

Induction Soldering connectors together

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering induction melting and induction surface treatment applications
<http://www.uihm.com>

Soldering connectors together Objective Soldering two connectors simultaneously to a tin plated copper ground plate

Material Tin plated copper ground plate 4" x 1.75" (101.6mm x 44.45mm), 2 connectors, one with 12 pins & one with 4 pins and 60/40 solder

Temperature 650 °F (343 °C)

Frequency 321 kHz

Equipment • Power of 10kW induction heating system, equipped with a remote workhead containing two 1.0µF capacitors for a total of 0.50 µF

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

Process A three turn helical coil is used to heat both sets of pins simultaneously.

Power is applied for less than 20 seconds

causing the solder to flow. A solder stick can be used but solder preforms work better.

Results/Benefits Induction heating provides:

- Non contact heat
 - Hands-free heating that involves no operator skill for manufacturing
 - Even distribution of heating
- Soldering connectors together**

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Connector with 12 pins



Connector with 4 pins



Ground plate in place for soldering of connectors