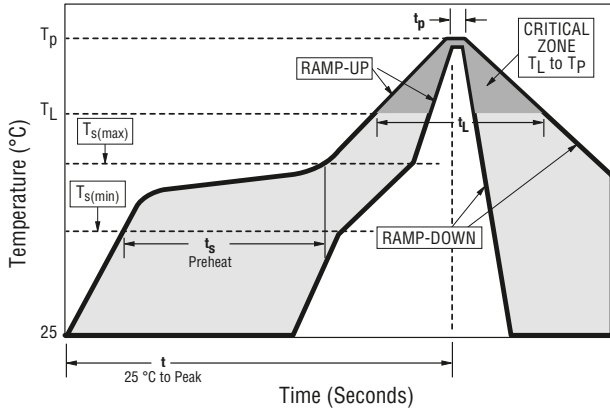


Soldering Parameters - Reflow Soldering



Profile Condition		SnPb Eutectic Assembly	Pb-free Assembly
Preheat	Temperature Min. ($T_{S(\min)}$)	100 °C	150 °C
	Temperature Max. ($T_{S(\max)}$)	150 °C	200 °C
	Time (Min. to Max.) (t_s)	60-120 seconds	60-180 seconds
Average Ramp-up Rate (Liquidus Temperature (T_L) to Peak)		3 °C / second max.	
Reflow	Temperature (T_L) (Liquidus)	183 °C	217 °C
	Time (t_L)	60 – 150 seconds	
Peak Temperature (T_p)		235 °C	260 °C
Time within 5 °C of Actual Peak Temperature (t_p)		10-30 seconds	20-40 seconds
Ramp-down rate		6 °C / second max.	
Time from 25 °C to Peak Temperature		6 minutes max.	8 minutes max.
Do not Exceed		235 °C	260 °C

REFLOW TIMES: 3 TIMES MAX.

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