



Soldering wires onto connector assemblies

Objective Heat connector assemblies for soldering

Material Device assembly
Tin plated brass terminals
Solder paste

Temperature 500°F (260°C) 5-7 seconds

Frequency 360 kHz

Equipment Ameritherm 2.4 kW induction heating system equipped with a remote heat station, containing two 0.66 μ F capacitor.

An induction heating coil designed and developed specifically for this application.

Process A single turn helical coil is used to heat the solder paste. The connectors are placed inside the induction heating coil and RF power is applied for 5-7 seconds until the connector heats. Solder paste is applied to the joint in two ways, stick-fed or manually.

- Results/Benefits**
- Compared to using a manual soldering iron, induction heating precisely applies heat to for higher quality solder joints
 - This is ideal for integrating with an automated system. By stick- feeding the solder more aesthetically pleasing parts are produced.

