



## SHADOW OF QN RECEPTACLE FOR VIDEO CAMERA



## R164.501.023

Series: QN

## SOLDER PROCEDURE

1. Deposit solder paste ' Sn Ag 4 Cu 0.5 ' 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. Video camera is prefered to check the positioning of the compnent. Adhesive agents are forbidden on the receptacle.
3. Soldering by infra-red reflow.
4. Cleaning of printed circuit boards.
5. Checking of solder joints and position of the component by visual inspection.

TEMPERATURE PROFILE


| Parameter | Value | Unit |
| :--- | :---: | :---: |
| Temperature rising Area | $1-4$ | ${ }^{\circ} \mathrm{C} / \mathrm{sec}$ |
| Max Peak Temperature | 260 | ${ }^{\circ} \mathrm{C}$ |
| Max dwell time @ $260^{\circ} \mathrm{C}$ | 10 | sec |
| Min dwell time @ $235^{\circ} \mathrm{C}$ | 20 | sec |
| Max dwell time @ $235^{\circ} \mathrm{C}$ | 60 | sec |
| Temperature drop in cooling Area | -1 to -4 | ${ }^{\circ} \mathrm{C} / \mathrm{sec}$ |
| Max dwell time above $100^{\circ} \mathrm{C}$ | 420 | sec |

