

Induction Soldering Ferrule to Fiber Optic Cable

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering induction melting and induction surface treatment applications
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Soldering Ferrule to Fiber Optic Cable Objective To heat a gold-plated ferrule and fiber optic cable to 475°F within 8 seconds for a soldering application

Material Gold-plated ferrule tube, fiber optic cable, solder preform

Temperature 475 °F

Frequency 270 kHz

Equipment Power of 6kW power supply with a specially designed induction coil.

Process A specially designed, two-turn plate concentrator coil was used to provide uniform heat to the fiber optic assembly. The assembly was placed in a specially designed fixture, then placed inside the induction coil. RF power was applied until the solder flowed and created a solid joint.

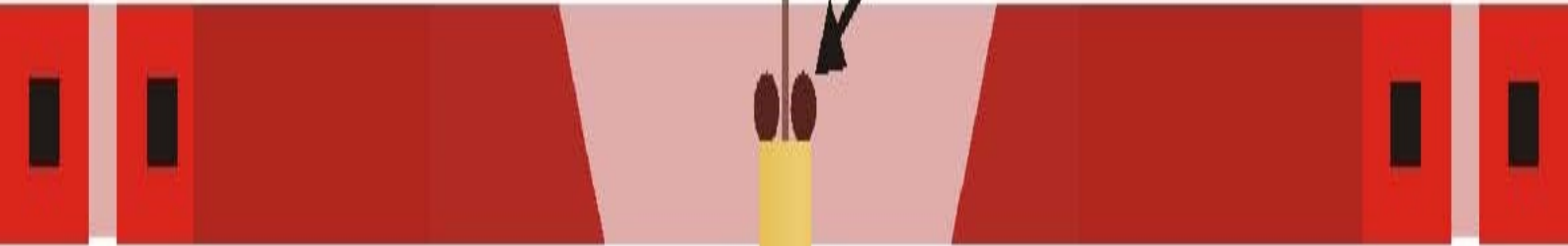
Results Consistent and repeatable results were achieved using the Power of 6 kW power supply and induction coil with a 5 to 7 second heat cycle, depending on the type of solder used (see solder chart below). Solder Heat Cycle
Solder Heat Cycle
52 In/48 Sn7 sec96.5 Sn/3.5 Ag5 sec80 In/15 Pb/5 Ag6 sec
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service@uihm.com

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Induction Coil

Solder Preforms



Gold Plated Ferrule