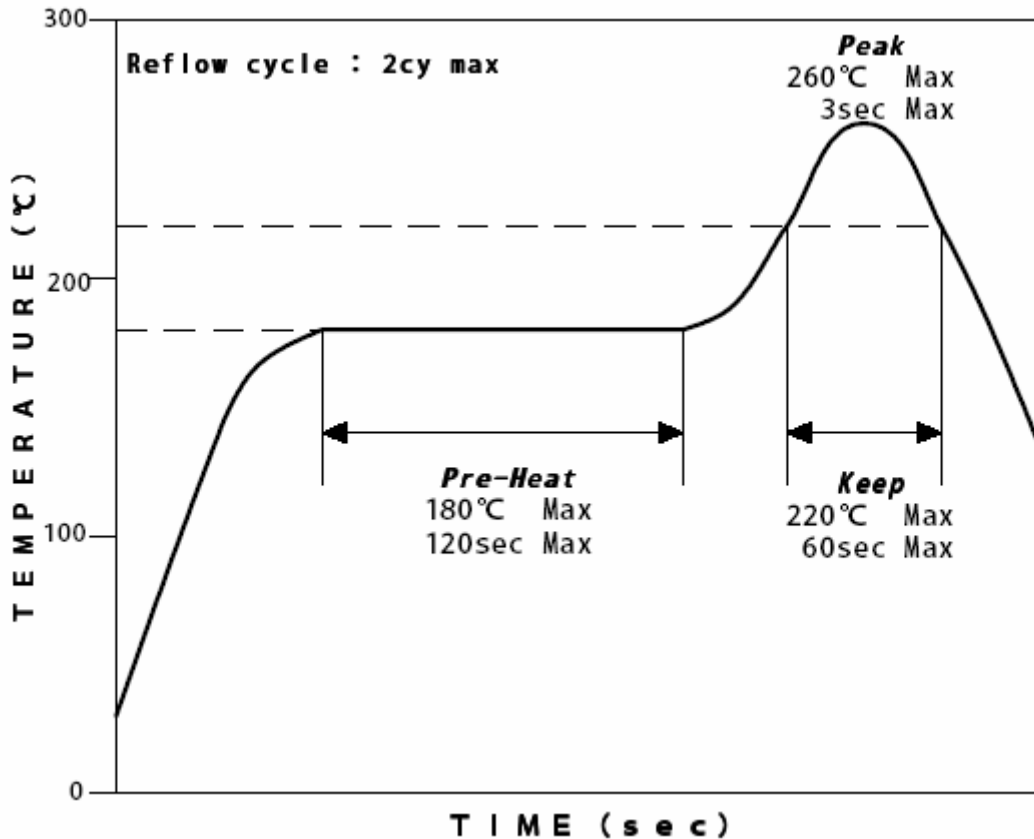


## KOA Pb-Free Components Recommended Soldering Information and Profile

### Reflow Profile



### Flow Soldering

Maximum Solder Temperature – 260 °C  
Maximum Time in Solder – 10 Seconds

### Hand Soldering

A pencil type soldering of 30 watts maximum and with a diameter of 3 mm maximum should be used. The soldering iron tip temperature should be less than 300 °C and maximum contact time should be 5 seconds. The soldering iron tip should never come in contact with the component body.