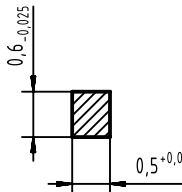
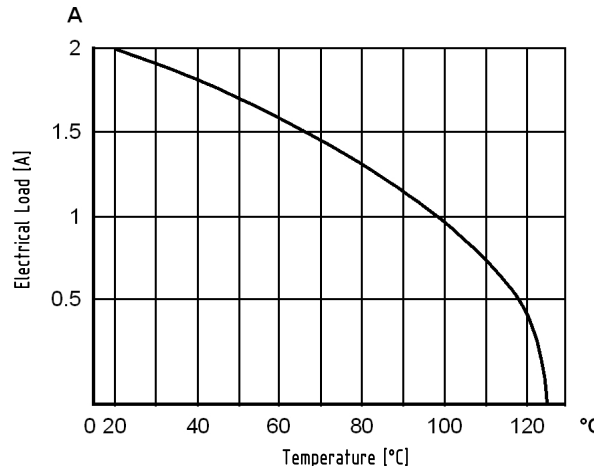


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HARTING DIN Signal male connector - THR c us RoHS compliant				Soldering instructions THR (Through Hole Reflow) connectors are designed to be used in a reflow oven together with other SMD (Surface Mount Device) components. In this process, called as well „Pin in Hole Intrusive Reflow“, the connectors are inserted into plated through holes in a comparable way to conventional component mounting. All other components can be assembled on the pcb surface. The length of the connector contacts should be such that they protrude by no more than 1.5 millimetres after insertion to the pcb. Each contact collects solder on its tip as it penetrates the solder paste in the hole. So if the contact is too long, this solder would no longer be able to reflow back into the plated through hole by capillary action during the soldering process, therefore the quality of the soldered connection would suffer as a result. Quantity of solder paste Before the components are assembled, solder paste must be applied to all the solder pads (for connecting surface-mount components) and the plated through holes. To ensure that the plated through holes are completely filled, significantly more solder paste must be applied than traditional solder pads on the pcb surface. There are numerous calculation methods available which are complicated to apply. The following rule of thumb has proved valuable in practice: VPaste = 2(VH - VP) in which: VPaste = Required volume of solder paste VH = Volume of the plated through hole VP = Volume of the connector termination in the hole Comment: the multiplier “2” compensates for solder paste shrinkage during soldering. For this purpose, it was assumed that 50 % of the paste consists of the actual solder, the other 50 % being soldering aids. Cross section of solder pins A= 0,29mm² - 0,33mm²  Derating diagram acc. to IEC 60512-5 (Current carrying capacity) The current carrying capacity is limited by maximum temperature of materials for inserts and contacts including terminals. The current capacity curve is valid for continuous, non interrupted current loaded contacts of connectors when simultaneous power on all contacts is given, without exceeding the maximum temperature. Control and test procedures according to DIN IEC 60512-5 																																																																																																
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Standard plating options highlighted in <i>italic</i> , other plating options are available on request.				HARTING All rights reserved Department EC PD - DE HARTING HARTING Electronics GmbH D-32339 Espelkamp Created by STORCK Inspected by LEHNERT Standardisation HOFFMANN Date 2018-06-28 State Final Release Title DIN Signal male connector - THR Type DS Number 09031230201 Doc-Key / ECM-Nr. 100561189/UGD/001/E 500000136565 Rev. E Page 1/1																																																																																																
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