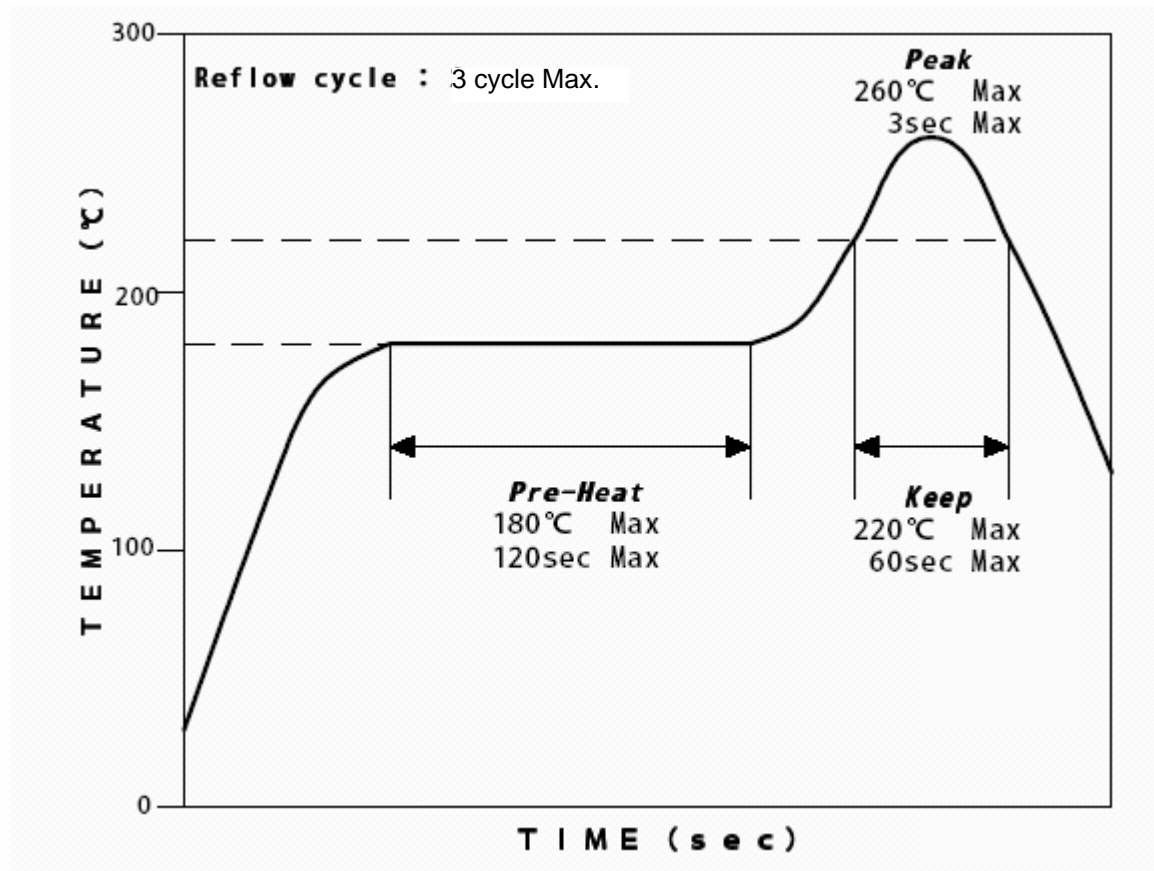


KOA Pb-Free Components Recommended Soldering Information and Profile

Reflow Profile



Flow Soldering

Maximum Solder Temperature – 260°C
Maximum Time in Solder – 10 Seconds

Hand Soldering

A pencil type soldering of 30 watts maximum and with a diameter of 3 mm maximum should be used. The soldering iron tip temperature should be less than 300°C and maximum contact time should be 5 seconds. The soldering iron tip should never come in contact with the component body.