

SOLDERING PROFILE

Profile Feature	Sn-Pb Eutectic Assembly	Pb-Free Assembly
Average Ramp-Up Rate ($T_{s_{max}}$ to T_p)	3 °C/second max.	3 °C/second max.
Preheat		
- Temperature Min ($T_{s_{min}}$)	100 °C	150 °C
- Temperature Max ($T_{s_{max}}$)	150 °C	200 °C
- Time ($t_{s_{min}}$ to $t_{s_{max}}$)	60-120 seconds	60-180 seconds
Time maintained above:		
- Temperature (T_L)	183 °C	217 °C
- Time (t_L)	60-150 seconds	60-150 seconds
Peak Temperature (T_p)	240 +0/-5 °C	260 +0 °C
Time within 5 °C of actual Peak Temperature (t_p)	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.

