**TABLE 1. REFLOW PROFILES**

<table>
<thead>
<tr>
<th>PROFILE FEATURE</th>
<th>SN-PB EUTECTIC ASSEMBLY</th>
<th>PB-FREE ASSEMBLY</th>
</tr>
</thead>
<tbody>
<tr>
<td>Preheat/Soak</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temperature Min (T_{SMin})</td>
<td>100°C</td>
<td>150°C</td>
</tr>
<tr>
<td>Temperature Max (T_{SMax})</td>
<td>150°C</td>
<td>200°C</td>
</tr>
<tr>
<td>Time (t_S) from (T_{SMin} to T_{SMax})</td>
<td>60-120 seconds</td>
<td>60-120 seconds</td>
</tr>
<tr>
<td>Ramp-up rate (T_L to T_P)</td>
<td>3 °C/second max.</td>
<td>3 °C/second max.</td>
</tr>
<tr>
<td>Liquidus Temperature (T_L)</td>
<td>183°C</td>
<td>217°C</td>
</tr>
<tr>
<td>Time (t_L) maintained above T_L</td>
<td>60-150 seconds</td>
<td>60-150 seconds</td>
</tr>
<tr>
<td>Peak package body temperature (T_P) For users, T_P must not exceed the Classification temp in Table 2. For suppliers, T_P must equal or exceed the Classification temp in Table 2.</td>
<td>For users, T_P must not exceed the Classification temp in Table 3. For suppliers, T_P must equal or exceed the Classification temp in Table 3.</td>
<td></td>
</tr>
<tr>
<td>Time (t_P) within 5°C of the specified classification temperature (T_C); see Figure 1 and Note 1</td>
<td>20 seconds (Note 1)</td>
<td>30 seconds (Note 1)</td>
</tr>
<tr>
<td>Ramp-down rate (T_P to T_J)</td>
<td>6 °C/second max.</td>
<td>6 °C/second max.</td>
</tr>
<tr>
<td>Time 25°C to peak temperature</td>
<td>6 minutes max.</td>
<td>8 minutes max.</td>
</tr>
</tbody>
</table>

NOTES:

1. Tolerance for peak profile temperature (T_P) is defined as a supplier minimum and a user maximum.

2. All temperatures refer to the center of the package, measured on the package body surface that is facing up during assembly reflow (e.g., live-bug). If parts are reflowed in other than the normal live-bug assembly reflow orientation (i.e., dead-bug), T_P shall be within ± 2 °C of the live-bug T_P and still meet the T_C requirements, otherwise, the profile shall be adjusted to achieve the latter. To accurately measure actual peak package body temperatures, refer to JEP140 for recommended thermocouple use.

3. Reflow profiles in this document are for classification/preconditioning and are not meant to specify board assembly profiles. Actual board assembly profiles should be developed based on specific process needs and board designs and should not exceed the parameters given above. For example, if T_C is 260°C and time t_P is 30 seconds, this means the following for the supplier and the user.

For a supplier: The peak temperature must be at least 260°C. The time above 255°C must be at least 30 seconds.

For a user: The peak temperature must not exceed 260°C. The time above 255°C must not exceed 30 seconds.

**TABLE 2. SnPb EUTECTIC PROCESS - REFLOW PEAK TEMPERATURES (T_C)**

<table>
<thead>
<tr>
<th>PACKAGE THICKNESS</th>
<th>VOLUME mm$^3$ &lt; 350</th>
<th>VOLUME mm$^3$ ≥ 350</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt; 2.5 mm</td>
<td>235°C</td>
<td>220°C</td>
</tr>
<tr>
<td>≥ 2.5 mm</td>
<td>220°C</td>
<td>220°C</td>
</tr>
</tbody>
</table>

**TABLE 3. PB-FREE PROCESS - REFLOW PEAK TEMPERATURES (T_C)**

<table>
<thead>
<tr>
<th>PACKAGE THICKNESS</th>
<th>VOLUME mm$^3$ &lt; 350</th>
<th>VOLUME mm$^3$ 350 -2000</th>
<th>VOLUME mm$^3$ &gt; 2000</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt; 1.6 mm</td>
<td>260°C</td>
<td>260°C</td>
<td>260°C</td>
</tr>
<tr>
<td>1.6mm-2.5 mm</td>
<td>260°C</td>
<td>250°C</td>
<td>245°C</td>
</tr>
<tr>
<td>&gt; 2.5 mm</td>
<td>250°C</td>
<td>245°C</td>
<td>245°C</td>
</tr>
</tbody>
</table>

NOTES:

4. At the discretion of the device manufacturer, but not the board assembler/user, the maximum peak package body temperature (T_P) can exceed the values specified in Tables 2 or 3. The use of a higher T_P does not change the classification temperature (T_C).

5. Package volume excludes external terminals (e.g., balls, bumps, lands, leads) and/or non-integral heat sinks.

6. The maximum component temperature reached during reflow depends on package thickness and volume. The use of convection reflow processes reduces the thermal gradients between packages. However, thermal gradients due to differences in thermal mass of SMD packages may still exist.
FIGURE 1. PEAK REFLOW PROFILE
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Renesas Electronics America Inc.
1001 Murphy Ranch Road, Milpitas, CA 95035, U.S.A.
Tel: +1-408-432-8888, Fax: +1-408-434-5351

Renesas Electronics Canada Limited
9251 Yonge Street, Suite 8309 Richmond Hill, Ontario Canada L4C 9T3
Tel: +1-905-237-2004

Renesas Electronics Europe GmbH
Arcadiastrasse 10, 40472 Düsseldorf, Germany
Tel: +49-211-6503-0, Fax: +49-211-6503-1327

Renesas Electronics (China) Co., Ltd.
Room 1709 Quantum Plaza, No.27 ZhichunLu, Haidian District, Beijing, 100191 P. R. China
Tel: +86-10-8235-1155, Fax: +86-10-8235-7679

Renesas Electronics (Shanghai) Co., Ltd.
Unit 30th, Tower A, Central Towers, 555 Langao Road, Putuo District, Shanghai, 200333 P. R. China
Tel: +86-21-2226-9888, Fax: +86-21-2226-0999

Renesas Electronics Hong Kong Limited
Unit 16/F., Tower 2, Grand Century Place, 139 Prince Edward Road West, Mongkok, Kowloon, Hong Kong
Tel: +852-2250-6688, Fax: +852-2886-9022

Renesas Electronics Taiwan Co., Ltd.
13F, No. 363, Fu Shing North Road, Taipei 10543, Taiwan
Tel: +886-2-8755-8600, Fax: +886-2-8755-8670

Renesas Electronics Singapore Pte. Ltd.
80 Brenda Road, Unit #06-02 Hyflux Innovation Centre, Singapore 339949
Tel: +65-6213-8200, Fax: +65-6213-5300

Renesas Electronics Malaysia Sdn.Bhd.
Unit 1027, Block B, Menara Aircorp, Aircorp Trade Centre, No. 18, Jln Persiaran Barat, 46050 Petaling Jaya, Selangor Darul Ehsan, Malaysia
Tel: +603-7955-9390, Fax: +603-7955-3710

Renesas Electronics India Pvt. Ltd.
No.777C, 100 Feet Road, HAL 2nd Stage, Indiranagar, Bangalore 560 038, India
Tel: +91-80-67207800, Fax: +91-80-67207877

Renesas Electronics Korea Co., Ltd.
17F, KAMICO Yangjae Tower, 262, Gangnam-daero, Gangnam-gu, Seoul, 06265 Korea
Tel: +82-2-558-3371, Fax: +82-2-558-5338

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