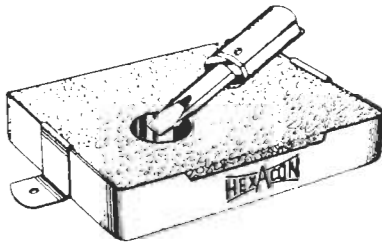
DUROTHERM and XTRADUR tips are furnished factory tinned ready for use. These iron clad tips will not become oxidized (de-tinned) if certain precautions are taken:

1. Keep the working surface tinned at all times.
2. Keep excess solder on the tip during prolonged idling periods.
3. Keep flux residues and plastic wire residues from accumulating on tip.
4. Keep solder impurities and flux voids out of the operation.

The following steps are recommended for retinning oxidized tips:

1. When using iron to retin, heat tip just hot enough to melt and clean on a wringing wet cellulose sponge.
2. Flux dip the clean tip and retin using large diameter high tin solder.
3. If a solder pot is available, flux dip the clean tip and retin by immersing in molten solder.

Never file or break coating because the copper base will then become exposed and wear like plain copper tip. Use good soldering tip practices such as removing the tip frequently to prevent sticking and keeping the tip fully inserted in the iron at all times.



TIP CLEANING SPONGE IN METAL TRAY—Insures reliability of soldered joints and extends tip life. Eliminates contamination caused by wiping rags. Pure cellulose sponge contains no harmful acids.

- Sponge in Metal Tray (3" x 4" Solid) ... No. 810
- Sponge only (3" x 4") No. 8101
- Sponge with hole (3" x 4") No. 8121
- Sponge in Plastic Tray (2" x 3") No. 814
- Sponge only (2" x 3") No. 8141

Hexacon Tip Cleaning Sponge

This new product has been introduced to fill the need in the electronics industry for a better material for cleaning long-life soldering iron tips. Many materials have been used to clean tips but none has all the advantages of the HEXACON TIP SPONGE. Wire brushes, steel wool and abrasive cloths of paper will wear away the tip and cannot be used when tip is at full heat.

Wiping rags (no matter how lint-free) will deposit carbon from singed fibers on the tip surface which will dewet the tip. Rags will often contain traces of oil which will also prevent adhesion of tin on tip. Wiping with any dry material will also remove all solder from tip exposing clean iron surface to oxidation making retinning impossible without cooling and recleaning. A moist HEXACON TIP SPONGE will efficiently remove all burned flux and solder residue from the tinned working surface of the tip without removing all the solder. This makes retinning easy without cooling the tip or recleaning.

The HEXACON TIP SPONGE is PURE CELLULOSE with LOW SULPHUR RESIDUE, NO ACID RESIDUE, and NO PLASTICIZER OILS. It is custom made for tip cleaning and contains no traces of acid which might be transferred to the tip and joint causing corrosion and failure of a critical connection. This special material is TEAR RESISTANT and has a fine porosity which makes it especially suitable for smaller diameter tips which could not readily be cleaned with coarse porosity, large hole type sponges. Because of its composition, the HEXACON TIP SPONGE holds more water making it easier to keep the sponge wet enough to be most efficient.

An aluminum alloy or plastic tray is provided which helps contain sufficient water to keep the sponge "wringing wet" without spilling water on the working area. The sponge should be kept wet enough so that there is no scorching when a tip is wiped across the surface. This normally requires refilling twice a day—early morning and again after lunch.

A large enough sponge surface is provided to clean effectively both large and small tips. When burned flux or solder residue

transferred from the tip covers the entire surface, the sponge should be rinsed in water. This prevents further contamination of the tip and connection by transfer of residues from the sponge.

Proper use of the HEXACON TIP SPONGE will give long and economical service. It is by far the most effective, fastest and neatest method for cleaning tips and helps to extend tip life by means of making abrasive cleaning unnecessary. A light, quick stroke of the tip across the wringing wet surface will do as much cleaning as several heavy strokes and this will also prevent burning of the sponge surface.

Do not overwipe tips. Remove only burned oxide residues. Under no circumstances should tips be wiped dry. A thin, bright coating of solder should always remain on working surface to provide path for conduction of heat to joint. If surface is dull or darkened it means that the tip has been wiped too much. It is good practice to flush tip surface with fresh solder after wiping on sponge. It is essential to *apply fresh solder before laying iron in rest stand* for any prolonged period of idle time.



.. and **READ!**

- Take good care of your tip sponge**
- Keep soaking wet — Don't scorch**
- Clean daily — Rinse in cold water**
- Don't let residue accumulate**
- Wipe tip lightly — Don't scrub!**



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