



## Solderbility Profile

Sub=Nylon 46 Material Temperture Specification

Date:Jan-24-2006 REV:B

<p>Solder regular Condition</p>	<ol style="list-style-type: none"> <li>1)Soldering temp:260° C±5° C</li> <li>2)Time:10±3sec</li> <li>3)Solder wetting percentage:95% min</li> </ol>
<p>Reflow Condition</p>	
<p>Temperature(°C)</p> <p>Time Max-6minute</p> <p>NYLON46 Recommended Temperature Profile</p>	<ol style="list-style-type: none"> <li>1)Solder Method: Reflow or Wave</li> <li>2)Environment: Room air</li> <li>3)Solder Composition: Soldering Paste</li> <li>4)Test Board: 52mmX36.5mmX1.6mm thick</li> <li>5) This temperature profile is based on the above conditions. In idndividual applications the actuar temperature may vary.Consult your solder paste and equipment manufacturer for specific recommendations</li> <li>6)There must not be visible defect after testing</li> </ol>