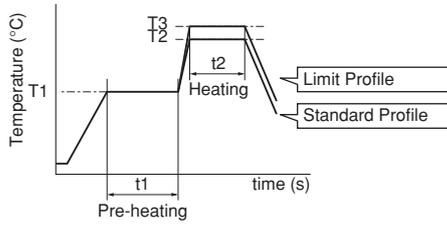


● **Flow Soldering Profile**

Soldering profile for Lead-free solder (96.5Sn/3Ag/0.5Cu), Eutectic solder (63Sn/37Pb)



| Standard Profile | | | | |
|------------------|---------------|------------|------------|-----------------|
| Pre-heating | | Heating | | Cycle of reflow |
| Temp. (T1) | Time (t1) | Temp. (T2) | Time (t2) | |
| 150°C | 60 to 120sec. | 250°C | 5sec. max. | 1 time |

| Limit Profile | | | | |
|---------------|---------------|------------|------------|-----------------|
| Pre-heating | | Heating | | Cycle of reflow |
| Temp. (T1) | Time (t1) | Temp. (T3) | Time (t2) | |
| 150°C | 60 to 120sec. | 265±3°C | 5sec. max. | 2 times |

● **Soldering Iron**

| Standard Profile | | | |
|-----------------------------------|----------------|-----------------------------|-------------------------|
| Temperature of soldering iron tip | Soldering time | Soldering iron power output | Cycle of soldering iron |
| 350±10°C | 3sec. max. | 30W max. | 1 time |