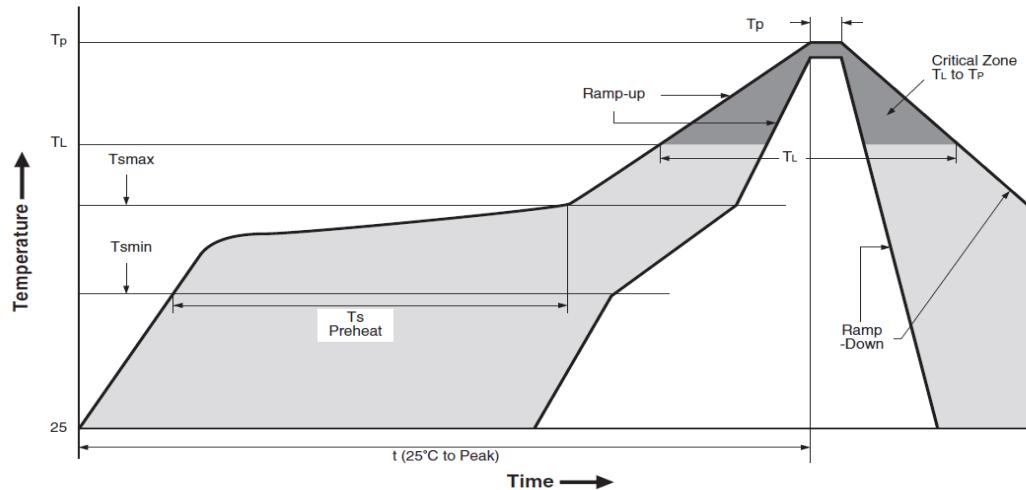


Aluminum Electrolytic Capacitor Reflow Soldering Conditions

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	
		$\Phi 4 \sim \Phi 10$	$\Phi 12.5$
Preheat	Average Ramp-up Rate ($T_s \sim T_p$)	3°C / second max.	3°C / second max.
	Temperature Min. ($T_s \text{ min}$)	150°C	150°C
	Temperature Max. ($T_s \text{ max}$)	200°C	200°C
	Time ($T_s \text{ min} \sim T_s \text{ max}$)	60~150 second	40~120 sec
Time maintained above	Ramp-up Rate ($T_s \text{ max} \sim T_L$)	3°C / second max.	3°C / second max.
	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.