

# CnC Tech

Industrial Cable and Connector Technology

## CnC Tech Soldering Recommendations for the 3X10 Series

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### Wave Soldering

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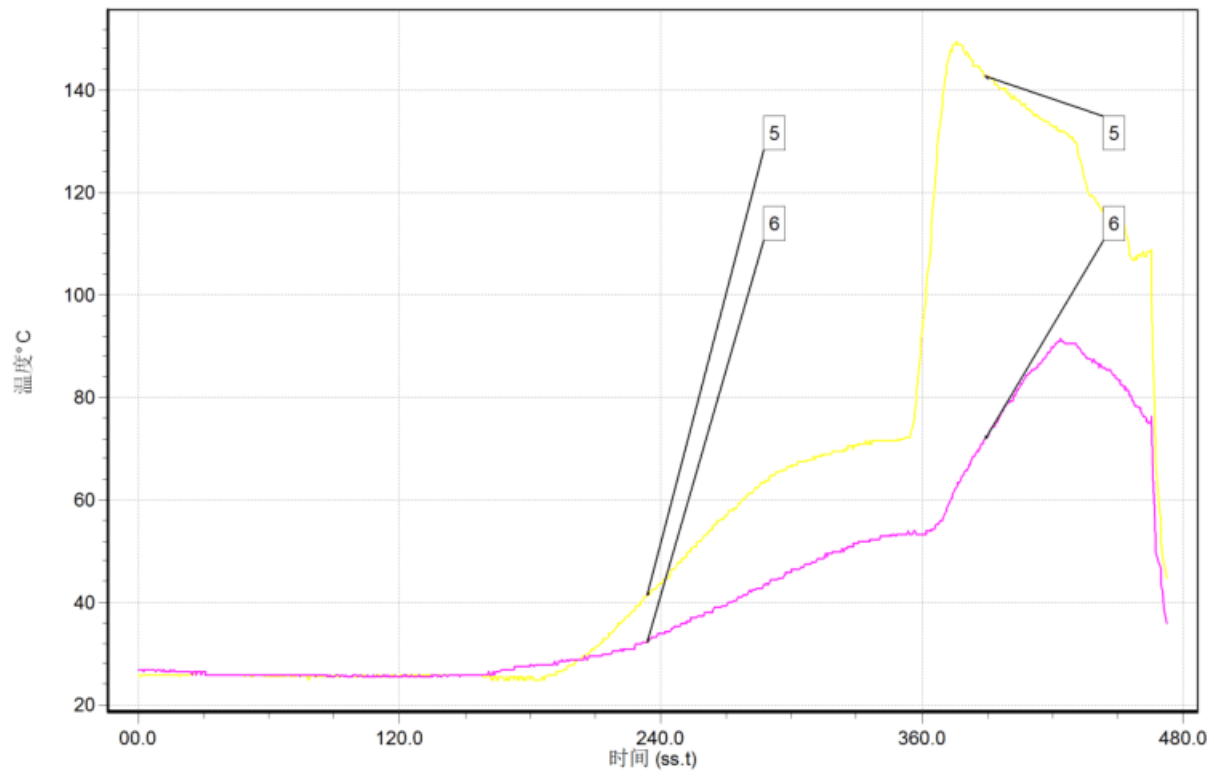
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Recommended temperature and time periods for the soldering process					
Series	Soldering method	Temperature in the furnace (lead -free)	Plastic	Furnace time	Soldering time
3X10	WAVE soldering	220°C to 230°C	PBT	1 to 3 minutes	0.3 to 3 seconds

The temperature for wave solder machine needs to be set, and then place the IDC with the board into the wave solder machine.

The tin contact temperature is 140°C - 180°C soldered to the IDC pin. There is no standard temperature for the board, because it is only 3 seconds when the tin contact the part, and then the tin attach the product, so 140°C to 230°C degree is allowed.

Below is the graph for wave soldering, based on factory self-testing:



The yellow line (5) shows the temp/seconds for the bottom board, the purple line (6) for above of board.