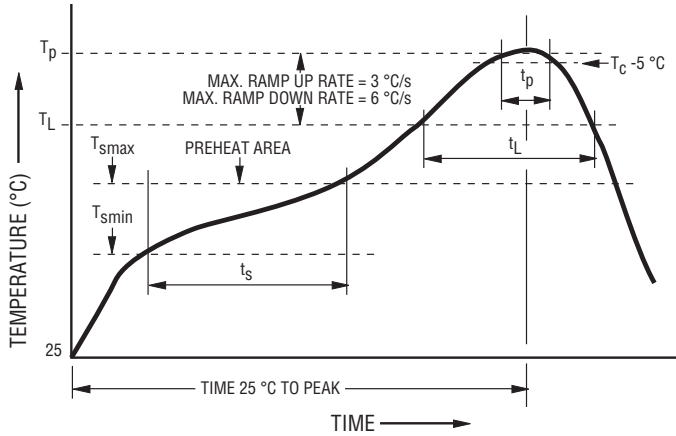


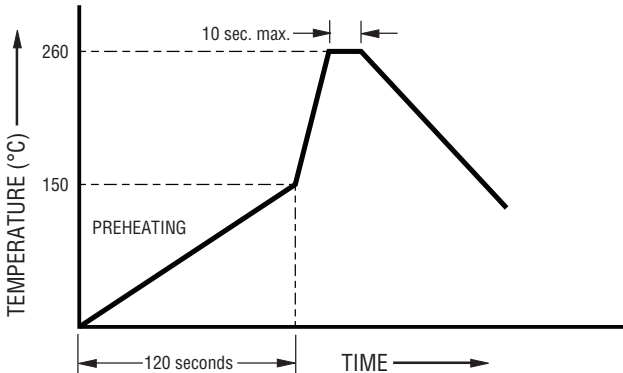
Solder Reflow Recommendations



Profile Feature	Pb-Free Assembly
Preheat / Soak: Temperature Min. (T_{smin}) Temperature Max. (T_{smax}) Time (t_s) from (T_{smin} to T_{smax})	150 °C 200 °C 60~120 seconds
Ramp Up Rate (T_l to T_d)	3 °C / second max.
Liquidous Temperature (T_l) Time (t_L) maintained above T_l	217 °C 60~150 seconds
Peak Package Body Temperature (T_d)	260 °C
Time (t_p)* within 5 °C of the specified classification temperature (T_c)	30 seconds*
Ramp Down Rate (T_d to T_l)	6 °C / second max.
Time 25 °C to Peak Temperature	8 minutes max.

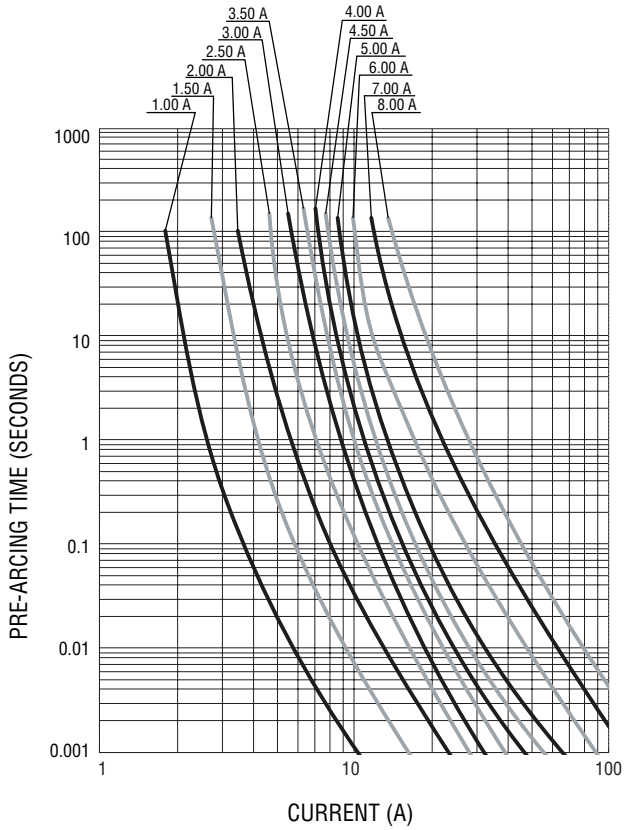
* Tolerance for peak profile temperature (T_p) is defined as a supplier minimum and a user maximum.

Recommended Temperature Profile for Wave Soldering



Wave soldering is suitable for 1206 size models.

Average Pre-Arcing Time vs. Current Curves



Average I^2t vs. t Curves

