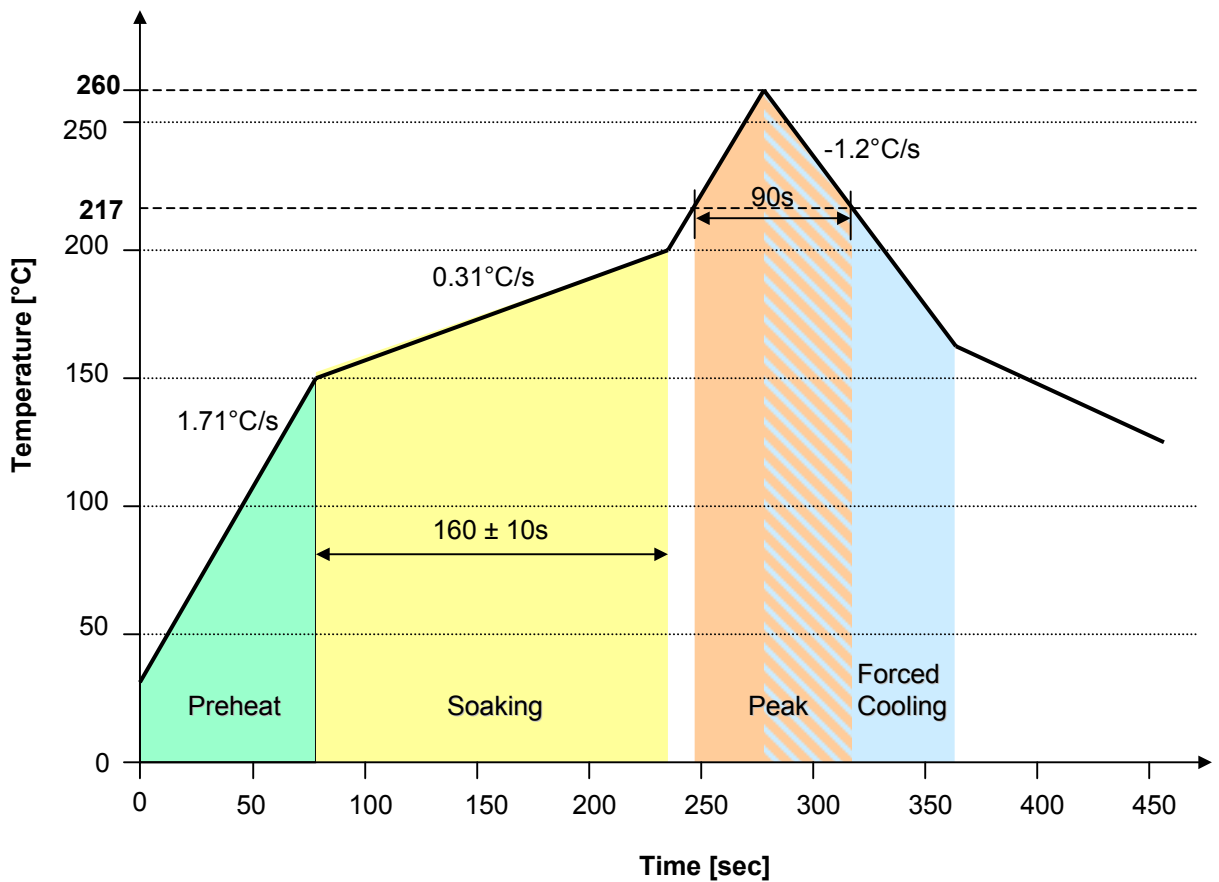


Lead Free Hot Air Reflow Soldering Profile (DIL-24 SMD)

Field of application: Fabrimex' RoHS compliant DIL-24 DC/DC Converters with SMD pinning.

Soldering profile:



Limits:

- Preheat:** Ramp up rate during preheating is 1.71°C / sec; from 30°C to 150°C.
- Soaking:** Ramp up rate during soaking is 0.31°C / sec; from 150°C to 200°C (160±10 sec).
- Peak:** Peak Temperature is 260°C and maximum 90 sec above 217°C is allowed.
- Cooling:** Ramp down rate during forced cooling is -1.2°C / sec from 250°C to 160°C.