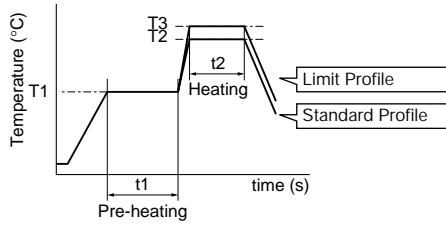


● Flow Soldering profile

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.	1time

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.	2time

● Solder Iron

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