

RECOMMENDABLE CONDITION OF SOLDERING

LEAD TYPE TRANSISTORSUR

CONDITION OF SOLDERING FOR LEAD TYPE TRANSISTOR LEAD FREE (Sn-3Ag-0.5Cu) VERSION

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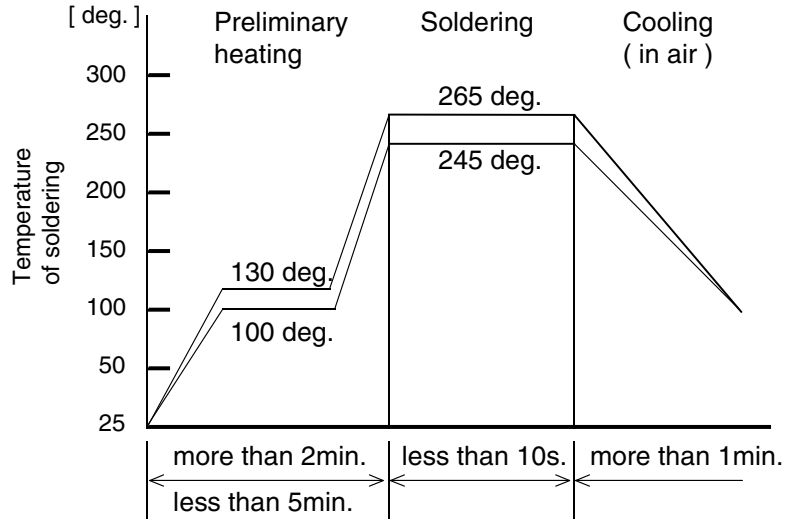
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CONDITION OF SOLDERING DIP AND HAND SOLDERING

■ CONDITION OF SOLDERING DIP

Soldering Temperature : 245 to 265 deg.

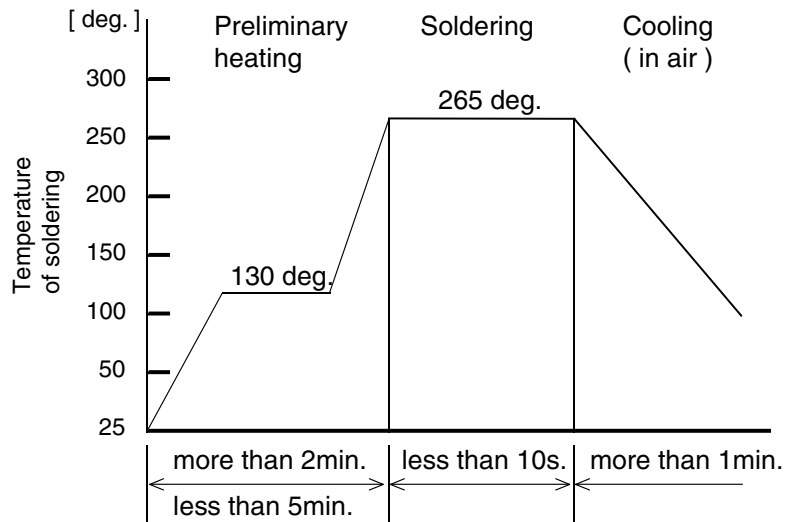
Soldering Time : 10s Max.



■ CONDITION OF HEAT-RESISTANT

Soldering Temperature : 265 deg.

Soldering Time : 10s Max.



■ CONDITION OF HAND SOLDERING

Temperature : Refer to Right Table

Time : 3s Max.

Number of Hand Soldering : One time

Temperature differ from Package

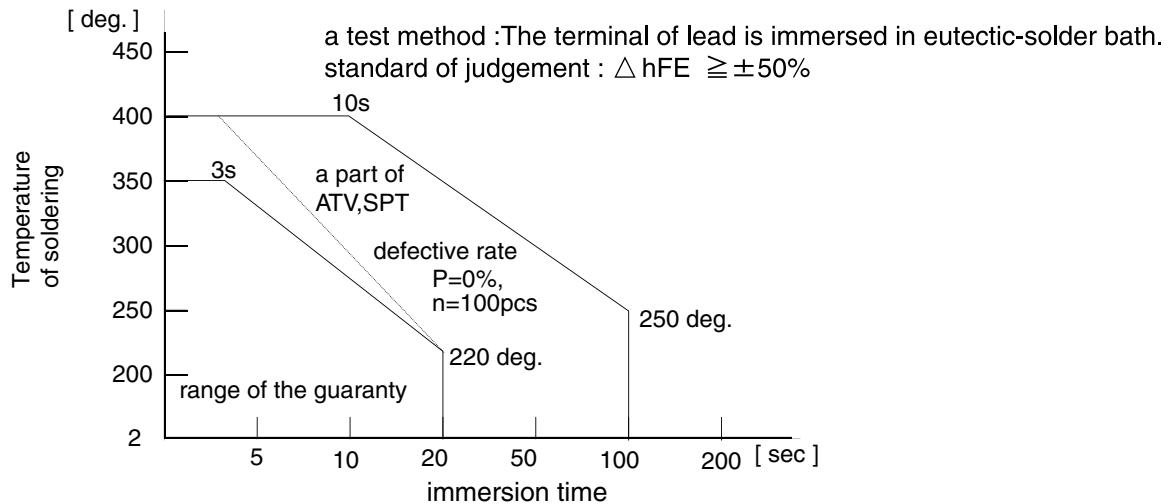
PKG less than 400 deg.

ATV (2SC4010,2SC5083,DTA1*V,DTC1***V)**
SPT (2SC1740S,2SC1809S,2SC2058S,2SC2926S,2SC4043S,2SC4044S,DTA1*S,DTC1***S)**

PKG less than 350 deg.

ATV (expect for 2SC4010,2SC5083,DTA1*V,DTC1***V)**
SPT (expect for 2SC1740S,2SC1809S,2SC2058S,2SC2926S,2SC4043S,2SC4044S,DTA1*S,DTC1***S)**
ATR , ATL , FTR , FTL , TO92 , TO92L , TO92LS , TO220SD , TO220FP , TO220FN , TO220FM, TO3PF, HRT , MRT , TO126 , TO126FP

TOLERANCE RANGE FOR HEATPROOF OF SOLDERING



CONDITION OF WASHING

APPLICATION : LEAD TYPE(Transistor / Transistor Array / Diode Array)

■ RECOMMENDABLE CONDITION OF WASHING

1. WASHING LIQUID

washing liquid	maker
water	-
ethanol	-
methanol	-
pine alpha ST-100S	ARAKAWA CHEMICAL
clean through 750H	KAO
technocare FRW-1	MOMENTIVE performance materials
mighty solve AH-V	ASAHI GLASS

2. CONDITION OF WASHING

washing bath		time	temperature	remarks
first bath	ultrasonic bath	less than 60 s	room temperature	25 to 28kHz , 15W / L
second bath	immersion bath	less than 60 s	room temperature	
third bath	vaper bath *	less than 60 s	less than 44.7 deg.	the boiling point varies from washing liquid

* In vaper bath, you can not use ethanol, methanol, and water due to their high boiling points.

Notes

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