

Table 4-1 Package Peak Reflow Temperatures

Reflow Conditions	Pkg. Thickness ≥ 2.5 mm or Pkg. Volume ≥ 350 mm ³	Pkg. Thickness < 2.5 mm and Pkg. Volume < 350 mm ³
SnPb Eutectic	Convection 225 +0/-5°C	Convection 240 +0/-5°C
Pb Free	Convection 245 +0/-5°C	Convection 250 +0/-5°C

Table 5-2 Classification Reflow Profiles

Profile Feature	Sn-Pb Eutectic Assembly		Pb-Free Assembly	
	Large Body	Small Body	Large Body	Small Body
Average ramp-up rate (T_L to T_p)	3°C/second max.		3°C/second max.	
Preheat				
- Temperature Min (T_{smin})	100°C		150°C	
- Temperature Max (T_{smax})	150°C		200°C	
- Time (min to max) (t_s)	60-120 seconds		60-180 seconds	
T_{smax} to T_L				
- Ramp-up Rate			3°C/second max	
Time maintained above:				
- Temperature (T_L)	183°C		217°C	
- Time (t_L)	60-150 seconds		60-150 seconds	
Peak Temperature (T_p)	225 +0/-5°C	240 +0/-5°C	245 +0/-5°C	250 +0/-5°C
Time within 5°C of actual Peak Temperature (t_p)	10-30 seconds	10-30 seconds	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.	

Note: All temperatures refer to topside of the package, measured on the package body surface.

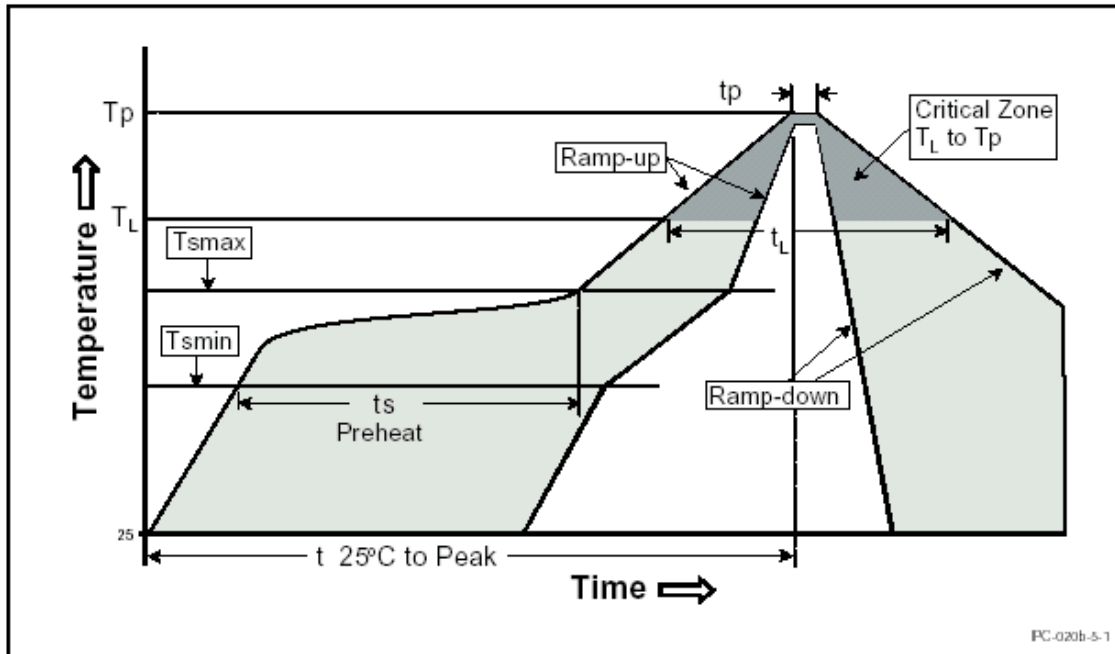


Figure 5-1 Classification Reflow Profile