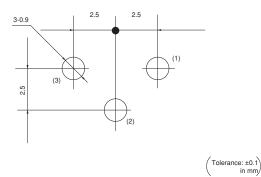
Mounting

Mounting Holes

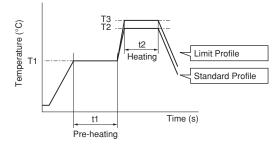


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Soldering Profile

• Flow Soldering Profile

Soldering profile for lead free solder (96.5Sn/3.0Ag/0.5Cu), Eutectic solder (63Sn/37Pb)



Series	Standard Profile					Limit Profile				
	Pre-heating		Heating		Cycle	Pre-heating		Heating		Cycle
	Temp. (T1)	Time (t1)	Temp. (T2)	Time (t2)	of Flow	Temp. (T1)	Time (t1)	Temp. (T3)	Time (t2)	of Flow
	°C	sec.	°C	sec.	Time	°C	sec.	°C	sec.	Time
PV12 PV37 PV36	150	60 to 120	250	5 max.	1	150	60 to 120	260	3 max.	1

Soldering Iron

	Standard Condition							
Series	Temperature of Soldering Iron Tip	Soldering Time	Soldering Iron Power Output	Cycle of Soldering Iron				
	C	sec.	W	Time				
PV12 PV37 PV36	350±10	3 max.	30 max.	1				

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