



Soldering Co-axial Wire Assemblies

Objective To solder center-conductor and shielding braid of wire assemblies to 500 (250) °F(°C).

- Material**
- Customer-supplied assemblies
 - Temperature indicating paint
 - Flux-cored solder wire

Temperature 500 (250) °F (°C)

Frequency 272 kHz

Equipment Ameritherm 2 kW induction heating system, equipped with a remote heat station containing two 0.33 μ F capacitors. An induction heating coil designed and developed specifically for this application.

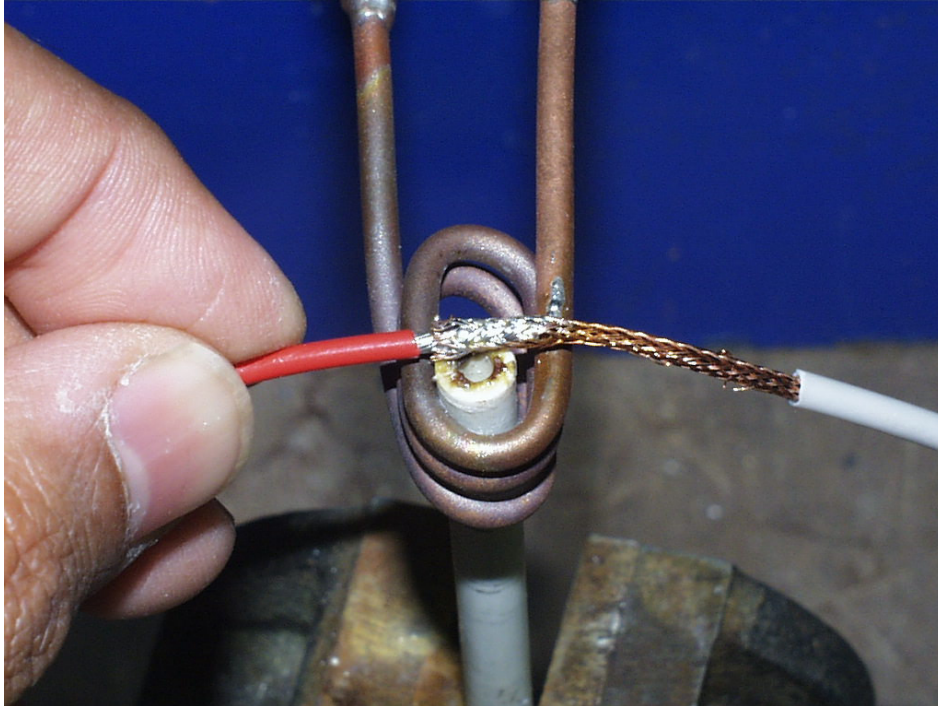
Process A multi-turn helical coil is used and temperature-indicating paint is applied to the joint area. The wire assembly is placed over the induction heating coil, and RF power is applied. The time-to-temperature and the heating pattern on the part are established. The next wire assembly is placed on the coil, the assembly is heated and solder wire is fed into the joint. The assembly heats well and reaches 500 °F in 10 seconds.

- Results/Benefits**
- elimination of a crimp process
 - more reliable connections are made
 - faster process times

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!



Soldering of a center conductor



Soldering of a co-axial shielding braid

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