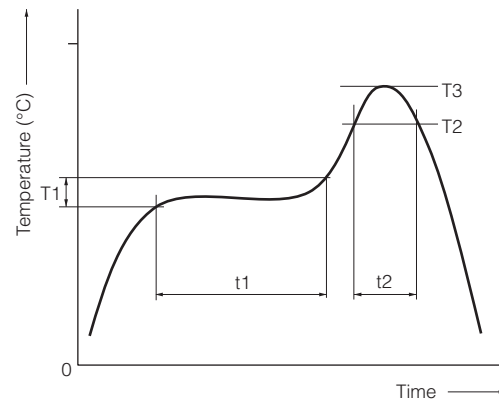


## Soldering Conditions

### Reflow soldering conditions



- Pb free solder recommended temperature profile

Power Choke Coils for Automotive application

Series	Preheat		Soldering		Peak Temperature		Time of Reflow
	T1 [°C]	t1 [s]	T2 [°C]	t2 [s]	T3	T3 Limit	
PCC-D1413H PCC-M0530M/M0540M PCC-M0630M/M0645M PCC-M0754M PCC-M0854M/M0850M PCC-M1054M/M1050M PCC-M1050ML/M1060ML	150 to 170	60 to 120	230 °C	30 to 40	250 °C, 5 s	260 °C, 10 s	2 times max.

Power Choke Coils for consumer use

Series	Preheat		Soldering		Peak Temperature		Time of Reflow
	T1 [°C]	t1 [s]	T2 [°C]	t2 [s]	T3	T3 Limit	
PCC-M0512W PCC-M0630L PCC-M0630W PCC-M0730L PCC-M074L PCC-M104L PCC-M104W PCC-M125L PCC-D124H PCC-D125H PCC-D126H PCC-D126F PCC-F126F	150 to 170	60 to 120	230 °C	30 to 40	250 °C, 5 s	260 °C, 10 s	2 times max.