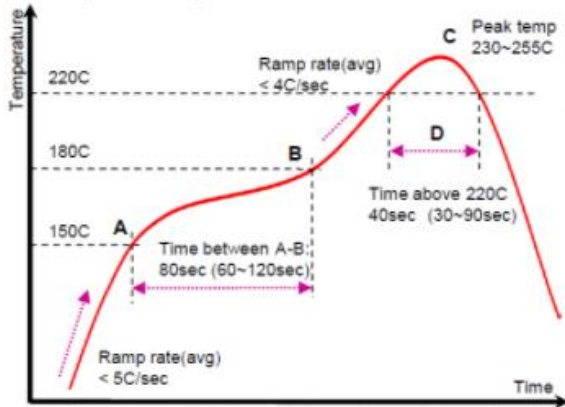


OVEN REFLOW Lead Free SAC305 solder

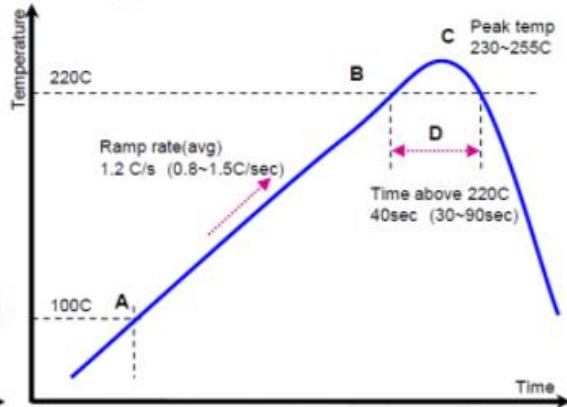
1. Trapezoidal type



Point		Standard	Upper	Lower
A	Pre-heat start point	150C	160C	140C
B	Pre-heat end point	180C	200C	160C
A-B	Pre-heat time	80sec	100sec	60sec
C	Peak temperature	240C	255C	230C
D	Time above 220C	40sec	90sec	30sec

M705-S101ZH-S4 AC305 Solder paste
 Senju Metal, Japan

2. Delta type



Point		Standard	Upper	Lower
A	Pre-heat start point	100C	-	-
B	Pre-heat end point	220C	-	-
A-B	Pre-heat time	100sec	150sec	80sec
Ramp up rate to Peak temp		1.2 C/sec	0.8C/sec	1.5C/sec
C	Peak temperature	240C	255C	230C
D	Time above 220C	40sec	90sec	30sec

WAVE Lead Free (B6A-PCB) SAC305 solder

