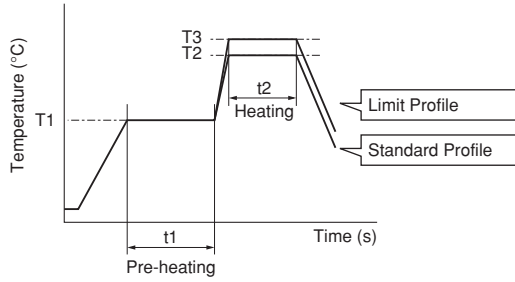


**● Flow Soldering Profile**

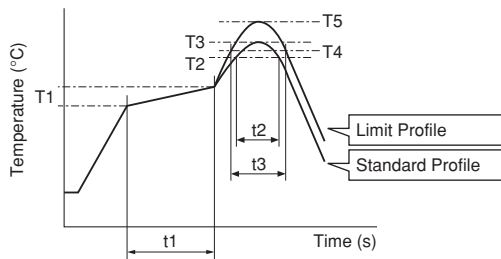
Soldering profile for lead free solder (96.5Sn/3.0Ag/0.5Cu), Eutectic solder (63Sn/37Pb)



Series	Standard Profile					Limit Profile				
	Pre-heating		Heating		Cycle of Flow	Pre-heating		Heating		Cycle of Flow
	Temp. (T1)	Time (t1)	Temp. (T2)	Time (t2)		Temp. (T1)	Time (t1)	Temp. (T3)	Time (t2)	
°C	sec.	°C	sec.	Time	°C	sec.	°C	sec.	Time	
<b>PVM4</b>	150	60 to 120	250	5 max.	1	150	60 to 120	265±3	5 max.	2

**● Reflow Soldering Profile**

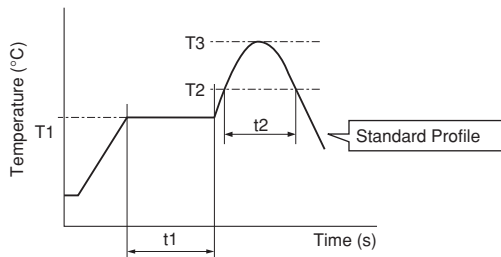
1. Soldering profile for Lead-free solder (96.5Sn/3.0Ag/0.5Cu)



Series	Standard Profile						Limit Profile					
	Pre-heating		Heating		Peak Temperature (T3)	Cycle of Reflow	Pre-heating		Heating		Peak Temperature (T5)	Cycle of Reflow
	Temp. (T1)	Time (t1)	Temp. (T2)	Time (t2)			Temp. (T1)	Time (t1)	Temp. (T4)	Time (t3)		
°C	sec.	°C	sec.	°C	Time	°C	sec.	°C	sec.	°C	Time	
<b>PVM4</b>	150 to 180	60 to 120	220	30 to 60	245±3	2	150 to 180	60 to 120	230	30 to 50	260 +5/-0	2

2. Soldering profile for Eutectic solder (63Sn/37Pb)

(Limit profile: refer to 1)



Series	Standard Profile					
	Pre-heating		Heating		Peak Temperature (T3)	Cycle of Reflow
	Temp. (T1)	Time (t1)	Temp. (T2)	Time (t2)		
°C	sec.	°C	sec.	°C	Time	
<b>PVM4</b>	150	60 to 120	183	30	230	1

**● Soldering Iron**

Series	Standard Condition			
	Temperature of Soldering Iron Tip	Soldering Time	Soldering Iron Power Output	Cycle of Soldering Iron
	°C	sec.	W	Time
<b>PVM4</b>	350±10	3 max.	30 max.	1