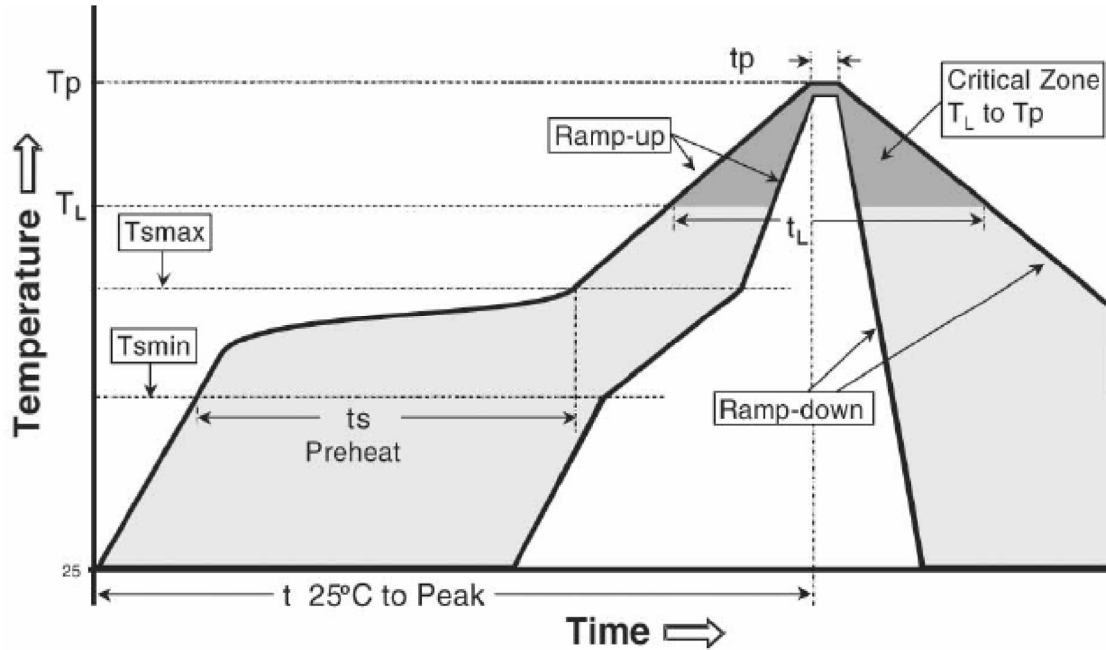


Recommend Reflow Soldering Profile



| Profile Feature | Lead Free Spec |
|--|-----------------|
| Average ramp-up rate | 3°C/second max. |
| Preheat | 150°C |
| - Temperature Min (T _{smin}) | 200°C |
| - Temperature Max (T _{smax}) | 60-120 seconds |
| Time maintained above: | 217°C |
| - Temperature (T _L) | 60-150 seconds |
| Peak Temperature (T _p) | 260+0/-5°C |
| Time within 5°C of actual Peak | 20-40 seconds |
| Ramp-down Rate | 6°C/second max. |
| Time 25°C to Peak Temperature | 8 minutes max. |