







## Grayhill DIP Switch Processing Information

The information provided within is intended as processing guidelines for the assembly, soldering, cleaning, and use of Grayhill DIP switches. This information supersedes any other process information that is available in Grayhill Inc. catalogs or data sheets as related to Grayhill Inc. standard DIP switch products. Please contact Grayhill Inc. for any questions related to the information in this document.

### Mounting

Unless otherwise noted, Grayhill DIP switches are shipped with slides or rockers in the ON position and rotary DIP switches are shipped with the actuators in the 0 position. It is recommended that they be solder processed in those positions to ensure proper performance without issue.

### Soldering

**WAVE SOLDER:** Switches that can be processed using wave solder equipment (thru hole soldering) are as follows:

Grayhill Series 76SB, 76PSB, 76RSB, 76SC, 76RSC, 76RSD, 76SD, 76STC, 76STD, 78B, 78RB, 78F, 78G, 78H, 78J, 78K, 90B, 94H (thru hole models), and 94R

**Wave soldering guidelines:** Solder wave temperature is 260°C. max. for 5 seconds max. (0.063" thick PCB). Exposure to flux should be kept to a minimum.

**Manual soldering guidelines** (for thru hole switches): Soldering temperature is 350C for soldering iron tip with 3 seconds maximum of dwell time.

**REFLOW SOLDER:** Switches that can be processed using reflow process equipment are as follows:

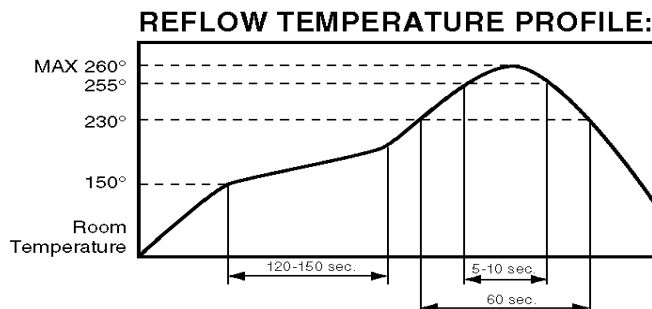
Grayhill Series 76HP, 78HF, 78HJ, 90B, 90HB, 94H, 94R, 97C, and 97R

**Reflow soldering guidelines:** Soldering temperature is 260C max. for 5 seconds, with a maximum of two reflow cycles at the maximum conditions. Switches should be allowed to cool for 3 to 5 minutes between reflow cycles. Reflow soldering should not be done to any Grayhill DIP switch products not listed directly above as the exposure to higher surface temperatures could cause permanent deformation of the plastic materials.

### Recommended Maximum Soldering Conditions:

#### Reflow Soldering Profile:

(260°C Peak Temperature)



### PCB Cleaning

In-line DIP switches that are tape sealed can be processed using certain washing processes as described below. Tape sealed switches can typically be identified by a suffix of ST or PT that follows after the series, switch style, and number of position identifiers (i.e., 76SB08ST). Non-tape sealed switches should not be subjected to any washing processes as they can introduce contaminants into the contact area of the switches. Rotary DIP products (94H & 94R) are internally sealed and can be processed the same as tape sealed products.

Tape sealed and rotary DIP switch products are qualified for immersion cleaning processes using alcohol or detergent based cleaning solvents at temperatures up to 140°F. maximum. Tape seal products must have the tape seal undisturbed until after any cleaning process. Cleaning processes that use ultrasonic agitation or that use pressurized sprays can defeat the tape and / or internal seals and allow contamination of the switches. They are not recommended for use on inline or rotary DIP products. Switches should not be washed directly after a soldering process. There should be a delay of at least three minutes to allow adequate time for cooling after soldering.

**Tape seal integrity:** Inline DIP products that are tape sealed are tested to meet and pass a gross leak test using 125°C Fluorinert for 20 seconds minimum. Reference MIL-202, Method 112.

Tape seal material:

76,78: Polyester film, rated to 170°F. maximum temperature

90: Polyimide film, rated to 260°C. maximum temperature

