![CHERRY]

Manufacturing Guideline VR-00002
Soldering for DB-, DC-, NM09-Switch
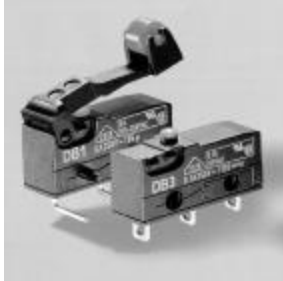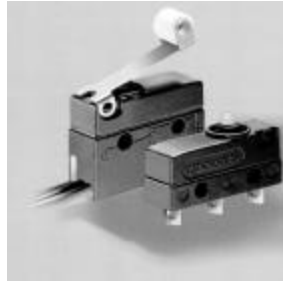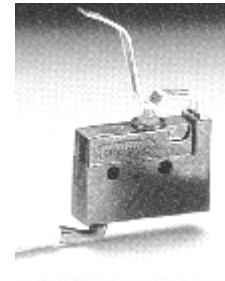
DB-Switch	DC-Switch	NM09-Switch

1. **Recommended Appliance, Solder and Adjustment for Manual Soldering:**
   Soldering Appliance: Temperature controlled soldering appliance power 50 to 80 VA (only with controlled temperature)
   (Appliance: e.g. ERSA, JBC or Weller)
   Solder Wire with Flux: Solder wire S-Sn60 Pb36 Ag4 $\varnothing$ 0,8mm or $\varnothing$ 1,0mm, Flux 2,2%
   Manufacturer e.g.: Fluitin, Stannol or ELSOLD
   Solder Temperature: 280°C – 320°C at tip of soldering appliance
   Solder Time: 1 – 2 sec. (=best possible); max. 3 sec.

2. **Wave Soldering:**
   Solder Temperature: 250° C $\pm 5^{o}$ C
   Solder Time: max. 3 sec.
   For additional comments and recommendation please contact Cherry.

3. **Other Soldering Processes:**
   For recommendation of other soldering processes please contact Cherry.

4. **Terminal Material and Dimensions:**
   Terminal Material: Cu Zn 10 F 35
   Terminal Plating: Standard: Silver plated 0,5 – 1,5 μm bk DIN 50960
                       Special design: Gold plated 0,5 µm or 5µm DIN 50960
   Edges: without plating
   Thickness: 0,5mm $\pm$ 0,05mm
   All available terminal dimensions are shown in the Technical Specification
   TS-DB-00001 / TS-DC-00002

5. **Warnings:**
   Mechanical stress on the terminals during the solder process is not allowed!
   Solder steam must be discharged from the switch.
   If you use other solder processes as above described it is important that you analyze all aspects and discuss them with Cherry.
   Snap switches are products which generally need to be accompanied by advisory service.

6. **Further Valid Documents:**
   TS-DB-00001 / TS-DC-00002   Technical Switch Specification
   DIN EN 29453 / DIN EN 29454:   Soft Solder Alloys / Fluxes
   DIN IEC 60068 - Part 2-20:   Test T: Soldering

02	08.04.03	S.Reindl	145183				
01	10.08.00	S. Reindl	135683				
00	24.01.00	S. Reindl	133214				
Index	Date	Name	ÄM-Nr.	EMS	LAB	QS/S	PK

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