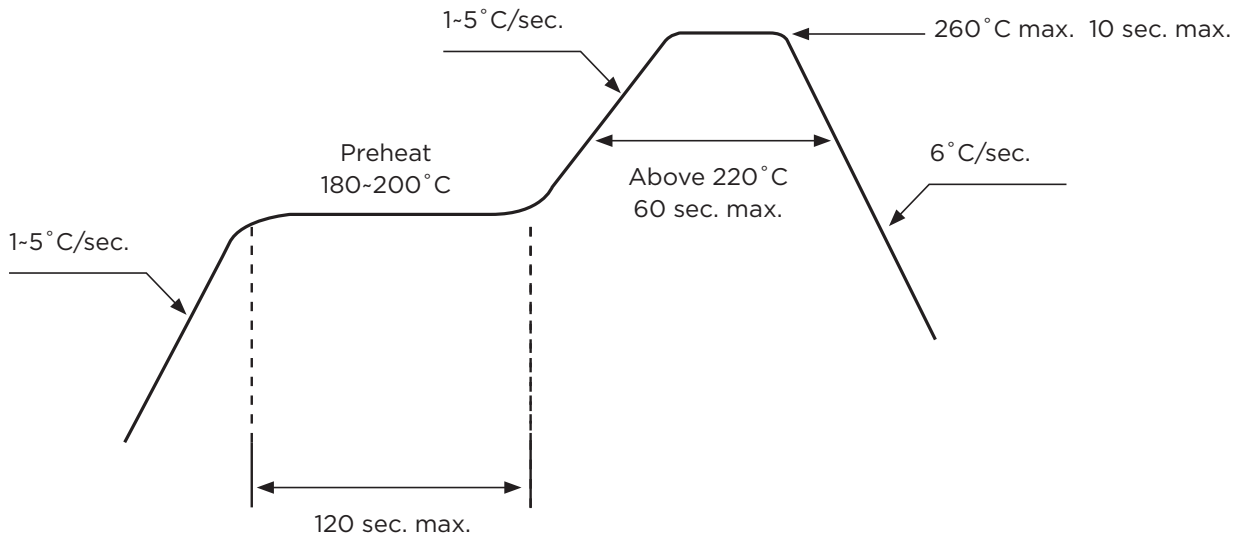


LED RECOMMENDED SOLDERING CONDITIONS

1. REFLOW PROFILE



- NOTE:**
1. Max number of reflow passes: 2.
 2. Do not warp the board during processing or subject the LED to any additional stress.

2. HAND SOLDERING RECOMMENDATIONS

- a. Limit hand soldering to 3 seconds max at 280°C maximum tip temperature.
- b. Soldering by hand should be limited to one time.