



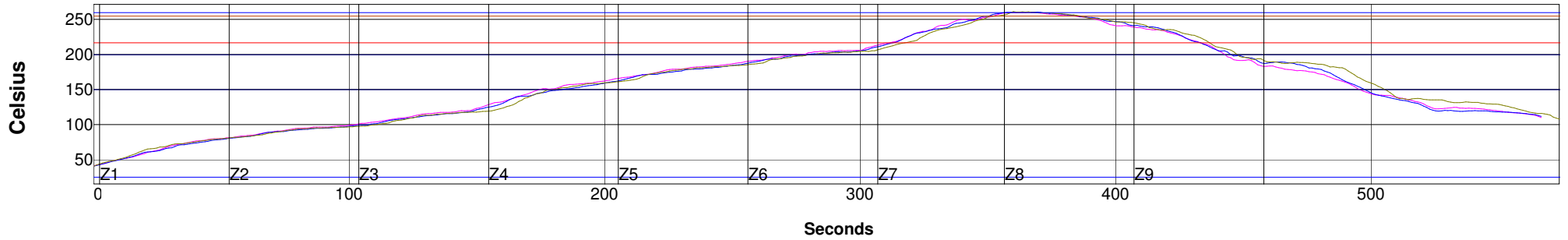
Company: CML
Oven Name: 1809EXL

Site: Rel Lab
Process Window Name: 260c_Jedec

Setpoints (Celsius)

Zone	1	2	3	4	5	6	7	8	9
Top	90	100	120	170	190	209	277	234	170
Bottom	90	100	120	170	190	209	277	234	170

Conveyor Speed (cm/min): 30.0



PWI= 90%	Preheat 150-200C	Soak Time 25-260C	Reflow Time /217C	Peak Temp	Tot Time /255C	Slope2	Slope3
TC1	98.3 28%	364.3 23%	121.1 36%	260.3 -90%	32.4 -68%	1.2 -17%	-0.9 87%
TC2	96.4 21%	357.3 18%	120.1 34%	261.0 -60%	34.8 -35%	1.1 -28%	-1.1 80%
TC3	101.5 38%	359.1 19%	118.9 31%	261.6 -38%	33.9 -47%	1.2 -21%	-0.9 88%
Delta	5.2	7.0	2.1	1.3	2.4	0.2	0.2

Process Window:

Statistic Name	Low Limit	High Limit	Units
Solder Paste: 260c_Jedec			
Slope2 (Target=1.5)			
Between 217.0 and 260.0	0.0	3.0	Degrees/Second
(Calculate Slope over 20 Seconds)			
Slope3 (Target=-3.3)			
Between 260.0 and 217.0	-6.0	-0.6	Degrees/Second
(Calculate Slope over 20 Seconds)			
Preheat Time 150-200C	60	120	Seconds
Soak Time 25-260C	180	480	Seconds
Time Above Reflow - 217C	60	150	Seconds
Peak Temperature	260	265	Degrees Celsius
Total Time Above - 255C	30	45	Seconds

Description:

