# APPLICATION NOTE

# Fixture Design

## for Soldering Connector Pins with Washer Preforms

### Objective

Design a fixture to facilitate placement of multiple solder washer preforms in one shot, thus minimizing process time.

## Fixture Design

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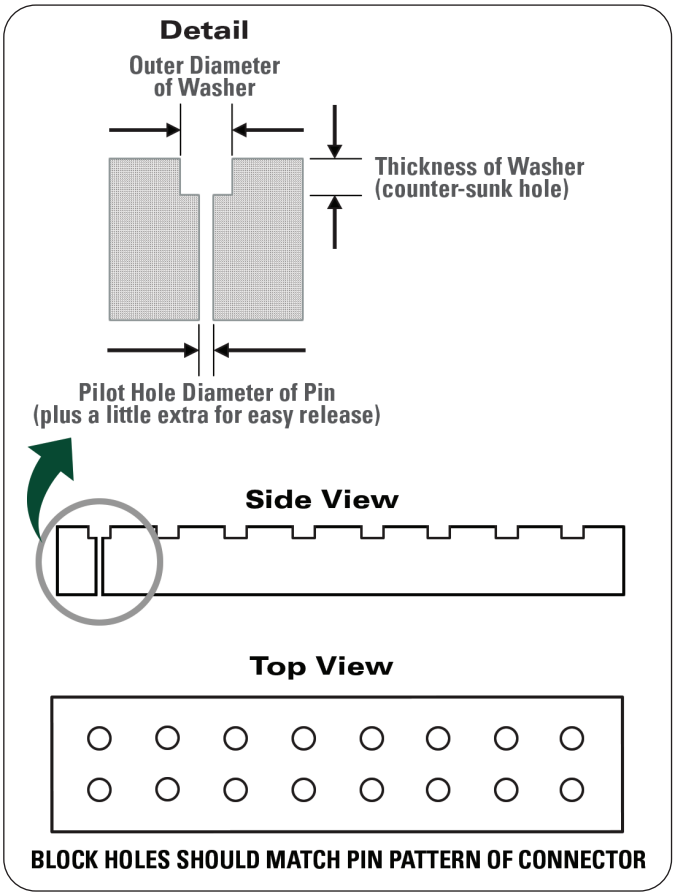
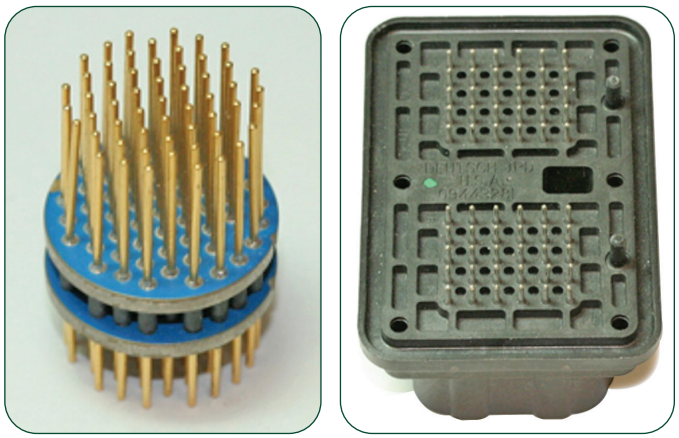



Ensure that the counter-sunk holes and the pilot holes in the fixture can accommodate the dimensional tolerances of the washer and connector pin, respectively.

Ensure that the fixture holes are machined to align with the connector pin array (X, Y, pitch).

## Placement Procedure of Solder Washer Preforms

- Gently slide the solder washer preforms over the fixture surface to fill all the counter-sunk holes.
- Ensure that each solder washer is securely seated within its respective hole.
- Mate the fixture with the washer preforms to the connector, aligning the pins with the corresponding counter-sunk holes and pilot holes.
- Now, gently invert the fixture to transfer the washer preforms from the fixture to the connector pins.
- Release the fixture away from the connector pins, ensuring that all washers have been successfully released from the fixture.
- If the washers are flux-coated, periodically clean the block to prevent solder washers sticking to the counter-sunk holes.



*Examples of multi-pin connector components.*

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*All of Indium Corporation's solder paste and preform manufacturing facilities are IATF 16949:2016 certified.*
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Contact our engineers: askus@indium.com
Learn more: www.indium.com

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ASIA +65 6268 8678 • CHINA +86 (0) 512 628 34900 • EUROPE +44 (0) 1908 580400 • USA +1 315 853 4900

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