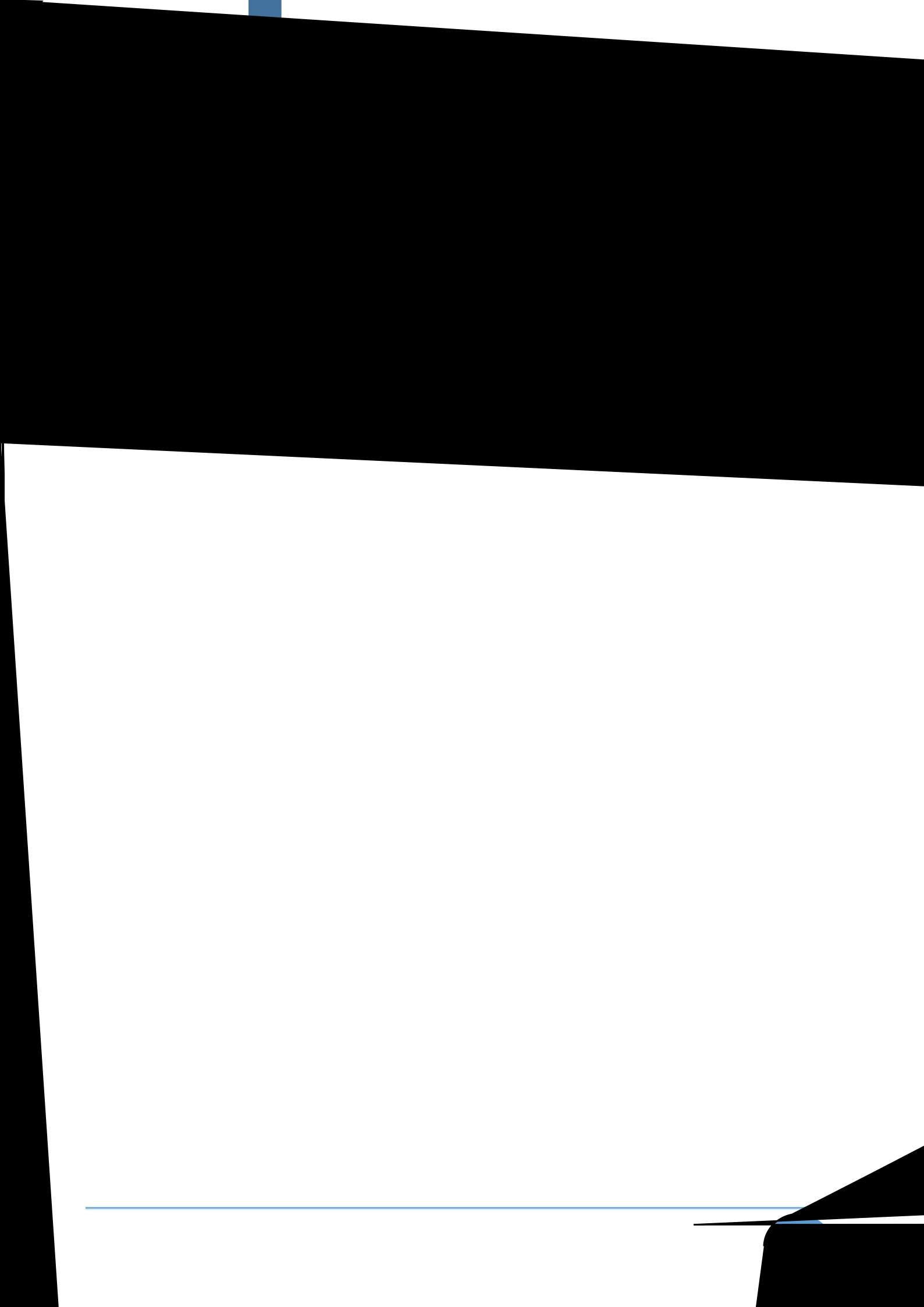
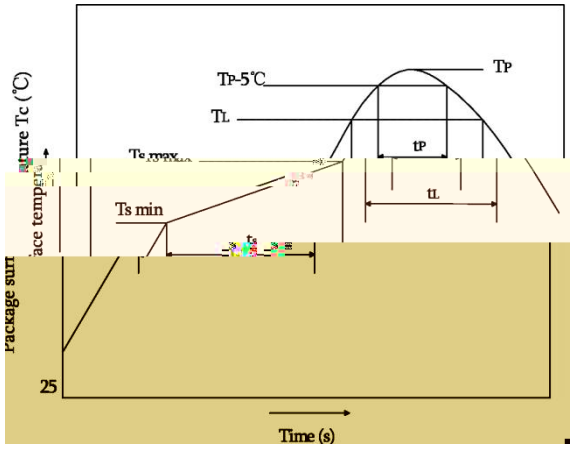
XLM301X,XLM302X,XLM305X



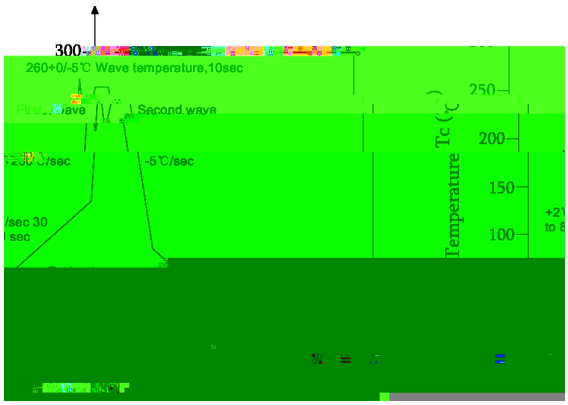
Reflow soldering



	Symbol	Min	Max	Unit
Preheat temperayure	Ts	150	200	
Preheat time	ts	60	120	s
Ramp-up ratea(TL to TP)			3	/s
Liquidus temperature	TL	217		
Time above TL	tL	60	150	s
Peak temperature	Tp		260	
Time during which Tc is between (TP-5) and TP	tp		30	s
Ramp-down rate(TP to TL)			6	/s

Note:

Wave soldering



Profile feature	
Average ramp-up rate	200 /s
Heating rate during preheat	1 /s to 2 /s typical;4 /s maximum
Final preheat temperature Ts	130
Preheat time (25 to Ts)	60s
Peak temperature Tp	260
Time within peak temperature tp	10s
Ramp-down rate	5 /s maximum