

HF3, HF3S and HF6 relay

1. SCOPE

1.1. Content

This specification covers the applicable documents, materials, equipment and packaging, packing, marking, and palletizing requirements for the TE Connectivity (TE) of HF (High Frequency) relays family.



Figure 1: HF3 relay

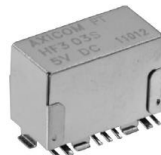


Figure 2: HF3S relay



Figure 3: HF6 relay

1.2. Application

This specification applies to the following versions of this relay:

HF3 relay (Figure 3: HF3 relay)

- HF3 01 PN 1462050-1 to HF3 97 PN 1-1462051-5

HF3S relay (Figure 2:)

- HF3 03S PN 2-1462050-2 to HF3 96S PN 2-1462051-6

HF6 relay (Figure 3: HF6 relay)

- HF6 51 PN 1462052-1 to HF6 96 PN 2-1462052-0

2. APPLICABLE DOCUMENTS

The following documents constitute a part of this specification to the extent specified herein. Unless otherwise stated, the latest edition of the document applies.

2.1. Specifications

- | | |
|----------------|--|
| A. 107-24 | Standard Packaging, Packing, Marking and Palletizing Methods |
| B. 107-18064 | Packaging and Marking Requirements for TE Connectivity Companies |
| C. TEC-107-236 | Transoceanic Shipments |

2.2. Drawings

- | | |
|------------------------|--|
| A. F23055-V6056-X79_35 | P2L2&3/FT/FU - Pizza box logo |
| B. F23055-V6057-X79_35 | P2L2&3/FT/FU - Insert for pizza box |
| C. D02955-Dok54 | HF Blister tape |
| D. C23303-A079-C119 | Blister tape long terminals P2L2/FU2 |
| E. 100_058 | CIVKA GURT P2 / FU reel for GURT SMT |
| F. 973169 | Antistatic Hot Sealing Cover Tape |
| G. SH3522 | Box f. 1 Reel PN 1-1462121-1 (Smurfit Kappa) |
| H. SH3523 | Inlet f. 1 Reel PN 1-1462121-2 (Smurfit Kappa) |
| I. V06740_T-100019_6 | DRYLOK_2100 |
| J. V06745_T-10029-3 | Desiccant |
| K. V06746_T-10030-4 | HIC |

3. PACKAGING & PACKINGMATERIALS

A.	1-973169-0	COVTAPE,97,5MM FOR BLISTER BELT 104MM
B.	3-1462130-3	P2/FU reel for gurt SMT
C.	2-1462150-0	FT/FU Blister tape SMT W 400
D.	1-1462120-0	D02955 Blister Tape
E.	6-1462110-4	P2L2&3/FT/FU - Pizza box logo
F.	6-1462110-6	P2L2&3/FT/FU - Insert for pizza box
G.	6-1462110-7	Humidity indicator card
H.	1-1462110-7	Dessicant for IM packaging IM32009
I.	1-1462110-6	Vacuum bag for IM relay IM32004
J.	1-1462121-2	F23055-V6069-X-35 Insert
K.	1-1462121-1	F23055-V6068-X-35 Box
L.	973169-4	COVERTAPE F 24MM CARTAPE
M.	7-1904070-2	V02955 Fita PPI – 1042
N.	7-1904070-3	V06318 Etiqueta HF
O.	6-1462110-7	Humidity indicator card
P.	6-1462110-8	Label humidity indicator card IM32011

4. EQUIPMENT

- A. Thermal-transfer printer
- B. Vacuum soldering machine
- C. Box folding jig
- D. Tape roller/cutter
- E. Module M25 (End of the HF production line)

5. PACKAGING PROCEDURE

5.1. HF3; HF3S; HF6 relays, pkg. quantity: 400 pcs

- A. Module M25 of the HF production line places 400 HF3, HF3S or HF6 relays into blister tape PN 2-1462150-0 or blister tape PN 1-1462120-0 and seal the blister tape with cover tape PN 973169-4 (see Figure 4)

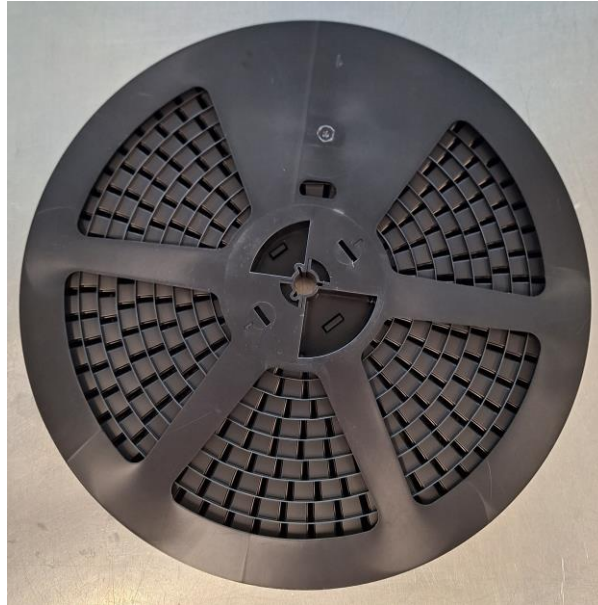


Figure 4: Relays with plastic cover in the blister tape

- B. Place label PN 7-1904070-3 (see chapter 7.2. “Blister tape reel label position”) on the side of plastic reel PN 3-1462130-3 with the blister tape
- C. Seal the end of the blister tape with green tape PN 7-1904070-2
- D. Insert the marked and sealed reel with the blister tape into vacuum bag PN 1-1462110-6 together with two desiccants PN 1-1462110-7 and humidity card PN 6-1462110-7 (see Figure 5)

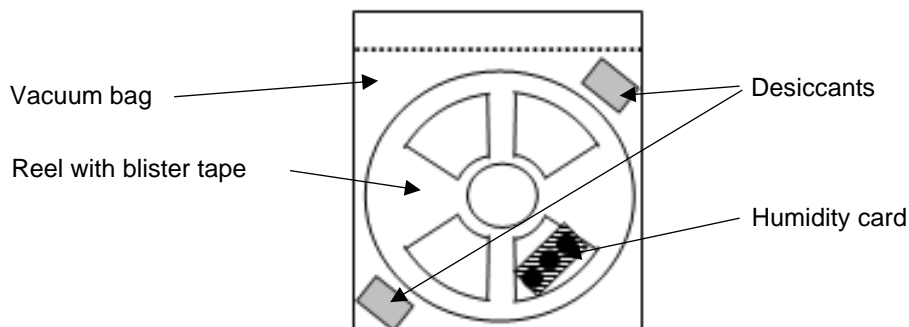


Figure 5: Contents of the vacuum bag

- E. Place the bag containing all the parts into a vacuum sealing machine and seal the bag (see Figure 6)



Figure 6: The vacuum bag in the vacuum sealing machine

- F. Place label PN 7-1904070-3 (see chapter 7.3. “Vacuum bag label position”) and humidity instructions label PN 6-1462110-8 on the side of the sealed vacuum bag
- G. Fold inner box PN 6-1462110-4, insert the sealed vacuum bag into the box, close the box and seal it with a tape (see Figure 7 and 8)



Figure 7: The vacuum bag in the inner box



Figure 8: The sealed inner box

H. Place label PN 7-1904070-3 (see chapter 7.4. “Inner box label position”) on the inner box.

- I. Fold outer box PN 1-1462121-1, insert 4 shock absorbers PN 6-1462110-6 creating two “X” and the inner box, close the box and seal it with a tape (see Figure 8 and 9)



Figure 9: Contents of the outer box



Figure 10: The sealed outer box

- J. Place label PN 7-1904070-3 (see chapter 7.5. “Outer box label position”) on the outer box.

6. PACKING

6.1. HF3; HF3S; HF6 relays, pkg. quantity: 400 pcs

- Product is to be palletized – 30 shipping boxes (5 layers - 6 boxes per a layer) on a pallet.
- Shipping boxes are to be stacked lying flat on the pallet as shown in Figure 11 and secured with stretch wrap film, edge protectors, and strappings, as described in specification TEC-107-236



Figure 11: Palletizing of boxes

- Double stacking is not permitted.
- Packing of the pallet should always comply with “UPSIDE” indication.
- Each shipping box should be placed on the pallet in such way that the licence tag is visible (see Figure 11)
- There should be no pallet overhang.

7. MARKING

7.1. Label – reel, vacuum bag, inner box, outer box

Label PN 7-1904070-3 (100x60mm) with print layout 995742-2CZ V10.1



Figure 42: Licence tag (For illustration only)

Examples of data printed out on the label:

PN (A)	Description (B)	Qty (C)	Production date (YYWWD) (D)
1462050-4	HF306=75OHM140MW12V MONO	400	24082
1462051-2	HF353=50OHM140MW 5V MONO	400	23423
2-1462050-7	HF3 06S=75OHM140MW 12V MONO	400	24202
2-1462051-6	HF3 96S=50OHM 140MW 12V BIST 2COIL	400	22354
1-1462052-0	HF6 73=50 OHM 70MW 5V BISTAB	400	24455
1-1462052-9	HF6 95=50OHM140MW 9V BIST 2COIL	400	24022

Table 1: Label data layout

7.2. Blister tape reel label position



Figure 53: Blister tape reel label position

7.3. Vacuum bag label position



Figure 64: Vacuum bag label position

7.4. Inner box label position



Figure 15: Inner box label position

7.5. Outer box label position



Figure 16: Outer box label position