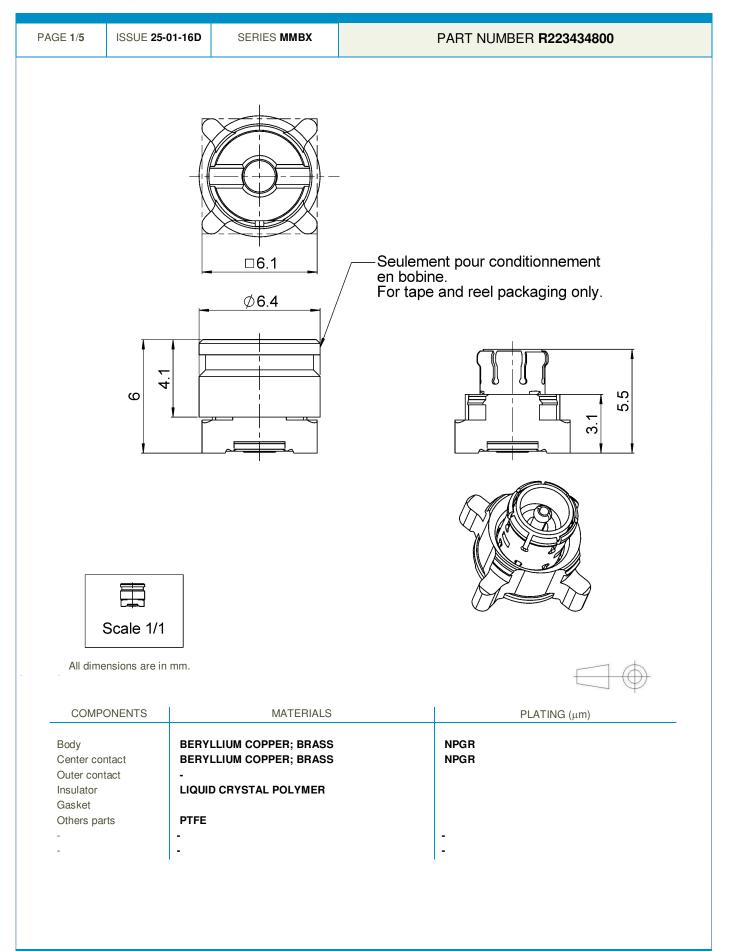
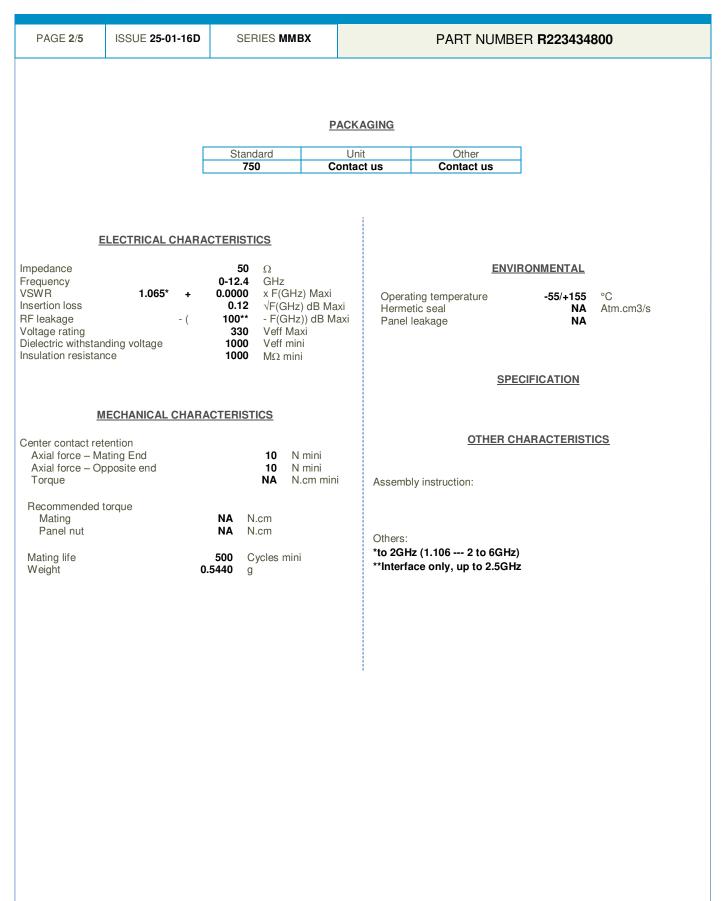
SMT PLUG RECEPTACLE REEL OF 750







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SERIES MMBX

PART NUMBER **R223434800** 

# SOLDER PROCEDURE OF MMBX RECEPTACLE IN INDUSTRIAL ENVIRONMENT

1. Deposit solder paste 'SnAg4Cu0.5' on mounting zone by screen printing application. We recommend a low residue flux.

We advise a thickness of 150 micromm ( 5.850 microinch ). Verify that the edges of the zone are clean.

2. Placement of the receptacle on the mounting zone with an automatic machine of 'pick and place' type.

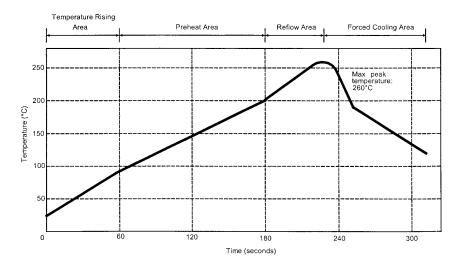
A video camera is recommended for positioning of the component.

Adhesive agents must not be used on the receptacle.

3. This process of soldering has been tested with convection oven. Below please find, the typical profile to use.

- 4. The cleaning of printed circuit boards is not obliged.
- 5. Verification of solder joints and position of the component by visual inspection.

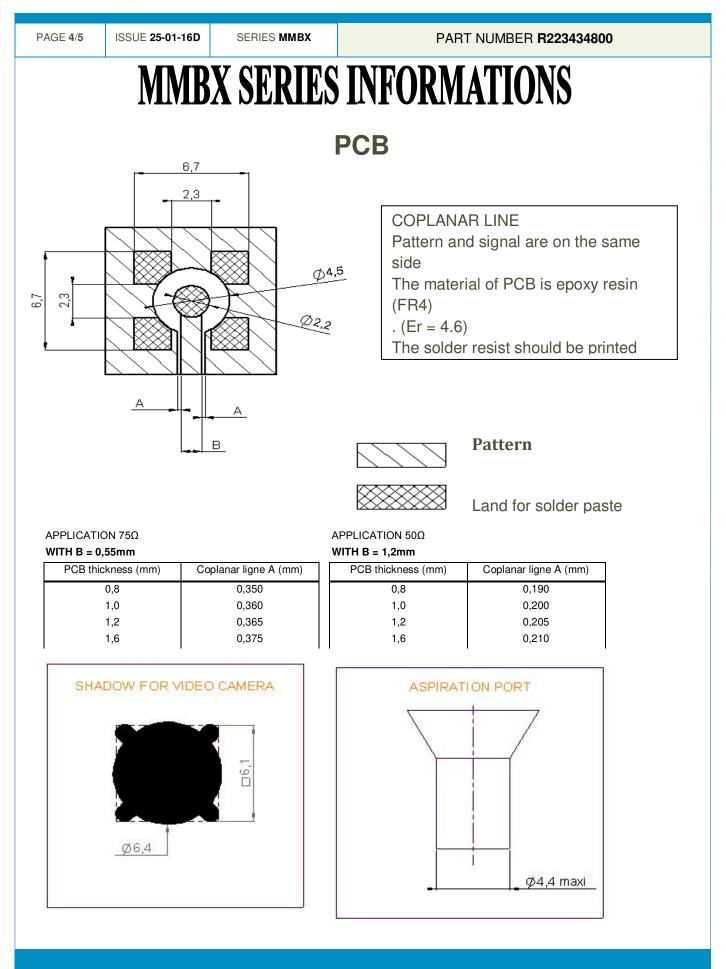
## **TEMPERATURE PROFILE**



Parameter	Value	Unit
Temperature rising Area	1 - 4	°C/sec
Max Peak Temperature	260	°C
Max dwell time @260°C	10	Sec
Min dwell time @235°C	20	Sec
Max dwell time @235°C	60	Sec
Temperature drop in cooling Area	-1 to - 4	°C/sec
Max dwell time above 100°C	420	Sec

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