

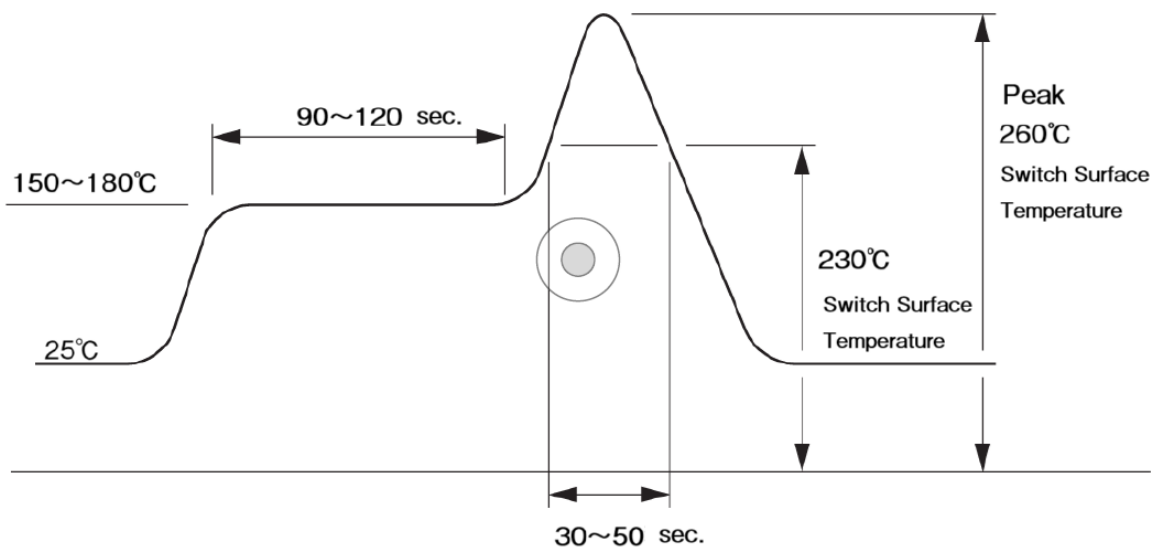
Hand-soldering Conditions

Type of Conditions	Soldering Bar Tip Temperature	Time
A	400 ± 10°C	Max. 4 sec.
B	Max. 350°C	Max. 3 sec.

Flow-soldering Conditions

Type of Conditions	Pre-heat Temp.	Pre-heat time	Soldering Temp.	Dipping Time
A	Max. 110°C	Within 60 sec.	260 ± 5°C	Within 5 sec.

Reflow -soldering Conditions



Note:

The above profile is based on conditions for a hot-air reflow oven.

For far-infrared or vapor phase soldering (VPS) ovens, please adjust the conditions as necessary.