



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

$t(25^{\circ}\text{C to Peak}) = 8$ minutes max.

t_s (Preheat) = 60 - 180 seconds.

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

t_p (Within 5°C of peak temperature) = 20 - 40 seconds.

Ramp-down rate = 6°C/second max.

Rev. Letter	Used On	Revision	Approved By	Date
A	-	Added shading to chart, clarified peak temperature.	BM	12/18/2009
Issue	-	-	BM	1/29/2008

Unless otherwise specified dimensions are in inches. XX ± 0.005 XXX ± 0.003 Angles ± 15°	Drawn By	BM	Date: 1/29/2008	 Gowanda Electronics Corp. One Magnetics Parkway Gowanda, New York 14070
	Engineering Approval	DP	Date: 1/29/2008	
	Quality Approval	KH	Date: 1/29/2008	
This drawing or specification is the property of Gowanda Electronics. Copies shall not be reproduced or copied as basis for the manufacture or sale of apparatus without permission.	Manufacturing Approval	GG	Date: 1/30/2008	Description: Reflow Soldering Profile – Lead Free
	Approval		Date:	
	Approval		Date:	Sheet: 1 of 1