

HANDLING/STORAGE PRECAUTIONS: DO NOT USE FLOW SOLDERING. DO NOT APPLY SOLDER OR FLUX TO ANY PARTS BUT TERMINAL WHEN USING SOLDERING IRON, THE SOLDERING IRON SHOULD NOT COME IN CONTACT WITH THE HOUSING OF THE CAPACITOR. PLEASE REFER TO SOLDER RECOMMENDATIONS CHART. NO-CLEAN METHOD IS PREFERED OVER SOLVENT WASHING. EXPERIMENT WITH SAMPLES BEFORE WASHING BY SOLVENTS. DO NOT APPLY LOCKING SPRAY OR PAINT TO TRIMMER. ELECTRIC SPECIFICATIONS MAY BE AFFECTED ADVERSELY. $.091 ^{+.005}_{-.000}$ $\left[2.3 ^{+0.127}_{-0.000} \right]$ $.012 \pm .005$ [0.3 ± 0.127] PRODUCT CONTAINS LUBRICATION OIL. LUBRICATION LEAKS WILL NOT AFFECT SECTION A-A PRODUCT SOLDERABILITY. USE OF CERAMIC SCREWDRIVERS IS RECOMMENDED FOR TUNING. SCALE 8: 1 DO NOT APPLY AXIAL LOAD DURING TUNING IN EXCESS OF 0.3[lbf]//1.5[N]. KEEP PARTS OUT OF DIRECT SUNLIGHT EXPOSURE. STORE PARTS IN DUST-FREE ENVIRONMENT. .217±.005 [5.5±0.127] $.069 \pm .005$ $[1.75 \pm 0.127]$ SOLDERING RECOMMENDATIONS \sim HOT TERMINAL Ø.059 ^{+.005} THRU ⁻ Peak $\left[\text{Ø}1.5\,^{+0.127}_{-0.000}\,\text{THRU} \right]$ Temperature Heating $.079 \pm .005$ [2 ± 0.127] Pre-heating .315 ⁺.005 - .000 [8 ⁺0.127] Time $.157 \pm .005$ $[4 \pm 0.127]$ STANDARD LEAD-FREE SOLDERING PROFILE STAGE SAC305 SOLDER EUTECTIC SOLDER TEMPERATURE: 150[°C] - 180[°C] TEMPERATURE: 120[°C] - 150[°C] PRE-HEATING **TIME: 60 - 120 SECONDS TIME: 60 - 120 SECONDS** TEMPERATURE: 220[°C] MIN. TEMPERATURE: 183[°C] MIN. **HEATING** TIME: 30 - 60 SECONDS TIME: 30 - 60 SECONDS TEMPERATURE: 265[°C] TEMPERATURE: 265[°C] FEED DIRECTION PEAK HEAT TIME: 3 SECONDS MAX TIME: 3 SECONDS MAX REFLOW CYCLES 2 TIMES MAX 2 TIMES MAX SOLDERING IRON TEMPERATURE 400[°C] MAX SPEC TIME: 3 SECONDS MAX CARRIER TAPE **ISO VIEW** SCALE 8: 1 $.472 \pm .012$ $[12 \pm 0.305]$ VOLTRONICS
THE TRIMMER CAPACITOR COMPANY
2250 NORTHWOOD DRIVE
SALISBURY, MARYLAND 21801 CARRIER TAPE DETAIL SCALE 8: 1 DLI • Novacap • Syfer • Voltronics SIZE | CAGE CODE | PART NUMBER 18736 JZxxx PER VIEW DWG NO. V-7531

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