

# Soldering instructions for hand soldering

The PCB mount contact blocks of Georg Schlegel GmbH & Co. KG are high-quality products and are subject to strict quality controls. In order to guarantee a reproducible quality, please respect the following instructions.

## Note

Hand soldering may only be done by trained and skilled staff. During the soldering process any mechanical load by the soldering device to the connecting pins has to be avoided. Component parts which have been stocked for a longer period can be post-treated in assembled condition with fluxing agents for soft solders.

## Soldering temperature and time

The soldering temperatures and the relating soldering times have to be kept in order to ensure a reliable function of the contact blocks.

Electronic contact blocks with snap action and PCB-mount terminals

Series C...

Maximum soldering temperature            360°C

Maximum soldering time                      2 seconds

Electromechanical contact blocks with PCB-mount terminals

Series A..., B... and PCT...

Maximum soldering temperature            380°C

Maximum soldering time                      3-4 seconds

## Solder

For the process of hand soldering a lead-free solder for electronic of Ø 0.5 mm up to 1 mm and a melting temperature of 217°C up to 227°C has to be used.

A solder in the composition Sn95.5Ag3.8Cu0.7 is recommended.

Attention:

- It must be ensured that no media enter the interior of the contact during cleaning or during soldering.
- C... contacts with Faston terminals 2.8x0.8mm are not suitable for hand soldering

Further details on request.

