

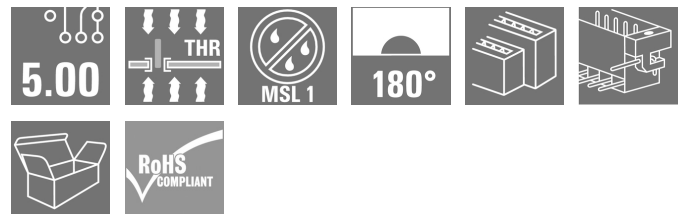
**SLDV-THR 5.00/38/180FLF 3.2SN BK BX****Weidmüller Interface GmbH & Co. KG**

Klingenbergstraße 26

D-32758 Detmold

Germany

www.weidmueller.com

**Product image**

High-temperature resistant, double level, laterally offset, closed ended male header, with solder flange option. 1.5 mm solder pin suitable for reflow soldering. 3.2 mm solder pin suitable for reflow and wave soldering. The pin headers provide space for labelling and can be coded.

**General ordering data**

|              |                                                                                                                                                                              |
|--------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Version      | PCB plug-in connector, male header, Flange / Solder flange, THT/THR solder connection, 5.00 mm, Number of poles: 38, 180°, Solder pin length (l): 3.2 mm, tinned, black, Box |
| Order No.    | <a href="#">1883300000</a>                                                                                                                                                   |
| Type         | SLDV-THR 5.00/38/180FLF 3.2SN BK BX                                                                                                                                          |
| GTIN (EAN)   | 4032248487653                                                                                                                                                                |
| Qty.         | 10 pc(s).                                                                                                                                                                    |
| Product data | IEC: 400 V / 15 A<br>UL: 300 V / 10 A                                                                                                                                        |
| Packaging    | Box                                                                                                                                                                          |

Creation date May 11, 2025 7:57:35 PM CEST

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## Technical data

## Dimensions and weights

|                          |            |                 |            |
|--------------------------|------------|-----------------|------------|
| Depth                    | 23.43 mm   | Depth (inches)  | 0.922 inch |
| Height                   | 29.36 mm   | Height (inches) | 1.156 inch |
| Height of lowest version | 26.16 mm   | Width           | 105 mm     |
| Width (inches)           | 4.134 inch | Net weight      | 30.2 g     |

## System specifications

|                                              |                                                     |                                            |                              |
|----------------------------------------------|-----------------------------------------------------|--------------------------------------------|------------------------------|
| Product family                               | OMNIMATE Signal - series BL/SL 5.00                 | Type of connection                         | Board connection             |
| Mounting onto the PCB                        | THT/THR solder connection                           | Pitch in mm (P)                            | 5 mm                         |
| Pitch in inches (P)                          | 0.197 "                                             | Outgoing elbow                             | 180°                         |
| Number of poles                              | 38                                                  | Number of solder pins per pole             | 1                            |
| Solder pin length (l)                        | 3.2 mm                                              | Solder pin length tolerance                | +0.1 / -0.2 mm               |
| Solder pin dimensions                        | d = 1.2 mm, Octagonal                               | Solder pin dimensions = d tolerance        | 0 / -0.03 mm                 |
| Solder eyelet hole diameter (D)              | 1.5 mm                                              | Solder eyelet hole diameter tolerance (D)  | + 0.1 mm                     |
| L1 in mm                                     | 90 mm                                               | L1 in inches                               | 3.543 "                      |
| Number of rows                               | 2                                                   | Pin series quantity                        | 2                            |
| Touch-safe protection acc. to DIN VDE 57 106 | finger-safe unplugged/<br>back-of-hand-safe plugged | Touch-safe protection acc. to DIN VDE 0470 | IP20 plugged/ IP10 unplugged |
| Protection degree                            | IP20                                                | Volume resistance                          | ≤5 mΩ                        |
| Can be coded                                 | Yes                                                 | Plugging force/pole, max.                  | 9 N                          |
| Pulling force/pole, max.                     | 8 N                                                 |                                            |                              |

## Material data

|                                       |                                |                                       |                                |
|---------------------------------------|--------------------------------|---------------------------------------|--------------------------------|
| Insulating material                   | LCP GF                         | Colour                                | black                          |
| Colour chart (similar)                | RAL 9011                       | Insulating material group             | IIla                           |
| Comparative Tracking Index (CTI)      | ≥ 175                          | Moisture Level (MSL)                  | 1                              |
| UL 94 flammability rating             | V-0                            | Contact material                      | Cu-alloy                       |
| Contact surface                       | tinned                         | Layer structure of solder connection  | 1...3 µm Ni / 2...4 µm Sn matt |
| Layer structure of plug contact       | 1...3 µm Ni / 2...4 µm Sn matt | Storage temperature, min.             | -40 °C                         |
| Storage temperature, max.             | 70 °C                          | Operating temperature, min.           | -50 °C                         |
| Operating temperature, max.           | 100 °C                         | Temperature range, installation, min. | -25 °C                         |
| Temperature range, installation, max. | 100 °C                         |                                       |                                |

## Rated data acc. to IEC

|                                                                           |                        |                                                                       |                   |
|---------------------------------------------------------------------------|------------------------|-----------------------------------------------------------------------|-------------------|
| tested acc. to standard                                                   | IEC 60664-1, IEC 61984 | Rated current, min. number of poles (Tu=20°C)                         | 15 A              |
| Rated current, max. number of poles (Tu=20°C)                             | 10.5 A                 | Rated current, min. number of poles (Tu=40°C)                         | 13 A              |
| Rated current, max. number of poles (Tu=40°C)                             | 9 A                    | Rated voltage for surge voltage class / pollution degree II/2         | 400 V             |
| Rated voltage for surge voltage class / pollution degree III/2            | 320 V                  | Rated voltage for surge voltage class / pollution degree III/3        | 250 V             |
| Rated impulse voltage for surge voltage class/ pollution degree II/2      | 4 kV                   | Rated impulse voltage for surge voltage class/ pollution degree III/2 | 4 kV              |
| Rated impulse voltage for surge voltage class/ contamination degree III/3 | 4 kV                   | Short-time withstand current resistance                               | 1 x 1s with 120 A |

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**Technical data****Rated data acc. to CSA**

Institute (CSA)



Certificate No. (CSA)

200039-1121690

Rated voltage (Use group B / CSA) 300 V

Rated voltage (Use group D / CSA) 300 V

Rated current (Use group B / CSA) 10 A

Rated current (Use group D / CSA) 10 A

Reference to approval values

Specifications are maximum values, details - see approval certificate.

**Rated data acc. to UL 1059**

Institute (UR)



Certificate No. (UR)

E60693

Institute (cURus)



Certificate No. (cURus)

E60693

Rated voltage (Use group B / UL 1059) 300 V

Rated voltage (Use group D / UL 1059) 300 V

Rated current (Use group B / UL 1059) 10 A

Rated current (Use group D / UL 1059) 10 A

Reference to approval values

Specifications are maximum values, details - see approval certificate.

**Packing**

|           |        |            |        |
|-----------|--------|------------|--------|
| Packaging | Box    | VPE length | 177 mm |
| VPE width | 123 mm | VPE height | 47 mm  |

**Classifications**

|             |             |             |             |
|-------------|-------------|-------------|-------------|
| ETIM 6.0    | EC002637    | ETIM 7.0    | EC002637    |
| ETIM 8.0    | EC002637    | ETIM 9.0    | EC002637    |
| ETIM 10.0   | EC002637    | ECLASS 9.0  | 27-44-04-02 |
| ECLASS 9.1  | 27-44-04-02 | ECLASS 10.0 | 27-44-04-02 |
| ECLASS 11.0 | 27-46-02-01 | ECLASS 12.0 | 27-46-02-01 |
| ECLASS 13.0 | 27-46-02-01 | ECLASS 14.0 | 27-46-02-01 |
| ECLASS 15.0 | 27-46-02-01 |             |             |

**Environmental Product Compliance**

|                        |                             |
|------------------------|-----------------------------|
| RoHS Compliance Status | Compliant without exemption |
| REACH SVHC             | No SVHC above 0.1 wt%       |

## SLDV-THR 5.00/38/180FLF 3.2SN BK BX

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## Technical data

## Important note

|                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
|----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| IPC conformity | Conformity: The products are developed, manufactured and delivered according international recognized standards and norms and comply with the assured properties in the data sheet resp. fulfill decorative properties in accordance with IPC-A-610 "Class 2". Further claims on the products can be evaluated on request.                                                                                                                                                                                                                                                                                                                                                                                                   |
| Notes          | <ul style="list-style-type: none"> <li>Rated current related to rated cross-section &amp; min. No. of poles.</li> <li>Spacing between rows: see hole layout</li> <li>P on drawing = pitch</li> <li>Rated data refer only to the component itself. Clearance and creepage distances to other components are to be designed in accordance with the relevant application standards.</li> <li>In accordance with IEC 61984, OMNIMATE-connectors are connectors without breaking capacity (COC). During designated use, connectors are not allowed to be engaged or disengaged when live or under load</li> <li>Long term storage of the product with average temperature of 50 °C and maximum humidity 70%, 36 months</li> </ul> |

## Approvals

Approvals



|                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
|-------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Approvals MAMID         | <a href="https://mdcop.weidmueller.com/mediadelivery/rendition/900_319226/-T1z1mm-S800/">https://mdcop.weidmueller.com/mediadelivery/rendition/900_319226/-T1z1mm-S800/</a> <a href="https://mdcop.weidmueller.com/mediadelivery/rendition/900_319230/-T1z1mm-S800/">https://mdcop.weidmueller.com/mediadelivery/rendition/900_319230/-T1z1mm-S800/</a> <a href="https://mdcop.weidmueller.com/mediadelivery/rendition/900_319262/-T1z1mm-S800/">https://mdcop.weidmueller.com/mediadelivery/rendition/900_319262/-T1z1mm-S800/</a> |
| ROHS                    | Conform                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| UL File Number Search   | UL Website                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| Certificate No. (UR)    | E60693                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
| Certificate No. (cURus) | E60693                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |

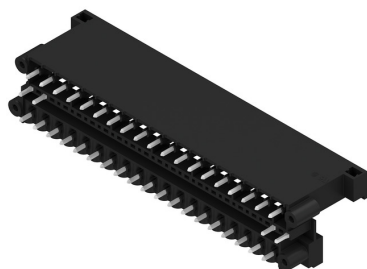
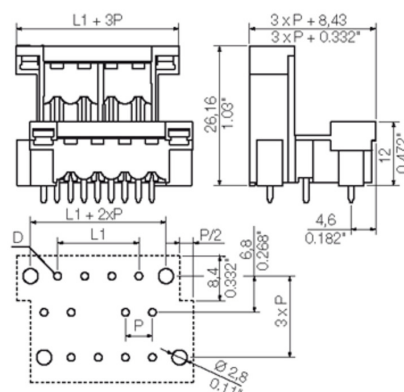
## Downloads

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
|---------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Approval/Certificate/Document of Conformity | <a href="#">Declaration of the Manufacturer</a>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| Engineering Data                            | <a href="#">CAD data – STEP</a>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| Catalogues                                  | <a href="#">Catalogues in PDF-format</a>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
| Brochures                                   | <a href="#">FL DRIVES EN</a><br><a href="#">MB DEVICE MANUF. EN</a><br><a href="#">FL DRIVES DE</a><br><a href="#">FL BUILDING SAFETY EN</a><br><a href="#">FL APPL LED LIGHTING EN</a><br><a href="#">FL INDUSTR.CONTROLS EN</a><br><a href="#">FL MACHINE SAFETY EN</a><br><a href="#">FL HEATING ELECTR EN</a><br><a href="#">FL APPL INVERTER EN</a><br><a href="#">FL BASE STATION EN</a><br><a href="#">FL ELEVATOR EN</a><br><a href="#">FL POWER SUPPLY EN</a><br><a href="#">FL 72H SAMPLE SER EN</a><br><a href="#">PO OMNIMATE EN</a><br><a href="#">PO OMNIMATE EN</a> |
| White paper surface mount technology        | <a href="#">Download Whitepaper</a>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |

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D-32758 Detmold  
Germany

[www.weidmueller.com](http://www.weidmueller.com)

**Drawings****Product image****Dimensional drawing****Product benefits**

Safe power transmission  
Proven properties

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## Accessories

## Additional accessories



**No task is too small when creating the perfect solution.** br />

Connections form just one part of the overall process. Small details are often the key to the perfect solution in applications where potentials are tested, grouped or even isolated.

A system is not a system without small but useful details:

- Test plugs - ensure reliable pick-up from diagnostic sockets
- Cross-connectors - ensure a stable electrical distribution contact directly at the connection
- Compartment partition elements - divide a large number of male connectors into several separate socket connector channels
- Locks and clips - optional vibration-resistant clip-on connection or mounting for male and female connectors

In tandem with the manufacturing process and application - more accessories = smaller workload

## General ordering data

| Type       | SL AT SW                   | Version                                                                | Product data | Packaging |
|------------|----------------------------|------------------------------------------------------------------------|--------------|-----------|
| Order No.  | <a href="#">1770240000</a> | PCB plug-in connector, Accessories, Spacer, black, Number of poles: 1  |              | Box       |
| GTIN (EAN) | 4032248117710              |                                                                        |              |           |
| Qty.       | 100 pc(s).                 |                                                                        |              |           |
| Type       | SL AT OR                   | Version                                                                | Product data | Packaging |
| Order No.  | <a href="#">1598300000</a> | PCB plug-in connector, Accessories, Spacer, orange, Number of poles: 1 |              | Box       |
| GTIN (EAN) | 4008190189266              |                                                                        |              |           |
| Qty.       | 100 pc(s).                 |                                                                        |              |           |

## Coding elements



**Only connects what is supposed to be connected: the right connection at the right place.**

Coding elements and locking devices clearly assign connecting elements during the manufacturing process and operation

The coding elements and locking devices are inserted prior to assembly or during the cable assembly phase. The Weidmüller alternative: configure online using the variant configurator to precode prior to delivery.

Incorrect assembly on the circuit board and incorrect plugging of connecting elements is no longer possible. The advantage: no troubleshooting during manufacture and no operational errors by the user.

## General ordering data

| Type       | BLZ/SL KO BK BX            | Version                                                                       | Product data | Packaging |
|------------|----------------------------|-------------------------------------------------------------------------------|--------------|-----------|
| Order No.  | <a href="#">1545710000</a> | PCB plug-in connector, Accessories, Coding element, black, Number of poles: 1 |              | Box       |
| GTIN (EAN) | 4008190087142              |                                                                               |              |           |
| Qty.       | 50 pc(s).                  |                                                                               |              |           |

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[www.weidmueller.com](http://www.weidmueller.com)**Accessories**

| Type       | BLZ/SL KO OR BX            | Version                                                            | Product data | Packaging |
|------------|----------------------------|--------------------------------------------------------------------|--------------|-----------|
| Order No.  | <a href="#">1573010000</a> | PCB plug-in connector, Accessories, Coding element, orange, Number |              | Box       |
| GTIN (EAN) | 4008190048396              | of poles: 1                                                        |              |           |
| Qty.       | 100 pc(s).                 |                                                                    |              |           |

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## Drawings

### Product benefits



Compliant with existing standards

## Technical Data

**Rev.**

### Material data

|                                        |                      |
|----------------------------------------|----------------------|
| Insulation material type               | LCP GF               |
| Insulation material colours            | black                |
| Insulation material flammability class | UL94 V-0             |
| Insulation resistance                  | 10 <sup>5</sup> MOhm |
| Contact base material                  | CuSn                 |
| Contact plating (mating end)           | tin plated           |
| Contact plating (solder end)           | tin plated           |

### System characteristic values

|                                                               |                 |                       |    |
|---------------------------------------------------------------|-----------------|-----------------------|----|
| Pitch <b>P</b>                                                | mm/inch         | 5.00/0.197            |    |
| Number of rows                                                |                 | 2                     |    |
| Dielectric strength (r.m.s withstand voltage)                 | kV              | 4                     |    |
| Mechanical operating cycles                                   | acc. to IEC 512 | 25                    |    |
| Plug in force (max.)                                          | N/pole          | n.a.                  |    |
| Pull out force (max.)                                         | N/pole          | n.a.                  |    |
| Through resistance (typical)                                  | mOhm            | <5                    |    |
| Operating temperature range                                   | °C              | -55...+100            | 1) |
| Degree of protection acc. to VDE 0106 (plugged/unplugged)     |                 | back of hands         | 7) |
| Degree of protection acc. to DIN EN 60529 (plugged/unplugged) |                 | IP10                  | 8) |
| Solder pin length <b>L</b>                                    | mm/inch         | 3.2/0.126 ; 1.5/0.059 |    |
| PCB hole diameter <b>D</b> (wave soldering)                   | mm/inch         | 1.4/0.055             | 2) |
| PCB hole diameter <b>D</b> (reflow soldering)                 | mm/inch         | 1.5/0.059             | 3) |
| Resistance to soldering heat acc. to DIN IEC 60512-6          | °C/sec          | 260/5                 | 4) |
| Resistance to soldering heat acc. to EN 61760-1               | °C/sec          | 290/30                | 5) |
| Solderability classification acc. to EN 61760-1               |                 | class A               |    |
| Solder connection type                                        |                 | through hole solder   |    |
| Solder pin diameter <b>d</b> (max.)                           | mm/inch         | 1.2/0.047             |    |

## Application notes

|                                |        |      |
|--------------------------------|--------|------|
| Coding possibility             | yes/no | yes  |
| Joinable without loss of pitch | yes/no | n.a. |
| Manual assembly of modules     | yes/no | n.a. |
| Max. number of poles           | n      | 48   |

**IEC 664-1 / VDE0110 (4.97) rated data**

|                                                       |                 |              |              |             |
|-------------------------------------------------------|-----------------|--------------|--------------|-------------|
| Rated cross section acc. to EN 60999                  | mm <sup>2</sup> | n.a.         |              |             |
| Rated current @ 20°C ambient (together with BLZ5.08)  | A               | 18.6         |              |             |
| Rated current @ 40°C ambient (together with BLZ 5.08) | A               | 16.1         |              |             |
| <b>Overvoltage category / Pollution degree</b>        |                 | <b>III/3</b> | <b>III/2</b> | <b>II/2</b> |
| Rated voltage                                         | V               | 250          | 320          | 400         |
| Rated impulse voltage                                 | kV              | 4.0          | 4.0          | 4.0         |

### UL 1059 rated data

|                                                |   |      |     |
|------------------------------------------------|---|------|-----|
| Rated voltage                                  | V | 300  | 300 |
| Rated current                                  | A | 10   | 10  |
| AWG wire range (field wiring / factory wiring) |   | n.a. |     |

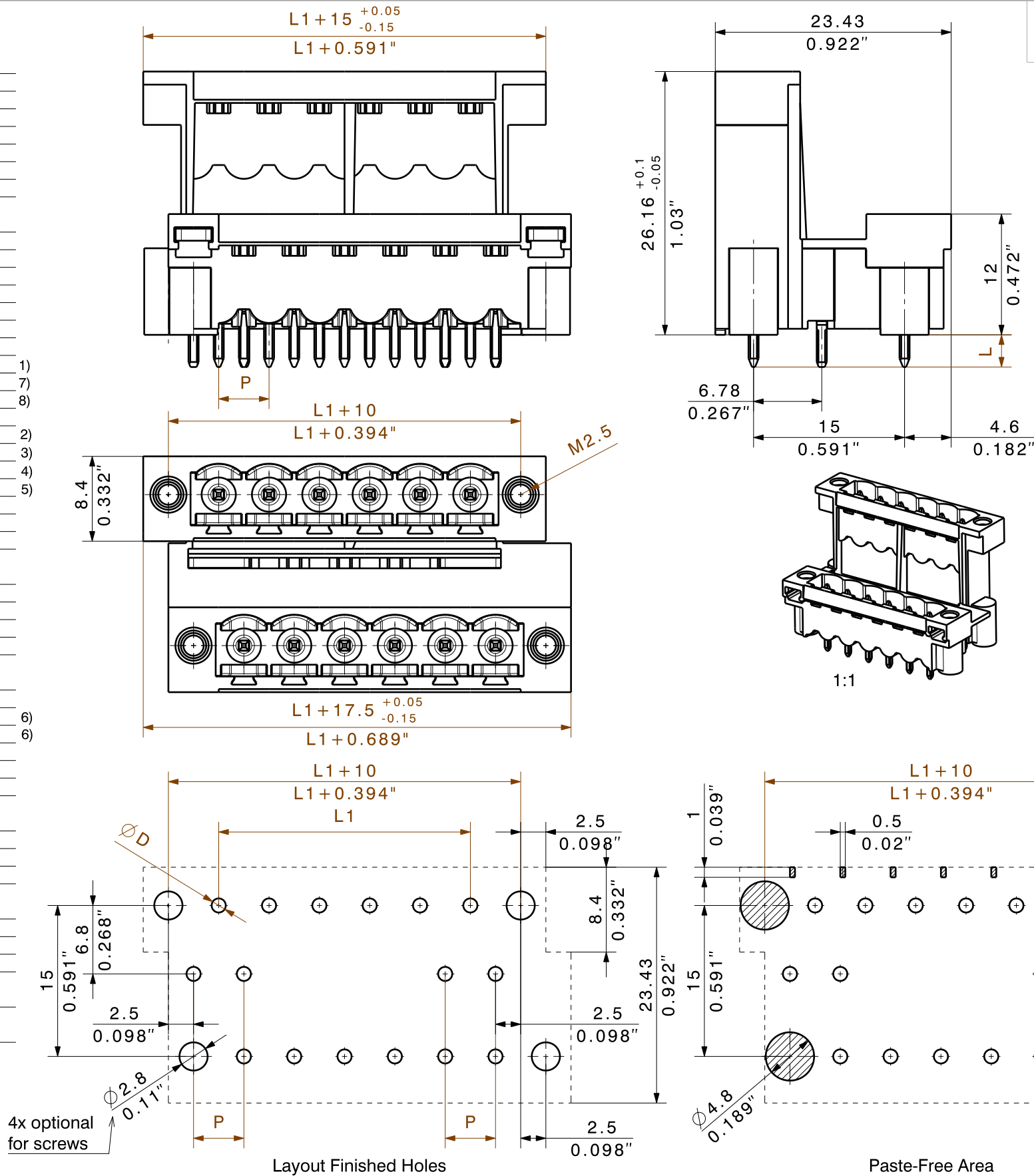
### CSA C22.2 rated data

|                                                |   |      |     |
|------------------------------------------------|---|------|-----|
| Rated voltage                                  | V | 300  | 300 |
| Rated current                                  | A | 10   | 10  |
| AWG wire range (field wiring / factory wiring) |   | n.a. |     |

### Packaging

|                  |                                                            |
|------------------|------------------------------------------------------------|
| <b>Downloads</b> | <a href="http://www.weidmueller.de">www.weidmueller.de</a> |
|------------------|------------------------------------------------------------|

## Downloads



**DIE DEUTSCHE VERSION IST VERBINDLICH  
THE GERMAN VERSION IS BINDING**

|          |                |                  |
|----------|----------------|------------------|
| 48       | 115,00         | 4,53             |
| 46       | 110,00         | 4,33             |
| 44       | 105,00         | 4,13             |
| 42       | 100,00         | 3,94             |
| 40       | 95,00          | 3,74             |
| 38       | 90,00          | 3,54             |
| 36       | 85,00          | 3,35             |
| 34       | 80,00          | 3,15             |
| 32       | 75,00          | 2,95             |
| 30       | 70,00          | 2,76             |
| 28       | 65,00          | 2,56             |
| 26       | 60,00          | 2,36             |
| 24       | 55,00          | 2,17             |
| 22       | 50,00          | 1,97             |
| 20       | 45,00          | 1,77             |
| 18       | 40,00          | 1,57             |
| 16       | 35,00          | 1,38             |
| 14       | 30,00          | 1,18             |
| 12       | 25,00          | 0,98             |
| 10       | 20,00          | 0,79             |
| 8        | 15,00          | 0,59             |
| 6        | 10,00          | 0,39             |
| 4        | 5,00           | 0,20             |
| <b>n</b> | <b>L1 [mm]</b> | <b>L1 [inch]</b> |

- 1) Sum of ambient temperature and temperature rise
- 2) Recommendation for manual assembly
- 3) Recommendation for automatic assembly
- 4) Recommendation for wave soldering
- 5) Recommendation for reflow soldering
- 6) Referred to rated cross section and minimum pole number
- 7) Fingersafe above PC-board, if plugged with BLZ
- 8) IP20 above PC-board, if plugged with BLZ

n.a. = not applicable

Subject to technical changes

For the mounting of PCBs, it should be noted that the rated data given in the catalogue relates only to the connection elements. The necessary creepage and clearance paths must be observed in connection with the respective applicant in accordance with VDE 0110. The current-carrying capacity and pitch tolerance is to be determined according to DIN IEC 326 part 3 very fine.

Weidmüller connectors are tested to the DIN VDE 0627 standard, and are valid for its field of application. Provided that the connectors are used to the intended purpose, all requirements with respect to the occurring of electrical, mechanical, thermic and corrosive stress will be satisfied.

shown: SLDV-THR 5.00/12/180FLF

|                                                                                       |                   |            |                                                                                                                                                               |                                                        |  |
|---------------------------------------------------------------------------------------|-------------------|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------|--|
| METRIC TOLERANCES                                                                     |                   |            |                                                                                                                                                               | CAT.NO.:                                               |  |
| X. = ±0.3                                                                             | 37601/5           |            | <div> <div> Weidmüller  </div> <div> C 36148 <div>02</div> </div> </div> |                                                        |  |
| X.X = ±0.1                                                                            | 07.09.07 HERTEL_S | 01         |                                                                                                                                                               |                                                        |  |
| X.XX = ±0.05                                                                          | MODIFICATION      |            | DRAWING NO. ISSUE NO.<br>SHEET 5 OF 6 SHEETS                                                                                                                  |                                                        |  |
| RoHS <input checked="" type="checkbox"/>                                              |                   | DATE       | NAME                                                                                                                                                          | SLDV-THR 5.00/.. /180 FLF<br>Stiftleiste<br>Pin header |  |
|  | DRAWN             | 04.08.2004 | HERTEL_S                                                                                                                                                      |                                                        |  |
| SCALE: 2:1                                                                            | RESPONSIBLE       |            |                                                                                                                                                               |                                                        |  |
| SUPERSEDES:                                                                           | CHECKED           | 13.09.2007 | HERTEL_S                                                                                                                                                      |                                                        |  |
| SUPERSEDED BY:                                                                        | APPROVED          |            |                                                                                                                                                               | PRODUCT FILE: SLDV-THR 5.08 None                       |  |

## Recommended wave soldering profiles

**Weidmüller Interface GmbH & Co. KG**  
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Germany  
Fon: +49 5231 14-0  
Fax: +49 5231 14-292083  
[www.weidmueller.com](http://www.weidmueller.com)

### Single Wave:



### Double Wave:



### Wave soldering profiles

Wired connection elements should be processed in accordance with the DIN EN 61760-1 standard. We have included two recommendations for practical wave soldering profiles, with which Weidmüller PCB terminals and connectors are qualified.

When choosing a suitable profile for your application, the following factors also need to be considered:

- PCB thickness
- Proportion of Cu in the layers
- Single/double-sided assembly
- Product range
- Heating and cooling rates

The single and double wave profiles each indicate the recommended operating range, including the maximum soldering temperature of 260°C. In practice, the maximum soldering temperature is quite often well below the above maximum profile.

We reserve the right to make technical changes.

## Recommended reflow soldering profile

**Weidmüller Interface GmbH & Co. KG**  
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Germany  
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Fax: +49 5231 14-292083  
www.weidmueller.com



### Reflow soldering profile

The perfect soldering profile for SMT Surface Mount Technology is one the most exiting question in SMT production. But there are more than one correct answer: The diagram of temperature-on-time is related to processing features of solder paste and to maximum load of components.

We have to consider the following parameters:

- Time for pre heating
- Maximum temperature
- Time above melting point
- Time for cooling
- Maximum heating rate
- Maximum cooling rate

We recommend a typical solder profile with associated process limits. With preheating components and board are prepared smoothly for the solder phase. Heating rate is typically  $\leq +3\text{K/s}$ . In parallel the solder paste is 'activated'. The time above melting point of 217°C the paste gets liquid and components and boards begin to connect. The maximum temperature of 245°C to 254°C should stay between 10 and 40 seconds. In the cooling phase at  $\geq -6\text{K/s}$  solder is cured. Board and components cool down while avoiding cold cracks.