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CAUTION

PRODUCT INSTALLATION RECOMMENDATIONS

BUSHING-STYLE EMI FILTER AND FEED THRUS PRODUCTS

LEADED and RoHS

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 CTS.

Mounting Torque: — See Table 1

Lead Soldering: — Use a temperature-controlled soldering iron with RMA Flux core solder wire (see Note 1). The recommended maximum temperature is 500°F (260°C) with a dwell time of 3 seconds maximum. Using the 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.

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

Note: Recommended solder types

1. **Leaded solder – SN60 or SN63**
   RoHS-compliant solder – 95.5Sn / 3.8Ag / 0.7Cu

For assistance with other installation requirements and/or component modifications, consult CTS Customer Service Representative.