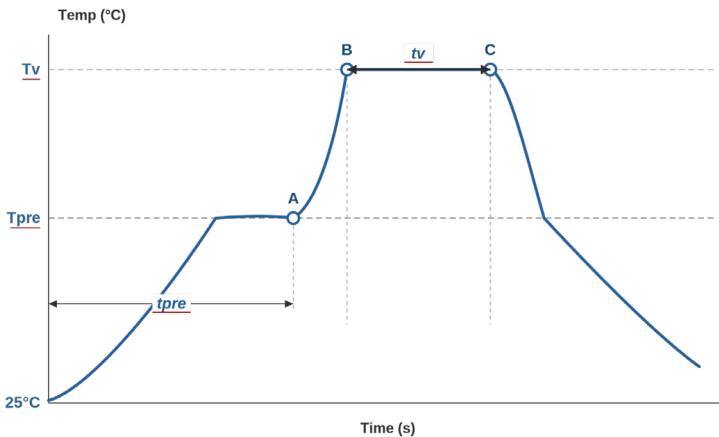


## VAPOUR PHASE REFLOW PROFILE



Parameter	Standard	Fragile
Tpre (A) – preheat plateau	100–130°C	100–130°C
Ramp-up to A	≤ 3°C/s	≤ 2°C/s
tpre – preheat dwell	60–120 s	≥ 120 s
Tv (B / C) – vapor temperature	215°C (SnPb) or 230°C (SAC305)	215°C (SnPb) or 230°C (SAC305)
tv (B→C) – time in vapor	30–60 s	30–45 s
Ramp-down rate (after C)	≤ 4°C/s	≤ 2°C/s
Max reflow passes	3	2
Atmosphere	process vapor (inert)	process vapor (inert)

## HAND SOLDERING

Hand soldering is not recommended; localized thermal shock can crack the ceramic body. Hot-air pencil reflow is preferred for rework. When a soldering iron must be used, observe the following procedure :

- Soldering iron tip diameter ≤ 3.0 mm; wattage ≤ 20 W.
- Pre-heat the component to 150°C minimum before iron contact.
- Iron tip temperature ≤ 280°C; contact time ≤ 5 s per termination.
- Pre-tin the iron tip with the required volume of solder; do not feed solder wire onto the part.
- Do not touch the ceramic body directly with the iron tip — apply heat to the termination metallization only.
- After soldering, allow the part to cool gradually at room temperature.
- Forced cooling is not allowed.

For fragile parts (SMD stacks > 2220, case sizes ≥ 2225, radial leaded HV, AgPd or gold terminations), additional precautions apply :

- Preheat the part to within 50°C of the iron tip temperature.
- Total iron contact time ≤ 3 s per termination.
- Single hand-soldering operation only; rework requires part replacement.

## RADIAL LEADED SOLDERING

Through-hole radial leaded capacitors are soldered by wave or by hand. Reflow is not applicable to leaded parts — no surface pads are available for solder paste deposition.

For wave soldering of standard radial sizes :

- Preheat the PCB underside to within 100°C of the wave temperature.
- Wave temperature : 235–260°C; total contact time ≤ 10 s.
- Two waves (turbulent + laminar) typically applied.

For high-voltage radials and large lead diameters, wave soldering is **not recommended**. Use hand soldering with the procedure above, including :

- Part preheat to within 50°C of the iron tip temperature.
- Iron contact time ≤ 5 s per lead.
- Allow each lead to cool before soldering the next.