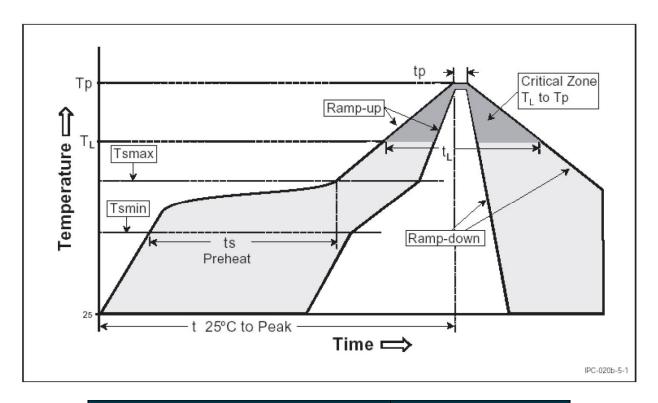
RAFI soldering profile for ROHS compliant reflow components



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Parameter	RAFI values
Gradient (T _L to T _P)	max. 3°C/s
Preheating zone Minimum temperature (T _{smin}) Maximum temperature (T _{smax}) Time (from min. to max.) (ts)	150°C 200°C 60 - 120 s
Gradient (T _{smax} to T _L)	max. 3°C / s
Time over melting temperature (T _L) time (t _L)	217°C 60 – 150 s
Peak temperature (T _P)	max. 260°C (+0°C)
Time within peak temperature – 5°C (tp)	20-40 s
Gradient ramp down	max. 6°C/s
Time difference from 25°C to peak temperature	max. 8 minutes

The reflow soldering profile is based on the definition of Jedec J-STD-020D.

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