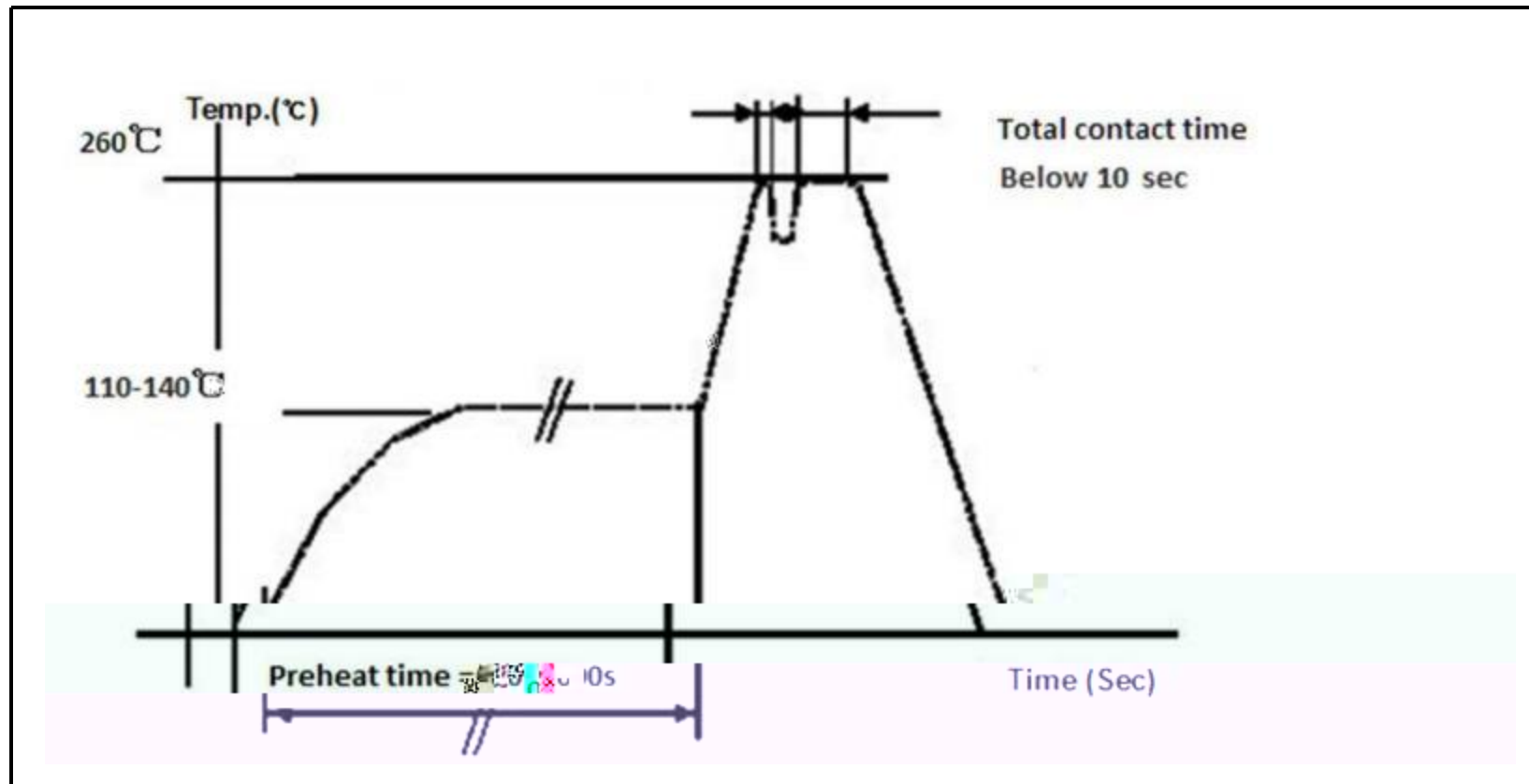


Welding Technique

Recommended Soldering Profile for Rectifier Diodes (Pb Free)

a) Wave Soldering Profile



| | |
|--|-----------------------------------|
| Preheat/Soak Temperature Min (T _{min}) Temperature Max (T _{max}) Time (ts) from (T _{min} to T _{max}) | 50 °C 200 °C 60-120 seconds |
| Melting Point of Solder (Sn Ag Cu) | 217 |
| Ramp-up Rate to 217 (Melting Point of Solder) | 3 °/sec |
| Time at Temp.>217 (Melting Point of Solder) | 60~ 150 Sec |
| Peak Temperature | 255 |
| | |
| | |
| | |

