

**OMNIMATE Signal - series BL/SL 5.08
SL-SMT 5.08HC/04/90G 3.2SN BK BX**

Weidmüller Interface GmbH & Co. KG
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www.weidmueller.com



High-temperature-resistant pin header, packed in box or tape. On tape, with 1.5 mm solder pin, optimised for automatic assembly. 3.2 mm solder pin suitable for reflow and wave soldering. The pin headers provide space for labelling and can be coded. HC = High Current.

General ordering data

Type	SL-SMT 5.08HC/04/90G 3.2SN BK BX
Order No.	1780200000
Version	PCB plug-in connector, male header, closed side, THT/THR solder connection, 5.08 mm, No. of poles: 4, 90°, Solder pin length (l): 3.2 mm, tinned, Black, Box
GTIN (EAN)	4032248165520
Qty.	100 pc(s).
Product data	IEC: 400 V / 27.5 A UL: 300 V / 18.5 A
Packaging	Box

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Technical data**Dimensions and weights**

Net weight	1.978 g
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System parameters

Product family	OMNIMATE Signal - series BL/SL 5.08	Mounting onto the PCB	THT/THR solder connection
Outgoing elbow	90°	Pitch in mm (P)	5.08 mm
Pitch in inches (P)	0.2 inch	No. of poles	4
Solder pin length (l)	3.2 mm	Solder pin length tolerance	0 / -0.3 mm
Solder pin dimensions	d = 1.2 mm, Octagonal	Plugging cycles	25
Can be coded	Yes	Number of solder pins per pole	1
Solder eyelet hole diameter (D)	1.4 mm	Solder eyelet hole diameter tolerance (D)	+ 0,1 mm
L1 in mm	15.24 mm	L1 in inches	0.6 inch
Insulation resistance	≥ 10 ⁸ Ω		


Material data

Insulating material	LCP GF	Moisture Level (MSL)	1
Colour	Black	Insulating material group	IIIa
UL 94 flammability rating	V-0	CTI	≥ 175
Contact material	CuSn	Layer structure of solder connection	2-3 µm Ni / 2-4 µm Sn matt
Contact surface	tinned	Operating temperature, min.	-50 °C
Operating temperature, max.	100 °C	Temperature range, installation, min.	-30 °C
Temperature range, installation, max.	100 °C	Storage temperature, min.	-25 °C
Storage temperature, max.	55 °C	Max. relative humidity during storage	80 %

Rating data acc. to IEC 60664-1 / IEC 61984

Rated current, min. no. of poles (Ta = 20°C)	27.5 A	Rated current, max. no. of poles (Ta = 20°C)	19 A
Rated current, min. no. of poles (Ta = 40°C)	24 A	Rated current, max. no. of poles (Ta = 40°C)	16.5 A
Rated voltage for surge voltage class / pollution degree III/3	250 V	Rated impulse voltage for surge voltage class/ contamination degree III/3	4 kV
Rated voltage for surge voltage class / pollution degree III/2	320 V	Rated impulse voltage for surge voltage class/ pollution degree III/2	4 kV
Rated voltage for surge voltage class / pollution degree II/2	400 V	Rated impulse voltage for surge voltage class/ pollution degree II/2	4 kV

Rated data acc. to CSA

Institute (CSA)		Certificate No. (CSA)	200039-1176845
Rated voltage (Use group B)	300 V	Rated voltage (use group D)	300 V
Rated current (use group B)	18.5 A	Rated current (use group D)	18.5 A
Reference to approval values	Specifications are maximum values, details - see approval certificate.		

Data sheet

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Technical data

Rated data acc. to UL 1059

Institute (UR)



Certificate No. (UR)

E60693

Rated voltage (use group B)	300 V
Rated current (use group B)	18.5 A
Reference to approval values	Specifications are maximum values, details - see approval certificate.

Rated voltage (use group D)	300 V
Rated current (use group D)	10 A

Classifications

ETIM 3.0	EC001284	ETIM 4.0	EC002637
ETIM 5.0	EC002637	ETIM 6.0	EC002637
UNSPSC	30-21-18-10	eClass 5.1	27-26-07-04
eClass 6.2	27-26-07-04	eClass 7.1	27-44-04-02
eClass 8.1	27-44-04-02	eClass 9.0	27-44-04-02

Notes

- Notes
- Gold-plated contact surfaces on request
 - Rated current related to rated cross-section & min. No. of poles.
 - Diameter of solder eyelet D = 1.4+0.1mm
 - Solder eyelet diameter D = 1.5 + 0.1 mm, from 9 poles
 - P on drawing = pitch
 - Rated data refer only to the component itself. Clearance and creepage distances to other components are to be designed in accordance with the relevant application standards.

IPC conformity The products are developed, manufactured and delivered according to the internationally recognised IPC-A-610 standard, category "permissible". More extensive demands on the products can be evaluated on request.

Approvals

Approvals



ROHS

Conform

Downloads

EDA Layout Library (Mentor Graphics Expedition, Mentor Graphics Pads, Altium Designer)

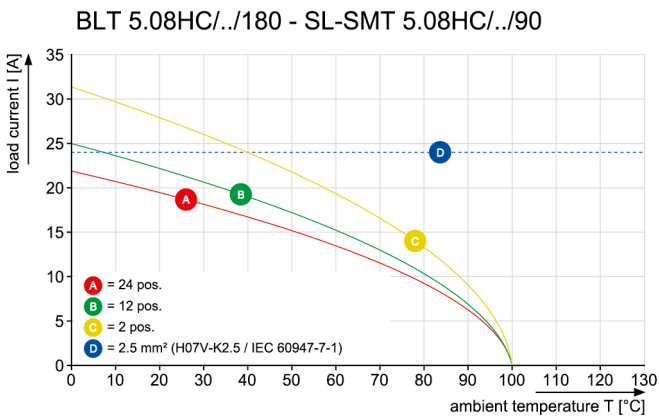
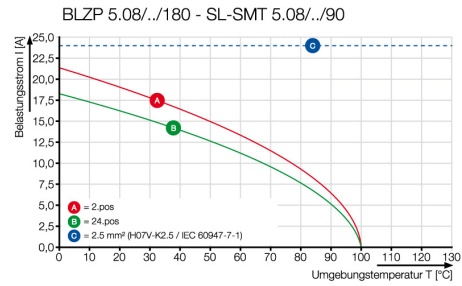
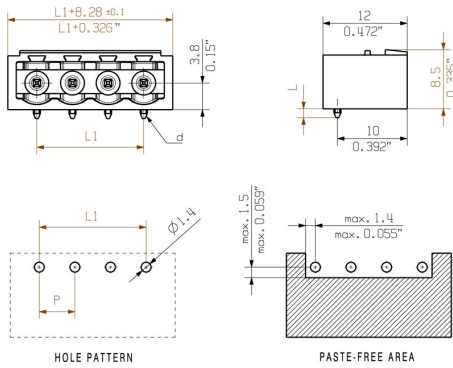
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Data sheet

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Drawings



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Mating connector (fully pluggable)

BLZ 5.08/180



Female plugs with clamping-yoke screw for wire connection with straight (180°) outlet direction. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future. 2017-12-31T00:00:00+01:00	BLZ 5.08/04/180 SN OR BX	1526660000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm², Box	4008190148232	100 pc(s).
This article will no longer be available in the future. 2017-12-31T00:00:00+01:00	BLZ 5.08/04/180 SN BK BX	1526610000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm², Box	4008190049454	100 pc(s).

BLZF 5.08/90



Female plugs with tension-clamp wire connection system. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future. 2015-12-31T00:00:00+01:00	BLZF 5.08/04/90 SN BK BX	1671040000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4,	4008190432713	90 pc(s).

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Mating connector (fully pluggable)

90°, Tension
clamp connection,
Clamping range,
rated connection,
max.: 3.31 mm²,
Box

This article will no longer be available in the future.	2017-12-31T00:00:00+01:00 BLZF 5.08/04/90 SN OR 1670810000 BX	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 90°, Tension clamp connection, Clamping range, rated connection, max.: 3.31 mm ² , Box 4008190432416 90 pc(s)
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BLZ 5.08/270



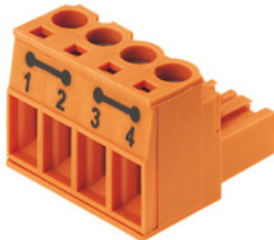
Female plugs with clamping-yoke screw connection. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN) Qty.
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00 BLZ 5.08/04/270 SN OR BX	1557560000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 270°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190104788 90 pc(s)
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00 BLZ 5.08/04/270 SN BK BX	1557510000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 270°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190269449 90 pc(s)

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Mating connector (fully pluggable)
BLZ 5.08 QV2


Female plugs with clamping-yoke screw connections for connecting wire, with straight 180° wire outlet direction and internal cross-connections between connections 1-2 and 3-4. Bus current at 4 mm² (without wire-end ferrule) is up to 32 A. The female plugs can be coded.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future.	BLZ 5.08/04/180QV2 SN BK BX PRT	1839780000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248350308	90 pc(s).
This article will no longer be available in the future.	BLZ 5.08/04/180QV2 SN OR BX PRT	1839770000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248350292	90 pc(s).

BLL 5.08/90


Female header for PCB mounting. The solder pin length is optimised for wave flow soldering.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLL 5.08/04/90 3.2 SN OR BX	1622960000	PCB plug-in connector, female header, closed side, THT solder connection, 5.08 mm, No. of poles: 4, 90°, Solder pin length (l):	4008190194024	90 pc(s).	IEC: 400 V / 23 A UL: 300 V / 15 A	Box

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Mating connector (fully pluggable)

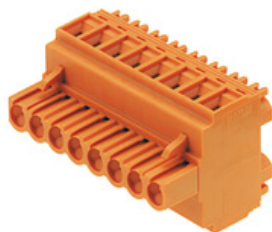
3.2 mm, tinned, Orange,
Box

BLZP 5.08HC/225 SN


Clamping-yoke connection with right-angled (90° or 270°) or angled (225°) outlet direction. The female connectors provide space for labelling and can be coded. Fastened by means of a flange or release latch. They also provide an integrated plus/minus screw, protection against faulty insertion of the wire, and they are delivered with open clamping yokes. HC = High Current.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLZP 5.08HC/04/225 SN BK BX	1946580000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 225°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	403224862235	1 90 pc(s).	IEC: 400 V / 17.5 A / 0.2 - 4 mm ² UL: 300 V / 15 A / AWG 30 - AWG 12	Box
BLZP 5.08HC/04/225 SN OR BX	1946270000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 225°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248621842	90 pc(s).	IEC: 400 V / 17.5 A / 0.2 - 4 mm ² UL: 300 V / 15 A / AWG 30 - AWG 12	Box

BLDT 5.08


Female plugs with two clamping-yoke screw connections per pole for wire connections with 90° and 270° outlet directions. The female plugs provide space for labelling and can be coded.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLDT 5.08/04/- SN BK BX	1660730000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, TOP connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190417185	75 pc(s).	IEC: 400 V / 14 A / 0.2 - 2.5 mm ² UL: 300 V / 10 A / AWG 26 - AWG 12	Box
BLDT 5.08/04/- SN OR BX	1644750000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, TOP	4008190283964	75 pc(s).	IEC: 400 V / 14 A / 0.2 - 2.5 mm ² UL: 300 V / 10 A / AWG 26 - AWG 12	Box

Creation date February 22, 2016 4:39:45 PM CET

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Mating connector (fully pluggable)

connection, Clamping
range, rated connection,
max.: 3.31 mm², Box

BLZP 5.08HC/180 SN



Female plug with clamping-yoke screw system for connecting wires with straight (180°) outlet direction. The female connectors provide space for labelling and can be coded. Fastened by means of a flange or release latch. They also provide an integrated plus/minus screw, protection against faulty insertion of the wire, and they are delivered with open clamping yokes. HC = High Current.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLZP 5.08HC/04/180 SN OR BX	1943600000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	403224861759390	90 pc(s).	IEC: 400 V / 23 A / 0.2 - 4 mm ² UL: 300 V / 20 A / AWG 30 - AWG 12	Box
BLZP 5.08HC/04/180 SN BK BX	1943830000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	403224861786990	90 pc(s).	IEC: 400 V / 23 A / 0.2 - 4 mm ² UL: 300 V / 20 A / AWG 30 - AWG 12	Box

BL 5.08



Female plugs with leaf-spring wire connection system. The female plugs provide space for labelling.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future.	BL 5.08/04/180 SN DKG BX	1723850000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Pressure clamp connection, Clamping range, rated connection,	4008190376215	100 pc(s).

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Mating connector (fully pluggable)

This article will no longer be available in the future.	2017-12-31T00:00:00+01:00 BL 5.08/04/180 SN OR BX 1716340000	max.: 2.08 mm ² , Box	PCB plug-in 4008190376376	100
			connector, female plug, 5.08 mm, No. of poles: 4, 180°, Pressure clamp connection, Clamping range, rated connection, max.: 2.08 mm ² , Box	pc(s).
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00 BL 5.08/04/180 SN BK BX 1716490000	PCB plug-in	4008190376536	100
			connector, female plug, 5.08 mm, No. of poles: 4, 180°, Pressure clamp connection, Clamping range, rated connection, max.: 2.08 mm ² , Box	pc(s).

BLL 5.08/180



Female header for PCB mounting. The solder pin length is optimised for wave flow soldering.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLL 5.08/04/180 3.2 SN OR BX	1630730000	PCB plug-in connector, female header, closed side, THT solder connection, 5.08 mm, No. of poles: 4, 180°, Solder pin length (l): 3.2 mm, tinned, Orange, Box	400819020415090	90 pc(s).	IEC: 400 V / 23 A UL: 300 V / 15 A	Box

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Mating connector (fully pluggable)

BLZF 5.08/270



Female plugs with tension-clamp wire connection system. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status	Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00	BLZF 5.08/04/270 SN OR BX	1671960000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 270°, Tension clamp connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190433673	90 pc(s).
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00	BLZF 5.08/04/270 SN BK BX	1672190000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 270°, Tension clamp connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190433901	90 pc(s).

BLIDC 5.08



Female plugs with IDC wire connection system. The female plugs provide space for labelling and can be coded.

General ordering data

Available until	Type	Order No.	Version	GTIN (EAN)	Qty.	Product data
2011-11-17T00:00:00+01:00	BLIDC 5.08/180 SN OR BX	1724960000	PCB plug-in connector, female plug,	4008190377304	100 pc(s).	IEC: 400 V /

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Mating connector (fully pluggable)

5.08 mm, No. of poles: 4, 180°, IDC terminal,	11 A / 0.5
Clamping range, rated connection, max.: 0.75 mm ² ,	- 0.75 mm ²
Box	UL: 300 V / 5 A / AWG 22 - AWG 20

BLZ 5.08/90



Female plugs with clamping-yoke screw connection. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future. 2017-12-31T00:00:00+01:00	BLZ 5.08/04/90 SN BK BX	1552910000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 90°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190267728	90 pc(s).
This article will no longer be available in the future. 2017-12-31T00:00:00+01:00	BLZ 5.08/04/90 SN OR BX	1552960000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 90°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190123932	90 pc(s).

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Mating connector (fully pluggable)

BLZ 5.08/225

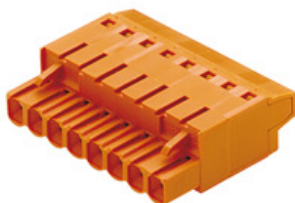


Female plugs with clamping-yoke screw for wire connection with 225° outlet direction. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status	Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00	BLZ 5.08/04/225 SN OR BX	1741660000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 225°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm², Box	4008190202637	90 pc(s).
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00	BLZ 5.08/04/225 SN BK BX	1741890000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 225°, Clamping yoke connection, Clamping range, rated connection, max.: 3.31 mm², Box	4008190254155	90 pc(s).

BLT 5.08HC



Female plugs with TOP screw connection system for connecting wires with straight 180° outlet direction. The female connectors provide space for labelling and can be coded. HC = High Current.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLT 5.08HC/04/180 SN OR BX	1499760000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, TOP connection, Clamping	4008190037536	90 pc(s).	IEC: 400 V / 27 A / 0.2 - 2.5 mm² UL: 300 V / 17 A / AWG 26 - AWG 14	Box

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Mating connector (fully pluggable)

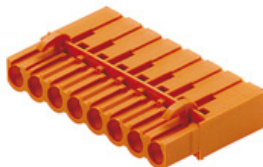
		range, rated connection, max.: 2.5 mm ² , Box			
BLT	1499710000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, TOP connection, Clamping range, rated connection, max.: 2.5 mm ² , Box	400819086171190 pc(s).	IEC: 400 V / 27 A / 0.2 - 2.5 mm ² UL: 300 V / 17 A / AWG 26 - AWG 14	Box
5.08HC/04/180					
SN BK BX					

BLZF 5.08/180


Female plugs with tension-clamp wire connection system, straight 180° outlet direction. The female plugs provide space for labelling and can be coded.

General ordering data

Delivery status	Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future.	2017-12-31T00:00:00+01:00	BLZF 5.08/04/180 SN BK BX	1707710000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Tension clamp connection, Clamping range, rated connection, max.: 3.31 mm ² , Box	4008190316716	90 pc(s).

BLC 5.08R


Female plugs with crimp wire connection system. The female plugs provide space for labelling and can be coded.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLC 5.08/04/180R OR BX	1610510000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Crimp connection, Clamping	4008190065102100 pc(s).		IEC: 400 V / 21 A UL: 300 V / 10 A / AWG 26 - AWG 14	Box

Creation date February 22, 2016 4:39:45 PM CET

**OMNIMATE Signal - series BL/SL 5.08
SL-SMT 5.08HC/04/90G 3.2SN BK BX**

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Mating connector (fully pluggable)

		range, rated connection, max.: 2.5 mm ² , Box		
BLC	1711980000	PCB plug-in connector,	4008190934996 100 pc(s).	IEC: 400 V / 21 A
5.08/04/180R		female plug, 5.08 mm, No.		UL: 300 V / 10 A / AWG 26 - AWG 14
BK BX		of poles: 4, 180°, Crimp connection, Clamping range, rated connection, max.: 2.5 mm ² , Box		

BLZ 5.08F QV2


Female plugs with clamping-yoke screw connections for connecting wire, with straight 180° wire outlet direction and internal cross-connections between connections 1-2 and 3-4. Bus current at 4 mm² (without wire-end ferrule) is up to 32 A. The female plugs can be coded.

General ordering data

Delivery status Available until	Type	Order No.	Version	GTIN (EAN)	Qty.
This article will no longer be available in the future. 2017-12-31T00:00:00+01:00	BLZ 5.08/04/180FQV2 SN BK BX PRT	1844500000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248354948	60 pc(s).
This article will no longer be available in the future. 2017-12-31T00:00:00+01:00	BLZ 5.08/04/180FQV2 SN OR BX PRT	1846870000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 180°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248362684	60 pc(s).

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Mating connector (fully pluggable)
BLZP 5.08HC/270 SN


Female plugs with clamping-yoke connection for connecting wires with a right-angle (90° or 270°) outlet direction. The female connectors provide space for labelling and can be coded. Fastened by means of a flange or release latch. They also provide an integrated plus/minus screw, protection against faulty insertion of the wire, and they are delivered with open clamping yokes. HC = High Current.

General ordering data

Type	Order No.	Version	GTIN (EAN)	Qty.	Product data	Packaging
BLZP 5.08HC/04/270 SN BK BX	1949040000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 270°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248626496 90 pc(s).		IEC: 400 V / 23 A / 0.2 - 4 mm ² UL: 300 V / 20 A / AWG 30 - AWG 12	Box
BLZP 5.08HC/04/270 SN OR BX	1948810000	PCB plug-in connector, female plug, 5.08 mm, No. of poles: 4, 270°, Clamping yoke connection, Clamping range, rated connection, max.: 4 mm ² , Box	4032248626267 90 pc(s).		IEC: 400 V / 23 A / 0.2 - 4 mm ² UL: 300 V / 20 A / AWG 30 - AWG 12	Box

Recommended reflow soldering profile

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Reflow soldering profile

The perfect soldering profile for SMT Surface Mount Technology is one the most exiting question in SMT production. But there are more than one correct answer: The diagram of temperature-on-time is related to processing features of solder paste and to maximum load of components.

We have to consider the following parameters:

- Time for pre heating
- Maximum temperature
- Time above melting point
- Time for cooling
- Maximum heating rate
- Maximum cooling rate

We recommend a typical solder profile with associated process limits. With preheating components and board are prepared smoothly for the solder phase. Heating rate is typically $\leq +3\text{K/s}$. In parallel the solder paste is ‚activated‘. The time above melting point of 217°C the paste gets liquid and components and boards begin to connect. The maximum temperature of 245°C to 254°C should stay between 10 and 40 seconds. In the cooling phase at $\geq -6\text{K/s}$ solder is cured. Board and components cool down while avoiding cold cracks.

Recommended wave soldering profiles

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Single Wave:



Double Wave:



Wave soldering profiles

Wired connection elements should be processed in accordance with the DIN EN 61760-1 standard. We have included two recommendations for practical wave soldering profiles, with which Weidmüller PCB terminals and connectors are qualified.

When choosing a suitable profile for your application, the following factors also need to be considered:

- PCB thickness
- Proportion of Cu in the layers
- Single/double-sided assembly
- Product range
- Heating and cooling rates

The single and double wave profiles each indicate the recommended operating range, including the maximum soldering temperature of 260°C. In practice, the maximum soldering temperature is quite often well below the above maximum profile.

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