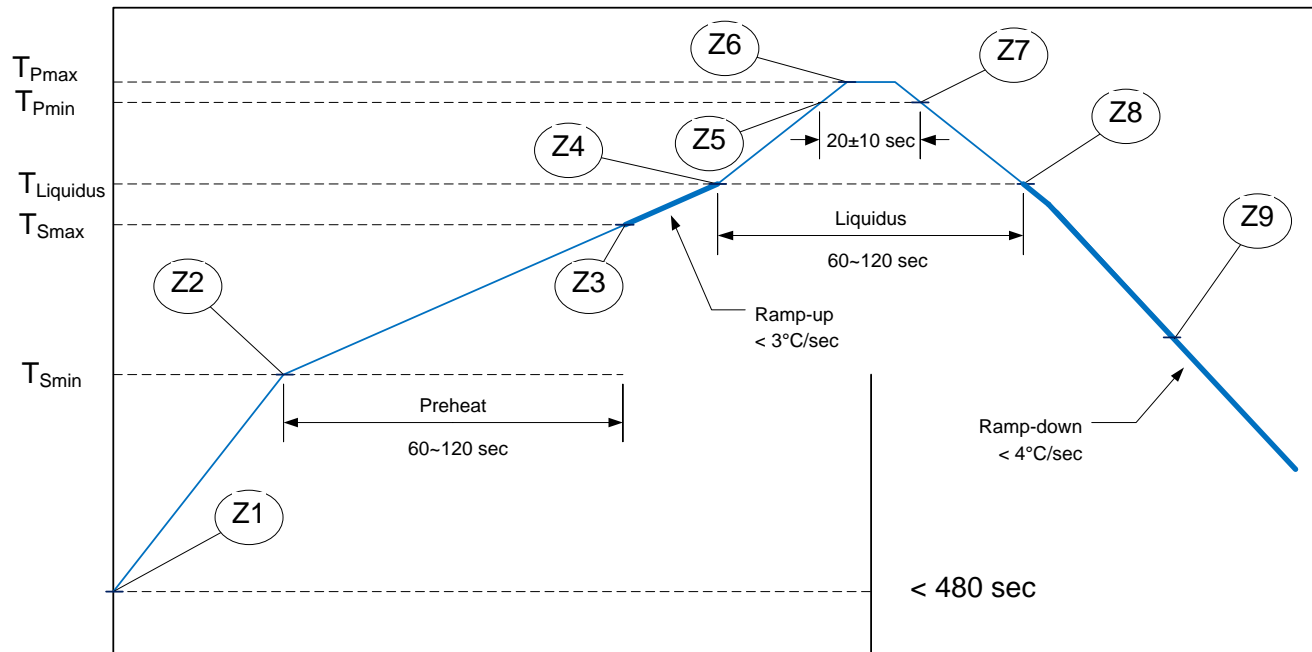


AN-07a Reflow Soldering Temperature Profile



Zone	Parameter	Limitation	
		Temp (°C)	Time (sec)
Z1	T_{room}	25	
Z2	T_{smin}	150	
Z3	T_{smax}	200	60~120 (Z2→Z3)
Z4	$T_{Liquidus}$	217	
Z5	T_{Pmin}	255/265	
Z6	T_{pmax}	260/265	< 480 (Z1→Z6)
Z7	T_{Pmin}	255/260	10~30 (Z5→Z7)
Z8	$T_{Liquidus}$	217	60~120 (Z4→Z8)

Suited for Series 52

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