Toby Electronics Ltd

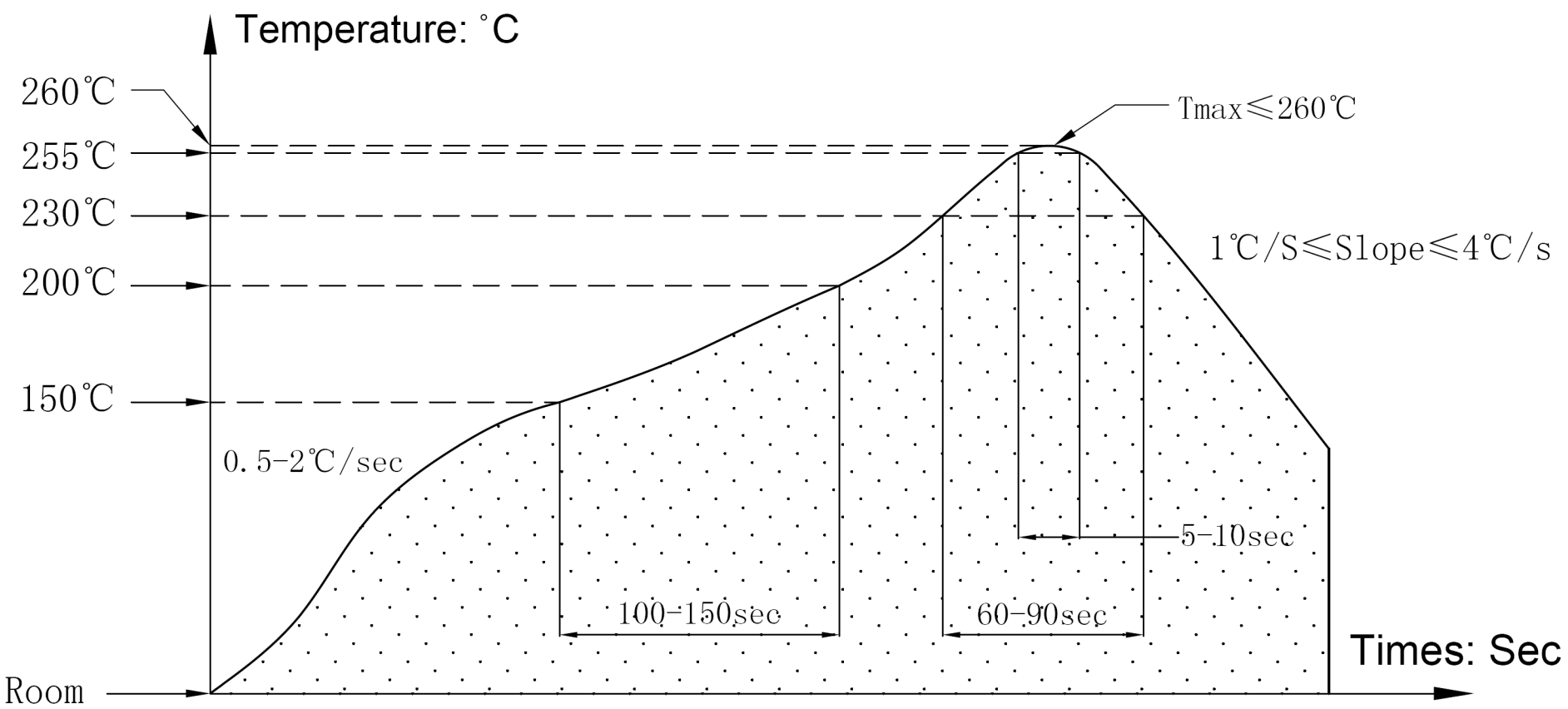
Valcon HTHX-xx-9T Headers

www.toby.co.uk

Reflow Soldering Information

Explanation:

1) Preheating section zone: The temperature is from normal to 150 degrees Celsius. The temperature rise rate is from 0.5 to 2 degrees Celsius per second. The temperature range from 60 seconds to 150 seconds.
2) Uniform temperature zone: The temperature is 150-200 degrees Celsius. The temperature rise rate is 1℃/s. The time of this temperature range is 100-150 seconds. (remarks: This temperature zone must be heated slowly or it may lead to bad welding).
3) Reflow zone: The temperature is from 230 to Tmax, and return to 230 degrees Celsius. The temperature range from 60 seconds to 90 seconds. The peak temperature zone(255-260 degrees Celsius) range from 5 to 10 seconds.
4) Cool down period: The temperature is from Tmax to 180 degrees Celsius. The temperature down rate no more than 4 degrees per second.
5) The temperature rise rate no more than 6 minute from the normal to 260 degree Celsius.
6) Reflow time aims to 60-90 seconds. For some board whose heat capacity is larger than the time requirement, the reflux time can be 120 seconds.
7) The reflow welding curve is only the recommended value, and the client side adjusts accordingly according to the actual production situation.



Recommended IR Reflow Profile

9) Specification of materials to meet the requirements of the above process: PA6T/PA9T/LCP/PPS and other heat-resisting materials.

ONLINE CERTIFICATIONS DIRECTORY

QMFZ2.E90350
Plastics - Component

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Click on a product designation for complete information.

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Plastics - Component

See General Information for Plastics - Component

KURARAY CO LTD E90350
GENESTAR DIV
OTE CENTER BLDG 1-1-3
OTEMACHI
CHIYODA-KU, TOKYO 100-8115 JAPAN

									H	D	
		Min.		H	H	RTI			V	4	C
		Thk	Flame	W	A	Elec	Mech		T	9	T
Material Dsg	Color	mm	Class	I	I		Imp	Str	R	5	I
Aromatic Polyamide, furnished as pellets.											
G2300(+)(#)	BK	0.75	V-0	-	-	65	65	65	-	-	-
Polyamide (PA), "Genestar", furnished as pellets.											
GW2458HFM	BR	1.5	V-0	0	0	150	130	140	4	5	0
		3.0	V-0	0	0	150	130	140			
Polyamide (PA), semi-aromatic, furnished as pellets.											
G2(k)0	ALL	0.75	V-0	-	-	65	65	65	-	-	-
G2330(#)(%)	ALL	0.75	V-0	0	0	150	130	150	2	5	0
		1.5	V-0	0	0	150	130	150			
		3.0	V-0	0	0	150	130	150			
G2450(#)	ALL	0.75	V-0	0	0	65	65	65	4	5	1
		1.5	V-0	0	0	65	65	65			
		3.0	V-0	0	0	65	65	65			
G2500	ALL	0.75	V-0	-	-	65	65	65	-	-	-
G3330NA(#)	NC	0.75	V-0	-	-	65	65	65	-	-	-
Polyamide 9T (PA9T), "Genestar", furnished as pellets.											
GP2450NH	ALL	0.150	V-0	-	-	-	-	-	0	4	0
		0.40-0.44	V-0	3	3	140	90	130			
		1.5	-	-	-	140	90	130			
		3.0	-	-	-	140	100	140			
GW1458HF	ALL	0.75	HB	-	-	65	65	65	-	-	-
		3.0	HB	-	-	65	65	65			
GW2458HF	ALL	0.75	V-0	0	0	150	130	140	4	5	0
		1.5	V-0	0	0	150	130	140			
		3.0	V-0	0	0	150	130	140			

LA121	NC, BK	0.75	HB	-	-	65	65	65	-	-	-
		3.0	HB	-	-	65	65	65			
LC122	NC, BK	0.75	HB	-	-	65	65	65	-	-	-
		3.0	HB	-	-	65	65	65			
N1006A	NC, BK	1.5	HB	-	-	65	65	65	-	-	-
		3.0	HB	-	-	65	65	65			
TA112	WT	0.75	HB	-	-	65	65	65	-	-	-
		3.0	HB	-	-	65	65	65			
Polyamide 9T (PA9T), furnished as pellets.											
G1300, G1300A, G1300H											
	ALL	0.8	HB	-	-	65	65	65	-	-	-
G1302	NC, BK	0.8	HB	-	-	65	65	65	-	-	-
G1302H	BK	0.81	HB	-	-	65	65	65	-	-	-
G1350H	ALL	0.75	HB	-	-	50	50	50	-	-	-
		3.0	HB	-	-	50	50	50			
GA2330	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2(k)1	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2(k)2	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2(n)0(#)	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2(p)0(#)	ALL	0.75	V-0	-	-	150	120	130	-	-	-
		1.5	V-0	-	-	150	130	140			
		3.0	V-0	-	-	150	130	140			
GN2(q)0(#)	ALL	0.75	V-0	-	-	150	120	130	-	-	-
		1.5	V-0	-	-	150	130	140			
		3.0	V-0	-	-	150	130	140			
GN2200(#)	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2330(#)	ALL	0.75	V-0	0	0	150	120	130	3	5	1
		1.5	V-0	0	0	150	130	140			
		3.0	V-0	0	0	150	130	140			
GN2331	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2332	ALL	0.75	V-0	0	0	150	115	130	4	5	1
		1.5	V-0	0	0	150	115	130			
		3.0	V-0	0	0	150	125	140			
GN2450(#)	ALL	0.75	V-0	0	0	150	120	130	4	4	0
		1.5	V-0	0	0	150	130	140			
		3.0	V-0	0	0	150	130	140			
GN2500(#)	ALL	0.75	V-0	-	-	150	130	140	-	-	-
		1.5	V-0	-	-	150	130	140			
		3.0	V-0	-	-	150	130	140			
GN2501	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GN2502	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GR2300(r)	ALL	0.8	V-0	0	0	150	110	115	3	5	0
		1.5	V-0	0	0	150	120	125			

		3.0	V-0	0	0	150	125	130			
GT2330	NC, BK	0.8	V-0	-	-	65	65	65	-	-	-
	ALL	0.94	V-0	-	-	65	65	65			
GW2(m)8HF	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GW2338HF	BK, NC	0.75	V-0	-	-	65	65	65	-	-	-
GW2459	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GW2508	NC, BK	0.75	V-0	0	0	150	130	140	3	4	1
		1.5	V-0	0	0	150	130	140			
		3.0	V-0	0	0	150	130	140			
GW2558	NC, BK	0.75	V-0	-	-	65	65	65	-	-	-
GW2558HF	BK, NC	0.75	V-0	-	-	65	65	65	-	-	-
N1000A	NC, BK	0.75	HB	-	-	65	65	65	-	-	-
T1320A	NC	0.75	HB	-	-	50	50	50	-	-	-
T1320H	NC	0.75	HB	-	-	50	50	50	-	-	-
T1420A	NC	0.75	HB	-	-	50	50	50	-	-	-
T1420H	NC	0.75	HB	-	-	50	50	50	-	-	-
Polyethylene Terephthalate (PET), "ESMO", furnished as pellets.											
50(b)(#)	ALL	0.75	HB	2	0	75	75	75	2	7	3
		1.5	HB	1	0	75	75	75			
		3.0	HB	0	0	75	75	75			
50(b)-NN(#)	ALL	0.75	V-0	0	0	75	75	75	0	6	3
		1.5	V-0	0	0	75	75	75			
		3.0	V-0	0	0	75	75	75			
5030-NN(#)	ALL	0.75	V-0	0	0	150	150	150	0	6	3
		1.5	V-0	0	0	150	150	150			
		3.0	V-0	0	0	150	150	150			
Thermoplastic Polyurethane (TPU), furnished as pellets.											
A165S(#)	NC, BK	1.0	HB	-	-	50	50	50	-	-	-
	ALL	1.5	HB	4	0	50	50	50			
		3.0	HB	3	0	50	50	50			
SU6050(#)	ALL	1.0	HB	4	0	50	50	50	-	-	-
		1.5	HB	3	0	50	50	50			
		3.0	HB	3	0	50	50	50			
TU-HM45395	ALL	1.5	HB	-	-	50	50	50	-	-	-

(#) - Suffix optional.

(%) - Virgin and regrind up to 50% by weight inclusive have the same flammability and izod impact characteristics only.

(+) - May be followed by two letters denoting color.

(b) - A two digit number 16-29 incl. denoting glass fiber content.

(k) - A two digit number (34-49 incl.) denoting the content of glass fiber.

(m) - A two digit number 34-54 incl. denoting the glass fiber content

(n) - A two digit number (21-32 incl.) denoting glass fiber content.

(p) - A two digit number (34-44 incl.) denoting the content of glass fiber.

(q) - A two digit number (46-49 incl.) denoting the content of glass fiber.

(r) - Virgin and regrind up to 50% by weight inclusive only have the same flammability characteristics in the natural and black colors. No other properties evaluated.

Marking: Company name or trademark MRP (PP), MRP (NYLON66), クラペット, ESMO, エスモ and material designation on container, wrapper or finished part.

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