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## **Soldering Guidelines for Epoxy Coated Orange Drop® Polypropylene Film Capacitors**

### **Maximum Soldering Temperature**

- 260°C for 4 seconds maximum peak exposure.
- 110°C for 1 minute maximum pre-heat exposure.

### **Internal Case Temperature**

- Process must insure that the internal case temperature remains at 110°C or below, throughout the process.

### **Recovery Time**

- If a second soldering process is required, insure that sufficient time is allotted for the temperature on the capacitor surface to reach 50°C.

### **Other Soldering Notes**

- Do not allow solder to touch any part of the epoxy coated body.
- Do not allow other components to come in contact with the capacitor during the soldering operation.
- The capacitor body should not be in direct contact with the PCB. A lead formed bend is recommended.
- Adhesive Curing Oven temperature exposure must also not exceed the maximum soldering or safe operating limits of the capacitor (for longer periods of time than 1 minute). Capacitor recovery time process must be employed as well.

# **Performance.**

**F R O M   D E S I G N   T O   D E L I V E R Y <sup>TM</sup>**