



Soldering a copper tab on a speaker ring

Objective Heat copper tab until the solder reflows.

Material Copper tab 0.25 X 0.25 inch square about 0.05 inches thick.
Lead free solder material (higher melting temperature than regular solder.)

Temperature 500 °F for 1.25 seconds

Frequency 286 kHz

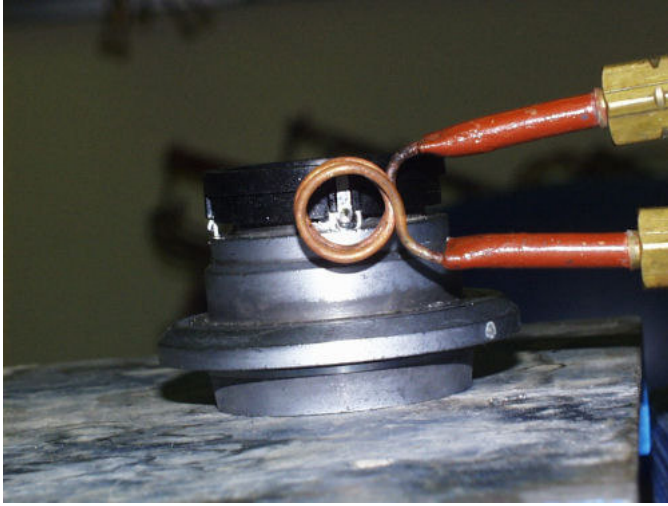
Equipment Ameritherm 1.2 kW, 150-400 kHz solid state induction heating system equipped with a remote heat station containing one 1.2 µF capacitor and a specially-designed work coil.
A multi-turn helical coil about 3/16 inch internal diameter made out of 1/16 inch diameter tubing.

Process Solder wire is fed onto speaker tab area using an automatic wire feeder. It is then heated to re-flow the solder.

Results/Benefits With an efficient coil design induction heating easily reaches the desired reflow temperature in a very short amount of time.

(Photos on next page)

Download and print our Applications Lab Process Sheet (<http://www.ameritherm.com/PDFs/4110038b.pdf>). Answer the questions on the form to help us understand your process and performance requirements. Call with the info on the form to see if you should send us your parts for a free evaluation. If you have questions, call or e-mail us (info@ameritherm.com). We'll be in touch!



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