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HARTING DIN Signal female connector RoHS compliant				Recommended configuration of plated through holes for press-in termination In addition to the hot-air-level (HAL), other PCB surfaces are getting more important. Due to their different properties – such as mechanical strength and coefficient of friction – we recommend the following configuration of PCB through holes. drilled hole Ø finished hole Ø plating (e.g. Sn) Cu min. 25 µm <table><tr><td rowspan="2">Tin plated PCB (HAL) acc. to EN 60352-5</td><td>Drilled hole Ø</td><td>1,15±0,025 mm</td></tr><tr><td>Sn plated hole Ø</td><td>max. 15 µm 0,94 – 1,09 mm</td></tr><tr><td rowspan="2">Chemical tin plated PCB</td><td>Drilled hole Ø</td><td>1,15±0,025 mm</td></tr><tr><td>Sn plated hole Ø</td><td>min. 0,8µm 1,00 – 1,10 mm</td></tr><tr><td rowspan="3">Gold /Nickel plated PCB</td><td>Drilled hole Ø</td><td>1,15±0,025 mm</td></tr><tr><td>Ni</td><td>3 – 7 µm</td></tr><tr><td>Au plated hole Ø</td><td>0,05 – 0,12 µm 1,00 – 1,10 mm</td></tr><tr><td rowspan="2">Silver plated PCB</td><td>Drilled hole Ø</td><td>1,15±0,025 mm</td></tr><tr><td>Ag plated hole Ø</td><td>0,1 – 0,3 µm 1,00 – 1,10 mm</td></tr><tr><td rowspan="2">Copper plated PCB (OSP)</td><td>Drilled hole Ø</td><td>1,15±0,025 mm</td></tr><tr><td>plated hole Ø</td><td>1,00 – 1,10 mm</td></tr></table>				Tin plated PCB (HAL) acc. to EN 60352-5	Drilled hole Ø	1,15±0,025 mm	Sn plated hole Ø	max. 15 µm 0,94 – 1,09 mm	Chemical tin plated PCB	Drilled hole Ø	1,15±0,025 mm	Sn plated hole Ø	min. 0,8µm 1,00 – 1,10 mm	Gold /Nickel plated PCB	Drilled hole Ø	1,15±0,025 mm	Ni	3 – 7 µm	Au plated hole Ø	0,05 – 0,12 µm 1,00 – 1,10 mm	Silver plated PCB	Drilled hole Ø	1,15±0,025 mm	Ag plated hole Ø	0,1 – 0,3 µm 1,00 – 1,10 mm	Copper plated PCB (OSP)	Drilled hole Ø	1,15±0,025 mm	plated hole Ø	1,00 – 1,10 mm																																																																																																										
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Cover the underside of the connector moulding and the adjacent parts of the pcb as well as the open sides of the connector. This will prevent heat and gases of the soldering apparatus from damaging the connector. About 140 × 5 mm of the tape should suffice. (2) For large series a jig is recommended. Its protective cover with a fast action mechanical locking device shields the connectors from gas and heat generated by the soldering apparatus. As an additional protection a foil can be used for covering the parts that should not be soldered. Cross section of solder terminations 0,3±0,01 0,75_{-0,07} 0,197 - 0,233 mm²			
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All Dimensions in mm Original Size DIN A3 Scale 1:1 Free size tol. Ref. Sub. HARTING All rights reserved Department EC PD – DE HARTING Electronics GmbH D-32339 Espelkamp Created by LEHNERT Inspected by ZWAHR Standardisation HOFFMANN Date 2016-11-03 State Final Release Title DIN Signale female connector Type DS Number 09032100001 Doc-Key / ECM-Nr. 100572187/UGD/001/B 500000111021 Rev. B Page 1/1																																																																																																																																												
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