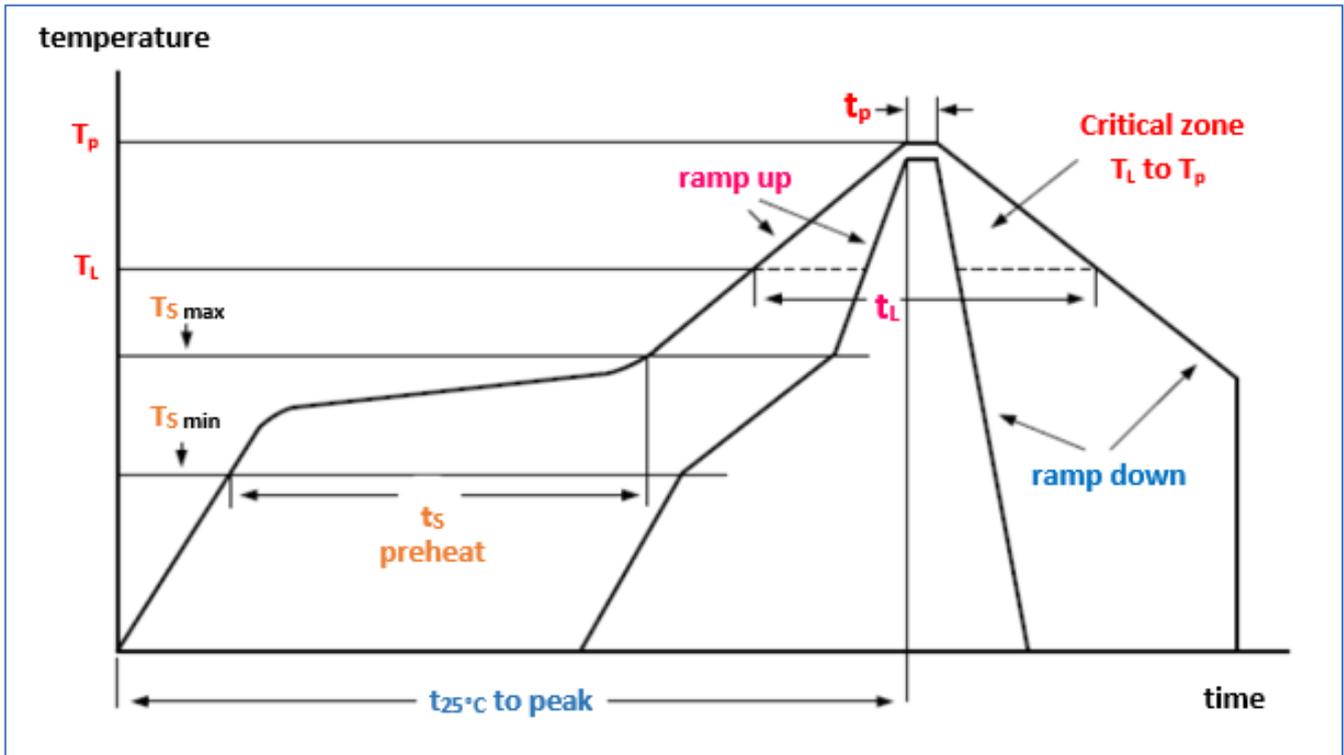




1. Reflow Soldering Profile



Profile Feature	SnPb eutectic assembly	Pb-free assembly
Average ramp-up rate ($T_{S\ max}$ to T_p)	max 3°C/s	max 3°C/s
Preheat		
Temperature minimum ($T_{S\ min}$)	100°C	150°C
Temperature maximum ($T_{S\ max}$)	150°C	200°C
Time ($t_{S\ min}$ to $t_{S\ max}$)	60 - 120s	60 - 180s
Time maintained above		
Temperature (T_L)	183°C	217°C
Time (t_L)	60 - 150s	60 - 150s
Peak Temperature (T_p)	220°C	245°C
Number of allowed reflow cycles	3	3
Time within 5°C of actual peak temperature (t_p)	10 - 30s	20 - 40s
Ramp-down rate	6°C/s maximum	6°C/s maximum
$t_{25^\circ\text{C}}$ to peak temperature	6 minutes maximum	8 minutes maximum

Revision history

Rev	Date	Description
v.1	20191104	New format update

Contact information

For more information and sales office addresses please visit: <http://www.ween-semi.com>

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