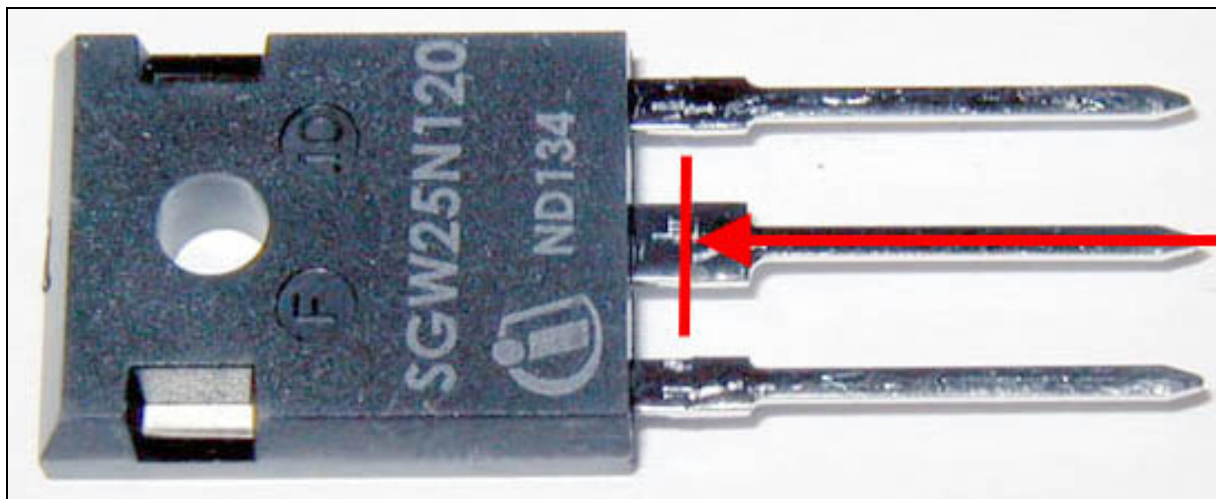


Mounting Instruction

SP80FB - SGW25N120 - assembly

Last update		2006-08-16	
Tools	ESD, Soldering iron, flat tong		
Part No.	Description	Info	Pos
SGW25N120	Transistor IGBT power SGW25N120		Q2-3
MRX3x10FBBBRB	Skruvkombination MRX3x10/FBB3.1/BRB3.2		11
ST15M3	Solder tag 15mm M3		12

Moment		Info	Pos
1.	Put the ESD protection pad on the table, connect wristband and soldering iron.	ESD handling	
2.	Pre-bend the middle pin on the transistor. Bending shall be in the middle of the thicker part of the pin.		Q2-3



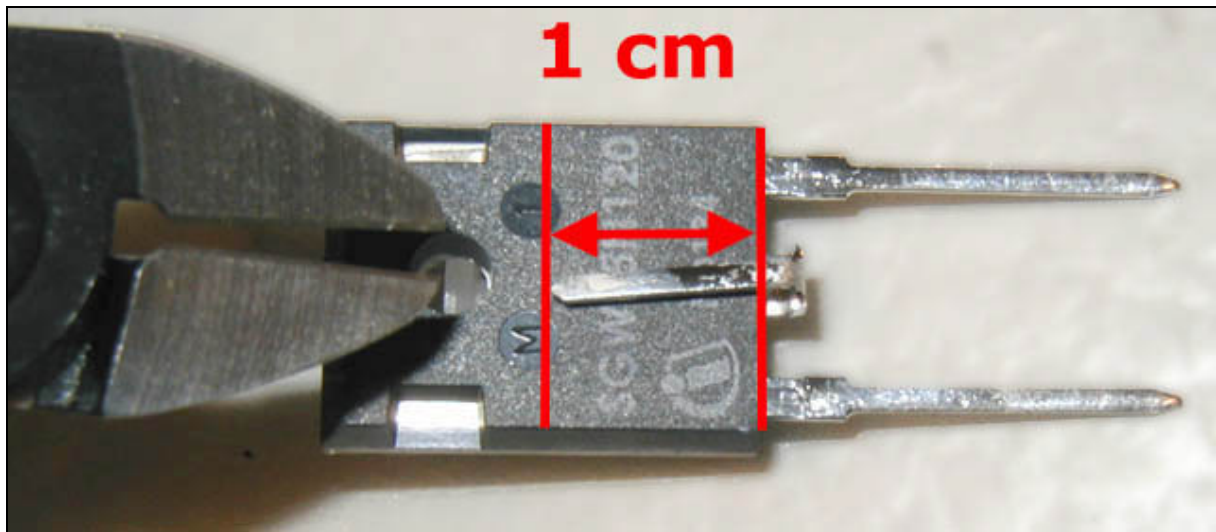
3.	Bend 90°		Q2-3
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4.	Bend 90° again. The pin shall follow the surface of the component.		Q2-3
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5.	Cut the middle pin 1 cm from the edge. See marking.		Q2-3
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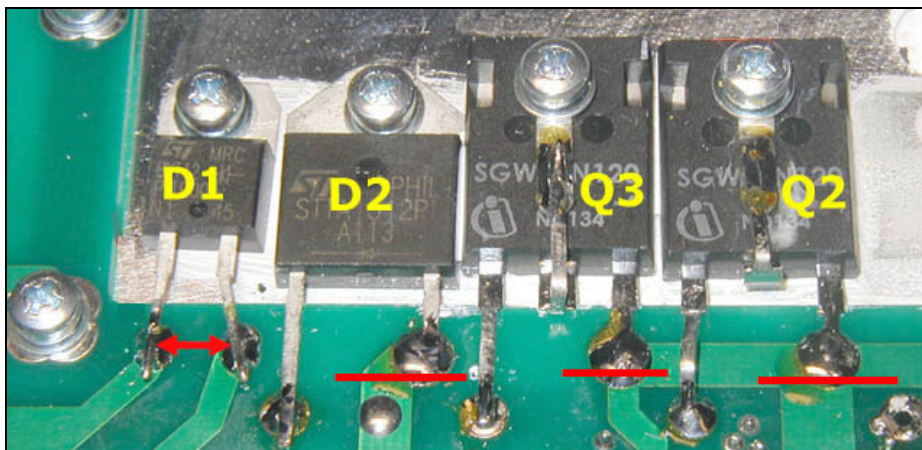
6.	Apply silicone paste on transistors and diodes.	Silicone paste	Q2-3, D1
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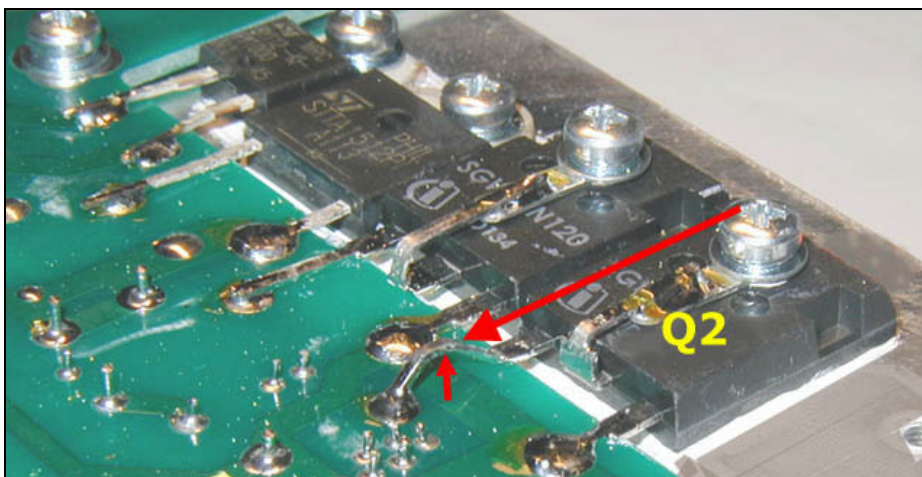
7.	Put transistors and diodes on their places.		Q2-3, D1-2
8.	Fasten diods with screws.		D1-2, 11
9.	Fasten transistors with screw and solder tag.		Q2-3, 18, 12



10.	Straighten transistors + diodes. Fasten.	0,7 Nm	
11.	Bend the diode pins out over the middle of the solder pad.	See marking	D1
12.	Cut the pins right inside the solder pad.	See marking	D1-2, Q2-3



13.	Bend 1 pin on the transistor.	See marking	Q2
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14.	Solder all pins and solder tags.		
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