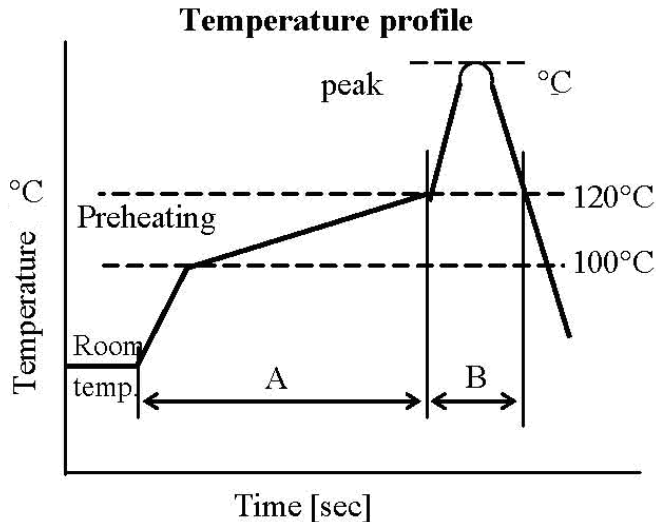


Metallized Film Capacitors	Soldering Profile
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## Lead free Wave Soldering Conditions

### Wave Flow Soldering



	Condition	Value	Units
A	Heating Time	50-100	Sec
	Heating Temperature	100-200	°C
	Temperature Gradient	1-2	°C /Sec
B	Dipping time	2-4	Sec
C	Peak Temperature	260	°C
	Peak Temperature holding time	momentary	Sec

### Wave Flow Soldering ( solder Dipping)

Peak Temperature	260°C
Dipping Time	4 sec
Soldering	1 Time

**Polypropylene Film capacitors body temperature not to exceed 120°C for 60seconds**  
**Polyester Film capacitors body temperature not to exceed 120°C for 60seconds**

### Hand Soldering

Soldering Iron Tip Temperature	350°C
Soldering Time	3 sec