1. Flow

- Solder temperature: 260 deg.C maximum
- Soldering time: Within 10 seconds
- Preheat: Wave solder 25 to 140 deg.C 80 seconds or more / Solder dip 145 deg.C 15 seconds or more

   If the double-wave method is used, keep the total dwell time for a first bath and a second bath within 10 seconds.

   Preheating conditions are based on the surface temperature of the PWB by the solder mounting side.

   (When the PWB surface by the device side is preheated, its condition should not exceed the maximum storage temperature of a device.)

2. Others

   We urge you to verify well before mounting to assure enough solder joint strength.

   Only once...

   Always solder the Product in accordance with the heat-resistance mounting conditions set forth above.

   In the event the Product is soldered otherwise, the applicable product warranty, if any, is void.
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