

Soldering Profile

Profile Parameter	Sn-Pb Parts	Pb Free Parts
Average Ramp-Up Rate (T_{Smax} to T_p)	3°C/second max.	3°C/second max.
Preheat - Temperature Min (T_{Smin}) - Temperature Max (T_{Smax}) - Time (T_{Smin} to T_{Smax})	100°C 150°C 60-120 seconds	130°C 180°C 60-90 seconds
Time maintained above: - Temperature (T_L) - Time (t_L)	183°C 60-150 seconds	220°C 30-90 seconds
Peak Temperature (T_p)	225 - 240°C	245 ±5°C
Time within 5°C of actual Peak Temperature (T_p)	10-30 seconds	10-30 seconds
Ramp Down Rate	6°C/second max.	6°C/second max.
Time 25°C to Peak Temperature	6 minutes max.	8 minutes max.

