



Profile Feature	Pb-Free Assembly
Average Ramp-Up Rate (Ts-max to Tp)	3 °C / second max
Preheat <ul style="list-style-type: none"> ◆ Temperature Min (Ts min) ◆ Temperature Max (Ts max) ◆ Time(ts min to ts max) 	150 °C 200 °C 60-180 second
Time maintained above : <ul style="list-style-type: none"> ◆ Temperature (Tl) ◆ Time (tl) 	217 °C 60-150 second
Peak (Tp)	260 °C
Time within 5 °C of actual Peak Temperature (tp)	20-40 second
Average Ramp-Down Rate (Tp to Ts-max)	6 °C / second max
Time 25 °C to Peak Temperature	8 minutes max