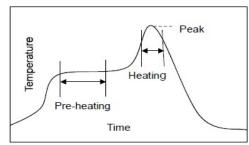


HANDLING/STORAGE PRECAUTIONS: DO NOT USE FLOW SOLDERING.
DO NOT APPLY SOLDER OR FLUX TO ANY PARTS BUT TERMINAL
WHEN USING SOLDERING IRON, THE SOLDERING IRON SHOULD NOT COME iii.-IN CONTACT WITH THE HOUSING OF THE CAPACITOR. iv.-PLEASE REFER TO SOLDER RECOMMENDATIONS CHART. NO-CLEAN METHOD IS PREFERED OVER SOLVENT WASHING.

EXPERIMENT WITH SAMPLES BEFORE WASHING BY SOLVENTS.

DO NOT APPLY LOCKING SPRAY OR PAINT TO TRIMMER. ٧.-ELECTRIC SPECIFICATIONS MAY BE AFFECTED ADVERSELY. .091 +.005 .012±.005  $[0.3 \pm 0.127]$ PRODUCT SOLDERABILITY. SECTION A-A [2.3 +0.127] PROJUCT SCLEENGLITT.
USE OF CERAMIC SCREWDRIVERS IS RECOMMENDED FOR TUNING.
DO NOT APPLY AXIAL LOAD DURING TUNING IN EXCESS OF 0.3[ibf]//1.5[n].
KEEP PARTS OUT OF DIRECT SUNLIGHT EXPOSURE. STORE PARTS IN DUST-FREE ENVIRONMENT. vii.-SCALE 8: 1 viii.- $.069 \pm .005$ .217 ± .005 SOLDERING RECOMMENDATIONS  $[1.75 \pm 0.127]$  $[5.5 \pm 0.127]$ HOT TERMINAL Ø.059 +.005 THRU [Ø1.5 +0.127 THRU] Temperature Heating  $.079 \pm .005$  $[2 \pm 0.127]$ Pre-heating .315 <sup>+.005</sup> <sub>-.000</sub> [8 <sup>+0.127</sup>] Time .157±.005 [4±0.127] **♦** A DIRECTION Α FED CARRIER TAPE ISO VIEW SCALE 8: 1 .472 ± .012  $[12 \pm 0.305]$ CARRIER TAPE DETAIL SCALE 8: 1 55153 SCALE PER VIEW DWG NO

PRODUCT CONTAINS LUBRICATION OIL. LUBRICATION LEAKS WILL NOT AFFECT



STANDARD LEAD-FREE SOLDERING PROFILE		
STAGE	S AC 305 S OLDER	EUTECTIC SOLDER
PRE-HEATING	TEMPERATURE: 150[ºC] - 180[ºC]	TEMPERATURE: 120[ºC] - 150[ºC]
	T IME: 60 - 120 S E C O N D S	TIME: 60 - 120 SECONDS
HEATING	TEMPERATURE: 220[ºC] MIN.	TEMPERATURE: 183[ºC] MIN.
	TIME: 30 - 60 SECONDS	TIME: 30 - 60 SECONDS
PEAK HEAT	TEMPERATURE: 265[ºC]	TEMPERATURE: 265[ºC]
	TIME: 3 SECONDS MAX	TIME: 3 SECONDS MAX
REFLOW CYCLES	2 TIMES MAX	2 TIMES MAX
	SOLDERING IRON	
SPEC	TEMPERATURE 400[ºC] MAX	
	TIME: 3 SECONDS MAX	

VOLTRONICS
THE TRIMMER CAPACITOR COMPANY
2250 NORTHWOOD DRIVE
SALISBURY, MARYLAND 21801 DLI • Novacap • Syfer • Voltronics
SIZE | CAGE CODE | PART NUMBER JZxxx V-7531 SHEET 2 OF 2

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