

BOURNS®

The graph illustrates the temperature profile for a soldering process. The Y-axis represents Temperature in degrees Celsius (°C), ranging from 0 to 250. The X-axis represents Time in Seconds, ranging from 0 to 250. The profile is divided into four distinct areas:

- Temperature Rising Area:** The initial heating phase with a maximum rate of $+4.0\text{ }^{\circ}\text{C/sec}$.
- Preheat Area:** A dwell region between $150\text{--}200\text{ }^{\circ}\text{C}$ for $60\text{--}120\text{ sec}$.
- Reflow Area:** The heating phase to the peak temperature with a maximum rate of $+3.0\text{ }^{\circ}\text{C/sec}$. It includes a dwell time of $60\text{--}150\text{ sec}$ at the peak.
- Forced Cooling Area:** The cooling phase with a rate of $-(1.0\text{--}5.0)\text{ }^{\circ}\text{C/sec}$.

Key temperature points and times are marked: the peak temperature is $245\text{ }^{\circ}\text{C}$, and the temperature at the end of the reflow dwell is $217\text{ }^{\circ}\text{C}$. The maximum dwell time at the peak is 60 sec. max. .

Packaging Specifications



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