Average Ramp-up Rate = 3°C/second max.

$t\ (25°C\ to\ Peak) = 6\ minutes\ max.$

$t_s\ (Preheat) = 60\ -\ 120\ seconds.$

$t_L\ (Ramp-up) = 60\ -\ 150\ seconds.$

$t_p\ (Within\ 5°C\ of\ peak\ temperature) = 10\ -\ 30\ seconds.$

Ramp-down rate = 6°C/second max.

<table>
<thead>
<tr>
<th>Rev. Letter</th>
<th>Used On</th>
<th>Revision</th>
<th>Approved By</th>
<th>Date</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>-</td>
<td>Added shading to chart, clarified peak temperature.</td>
<td>BM</td>
<td>12/18/2009</td>
</tr>
</tbody>
</table>

Unless otherwise specified, dimensions are in inches.

- XX ± 0.005
- XXX ± 0.003
- Angles ± 15°

Description:
Reflow Soldering Profile - Eutectic

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