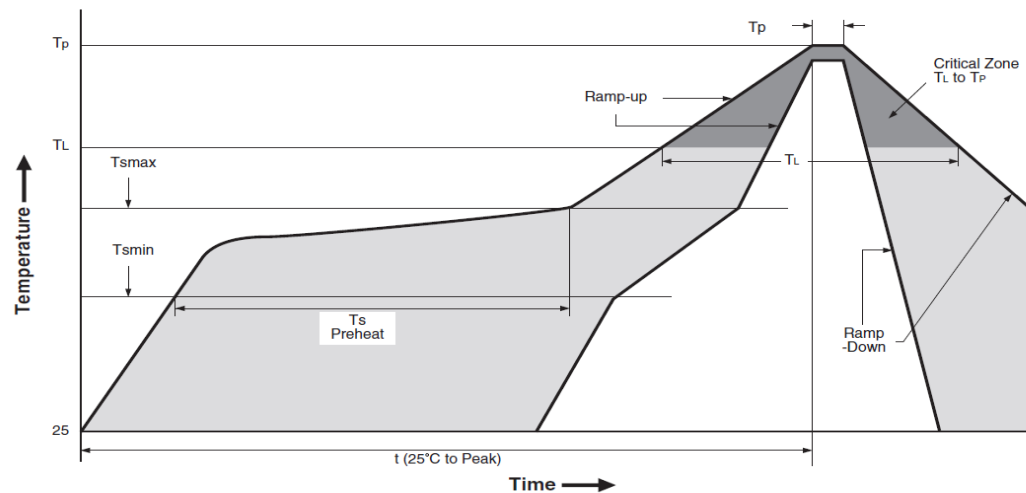


Aluminum Electrolytic Capacitor Reflow Soldering Conditions

SAMWHA ELECTRIC

Reflow Soldering Conditions



■ Reflow Profile

- Measured based on the temperature of the product.
- Reflow soldering conditions may be changed upon request.

Profile Feature		Soldering condition	
		Φ4 ~ Φ10	Φ12.5
Average Ramp-up Rate ($T_l \sim T_p$)		3°C / second max.	3°C / second max.
Preheat	Temperature Min. ($T_{s\ min}$)	150°C	150°C
	Temperature Max. ($T_{s\ max}$)	200°C	200°C
	Time ($T_{s\ min} \sim T_{s\ max}$)	60~150 second	40~120 sec
Ramp-up Rate ($T_{s\ max} \sim T_l$)		3°C / second max.	3°C / second max.
Time maintained above	Temperature (T_l)	217°C	217°C
	Time (t_l)	60~90 second	60~90 second
Peak/classification Temperature (T_p)		250°C	240°C
Time within 5°C of actual peak temperature		10 seconds max.	10 seconds max.
Ramp-Down Rate		3°C / second max.	3°C / second max.
Time 25°C to peak temperature		8 minutes max.	8 minutes max.