

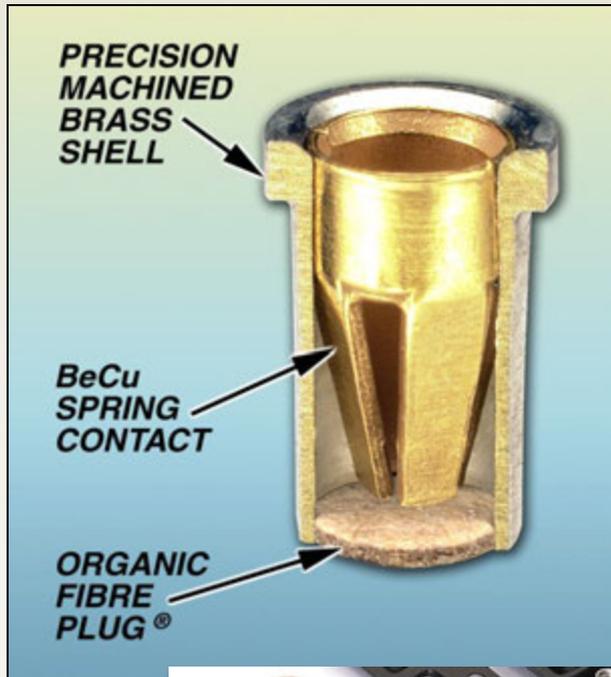


APPLICATION NOTE

Assembly Sequence for Intrusive Reflow Soldering for
OFP® receptacles



What are Organic Fibre Plug[®] Receptacles?



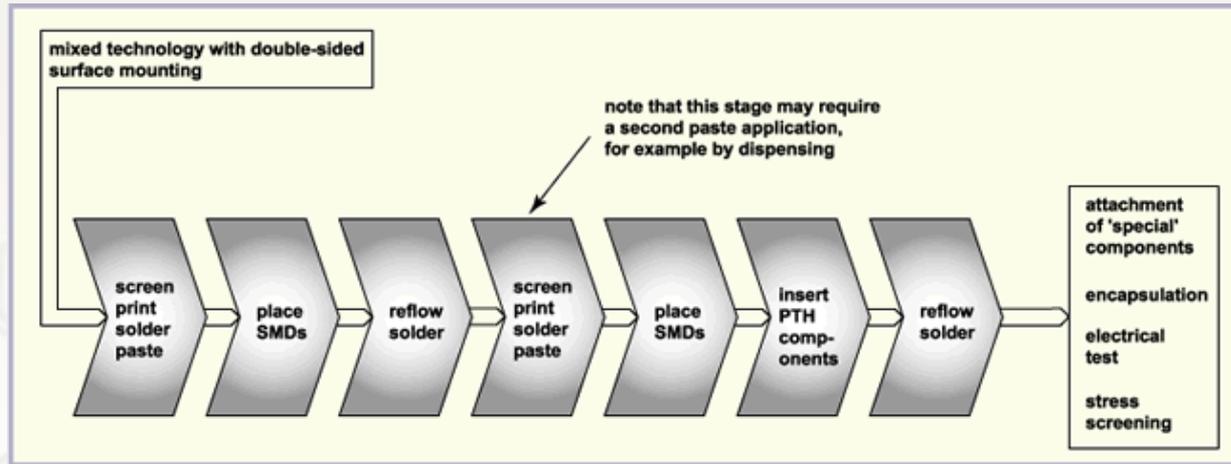
- Designed for hand, wave or reflow soldering. The organic fibre plug[®] prevents solder, paste or flux from contaminating the spring contact.
- After soldering, the organic fibre plug[®] is pushed out of the receptacle when the component is plugged in.
- Supplied as discrete receptacles or on carrier tape per EIA-481 for industry standard pick and place machines.
- All Mill-Max receptacles use a precision-machined brass housing with a press-fit beryllium copper “multi-finger” contact (heat-treated BeCu is the best electrical spring contact material.)

What is Intrusive Reflow?

Intrusive reflow (also called “pin-in-paste”) is a technique of using conventional through-hole components in a reflow soldering process.

The receptacles are placed into plated-through-holes in the circuit board (solder paste has previously been screen printed on pads adjacent to the holes) and the board is reflowed in the same pass as other SMT components.

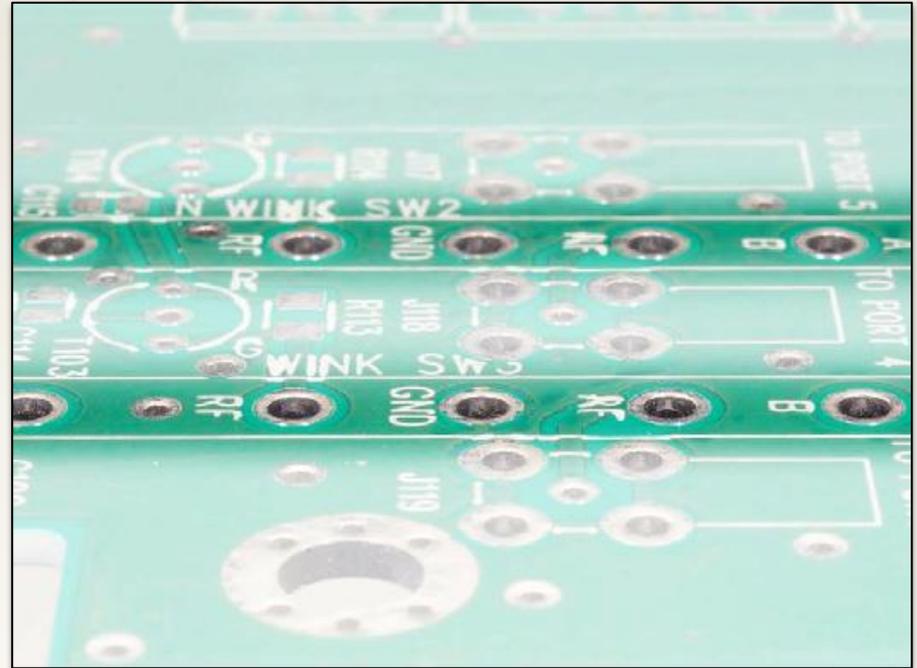
Solder will fill the plated-through-holes and achieve solder joints as reliable as wave soldering. The OFP[®] barrier prevents solder paste from being picked up inside the contact during pick’n place assembly. “Overprinting paste on the solder mask can be used to adjust the volume of paste required to fill each hole.



Source: http://www.ami.ac.uk/courses/topics/0226_pip/

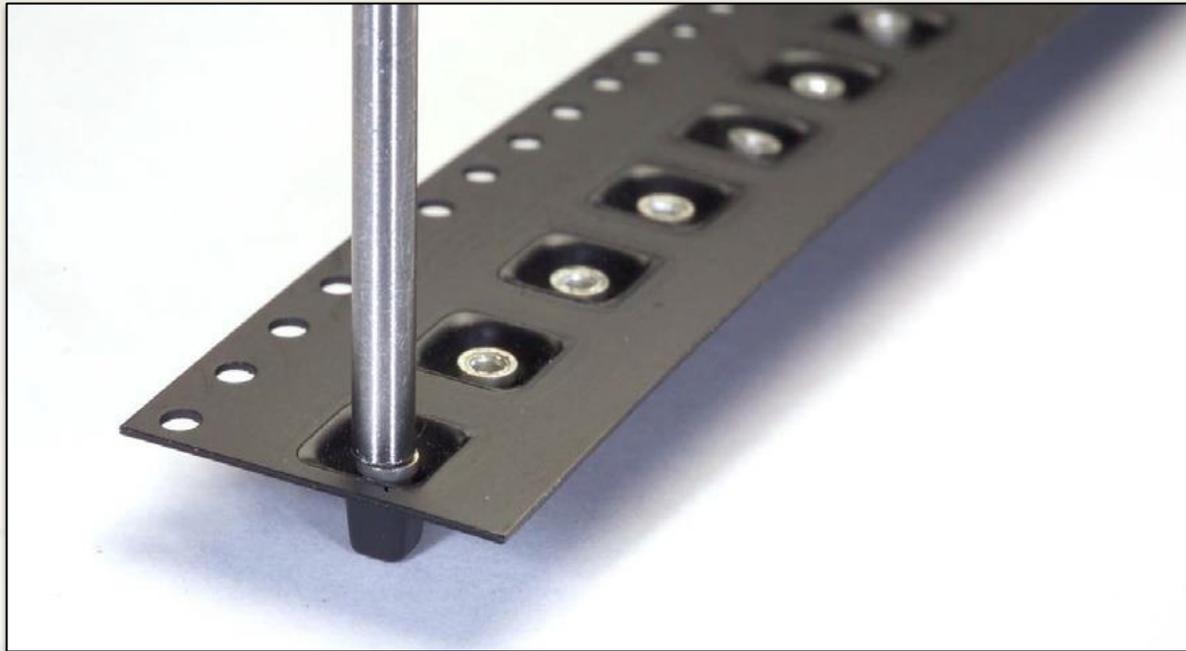
Assembly Sequence for Intrusive Reflow Soldering

1. Start with a printed circuit board having plated-through-holes .005" larger than the receptacles.
2. Screen solder paste onto the pads adjacent to the holes.



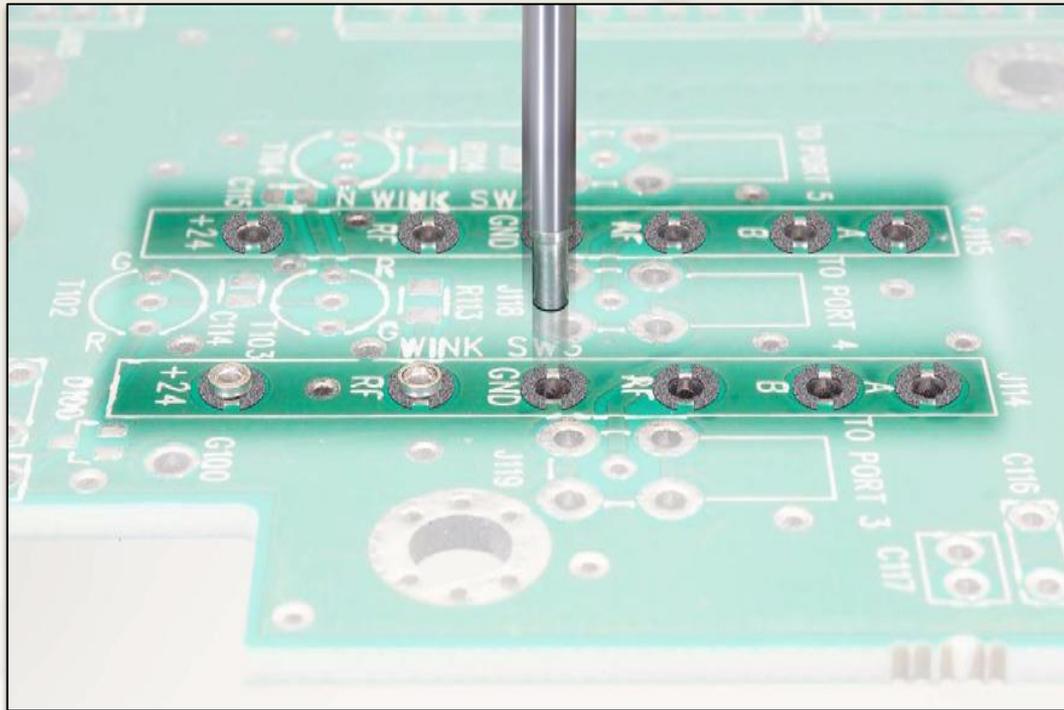
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3. Vacuum pick receptacle from EIA-481 standard carrier tape.



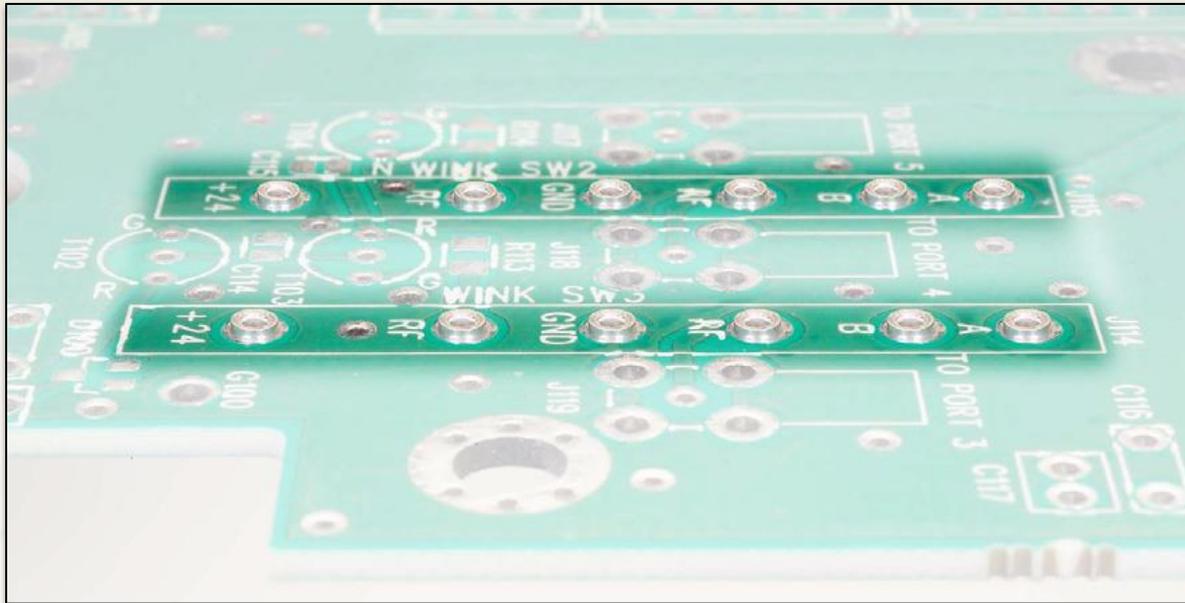
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4. Place receptacles into circuit board.



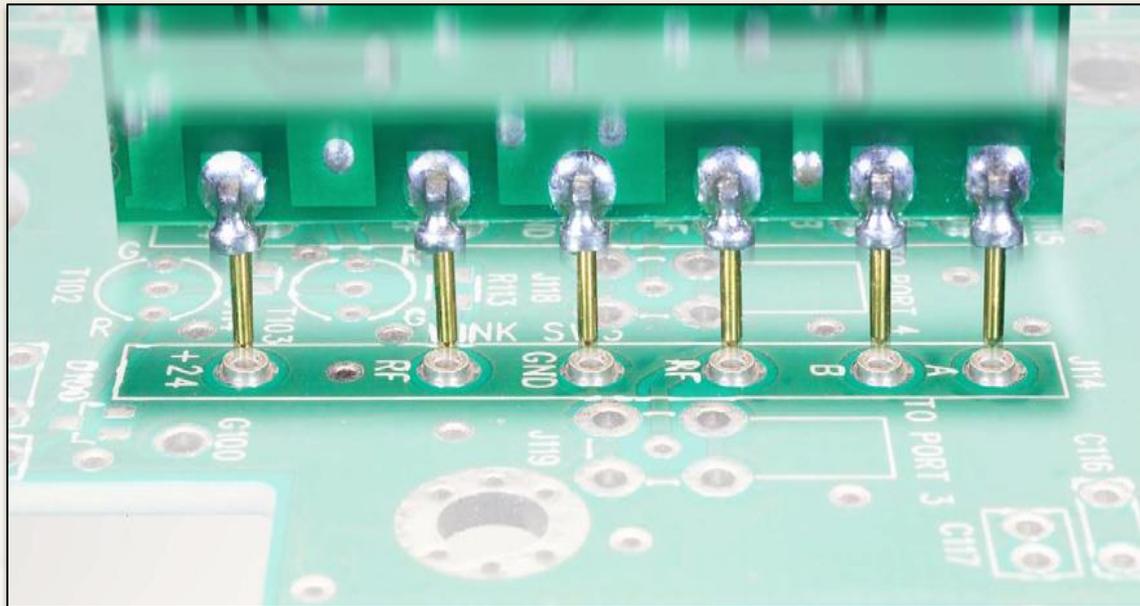
Assembly Sequence for Intrusive Reflow Soldering

5. Reflow completely assembled circuit board in a SMT conveyor oven.



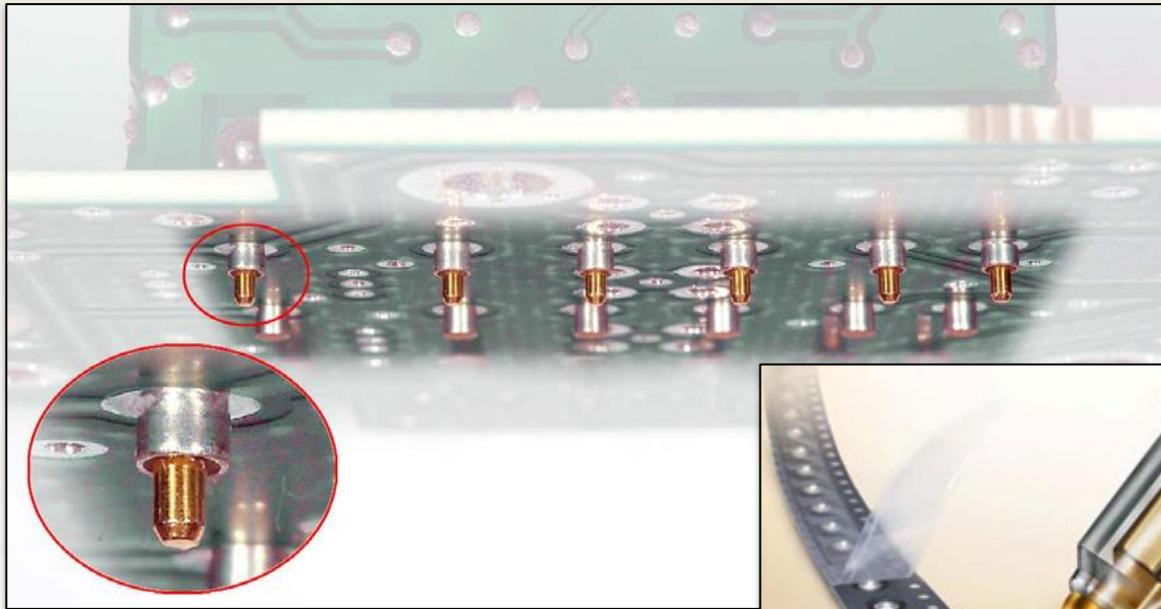
Assembly Sequence for Intrusive Reflow Soldering

6. Install leaded component into receptacles.



Assembly Sequence for Intrusive Reflow Soldering

7. The component leads will push out the organic fibre plugs.



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