Average Ramp-up Rate = 3°C/second max.

\( t_{25\text{°C to Peak}} = 6 \text{ minutes max.} \)

\( t_0 \) (Preheat) = 60 - 120 seconds.

\( t_L \) (Ramp-up) = 60 - 150 seconds.

\( t_p \) (Within 5°C of peak temperature) = 10 - 30 seconds.

Ramp-down rate = 6°C/second max.

---

**Revision History**

<table>
<thead>
<tr>
<th>Rev. Letter</th>
<th>Used On</th>
<th>Revision</th>
<th>Approved By</th>
<th>Date</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>-</td>
<td>Added shading to chart, clarified peak temperature.</td>
<td>BM</td>
<td>12/18/2009</td>
</tr>
</tbody>
</table>

Unless otherwise specified dimensions are in inches.

\[
XX \pm 0.005 \\
XXX \pm 0.003 \\
\text{Angles } \pm 15^\circ
\]

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**Description:**

Reflow Soldering Profile - Eutectic