



RoHS COMPLIANT BUSHING PRODUCTS

The enclosed components are manufactured with ceramic dielectrics. To minimize possible damage to the components during installation, the following recommendations should be followed.

Handling: Excessive force or direct impact to the components may result in breakage. Lead bending or cutting if necessary should only be done with a support for the lead to prevent mechanical stress to the component. Components with required lead modifications are available from Tusonix.

Mounting Torque: See Table 1

Lead Soldering: Use a temperature controlled soldering iron with 95.5 Sn / 3.8 Ag / 0.7 Cu RMA Flux core solder wire. Maximum temperature to be 500°F (260°C) and a dwell time of 3 seconds maximum. The use of a heat sink between the component body and the solder joint is highly recommended.

Flux Removal: Optimum flux removal can be achieved by vapor degreasing the components immediately after the soldering operation. Total immersion of the components is not recommended.

For information concerning other installation requirements and/or component modifications, consult Tusonix Customer Engineering @ (520) 744-0400.

TABLE 1

Mounting Torque Limits

Thread Size	Clearance Hole	Threaded Hole
4-40 UNC	2 lb-in .226 N-m	1 lb-in .113 N-m
6-32 UNC	2 lb-in .226 N-m	1 lb-in .113 N-m
6-40 UNF	3 lb-in .339 N-m	1.5 lb-in .169 N-m
8-32 UNC	5 lb-in .565 N-m	2.5 lb-in .282 N-m
8-36 UNF	1 lb-in .113 N-m	.5 lb-in .056 N-m
12-28 UNF	8 lb-in .904 N-m	4 lb-in .452 N-m
12-32 UNEF	8 lb-in .904 N-m	4 lb-in .452 N-m
1/4-28 UNF	8 lb-in .904 N-m	4 lb-in .452 N-m
5/16-24 UNF	9 lb-in 1.02 N-m	4.5 lb-in .508 N-m
5/16-32 UNEF	9 lb-in 1.02 N-m	4.5 lb-in .508 N-m
3/8-32 UNEF	9 lb-in 1.02 N-m	4.5 lb-in .508 N-m
M3X0.5	2 lb-in .226 N-m	1 lb-in .113 N-m
M5X0.8	7 lb-in .790 N-m	3.5 lb-in .395 N-m
M6X0.75	8 lb-in .904 N-m	4 lb-in .452 N-m