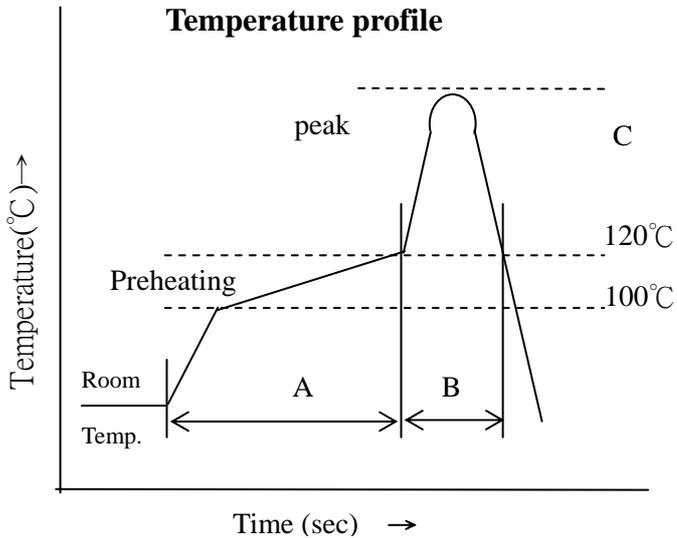


Lead Free wave soldering conditions

Component: Film Capacitors

1. Wave flow soldering



Recommendable condition

	Conditions	Values	Unit
A	Heating time	50-100	sec
	Heating temperature	100-120	°C
	Temp. rise gradient	1-2	°C/sec
B	Dipping time	2-4	sec
C	Peak temperature	260	°C
	Peak-temp. hold time	Momentary	sec

2. Requirement (Wave flow soldering):

Polypropylene film capacitors body temperature less than 120°C, 60sec

Polyester film capacitors body temperature less than 150°C, 60sec

3. Wave Flow soldering(solder dipping)

Peak temperature	260°C
Dipping time	4 sec
Soldering	1 time

4. Hand soldering

Soldering iron tip temperature	350°C
Soldering time	3 sec