

General Information

How to get the best results with MEC Switches

Usage Guidelines

successful and reliable switch operation These guidelines are offered to users of MEC switches as an aid to ensure

MEC strongly recommend that the temperature profile is analysed and compared with the temperature rating of the switch. In case of doubt always select the high temperature version 3XXH9. operating and storage temperatures and soldering guidelines to make sure temperature materials. Please see the technical specifications for details you select the switch best suited to your application. When flow soldering, Both UNIMEC and MULTIMEC switches are produced in standard and high

recommended that accessories are mounted after soldering.

LED's have their own temperature specifications. When fitted in a high temperature switch the LED will determine the max, operating temperature. soldering processes exposing the switch to high temperatures it is strongly be taken not to overheat the accessories during the soldering process. In All accessories for both UNIMEC and MULTIMEC switches are made from ABS plastic with a maximum operating temperature of 65°C. Care must . 3FTH922 has an upper temperature limit of 85°C - not 160°C!

When infrared reflow soldering is used, it is very important to monitor the surface temperature of the switch during the pre-heat stage to prevent essive heat buildup and overheating during soldering

Mounting

and terminal hole diameters should be 0.9mm If switches are to be mounted in rows it is critical that the recommendations regarding spacing are followed. PC board thickness should be 1.2 to 1.6mm

All UNIMEC and MULTIMEC caps and bezels are easily snapped onto the switch modules and can be changed at a later time with the exception of the UNIMEC 16.700 cap. Once this cap is installed it is not designed to be removed. To do so may cause damage to the switch and the PC board if not done with extreme care. If the 16.300 or 16.700 cap must be removed. released, upper position before attempting to remove the cap. This will prevent possible damage to the internal latching pin. an alternate action switch, make sure that the switch actuator is in the

Care must be taken when inserting the 3FT switch and LED assembly into the PC board. Do not press direct on the LED. This will force the LED down into the actuator and cause the switch contacts to remain in the closed position. To correct the fault, the LED must be raised slightly and centered in the actuator to assure unrestricted movement of the actuator.

Soldering and Cleaning UNIMEC

the switch in the solder bath or spray the switch during cleaning. The switch must be protected at all times to prevent contamination by flux or cleaning and cleaning. Contact contamination may be recognized by an increase in contact resistance and possible intermittent operation of the switch, especially in low power applications. Care must be taken not to submerge switches are caused by the contamination of the contacts during soldering embly and field problems experienced by users of unsealed

solder flux and aqueous or solvent cleaning solutions from entering the switch and contaminating the contacts. The switches can be placed on the Soldering and Cleaning MULTIMEC MULTIMEC switches are fully sealed to IF MULTIMEC switches is required, but notice the guidelines mentioned under PC board with other components and wave soldered. No spec switches are fully sealed to IP-67M specifications to prevent ial handling of

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Soldering Multimec

Hand soldering: Max 350°C for max. 3 s., this applies for both low tempera Through hole versions

must not exceed 260°C, and soldering time is max. 10 s. commend using high temperature switches some reason, a high pre-heating temperature is required, Mec strongly remust not exceed the maximum operating temperature of the switch. If, for Wave soldering: Heat built up in the switch during pre-heating and soldering ture and high temp. versions . In any cases peak temperature

Surface Mount versions

moderate temperature gradients 260°C/30 s. must be observed. The soldering temperature profile must have For all methods - Infrared, convection and vapour phase - the upper limit ∆T/t.

General Temperature limitations

LE D'S High temperature Low temperature 65°C 160°C 85/100°C 65°C

Mec recommend that accessories are mounted after soldering, unless the process allows the heat exposure to be kept within the limits of 65°C. Combinations of high temperature switches with LED's will be limited by the temperature capability of the LED.

each and MULTIMEC switches are packed in rigid tubes of 50 pieces

How to Assemble Examples

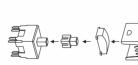
unimec 15 16300 + 16310

> unimec 15 + 16270 + 16300 + 16324









multimec® 3AT + 1A/H + 2A/B

multimec® 3AT + 1B/C + 2A/B



