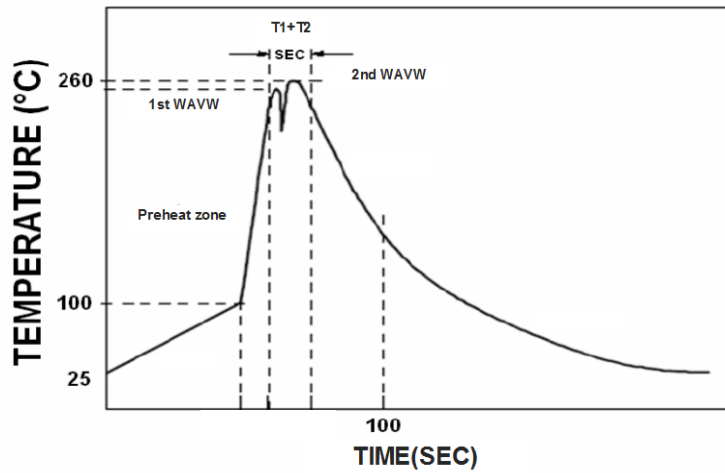


Soldering Consideration



Zone	Reference Parameter
Preheat	Rise temp. speed 3°C/sec max.
zone	Preheat temp.: 100~130°C
Actual	Peak temp.: 250~260°C
heating	Peak time(T1+T2): 4~6 sec

Reference Solder: Sn-Ag-Cu, Sn-Cu, Sn-Ag

Hand Welding: Soldering iron: Power 60W

Welding Time: 2~4 sec

Temp.: 380~400°C