



Reflow Condition		Pb - Free assembly
Pre Heat	- Temperature Min ($T_{s(min)}$)	150°C
	- Temperature Max ($T_{s(max)}$)	200°C
	- Time (Min to Max) (t_s)	60 - 120 seconds
Average Ramp-up Rate (Liquidus Temp (T_L) to peak)		5°C/second max.
$T_{s(max)}$ to T_L - Ramp-up Rate		5°C/second max.
Reflow	- Temperature (T_L) (Liquidus)	217°C
	- Temperature (t_L)	60 - 90 seconds
Peak Temperature (T_p)		260 ^{+0/-5} °C
Time within 5°C of actual peak Temperature (t_p)		20 - 40 seconds
Ramp-down Rate		5°C/second max.
Time 25°C to peak Temperature (T_p)		8 minutes max.
Do not exceed		260°C

		东莞市奥力特电子科技有限公司	
CUSTOMER NO.		DRAWN BR.	
CHECKED BY.		APPROVED BY.	
PART NO.	0154	DRAWING NO.	
SCALE.		DATE.	2019/12/09
TOLERANCE.		TITLE.	
DECIMALS	ANGULAR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING	
	±0.2		