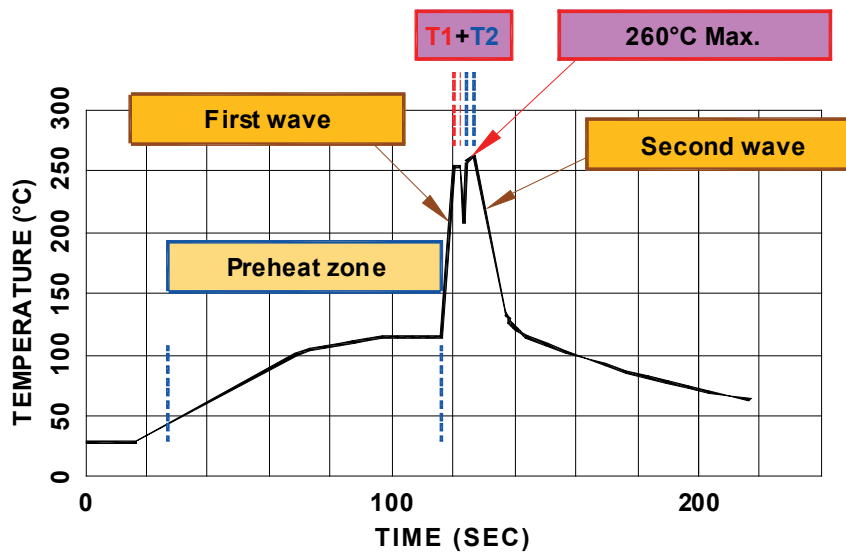


Soldering Considerations

Recommended wave solder profile



Zone	Reference Parameter
Preheat zone	Rise temp. speed: 3°C/sec max. Preheat temp. 100 ~ 130°C
Actual heating	Peak temp. : 250 ~ 260°C Peak time (T1 + T2 time): 4 ~ 6 sec

Reference Solder: Sn-Ag-Cu; Sn-Cu

Hand Welding (Reference):

Soldering iron: Power 150W

Welding Time: 2 ~ 4 sec

Temperature: 380 ~ 400°C