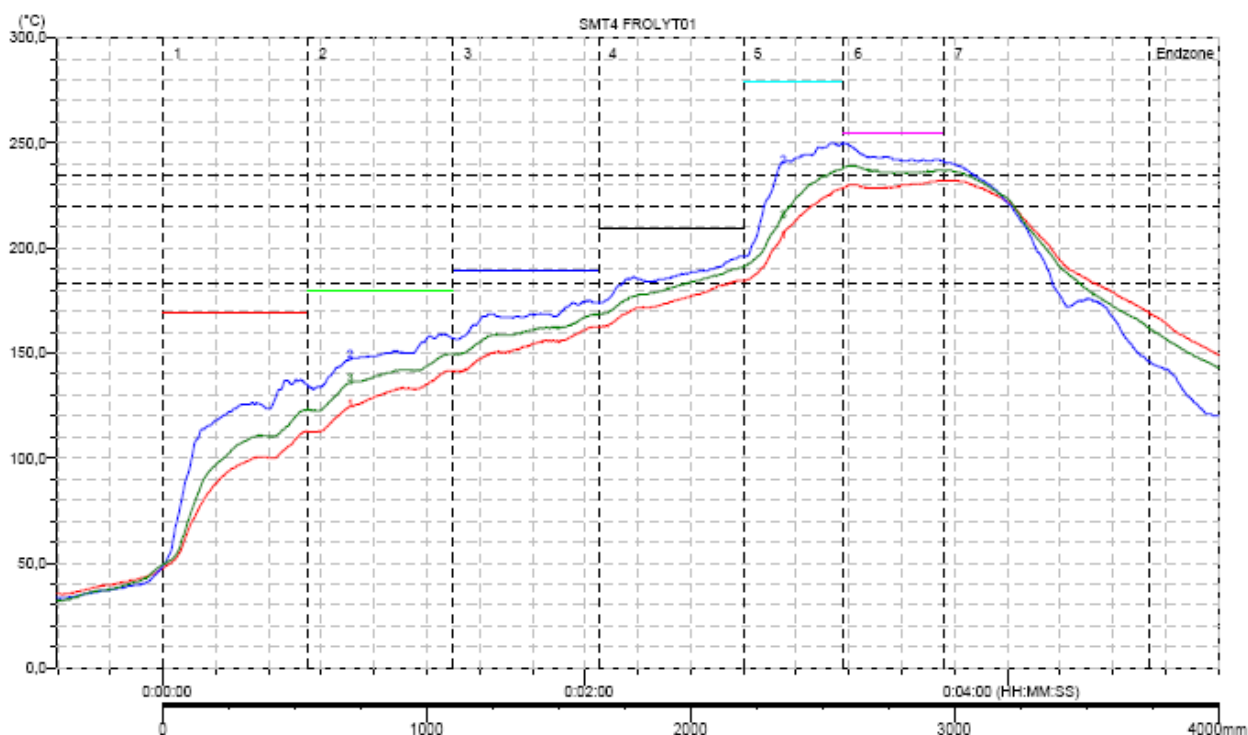


Soldering profiles for electrolytic capacitors in conformity with the RoHS (SMD-style and wired style)

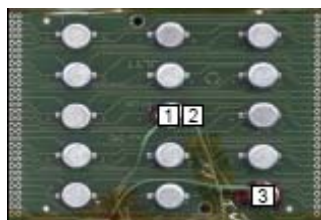
Wave soldering with simple or double wave

Lead: SN100C-NS	Pot temperature: +255°C ± 5K
Soldering flux: PF7720/G or PF7721/G	Soldering period: 1 - 4 s
Printed circuit board: FR 4	Activation temperature: + (100 -120)°C
	Activation time: 10 - 30 s

Temperature profile reflow soldering



Stove speed: 800 mm/min
Fan speed: minimal



Meßfühlerangaben	Temperaturmaxima und -minima in °C		Zeit darüber Erreicht		Zeit darüber Erreicht		Zeit darüber Erreicht	
	Max: Temp	Max: Zeit	183,0°C	183,0°C	220,0°C	220,0°C	235,0°C	235,0°C
#1 BE-Oberseite (ELKO)	232,0	0:03:40	0:01:45	0:02:40	0:00:57	0:03:04	0:00:00	***
#2 LP	250,0	0:03:09	0:02:02	0:02:10	0:01:10	0:02:51	0:00:56	0:02:54
#3 BE-Oberseite (ELKO)	239,0	0:03:14	0:01:52	0:02:28	0:01:03	0:02:58	0:00:39	0:03:09

These details replace existing soldering profiles in the data sheets FROLYT!