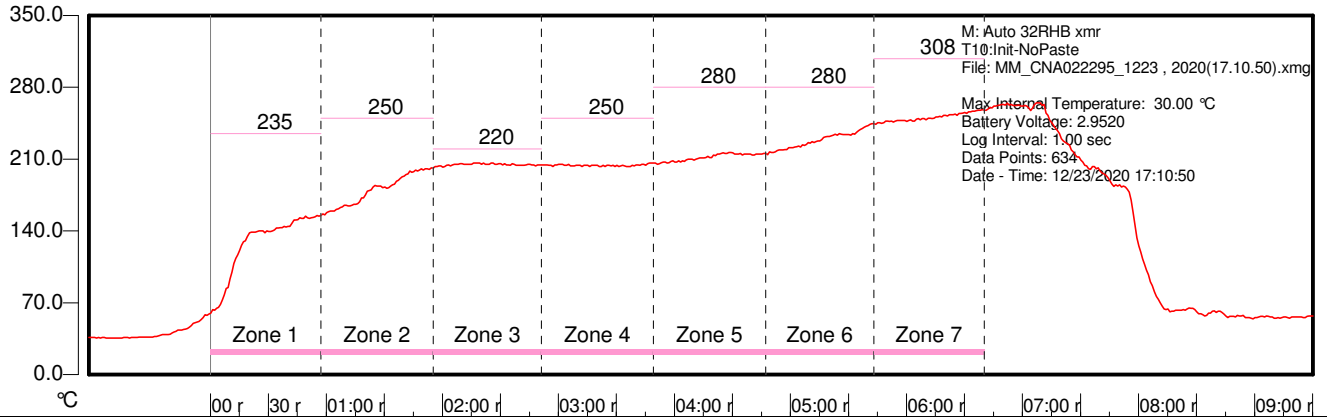


Oven Name: Manix TSC1412

Setpoints: °C									
Oven Area:	1	2	3	4	5	6	7	8	9
Up Side:	235	250	220	250	280	280	308		
Down Side:	235	250	220	250	280	280	308		
Oven Area:	10	11	12	13	14	15	16	17	18
Up Side:									
Down Side:									
Conveyor Speed:	21.00 in/min								



		Maximum Positive Slope	Time Between	Time Between	Time Above	Maximum Positive Slope	Maximum Temperature	Time Above	Slope: Peak to	Maximum Negative Slope	Time Above
		°C/sec	sec	sec	sec	°C/sec	°C	sec	°C/sec	°C/sec	sec
		=25-150=	50-200	00-217	217	217-Peak		255	Peak-217	=217-50=	0
		°C/sec	sec	sec	sec	°C/sec	°C	sec	°C/sec	°C/sec	sec
1	Sensor 1 Location	5.3	66	183	135	1.0	265.2	42	-2.5	-7.0	427
	Range	0.0	0	0	0	0.0	0.0	0	0.0	0.0	0
	Average	5.30	66.0	183.0	135.0	1.00	265.20	42.0	-2.50	-7.00	427.0
	Std Deviation	-1.#IO	-1.#J	-1.#J	-1.#J	-1.#IO	-1.#IO	-1.#J	-1.#IO	-1.#IO	-1.#J

QSS 009-138 (Pb-free)

Statistic Name	Actual	Spec	Units
Ramp-Up Rate-1 (to 150C)	5.3	3 min.	C/sec
Preheat Time (150C to 200C)	66.0	60-80	sec
Time Between 200C and 217C	183	130 min.	sec
Ramp-Up Rate-2 (217C to Tp)	1.0	0.5-3	C/sec
Time above Liquidus Temperature (217C)	135	90-150	sec
Peak Temperature (Tp)	265.2	260 +5/-0	C
Time within 5C of Tc	42	40-50	sec
Ramp-Down Rate-1 (Tp to 217C)	-2.5	6 max.	C/sec
Ramp-Down Rate-2 (217C to 50C)	-7.0	6 min.	C/sec
Time from RT (25C) to Tp	427	300-480	sec

Prepared by: