

1. Scope

This specification specifies soldering temperature profile and manual soldering conditions for TM Series connector compliant to lead-free and RoHS requirements.


2. Object products

All the products with lead-free plating and RoHS compliant.

3. Recommended mounting temperature profile and manual solder condition

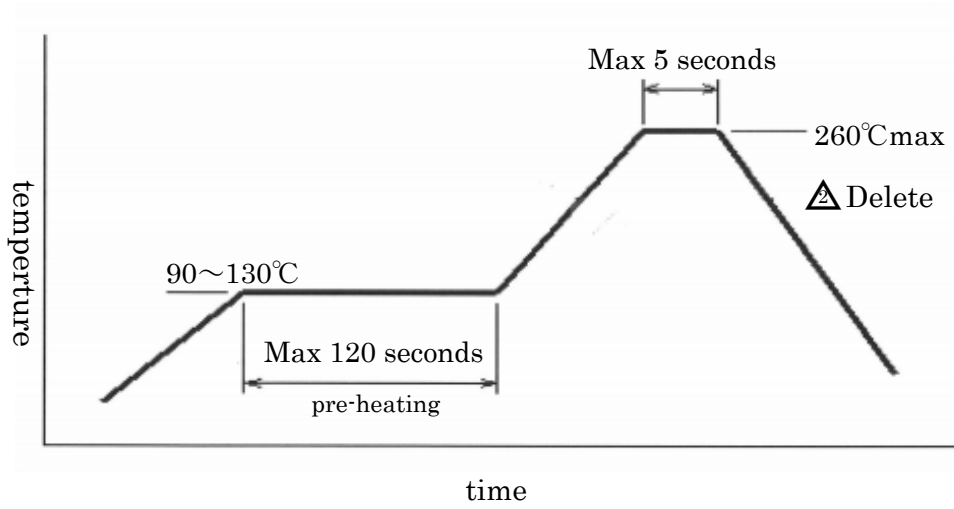
Refer to the next page.

Note: Apply “flow profile” for pin through hole products, and “reflow profile” for SMT products.

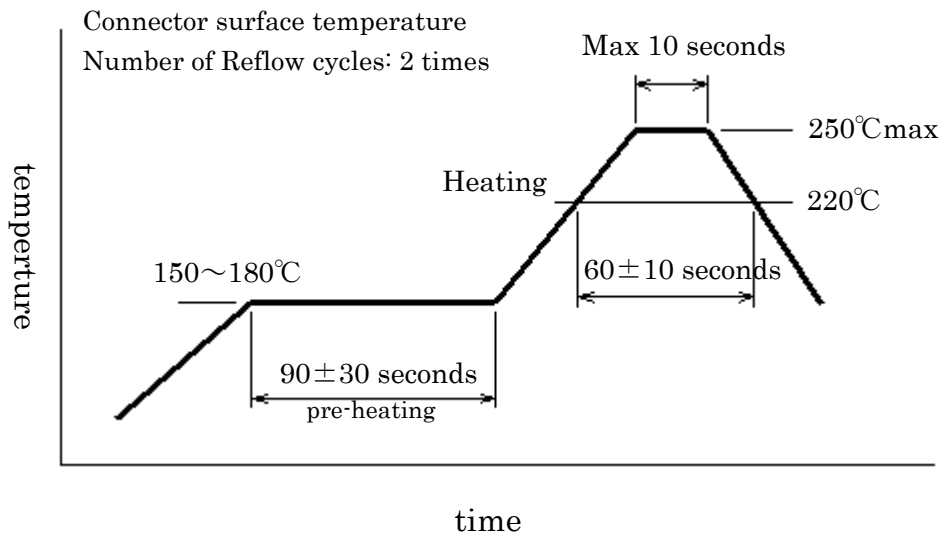
COUNT	DESCRIPTION OF REVISIONS	DESIGNED	CHECKED	DATE			
△ 1	DIS-E-00006584	KG. OKITA	MN. KENJO	20210811			
名称 TITLE		 <b>HIROSE ELECTRIC CO., LTD.</b>					
Profile for TM Series connector							
					APPROVED	YH. ENAMI	20100129
					CHECKED	HO. MIWA	20100129
					DESIGNED	YH. MAMADA	20100129
		WRITTEN	YH. MAMADA	20100129			
技術指定書 TECHICAL SPECIFICATION		ETAD-E2546-00		△ 1 / 2			

Recommended mounting temperature profile and manual soldering condition

◇ Flow profile (Sn-Ag-Cu solder)



◇ Reflow profile (Sn96.5-Ag3-Cu0.5 solder paste)



◇ Manual solder condition (Sn-3.0Ag-0.5Cu solder)

Temperature of soldering iron tip : 380°C max Soldering time : Max 3 seconds