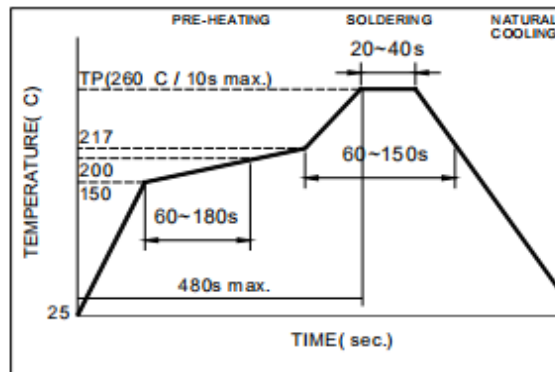




**SOLDERING CONDITIONS**

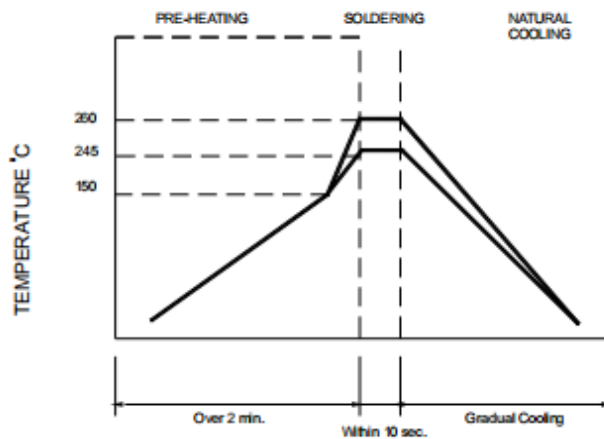
**Figure 1.  
Re-flow  
Soldering (Lead  
Free)**



Note:

- Preheat circuit and products to 150°C
- 260°C tip temperature (max)
- Reflow times: no more than 2 times
- Solder paste thickness: the best 0.08mm is, but max is 0.1mm

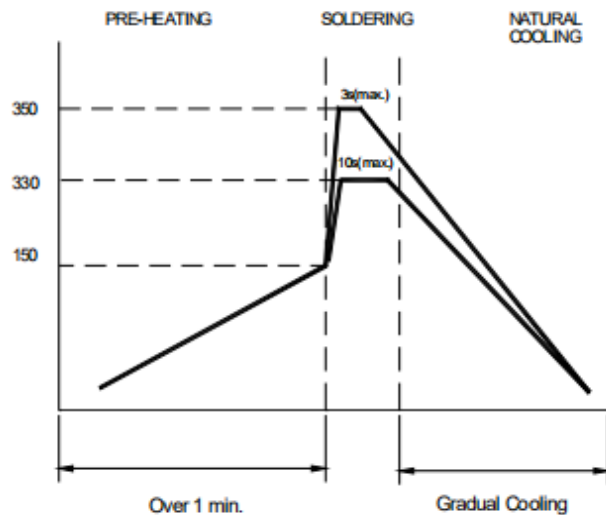
**Figure 2.  
Wave Soldering**



Note :

- Never contact the ceramic with the iron tip
- 1.0mm tip diameter (max)

**Figure 3.  
Hand Soldering**



Note:

- Use a 20 watt soldering iron with tip diameter of 1.0mm
- Limit soldering time to 3 sec.

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