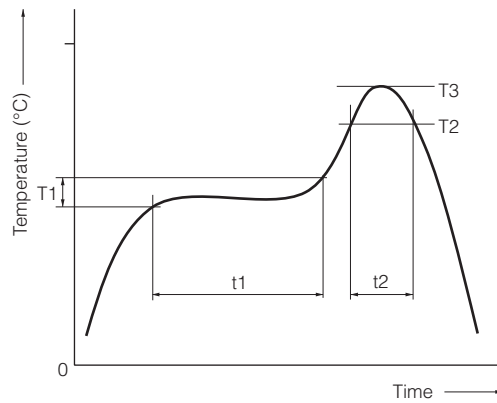


Soldering Conditions

Reflow soldering conditions



● Pb free solder recommended temperature profile

Part No.	Preheat		Soldering		Peak Temperature		Time of Reflow
	T1 [°C]	t1 [s]	T2 [°C]	t2 [s]	T3	T3 Limit	
ELT3KN	150 to 170	60 to 120	230 °C	30 max.	245 °C, 10 s	260 °C, 10 s	2 times max.