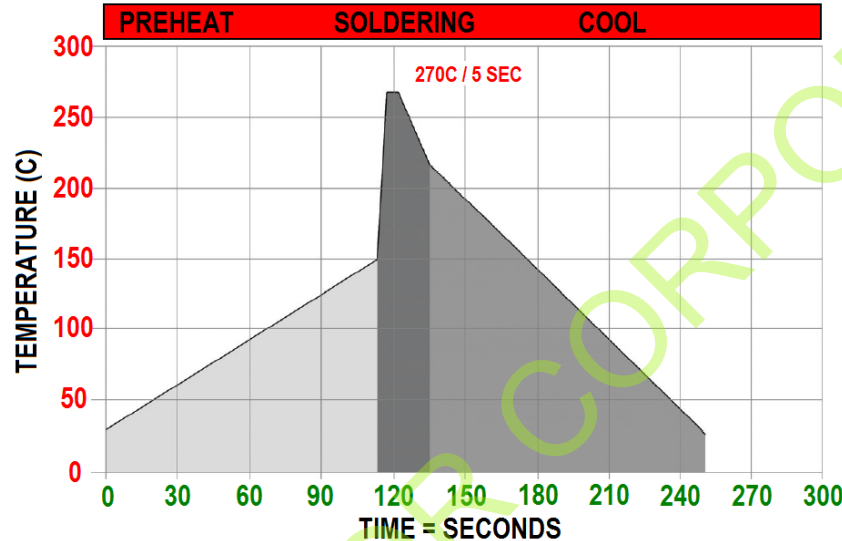


MoxiE Inductor Corporation recommends the following reflow soldering, J-STD-020C, IPC/JEDEC compatible & wave soldering profiles for processing its Lead Free (Pb) surface mount and thru-hole products. MoxiE Inductor Corporation surface mount products are tested to withstand maximum peak temperature up to 260°C.

PB FREE WAVE SOLDER

MoxiE PB Free Wave Solder Notes:

The maximum dwell time in the solder wave (270°C) shall not exceed 5 seconds.



PB FREE REFLOW SOLDER

MoxiE PB Free Reflow Solder Notes:

The maximum duration of peak temperature shall not exceed 10 seconds.
The maximum duration of temperature above 217°C shall not exceed 90 seconds.

The maximum ramp rate up 3°C/down 6°C per second.
The temperature shall be taken from the component leads.

