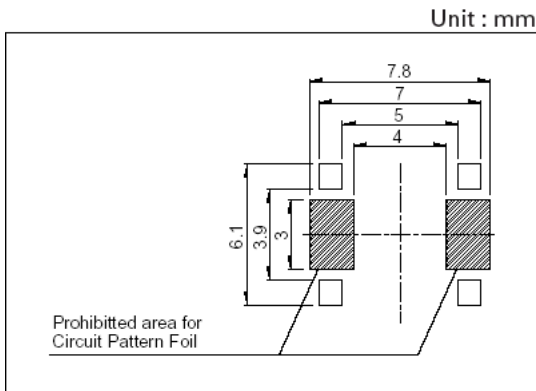
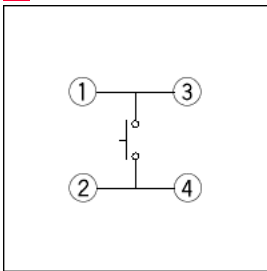




**PC board Land Dimensions**  
(Viewed from Mounting Face)



**Circuit Diagram**



**Soldering Conditions**

Condition for Reflow

1. Heating method

Double heating method with infrared heater.

2. Temperature measurement

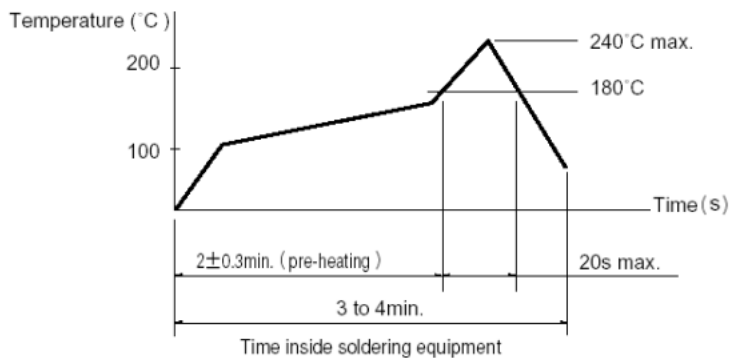
Thermocouple 0.1 to 0.2  $\Phi$  CA(K) or CC(T) at soldering portion(copper foil surface).A heat resisting tape should be used for fixed measurement.

3. Temperature profile

(1) The condition mentioned above is the temperature on the mounting surface of a PC board. There are cases where PC board's temperature greatly differs from that of the switch, depending on the PC board's material, size, thickness, etc. Care, should be taken to prevent the switch's surface temperature from exceeding 260° C.

(2) Soldering conditions differ depending on reflow soldering machines. You are requested to verify the soldering conditions thoroughly beforehand.

(3) Ask us for the specifications of lead-free products.

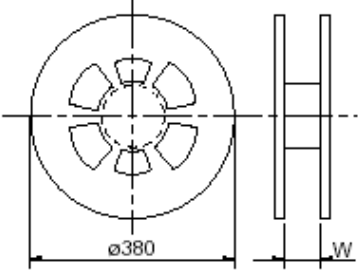
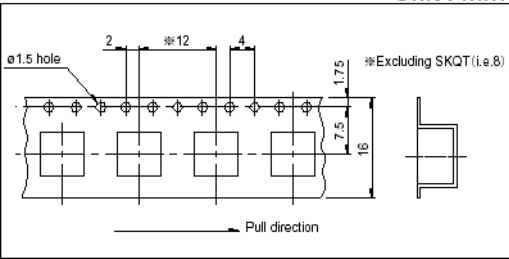


Manual Soldering

Items	Condition
Soldering temperature	350°C max.
Continuous soldering time	3s max.

**Taping Specifications**

Taping Packaging for Auto-insertion

Reel size	Reel width (mm)	Qty/reel (pcs.) (Minimum packing unit)	Tape dimensions
<p style="text-align: right;">Unit : mm</p> <p><b>Plastic Reel</b></p> 	17.5	7,000	<p style="text-align: right;">Unit : mm</p> 

- **Notes**
1. Please order products at N times the minimum packing unit (1 reel or 1 case).
  2. Consult with us for a  $\phi 330$  mm diameter reel.

## Caution

1. Note that terminals might suffer deformation of the switch and the defects in electrical performance, if the load is applied to the terminals during soldering.
2. If you use a through-hole PC board or a PC board thinner or thicker than the recommendation, there may be greater heat stress. Verify the soldering conditions thoroughly before use.
3. When soldering twice, wait until the first soldered portion cools to normal temperature. Continuous heating will deform the external portions, loosen or dislodge terminals, or may deteriorate their electrical characteristics.
4. Verify soldering conditions under actual mass production conditions.
5. This product is designed and manufactured assuming that it is to be used with the resistance for direct current. If you use other kinds of resistance [inductive (L) or capacitive (C)], consult with us beforehand.
6. For the sizes of holes and patterns on a PC board for mounting a switch, refer to the recommended dimensions in the outline drawings.
7. This switch is designed for manually operated units. Do not use this switch in a mechanical detection unit. For detection purposes, please use our detection switch.
8. The switch will break if you apply a greater stress than that specified. Take great care not to let the switch be subject to greater stress than specified.
9. Do not press the side of the stem.
10. Be sure to push the center position of a flat stem switch. Extreme care is required for a hinge structure type because the stem press position moves when it is pressed.
11. If you put the board with the switch in the oven so as to harden adhesive for other parts, consult with us.
12. When corrosive gas is generated by a peripheral material of a product using the TACT switch, malfunctions such as imperfect contacts can occur. Check this point thoroughly in advance.
13. The contact resistance of a rubber contact type changes depending on pressure load. Confirm that it functions sufficiently when you use this TACT switch with a voltage divider circuit.
14. Be aware of dust intrusion into an unsealed-type TACT switch.
15. Storage method
  - (1) If you do not use the product immediately, store it just as delivered in the following environment : with neither direct sunshine nor corrosive gas and in normal temperatures. However, it is recommended that you should use it as soon as possible or within six months from the date of delivery at the most.
  - (2) After you break the seal, you should put the remainder in a plastic bag to shut out outside air, and store it in the same environment mentioned above. You should use it up as soon as possible.
  - (3) Do not stack too many switches for safety.
  - (4) Store the key switches with the switch in the released position.

## Measurement and Test Methods

### [Rotational Torque (Operating Force) ]

Measures the torque (operating force) necessary to rotate (move) the shaft (lever) . Unless otherwise specified, measurement shall be made at ambient temperature of 5 to 35° C, the shaft rotational speed shall be 60° per second, and the lever traveling speed shall be 20mm per second.

### [Withstand Voltage]

Applies AC voltage to the specified spot for a minute and then checks for arc, burning, dielectric breakdown and other abnormalities. Respective terminals may be tested as a group. The sections described below shall be tested unless otherwise specified. However, if the section concerned is so constructed as to conduct, that particular part shall not be tested.

### [Insulation Resistance]

Applies specified voltage to the specified locations and then measures the insulation resistance with a megger. The locations described below shall be tested unless otherwise specified. However, if the section concerned is so constructed as to conduct, that particular part shall not be tested.

### [Sections to be Tested for Withstand Voltage and Insulation Resistance]

- Between terminal and shaft(lever).
- Between terminal and metal cover(frame).

### [Shaft (Lever) Strength against Push/Pull Actions]

Applies a specified force in the axial direction of the shaft (lever) for 10 seconds and then checks the operating part and other sections for deformation, breakage, operating condition, etc.