

GENERAL NOTES: RF CONNECTOR SOLDERING GUIDE

CD 0018

The following is only a Guide.

Extra care must be exercised with Epoxy sealed connectors to ensure the seal is not compromised by any soldering process.

Typically, the solder supplier will provide a recommended profile for use with their paste and preforms. A specific profile used for the assembly will depend on the reflow furnace capabilities and the thermal mass going through the furnace.

In all cases, the profile must be optimized for the specific PCB assemblies based on parameters such as total thermal mass going through the furnace, furnace capabilities, temperature restrictions for key components, and size of the PCB.

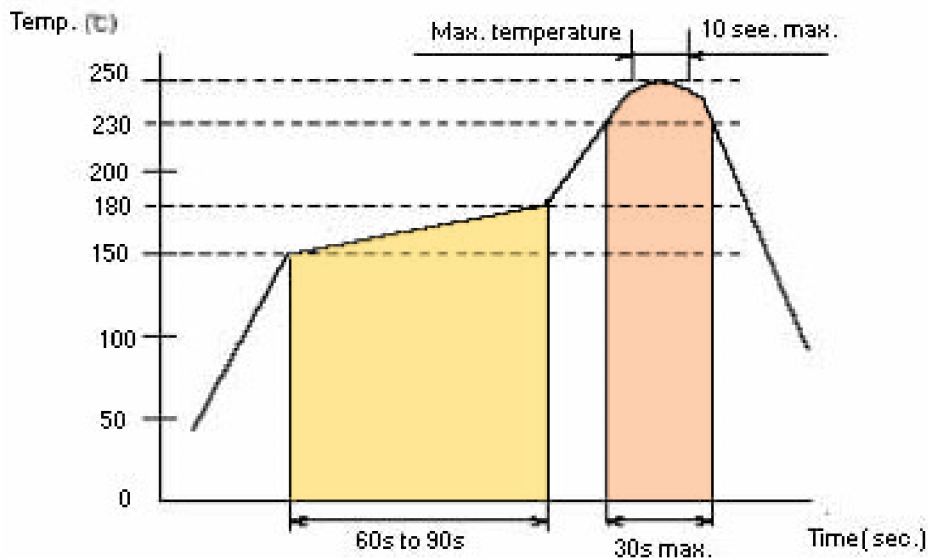
Soldering must be carried out without exceeding the allowable temperature and time as shown in the chart below.

In case of repeat soldering. The component should be cooled down. or reduce the max. temperature time.

For hand soldering, the following procedure is recommended.

- Pre-heating: 150°C for 60-120 seconds.
- Soldering 350°C (at the tip of soldering iron) for 2 seconds.

Flux should be completely cleaned from all the solder joints to prevent possible reduction in the connectors performance.



A4	SHEET 1 OF 1	DIMENSIONS ARE IN MILLIMETRES		
REVISION :	A00	NAME	SIGNATURE	DATE
ISSUE :	1	DRAWN	G.E.	28/11/2023
6-8 COLNE ROAD, TWICKENHAM, MIDDLESEX. TW1 4JR		CHK'D	P.S.	28/11/2023
		APPV'D		
<small>THE INFORMATION IS GIVEN AS AN INDICATION ONLY AND IS SUBJECT TO CHANGE WITHOUT NOTICE. IN THE CONTINUAL GOAL TO IMPROVE OUR PRODUCTS, WE RESERVE THE RIGHT TO MAKE ANY MODIFICATIONS NECESSARY WITHOUT PRIOR NOTICE.</small>				