





Pb-free Soldering IR Reflow(SMD)



1,MSL Grade: 1 Level 2,Floor life: 2years 3,Condition:≤30°C RH 85% 2,Form-1(Reference JEDEC J-STD-020D Table 5-2)

	IR reflow profile	Pb-free	
step#	Profile Feature	Condition/Duration	
step1	Ramp-up rate	3°C/second max	
step2 step3	Preheat:150°C-200°C(Ta-Tb)	t1-t2:60-120seconds	
	Ramp-up rate(TL to Tp)	3°C/second max	
	Temperature maintained above 217°C	60-150seconds	
step4	Peak temperature(Tp)	260+0/-5°C	
	Time within 5°C of actual peak temperature	30seconds max	
Ramp-down rate(Tp to TL)		6°C/second max	

3,Form-2(Reference JEDEC J-STD-020D Table 4-2)

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Package	Volume mm ³	Volume mm ³	Volume mm ³
Thickness	<350	350-2000	>2000
<1.6mm	260+0/-5°C	260+0/-5°C	260+0/-5℃
1.6mm-2.5mm	260+0/-5°C	250+0/-5°C	245+0/-5℃
>2.5mm	250+0/-5° C	245+0/-5°C	245+0/-5℃