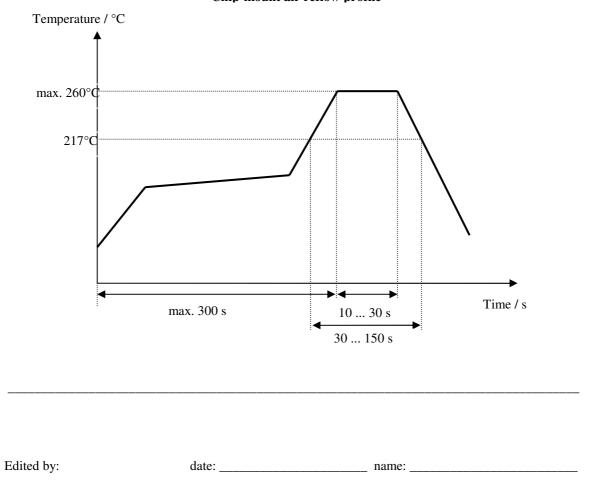


6. Air reflow temperature conditions

conditions	Exposure
average ramp-up rate (30°C to 217°C)	less than 3°C/second
> 100°C	between 300 and 600 seconds
> 150°C	between 240 and 500 seconds
>217°C	between 30 and 150 seconds
peak temperature	max. 260°C
time within 5°C of peak temperature	between 10 and 30 seconds
cool-down rate (starting at peak temperature to 50°C)	less than 6°C / second
time from 30°C to peak temperature	no more than 300 seconds



Chip-mount air reflow profile