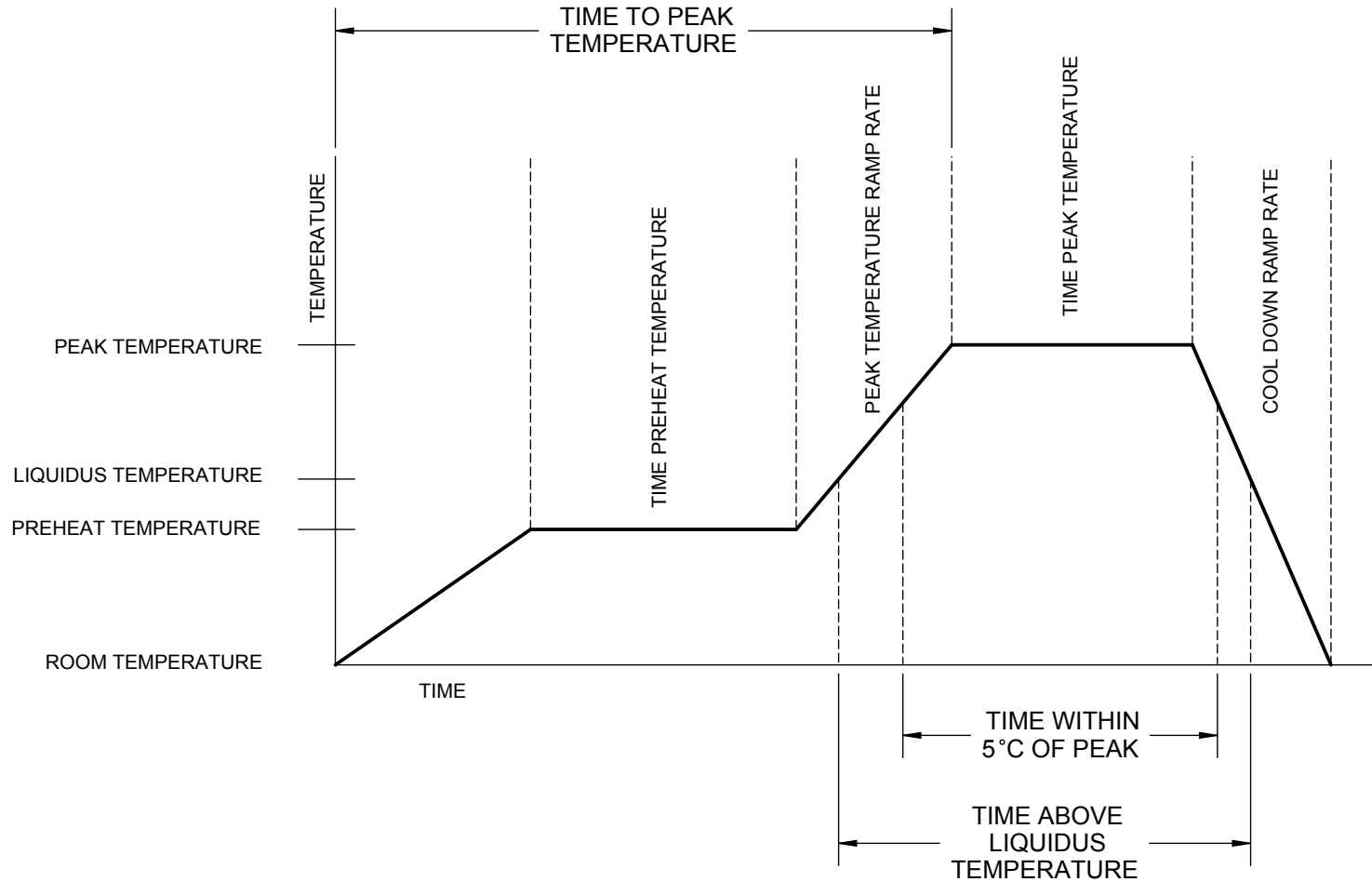


# LEAD FREE REFLOW PROFILE OF SMD PACKAGE



DESCRIPTION	REQUIREMENT
AVERAGE PREHEAT RAMP RATE	3°C /SECOND MAXIMUM
PREHEAT TEMPERATURE	150°C MINIMUM, 200°C MAXIMUM
PREHEAT TIME	60 TO 80 SECONDS
RAMP TO PEAK	3°C /SECOND MAXIMUM
TIME OVER LIQUIDUS (217°C)	60 TO 150 SECONDS
PEAK TEMPERATURE	260°C +0/-5°C
TIME WITHIN 5°C OF PEAK	20 TO 40 SECONDS
RAMP - COOL DOWN	6°C /SECONDS MAXIMUM
TIME 25°C TO PEAK	8 MINUTES MAXIMUM

<b>TopLine®</b>			
TITLE		TEMPERATURE PROFILE LEAD FREE COMPONENTS	
SCALE	SIZE	DRAWING NO.	REV
	A	129999	A
DO NOT SCALE DRAWING			SHEET 1 OF 1