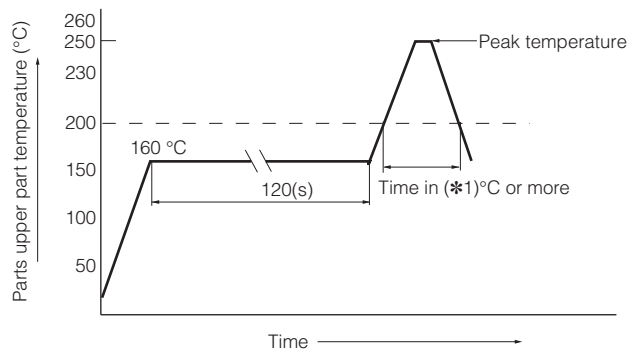


- Reflow guaranteed condition
- RoHS compliant



■ Lead-Free reflow

Reflow No.	Fig. (1)	Fig. (2)	Fig. (3)	Fig. (4)
Category	φ3 to φ6.3	φ8 to φ10	φ12.5 to φ18	EB series (φ10 to φ18)
Peak temperature	250 °C	235 °C	230 °C (220 °C)	230 °C
Time in peak temperature	5 s	5 s	5 s (5 s)	5 s
Time in (*1) °C or more	≥200 °C 60 s	≥200 °C 60 s	≥200 °C 20 s (30 s)	≥200 °C 20 s
Time of reflow	1 time	1 time	1 time	1 time

■ High temperature Lead-Free reflow

Reflow No.	Fig. (5)	Fig. (6)		Fig. (7)		Fig. (8)	
Category	φ4 to φ6.3	φ8 to φ10		φ8 to φ10		φ8 to φ10 (TK · TP series)	
Peak temperature	260 °C (255 °C)	245 °C	260 °C	250 °C	260 °C	255 °C	260 °C
Time in peak temperature	≥250 °C 5 s (10 s)	≥240 °C 10 s	≥250 °C 5 s	≥240 °C 10 s	≥250 °C 5 s	≥250 °C 30 s	≥250 °C 20 s
Time in (*1) °C or more	≥230 °C 30 s	≥230 °C 30 s	≥230 °C 30 s	≥230 °C 30 s	≥230 °C 30 s	≥230 °C 40 s	≥230 °C 30 s
	≥217 °C 40 s	≥217 °C 40 s	≥217 °C 40 s	≥217 °C 40 s	≥217 °C 40 s	≥217 °C 65 s	≥217 °C 65 s
	≥200 °C 70 s	≥200 °C 70 s	≥200 °C 70 s	≥200 °C 70 s	≥200 °C 70 s	≥200 °C 90 s	≥200 °C 70 s
Time of reflow	2 times	2 times	1 time	2 times	1 time	2 times	2 times

Reflow No.	Fig. (9)	Fig. (10)	Fig. (11)
Category	φ12.5 to φ18 (FK, TK, XD series) 6.3 V to 35 V	φ12.5 to φ18 (FK series) 50 V to 63 V (TK series) 50 V	φ12.5 to φ18 (FK series) 80 V to 100 V (TK series) 63 V to 100 V
Peak temperature	245 °C	245 °C	245 °C
Time in peak temperature	≤240 °C 30 s	≤240 °C 5 s	≤240 °C 5 s
Time in (*1) °C or more	≤217 °C 90 s	≤217 °C 30 s	≤217 °C 30 s
Time of reflow	2 times	2 times	1 time

- * For reflow, use a thermal condition system such as infrared radiation (IR) or hot blast.
- * Vapor heat transfer systems (VPS) are not recommended.