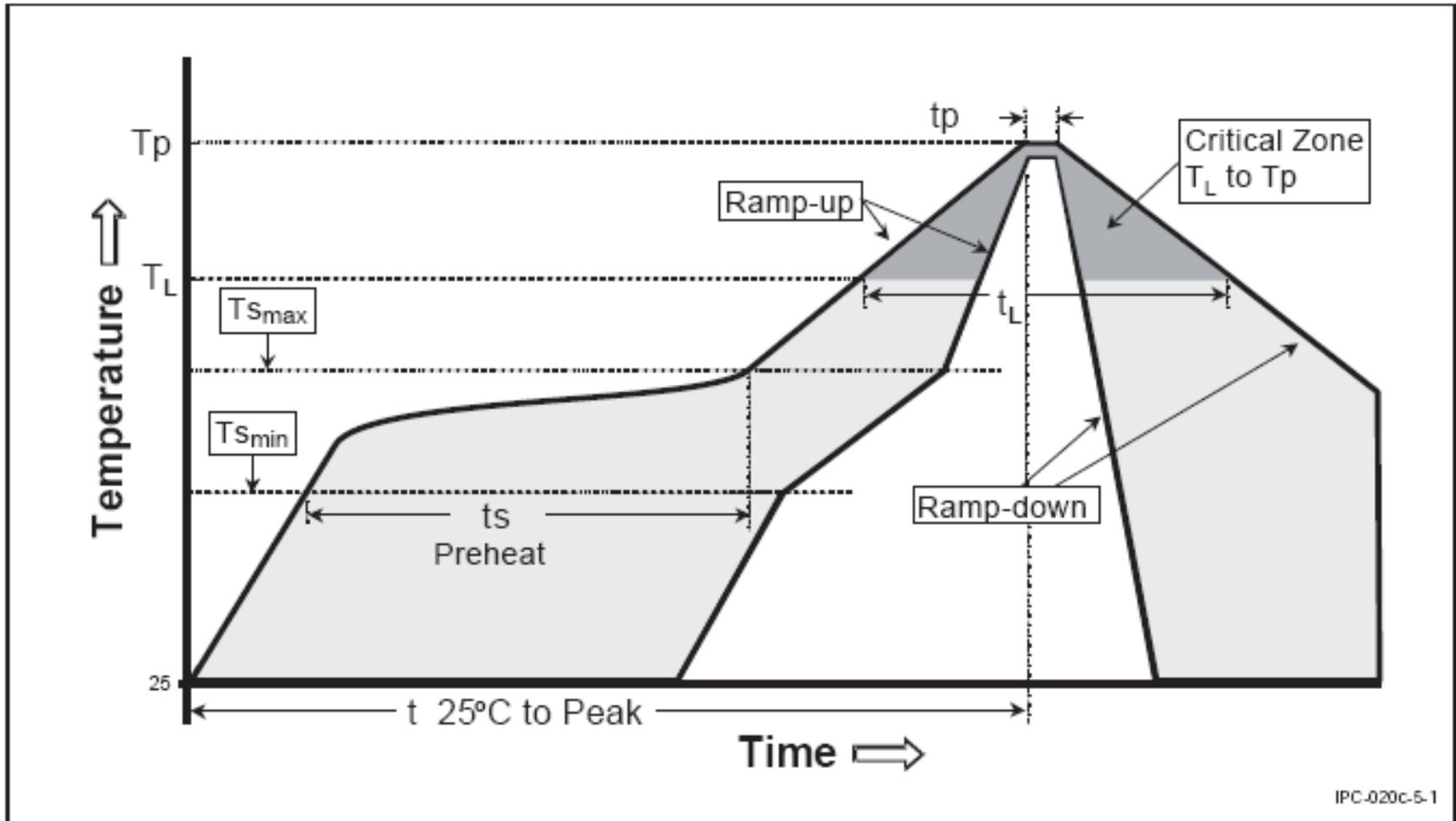


# **REFLOW RECOMMENDATION**

# RECOMMENDED TEMP PROFILE

Profile Feature	Pb Free Assy
Average Ramp-up Rate ( $T_{s_{max}}$ to $T_p$ )	3 °C/second max
<p style="text-align: center;"><b>PREHEAT</b></p> <ul style="list-style-type: none"> <li>- Temperature Min (<math>T_{s_{min}}</math>)</li> <li>- Temperature Max (<math>T_{s_{max}}</math>)</li> <li>- Time (<math>t_{s_{min}}</math> to <math>t_{s_{max}}</math>)</li> </ul>	<p style="text-align: center;">150 °C 200 °C 60-180 seconds</p>
<p style="text-align: center;">Time Maintained Above:</p> <ul style="list-style-type: none"> <li>-Temperature (<math>T_L</math>)</li> <li>-Time (<math>t_L</math>)</li> </ul>	<p style="text-align: center;">217 °C 60-150 seconds</p>
Peak/Classification Temp ( $T_p$ )	260 deg C Max
Time within 5 °C of Actual Peak Temperature ( $t_p$ )	20- 40 seconds
Ramp Down Rate	6 °C/second max
Time 25 °C to Peak Temperature	8 minutes max
11/16/2018	

# RECOMMENDED OVEN PROFILE (Pb FREE)



IPC-020c-5-1