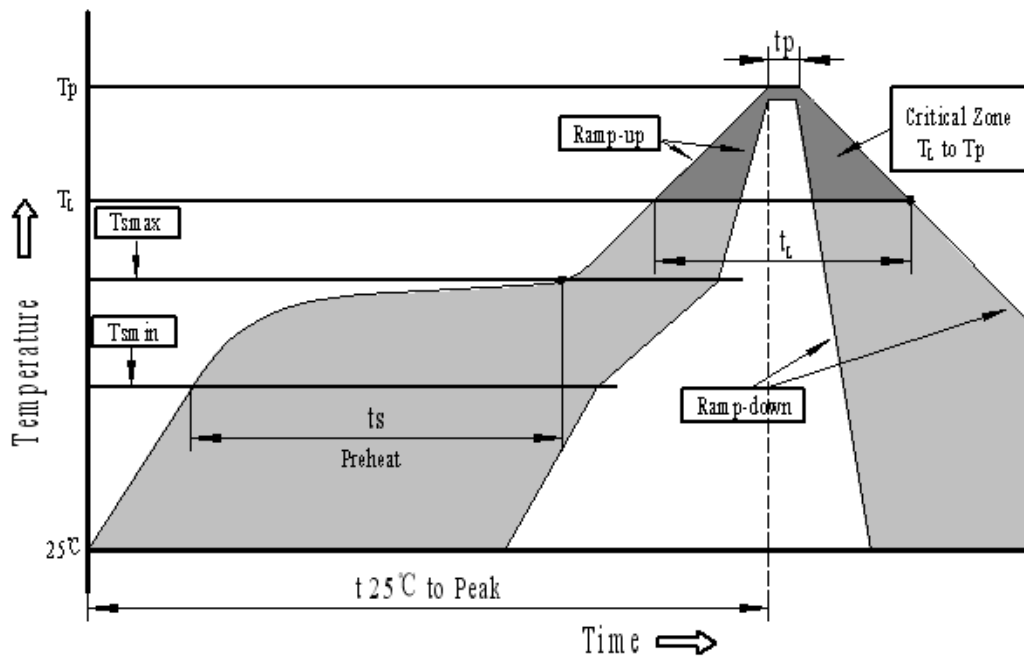


Recommended Temperature Profile for Reflow Oven



Profile Feature	Pb-Free Assembly
Average ramp-up rate(T _L to Tp)	3°C/second max.
Preheat	
-Temperature Min.(T _{min})	150°C
-Temperature Min.(T _{max})	200°C
-Temperature Min.(ts)	60~180 seconds
T _{max} to T _L	
-Ramp-up Rate	3°C/second max.
Time maintained above:	
- Temperature(T _L)	217°C
-Time(T _L)	60~150 seconds
Peak temperature(Tp)	245°C +0/-5
Time within 5°C of actual Peak temperature (tp)	6 seconds max.
Ramp-down Rate	6°C/second max.
Time 25°C to Peak Temperature	8 minutes max.
We suggest the customer do the reflow soldering once.	