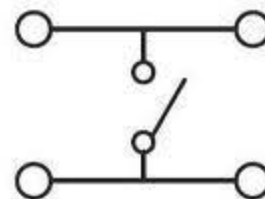
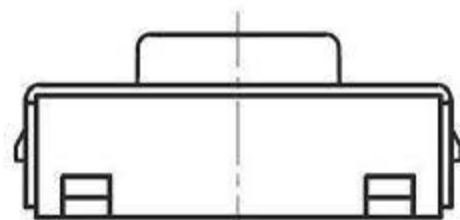


电路图

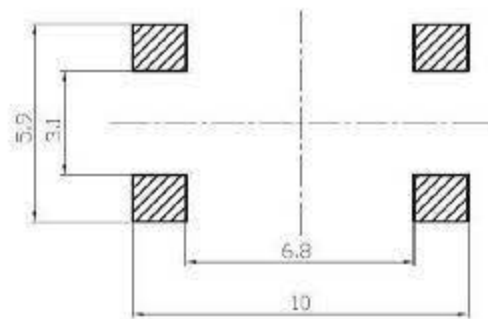


| TYPE            | 1        | 2        | 3        |
|-----------------|----------|----------|----------|
| Operating Force | 100±30gf | 160±30gf | 250±50gf |
| Return Force    | 20gf     | 40gf     | 60gf     |

| Product height (L) | P/N:     | Stem Color |
|--------------------|----------|------------|
| 2.5mm              | 1157ND   | Black/Red  |
| 2.7mm              | 1157NDAA | Black/Red  |
| 3.1mm              | 1157NDA  | Black/Red  |
| 3.4mm              | 1157NDB  | Black/Red  |
| 3.7mm              | 1157NDC  | Black      |
| 5.1mm              | 1157NDD  | Black      |



安装尺寸图:



| 未标注公差尺寸 |           |
|---------|-----------|
| METRIC  | TOLERANCE |
| .0      | ±0.15     |
| .00     | ±0.10     |
| .000    | ±0.05     |

| 序号 | 部件名称 | 型号规格     | 备注    |
|----|------|----------|-------|
| 1  | 接线片  | 黄铜       | 镀银    |
| 2  | 底座   | PPA      | 黑色    |
| 3  | 簧片   | 覆银       |       |
| 4  | 盖板   | 不锈钢      |       |
| 5  | 手柄   | PPA/FR52 | 红色/黑色 |

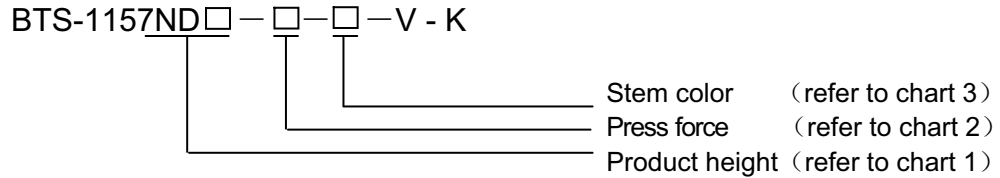
| 单位     | 比例   | 日期 | 核准   | 审核      | 设计绘图 | 料號 | FLY-1157ND(L)-(OF)-(X)-V-K |  | 頁數 | 1/1 |
|--------|------|----|------|---------|------|----|----------------------------|--|----|-----|
| mm     | Free |    | MARY | WILLIAN | HUNK | 品名 | <b>Tact Switch</b>         |  | 版本 | A   |
| FLYING |      |    |      |         |      | 圖號 | FLY-1157ND(L)-(OF)-(X)-V-K |  |    |     |

# APPROVAL SPECIFICATIONS

|          |                |            |             |          |
|----------|----------------|------------|-------------|----------|
| CUSTOMER | CUSTOMER'S P/N | P/N        | PRODUCT     | REVISION |
|          |                | BTS-1157ND | TACT SWITCH | A        |

## A. Specification & meanings

The name of the tact switch is composed by type and specification, the particular meaning of the type、specification and code is as follows.



- 1、 **Product height:** It is denoted by three figures; For examples, “1157ND”expresses the product which the total height is 2.5mm,as chart 1 shows:

| Code     | Product height | Code    | Product height | Code | Product height |
|----------|----------------|---------|----------------|------|----------------|
| 1157ND   | 2.5            | 1157NDD | 5.1            |      |                |
| 1157NDAA | 2.7            |         |                |      |                |
| 1157XX   |                |         |                |      |                |
| 1157NDA  | 3.1            |         |                |      |                |
| 1157NDB  | 3.4            |         |                |      |                |
| 1157NDC  | 3.7            |         |                |      |                |
| 1157XX   |                |         |                |      |                |

- 2、 **Operating force:** An English letter expresses it, unite: Newton (N),as chart 2 shows:

| force Code | Operating |  | Press force | Return force |
|------------|-----------|--|-------------|--------------|
|            | Spec      |  |             |              |
| 1          | 1.0       |  | 1.0±0.3     | 0.2min       |
| 2          | 1.6       |  | 1.6±0.5     | 0.4min       |
| 3          | 2.6       |  | 2.6±0.5     | 0.6min       |

- 3、 **Stem color:** It is expressed by a figure, as chart 3 shows:

|       |       |     |       |       |
|-------|-------|-----|-------|-------|
| Color | Black | Red | White | Brown |
| Code  | B     | R   | W     | N     |

Examples: “BTS-1157ND-2-R-V-K” denotes the tact switch with 6.2×6.2 base,the height is 2.5mm, the stem is red , the operating force is 1.6N.

|            |                |            |              |           |               |
|------------|----------------|------------|--------------|-----------|---------------|
| APPROVE BY | Jason 08.08.13 | CHECKED BY | Max 08.08.13 | PRPARE BY | Euni 08.08.13 |
|------------|----------------|------------|--------------|-----------|---------------|

# APPROVAL SPECIFICATIONS

| CUSTOMER | CUSTOMER'S P/N | P/N        | PRODUCT     | REVISION |
|----------|----------------|------------|-------------|----------|
|          |                | BTS-1157ND | TACT SWITCH | A        |

1、概述

**GENERAL**

1.2 适用范围

**APPLICATION**

此规格书适用于机械式轻触开关的相关要求

This specification is applied to the requirements for TACTILE SWITCH (MECHANICAL CONTACT)

1.3 工作温度范围

**Operating Temperature Range**

-20℃~70℃(在标准大气压、标准湿度条件下)

-20℃~70℃ (Normal humidity, normal air pressure)

1.4 贮藏温度范围

**Storage Temperature Range**

-30℃~80℃(在标准大气压、标准湿度条件下)

-30℃~80℃ (Normal humidity, normal air pressure)

1.5 测试条件

**Test Conditions**

在没有其它特定的条件下，应该在以下的条件下进行测试和测量：

Unless otherwise specified, tests and measurement shall be made in the following standard conditions:

常温.....5℃~35℃

Normal temperature.....5℃~35℃

标准湿度.....相对湿度 25%~85%

Normal humidity.....relative humidity 25%~85%

标准大气压.....86KPa~106Kpa

Normal air pressure.....86Kpa~106Kpa

在制造过程中，测试和测量应该在以下的条件下进行：

If any doubt arise from the judgment, tests shall be conducted at the following conditions:

温度.....20℃±2℃

Temperature.....20℃±2℃

相对湿度.....65%±5%

Relative humidity.....65%±5%

环境气压.....86KPa~106Kpa

Air pressure.....86KPa~106Kpa

|            |                |            |              |           |               |
|------------|----------------|------------|--------------|-----------|---------------|
| APPROVE BY | Jason 08.08.13 | CHECKED BY | Max 08.08.13 | PRPARE BY | Euni 08.08.13 |
|------------|----------------|------------|--------------|-----------|---------------|

# APPROVAL SPECIFICATIONS

|          |                |            |             |          |
|----------|----------------|------------|-------------|----------|
| CUSTOMER | CUSTOMER'S P/N | P/N        | PRODUCT     | REVISION |
|          |                | BTS-1157ND | TACT SWITCH | A        |

2、 详细说明

**Detailed specification**

2.1 外观：应无影响、降低产品性能的缺陷；

**Appearance: There should be no defects that affect the serviceability of product.**

2.2 结构尺寸和安装尺寸：应符合图纸要求；

**Style and dimension: shall conform to the assemble drawings.**

2.3 操作形式：有触觉反应的操作

**Type of actuating: Tactile feedback.**

2.4 开关结构：单回路单输出(具体的触点结构在图纸中已绘出)；

**Contact arrangement: 1 pole, 1 throw**

**(Details of contact arrangement are given in the assembly drawings.)**

2.5 开关工作额定值：DC 12V, 50mA (有效值)

**Ratings: 12V DC, 50mA (effective value)**

3. 电气性能：

**ELECTRICAL SPECIFICATION**

|            | 项 目<br>ITEM                         | 试 验 条 件<br>TEST CONDITIONS   | 要 求<br>REQUIREMENTS   |
|------------|-------------------------------------|--|---|
| 1          | 接触电阻<br>Contact<br>Resistance       | <p>在以 5V 10mA 的直流电源或不低于 1KHz 的交流电源的电路中，以一个等于 2 倍按力的静负荷施加于手柄中心</p> <p><b>Applying a static load of 2 times operating force to the center of the stem, measurements shall be made by 5V DC 10mA or more than 1KHZ AC small-current contact resistance meter.</b></p> | $\leq 50m\Omega$  |
| 2          | 绝缘电阻<br>Insulation<br>Resistance    | <p>在端子之间施加 DC 100V /1min 的条件下，测量端子之间底座、盖板的电阻值</p> <p><b>Measurement shall be made following application of 100V DC potential, across terminals, and across terminals and cover, for one minute.</b></p>  | $\geq 100M\Omega$   |
| 3          | 介质耐压<br>Dielectric<br>voltage proof | <p>在端子之间施加 250V AC(50HZ 或 60HZ)/1min</p> <p><b>250V AV (50HZ or 60HZ) shall be applied across terminals, for one minute.</b></p>   | <p>无击穿、无飞弧</p> <p><b>There should be no breakdown and flashover</b></p> |
| APPROVE BY | Jason 08.08.13                      | CHECKED BY   | Max 08.08.13  |
| PRPARE BY  | Euni 08.08.13                       |  |   |

# APPROVAL SPECIFICATIONS

| CUSTOMER                                     | CUSTOMER'S P/N  | P/N        | PRODUCT      | REVISION                              |
|--|---|------------|--------------|---------------------------------------|
|  |   | BTS-1157ND | TACT SWITCH  | A                                     |
| 项目<br>ITEM                                   | 试验条件<br>TEST CONDITIONS   |            |              | 要求<br>REQUIREMENTS                    |
| 4  | <p>触点弹力<br/>Bounce</p> <p>按照正常使用时的力度轻按手柄中心（每秒 3~4 次），在导通和断开过程中测试开关弹力<br/>Lightly striking the center of the stem at a rate encountered in normal use (3 to 4 times per second), and bounce shall be tested at "ON" and "OFF"</p> <div style="text-align: center;"> </div>   |            |              | <p>ON-3msec.max<br/>OFF-8msec.max</p> |
| <p>4. 机械性能:<br/>MECHANICAL SPECIFICATION</p> |   |            |              |                                       |
| 1  | <p>按力<br/>Operating Force</p> <p>开关垂直于操作方向放置，在开关驱动件顶端中心逐渐施力，测量开关导通所需的最大力度。<br/>Placing the switch such that the direction of switch operation is vertical and then gradually increasing the load applied to the center of the stem, the maximum load required for the switch to come to a stop shall be measured.</p> |            |              | <p>refer to chart 2</p>               |
| APPROVE BY                                   | Jason 08.08.13  | CHECKED BY | Max 08.08.13 | PRPARE BY                             |
|  |   |            |              | Euni 08.08.13                         |

# APPROVAL SPECIFICATIONS

| CUSTOMER   | CUSTOMER'S P/N                 | P/N   | PRODUCT      | REVISION  |
|------------|--------------------------------|---|--------------|---|
|            |                                | BTS-1157ND  | TACT SWITCH  | A   |
| 项目<br>ITEM | 试验条件<br>TEST CONDITIONS        |   |              | 要求<br>REQUIREMENTS  |
| 2          | 最大行程<br>Full<br>Travel         | 开关垂直于操作方向放置，以一个等于 2 倍按力的静负荷施加在开关驱动件顶端中心，测量顶端移动的距离。<br>Placing the switch such that the direction of switch operation is vertical and then applying static load of 2times operating force to the center of the stem; the travel distance for the switch to come to a stop shall be measured. |              | 0.25±0.1mm  |
| 3          | 回弹力<br>Return<br>Force         | 开关垂直于操作方向放置，在开关驱动件顶端中心下降至全行程后，测量顶端向自由位置转换的力度。<br>The sample switch is installed such that the direction of switch operation is vertical and upon depressing the stem in its center to the whole travel distance, the force of the stem to return to its free position shall be measured.    |              | refer to chart 2  |
| 4          | 停止强度<br>Stop<br>Strength       | 开关垂直于操作方向放置，从操作方向向驱动件施加 30N 的静负荷持续 1min。<br>Placing the switch such that the direction of switch operation is vertical, and then a static load of 30N shall be applied in the direction of stem operation for a period of 1 min.  |              | 无机械和电气损坏<br>There shall be no sign of damage mechanically and electrically. |
| 5          | 手柄拔出<br>强度<br>Stem<br>Strength | 开关垂直于操作方向放置，反方向实施最大操作力，并测量手柄的行程范围。<br>Placing the switch such that the direction of switch operation is vertical, and then the maximum force to withstand a pull applied opposite to the direction of stem operation shall be measured.   |              | 20N.min.  |
| APPROVE BY | Jason 08.08.13                 | CHECKED BY  | Max 08.08.13 | PRPARE BY<br>Euni 08.08.13  |

# APPROVAL SPECIFICATIONS

| CUSTOMER                                 | CUSTOMER'S P/N                        | P/N  | PRODUCT      | REVISION   |
|--|---------------------------------------|--|--------------|--|
|  |                                       | BTS-1157ND   | TACT SWITCH  | A  |
| 项目<br>ITEM                               |                                       | 试验条件<br>TEST CONDITIONS  |              | 要求<br>REQUIREMENTS   |
| 6  | 可焊性<br>Solderability                  | 在以下设定条件下进行测量:<br>Measurements shall be made following the test set forth below:<br>(1) 焊接温度:255±5℃<br>Solder temperature : 255±5℃<br>(2) 浸入时间:2s±0.5s<br>Immersion time: 2s±0.5s<br>对于其它步骤参考《GB 5095.6—86》试验 12a<br>The other steps please refer to 《GB 5095.6-86》TEST 12a |              | 除边缘外涂层应均匀覆盖 90%以上<br>Except for the edge, the coating should cover a minimum 90%     |
| 5、极限电气性能:<br>ENVIRONMENTAL SPECIFICATION |                                       |  |              |  |
| 1  | 低温测试<br>Resistance to low temperature | 样品应放在常温及标准湿度的环境中 1 小时后，根据下面的测试要求进行测试:<br>Following the test set forth below the sample shall be left in normal temperature and humidity conditions for 1 h before measurements are made:<br>(1) 温度: -30±2℃<br>Temperature :-30±2℃<br>(2) 时间: 96h<br>Time: 96h              |              | 接触电阻: ≤200mΩ<br>Contact resistance: ≤200mΩ<br>项目 3,4.1,4.2,4.3<br>Item 3,4.1,4.2,4.3 |
| APPROVE BY                               | Jason 08.08.13                        | CHECKED BY   | Max 08.08.13 | PRPARE BY<br>Euni 08.08.13   |

# APPROVAL SPECIFICATIONS

| CUSTOMER   | CUSTOMER'S P/N                      | P/N   | PRODUCT      | REVISION           |   |             |      |            |        |         |         |   |       |   |         |   |   |
|------------|-------------------------------------|---|--------------|--------------------|---|-------------|------|------------|--------|---------|---------|---|-------|---|---------|---|---|
|            |                                     | BTS-1157ND  | TACT SWITCH  | A                  |   |             |      |            |        |         |         |   |       |   |         |   |   |
| 项目<br>ITEM | 试验条件<br>TEST CONDITIONS             |   |              | 要求<br>REQUIREMENTS |   |             |      |            |        |         |         |   |       |   |         |   |   |
| 2          | 高温测试<br>Heat<br>resistance          | 样品应放在常温及标准湿度的环境中 1 小时后，根据下面的测试要求进行测试：<br>Following the test set forth below the sample shall be left in normal temperature and humidity conditions for 1 h before measurements are made:<br>(1) 温度: 80±2℃<br>temperature:80±2℃<br>(2) 时间: 96h<br>time: 96h  |              |                    | 接触电阻: ≤200mΩ<br>Contact resistance:<br>≤200mΩ<br>项目 3,4.1,4.2,4.3<br>Item 3,4.1,4.2,4.3 |             |      |            |        |         |         |   |       |   |         |   |   |
| 3          | 温度周期性测试<br>Change of<br>temperature | 样品应放在常温及标准湿度的环境中 1 小时后，根据下面的测试要求进行 5 次循环的温度周期性测试：<br>测试期间样品应保持干燥<br>After 5 cycles of following conditions, the sample shall be allowed to stand under normal temperature and humidity conditions for 1 h. and measurements shall be made. During the test waterdrops shall be removed. <table border="1" style="margin: 10px auto; border-collapse: collapse;"> <thead> <tr> <th style="width: 10%;"></th> <th style="width: 40%;">Temperature</th> <th style="width: 50%;">Time</th> </tr> </thead> <tbody> <tr> <td rowspan="4" style="text-align: center; vertical-align: middle;">1<br/>cycle</td> <td style="text-align: center;">-10±2℃</td> <td style="text-align: center;">2(hour)</td> </tr> <tr> <td style="text-align: center;">-10~65℃</td> <td style="text-align: center;">1</td> </tr> <tr> <td style="text-align: center;">65±2℃</td> <td style="text-align: center;">2</td> </tr> <tr> <td style="text-align: center;">65~-10℃</td> <td style="text-align: center;">1</td> </tr> </tbody> </table> |              |                    |   | Temperature | Time | 1<br>cycle | -10±2℃ | 2(hour) | -10~65℃ | 1 | 65±2℃ | 2 | 65~-10℃ | 1 | 接触电阻: ≤200mΩ<br>Contact resistance:<br>≤200mΩ<br>项目 3,4.1,4.2,4.3<br>Item 3,4.1,4.2,4.3 |
|            | Temperature                         | Time  |              |                    |   |             |      |            |        |         |         |   |       |   |         |   |   |
| 1<br>cycle | -10±2℃                              | 2(hour)   |              |                    |   |             |      |            |        |         |         |   |       |   |         |   |   |
|            | -10~65℃                             | 1   |              |                    |   |             |      |            |        |         |         |   |       |   |         |   |   |
|            | 65±2℃                               | 2   |              |                    |   |             |      |            |        |         |         |   |       |   |         |   |   |
|            | 65~-10℃                             | 1   |              |                    |   |             |      |            |        |         |         |   |       |   |         |   |   |
| APPROVE BY | Jason 08.08.13                      | CHECKED BY  | Max 08.08.13 | PRPARE BY          | Euni 08.08.13   |             |      |            |        |         |         |   |       |   |         |   |   |

# APPROVAL SPECIFICATIONS

| CUSTOMER   | CUSTOMER'S P/N                    | P/N  | PRODUCT      | REVISION  |
|------------|-----------------------------------|--|--------------|---|
|            |                                   | BTS-1157ND   | TACT SWITCH  | A   |
| 项目<br>ITEM | 试验条件<br>TEST CONDITIONS           |  |              | 要求<br>REQUIREMENTS  |
| 4          | 湿温测试<br>Moisture<br>resistance    | <p>样品应放在常温及标准湿度的环境中 1 小时后，根据下面的测试要求进行测试：<br/>Following the test set forth below the sample shall be left in normal temperature and humidity conditions for 1 h before measurements are made:</p> <p>(1) 温度: 60±2℃<br/>temperature: 60±2℃</p> <p>(2) 相对湿度: 90%~95%<br/>relative humidity:90% to 95%</p> <p>(3) 时间: 96h<br/>time: 96h</p>  |              | <p>接触电阻: ≤200mΩ<br/>Contact resistance:<br/>≤200mΩ</p> <p>项目 3,4.1,4.2,4.3<br/>Item 3,4.1,4.2,4.3</p> |
| 5          | 硫化试验<br>Sulfuration<br>resistance | <p>样品应放在常温及标准湿度的环境中 1 小时并重复 2~3 次后，根据下面的测试要求进行测试：<br/>Following the test set forth below the sample shall be left in normal temperature and humidity conditions for 1 h and repeat two to three times before measurements are made:</p> <p>(1) H<sub>2</sub>S 气体浓度: 3ppm±1ppm<br/>H<sub>2</sub>S gas concentration: 3ppm±1ppm</p> <p>(2) 时间: 72h<br/>Time: 72h</p> <p>(3) 温度: 40±2℃ (90~95%RH)<br/>temperature: 40±2℃ (90~95%RH)</p> |              | <p>接触电阻: ≤200mΩ<br/>Contact resistance:<br/>≤200mΩ</p> <p>项目 3,4.1,4.2,4.3<br/>Item 3,4.1,4.2,4.3</p> |
| 6          | 盐雾试验<br>Salt Mist                 | <p>在以下设定条件下进行测量：<br/>The switch shall be checked after following test:</p> <p>(1) 温度: 35℃±2℃<br/>temperature: 35℃±2℃</p> <p>(2) 盐溶液浓度: 5±1% (质量百分比)<br/>salt solution : 5±1%(solids by mass)</p> <p>(3) 时间: 8h±1h<br/>Time: 8h±1 hour</p> <p>实验后的盐沉积物后水冲掉 After test,salt deposit shall be removed by running water.</p>   |              | <p>金属件上没有腐蚀斑点<br/>No<br/>remarkable corrosion<br/>shall be recognized in<br/>metal part.</p>          |
| APPROVE BY | Jason 08.08.13                    | CHECKED BY   | Max 08.08.13 | PRPARE BY<br>Euni 08.08.13  |

# APPROVAL SPECIFICATIONS

|          |                |            |             |          |
|----------|----------------|------------|-------------|----------|
| CUSTOMER | CUSTOMER'S P/N | P/N        | PRODUCT     | REVISION |
|          |                | BTS-1157ND | TACT SWITCH | A        |

**6、极限机械性能:**

**ENDURANCE SPECIFICATION**

|   | 项目<br>ITEM             | 试验条件<br>TEST CONDITIONS   | 要求<br>REQUIREMENTS                     |     |          |   |     |         |   |     |         |  |
|---|------------------------|---|--|-----|----------|---|-----|---------|---|-----|---------|--|
| 1 | 工作寿命<br>Operation life | 根据下面的测试要求进行测试:<br>Measurement shall be made following the test set forth below:<br>(1) DC 12V, 50mA 带负载<br>DC 12V, 50 mA resistive load<br>(2) 按动速率: 2~3 次/秒<br>Rate of operation: 2 to 3 times/s<br>(3) 按力: 按力的 1.5~2 倍<br>(4) Operating Force: Operating Force 1.5~2 倍<br>(5) 平均无故障寿命: Average fault-free life<br><table border="1" style="margin-left: 20px; border-collapse: collapse; width: 100%;"> <tr> <td style="width: 10%; text-align: center;">1</td> <td style="width: 15%; text-align: center;">1.0</td> <td style="width: 75%; text-align: center;">100000 次</td> </tr> <tr> <td style="text-align: center;">2</td> <td style="text-align: center;">1.6</td> <td style="text-align: center;">80000 次</td> </tr> <tr> <td style="text-align: center;">3</td> <td style="text-align: center;">2.6</td> <td style="text-align: center;">60000 次</td> </tr> </table> | 1                                      | 1.0 | 100000 次 | 2 | 1.6 | 80000 次 | 3 | 2.6 | 60000 次 | 接 触 电 阻<br>≤200mΩ Contact resistance ≤200mΩ<br>触点弹力 ≤10ms<br>Contact bounce ≤10ms<br>按力: 初值的 ±30%<br>Operating Force: initial value ±30%<br>项目 3,4.1,4.2,4.3<br>Item 3,4.1,4.2,4.3 |
| 1 | 1.0                    | 100000 次  |  |     |          |   |     |         |   |     |         |  |
| 2 | 1.6                    | 80000 次   |  |     |          |   |     |         |   |     |         |  |
| 3 | 2.6                    | 60000 次   |  |     |          |   |     |         |   |     |         |  |
| 2 | 振动<br>Vibration        | 根据以下给定条件进行测试:<br>Measurement shall be made following the test set forth below:<br>(1) 振动频率范围: 10~55~10Hz<br>Vibration frequency range: 10 to 55 to 10Hz<br>(2) 振幅 (峰-峰): 1.5mm<br>Amplitude: 1.5mm<br>(3) 振动方向: 包括手柄行程方向在内的三个相互垂直的方向<br>Direction of vibration: Three mutually perpendicular direction including the direction of stem travel<br>(4) 测试时间: 每次 2hours .<br>Duration: Each 2hours.  | 项目 3,4.1,4.2,4.3<br>Item 3,4.1,4.2,4.3 |     |          |   |     |         |   |     |         |  |

|            |                |            |              |           |               |
|------------|----------------|------------|--------------|-----------|---------------|
| APPROVE BY | Jason 08.08.13 | CHECKED BY | Max 08.08.13 | PRPARE BY | Euni 08.08.13 |
|------------|----------------|------------|--------------|-----------|---------------|

# APPROVAL SPECIFICATIONS

|          |                |            |             |          |
|----------|----------------|------------|-------------|----------|
| CUSTOMER | CUSTOMER'S P/N | P/N        | PRODUCT     | REVISION |
|          |                | BTS-1157ND | TACT SWITCH | A        |

**7. 焊接条件:**

**SOLDERING CONDITIONS:**

| 项目<br>ITEM | 推荐条件<br>Recommended conditions |
|------------|--------------------------------|
|------------|--------------------------------|

|     |                        |  |
|-----|------------------------|--|
| 7.1 | 手工焊接<br>Hand soldering | <p>请按以下条件进行焊接:</p> <p>(1) 焊锡温度: <math>\leq 350^{\circ}\text{C}</math></p> <p>(2) 连续焊接时间: <math>\leq 3\text{s}</math></p> <p>Please practice according to below conditions:</p> <p>(1) Soldering temperature: <math>\leq 350^{\circ}\text{C}</math> Max.</p> <p>(2) Continuous soldering time: <math>\leq 3\text{s}</math> Max.</p> |
|-----|------------------------|--|

|     |                               |  |
|-----|-------------------------------|--|
| 7.2 | 回流焊时<br>Conditions for reflow | <div style="text-align: center;"> <p>Temperature(<math>^{\circ}\text{C}</math>)</p> <p>30~40s</p> <p>2min <math>\pm</math> 0.3min</p> <p>10s max.</p> <p>3~4min</p> <p>焊接炉内通过的时间<br/>Time inside soldering equipment</p> </div> <p>说明:</p> <ol style="list-style-type: none"> <li>1、建议选用含助焊剂 0.2% 以下的锡膏，并避免助焊剂进入开关内而导致开关失效。</li> <li>2、设计按压推柄时，请参考所提供的图低，切勿以尖状物直接按压开关，且压柄需垂直置于开关中心位置按压，并将压柄摇晃度控制在 <math>\pm 3^{\circ}</math> 以内。</li> <li>3、开关焊接加工时，应特别注意将温度及时间控制在 <math>260^{\circ}\text{C} \pm 2^{\circ}\text{C}</math>、10 秒内，否则过高的温度及过长的时间会导致开关的损坏或使用寿命减短。</li> <li>4、焊接加工时开关应保持 OFF 状态，以避免开关损坏。</li> </ol> |
|-----|-------------------------------|--|

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|------------|----------------|------------|--------------|-----------|---------------|
| APPROVE BY | Jason 08.08.13 | CHECKED BY | Max 08.08.13 | PRPARE BY | Euni 08.08.13 |
|------------|----------------|------------|--------------|-----------|---------------|