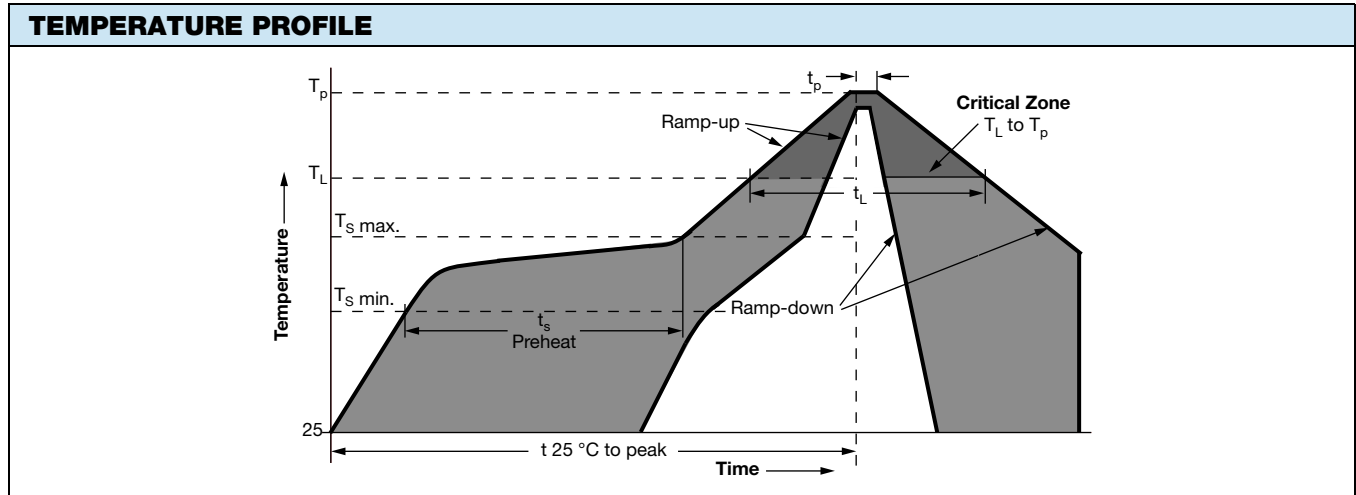


## Recommended Reflow Profile

Applicable for resistors of the Vishay Draloric and Vishay Beyschlag brand.



Light and dark grey area is free for customers application.

REFLOW PROFILES		
PROFILE FEATURE	Sn-Pb EUTECTIC ASSEMBLY	LEAD (Pb)-FREE ASSEMBLY (e.g. SnAgCu)
Maximum average ramp-up rate, $T_s \text{ max. to } T_p$	3 °C/s	3 °C/s
<b>Preheat</b>		
Minimum temperature, $T_s \text{ min.}$	100 °C	150 °C
Maximum temperature, $T_s \text{ max.}$	150 °C	200 °C
Preheating time ( $T_s \text{ min. to } T_s \text{ max.}$ ), $t_s$	60 s to 120 s	60 s to 180 s
<b>Time maintained above</b>		
Liquidus temperature, $T_L$	183 °C	217 °C
Time above liquidus, $t_L$	60 s to 150 s	60 s to 150 s
Minimum peak temperature, $T_p \text{ min.}$	210 °C	230 °C
Maximum peak temperature, $T_p \text{ max.}$	260 °C	260 °C
Time within ( $T_p \text{ max.} + 0 \text{ °C}/- 5 \text{ °C}$ or $T_p \text{ min.} + 5 \text{ °C}/- 0 \text{ °C}$ )	10 s to 40 s	10 s to 40 s
Maximum ramp-down rate	6 °C/s	6 °C/s
Maximum time 25 °C to peak temperature	6 min	8 min