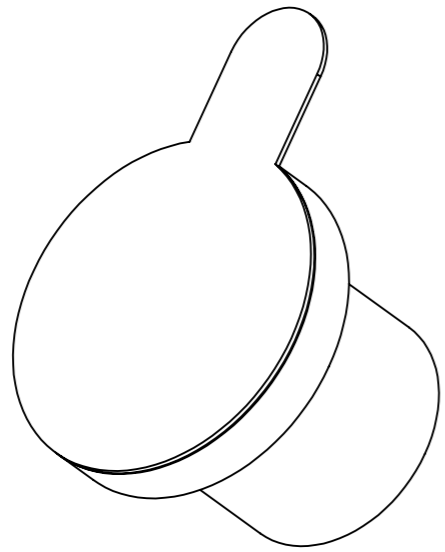
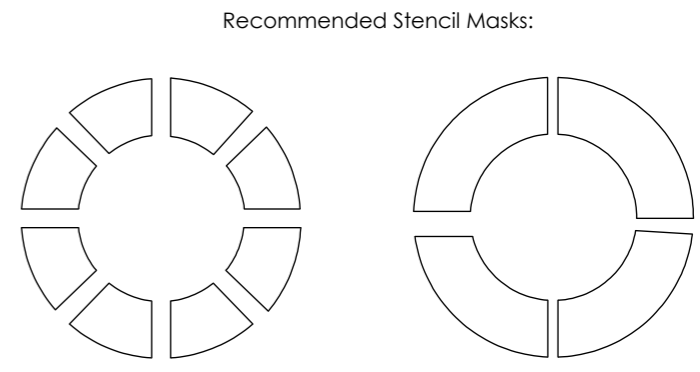
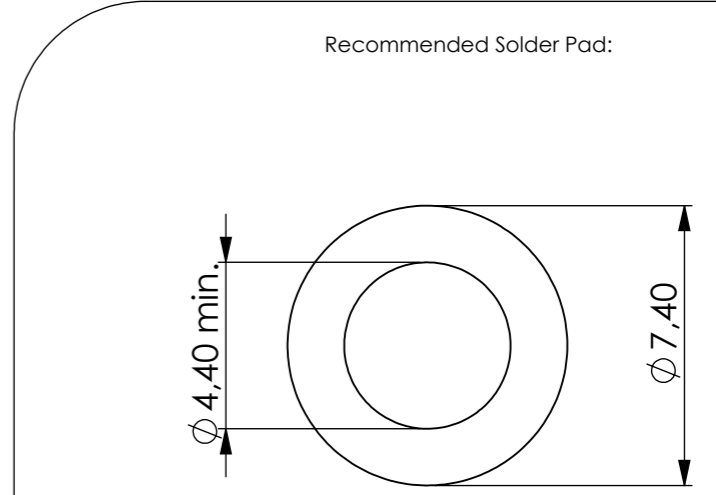
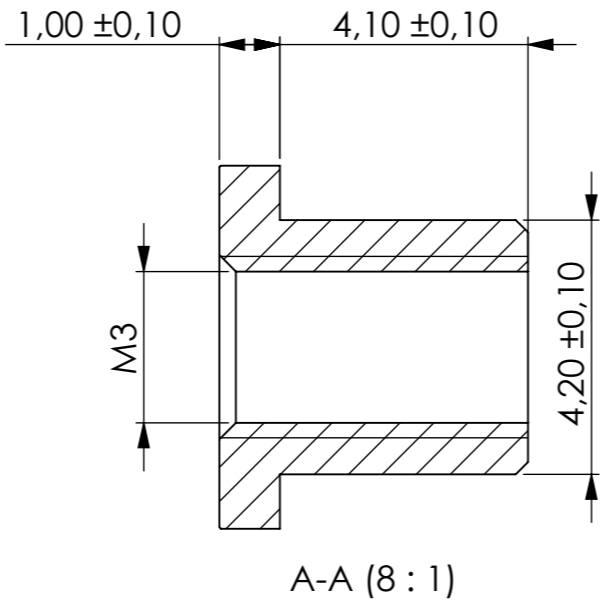
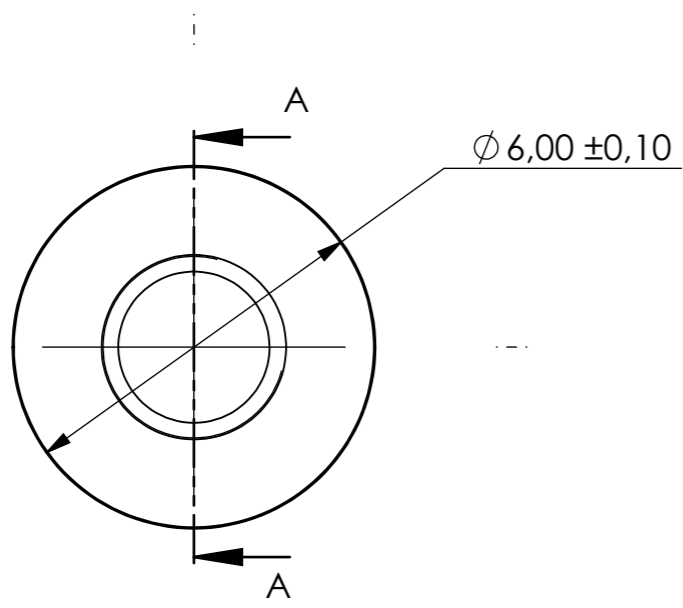


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						Order Code: SMTWGM3010MTJ (4.1)	
						Description: M3*6.0*1.0+4.1mm	
00	Created Part	03.Oct.23	K.M.	03.Oct.23	S.R.		
Rev:	Description of change	Date Created:	Name:	Date checked:	Name:	General Tolerances:	Partnumber:
						X.±0.30 X.°±5° X.X±0.2 .X°±2° X.XX±0.15 .XX°±1° X.XXX±0.10 .XXX°±0.5°	100-201
Material: Steel							
Surface: Tin						MS-Level: 1 info@samytronic.de www.samytronic.de	
Weight: 0.059 g		Area: mm²		Sheet size: A3	Unit: mm	Scale: 5:1	Projection
						Sheet: 1 OF 3	

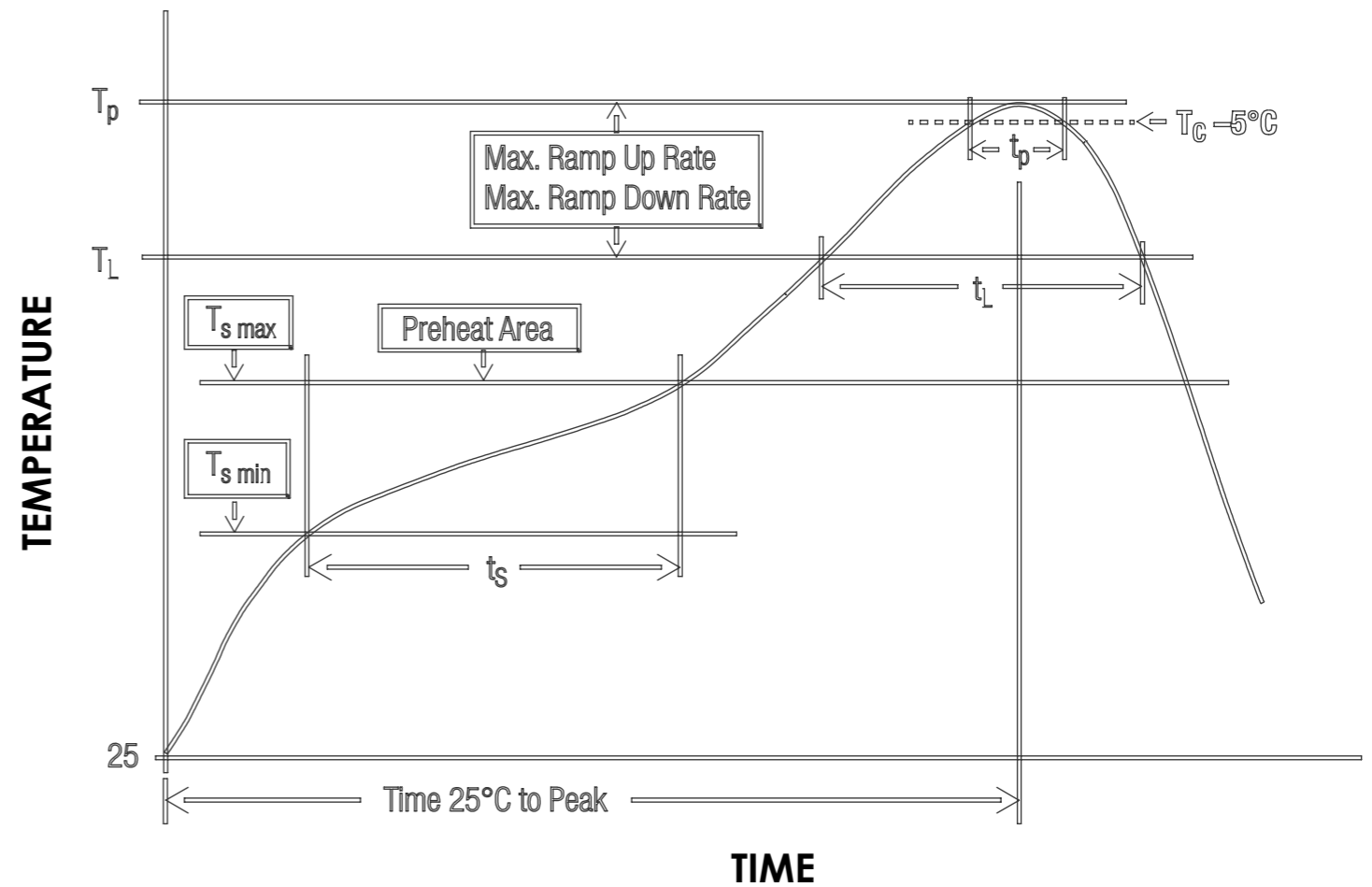


CLASSIFICATION REFLOW PROFILE

Classification Reflow Soldering Profile:

Profile Feature	Value
Preheat Temperature Min (T_{smin}) ¹⁾	150 °C
Preheat Temperature Max (T_{smax})	200 °C
Preheat Time (t_s) from (T_{smin} to T_{smax})	60 - 120 seconds
Ramp-up rate (T_L to T_P)	3 °C / second max.
Liquidous temperature (T_L)	217 °C
Time (t_L) maintained above T_L	60 - 150 seconds
Peak package body temperature (T_P)	$T_P \leq T_C$, see table below
Time (t_p)* within 5 °C of actual peak temperature	20 - 30 seconds
Ramp-down rate (T_P to T_L)	6 °C / second max.
Time 25 °C to peak temperature	8 minutes max.




1) refer to IPC/JEDEC J-STD-020E



Package Classification Reflow Temperature (T_C):

Properties	Volume mm ³ < 350	Volume mm ³ 350 - 2000	Volume mm ³ >2000
PB-Free Assembly Package Thickness < 1.6 mm ¹⁾	260 °C	260 °C	260 °C
PB-Free Assembly Package Thickness 1.6 mm - 2.5 mm	260 °C	250 °C	245 °C
PB-Free Assembly Package Thickness ≥ 2.5 mm	250 °C	245 °C	245 °C

1) refer to IPC/JEDEC J-STD-020E

					Order Code:	
					Description: Classification Profile	
Rev:	Description of change	Date Created:	Name:	Date checked:	Name:	General Tolerances: X.±0.30 X.°±5° X.X±0.2 .X°±2° X.XX±0.15 .XX°±1° X.XXX±0.10 .XXX°±0.5°
					Partnumber: 	
Material:					 info@samytronic.de www.samytronic.de	
Surface:					MS-Level: 33605 Bielefeld Germany	
Weight:	g	Area:	mm ²	Sheet size:	A3	Unit: mm
Scale: 3:1		Projection				Sheet: 3 OF 3

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