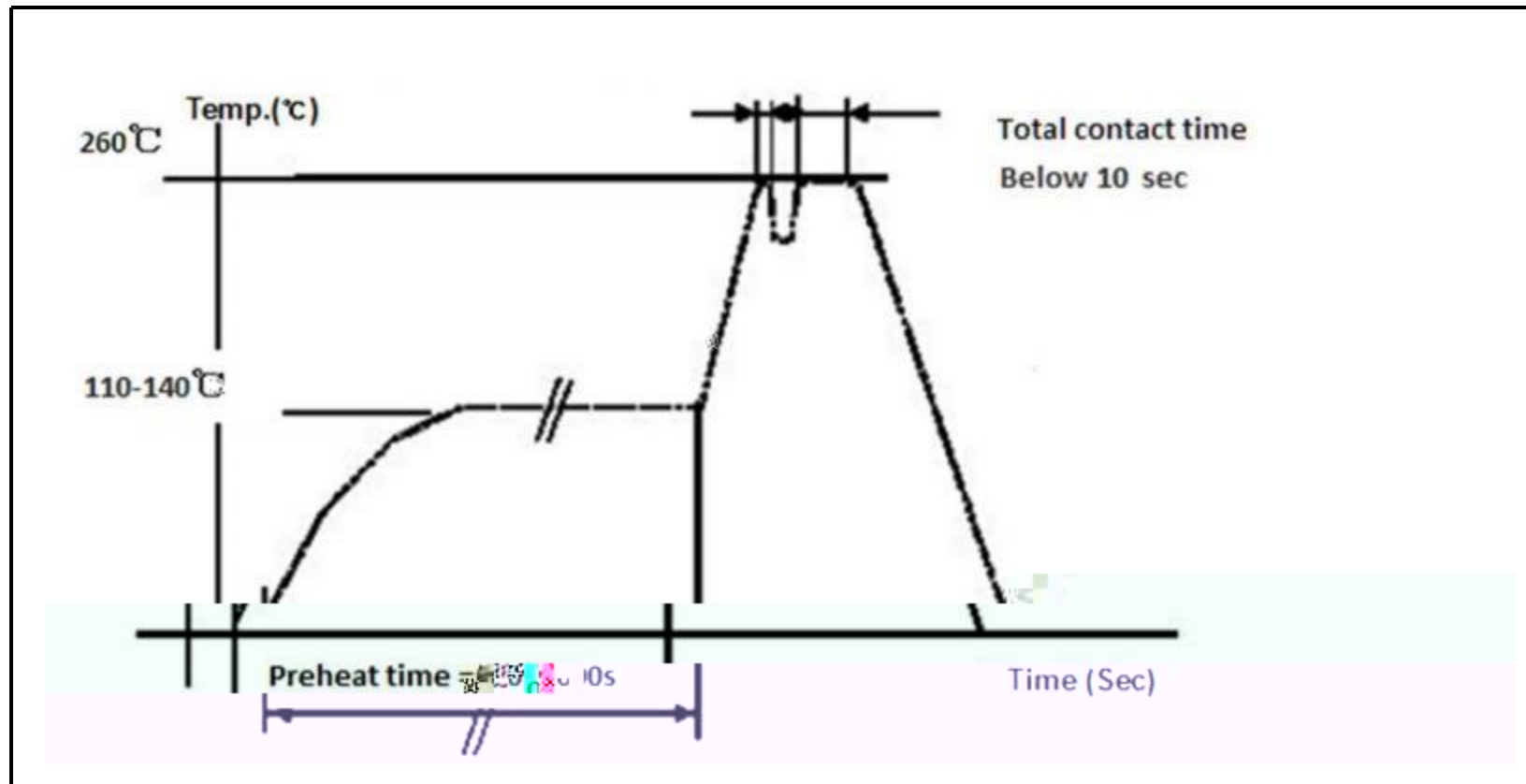


Welding Technique

Recommended Soldering Profile for Rectifier Diodes (Pb Free)

a) Wave Soldering Profile



Preheat/Soak Temperature Min (T _{smin}) Temperature Max (T _{smax}) Time (ts) from (T _{smin} to T _{smax})	50 °C 200 °C 60-120 seconds
Melting Point of Solder (Sn Ag Cu)	217
Ramp-up Rate to 217 (Melting Point of Solder)	3 °/sec
Time at Temp.>217 (Melting Point of Solder)	60~150 Sec
Peak Temperature	255

