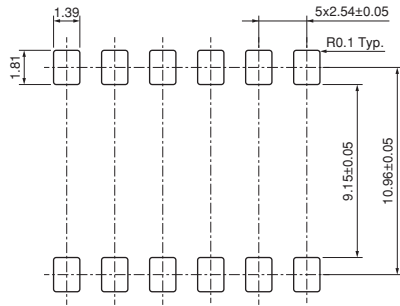


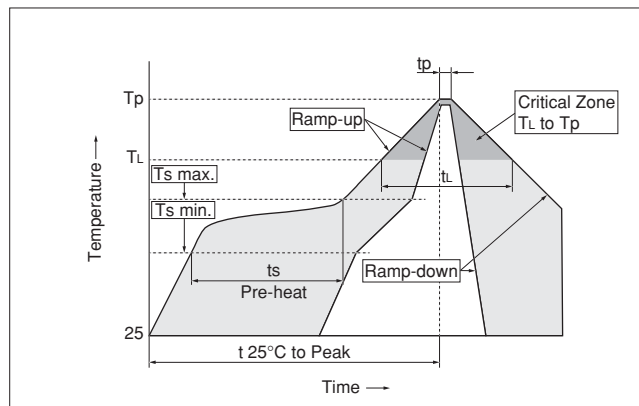
Mounting

Land Pattern



(in mm)

Reflow Chart



Profile Feature	Sn-Pb Eutectic Assembly	Pb-free Assembly
Average Ramp-up Rate (TL to Tp)	3°C/second max.	3°C/second max.
Preheat		
· Temperature min. (Ts min.)	100°C	150°C
· Temperature max. (Ts max.)	150°C	200°C
· Time (min. to max.) (ts)	60-120 seconds	60-180 seconds
Ts max. to T, Ramp-up Rate		3°C/second max.
Time Maintained Above:		
· Temperature (TL)	183°C	217°C
· Time (tL)	60-150 seconds	60-150 seconds
Peak Temperature (Tp)	240 +0/-5°C	250 +0/-5°C
Time within 5°C of Actual Peak Temperature (Tp)	10-30 seconds	20-40 seconds
Ramp-down Rate	6°C/second max.	6°C/second max.
Time 25°C to Peak Temperature	6 minutes max.	8 minutes max.