

# CnC Tech

Industrial Cable and Connector Technology

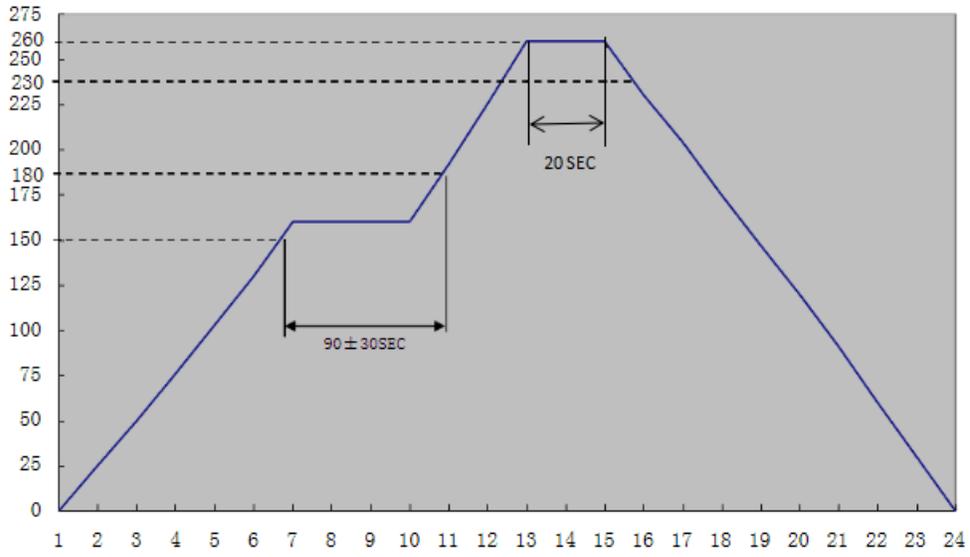
## CnC Tech Soldering Recommendations for the 3X20 and 3221 Series

### Reflow Soldering

Recommended temperature and time periods for the soldering process					
Series	Soldering method	Temperature in the furnace (lead -free)	Plastic	Furnace time	Soldering time
3X20	Reflow soldering	260°C	Nylon 6T	6 minutes	10 to 30 seconds
3221	Reflow soldering	260°C	Nylon 6T	6 minutes	10 to 30 seconds

#### Nylon 6T reflow soldering profile:

1. Preheat zone: Temperature from room temperature to 150°C, the temperature rise rate controlled is at about 2°C / seconds, the time zone from 60 to 150 seconds.
2. The average temperature zone ([thermal soak zone](#)): Temperatures from 150°C to 200°C, slowly warming stability, rate of temperature rise of less than 1°C / second and the time control in the area of 60 to 120 seconds;
3. Reflux zone ([reflow zone](#)): Temperature from 210~220°C degrees, the whole interval time control in 60 to 90 seconds
4. Peak temperature: 240°C to 260°C for about 10~30 seconds
5. Melt temperature: 285°C
6. Cooling zone: Temperature from max 180°C, the temperature drop rate cannot exceed 4°C per second.
7. Heating from room temperature of 25°C to 250°C time should not exceed 6 minutes.
8. Reflux zone ([reflow zone](#)) time of 30 to 90 seconds should be the goal



The time period shown in this graph above is 240 seconds.