

GUIDELINE FOR AUTOMATED REFLOW SOLDERING PROCESS FOR SYNSTRIP DEVICES

Forward

The guidelines provided in this application note comply with JEDC J-STD-020 and describe the basic surface-mounting assembly requirements for solder reflow of Synstrip devices manufactured by Synergy Microwave Corporation. Optimum yields are achieved by careful optimization of the heating profile to allow for package size limitations.

Peak Reflow Temperature

Determining the maximum allowable peak reflow temperature is a process that involves consideration of the package volume and thickness for Pb-Free soldering processes as described in Table I below:

Table I. Package peak reflow temperature (T_p)

Reflow Process	Thickness	Volume		
		<350 mm ³	>350 mm ³	>2000 mm ³
Pb-Free	>2.5 mm	250°C +0/-5°C	245°C +0/-5°C	245°C +0/-5°C

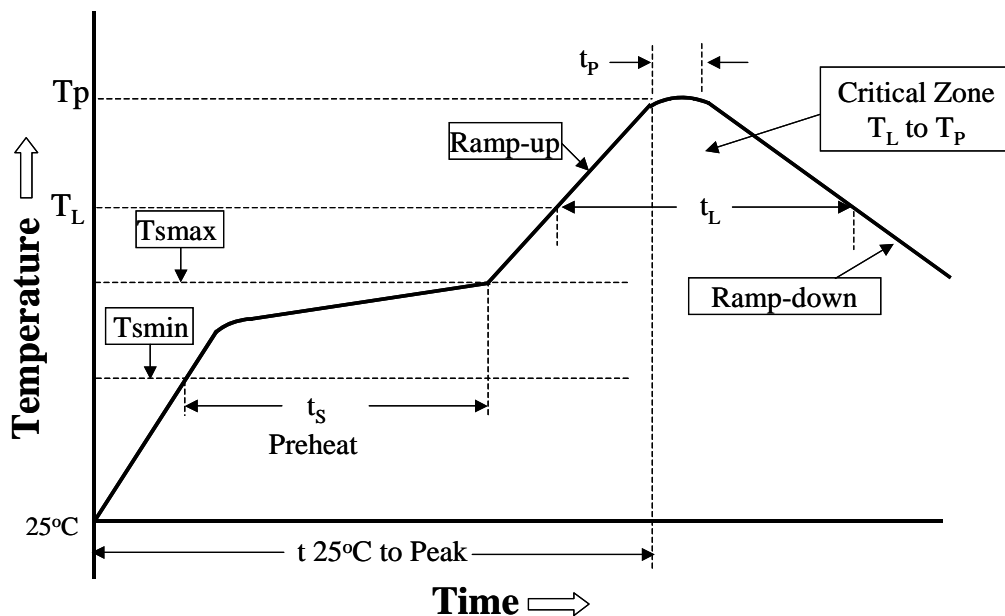


Figure 1. Temperature reflow profile



Table II. Reflow profile parameters

Reflow Profile Feature	Pb-Free Assembly
Average ramp-up rate (T _{Smax} to T _p)	3°C/second max.
Preheat -Minimum Temperature (T _{Smin}) -Maximum Temperature (T _{Smax}) -Time (T _{Smin} to T _{Smax})	150°C 200°C 60 – 180 seconds
Time maintained above: -Minimum Temperature (T _L) -Time (t _L)	217°C 60 – 150 seconds
Peak Temperature (T _p)	Per Table I
Time within 5°C of actual peak temperature (t _p)	20-40 seconds
Ramp-down rate	6°C/second max.
Time at 25°C to Peak Temperature	8 minutes max.

Consideration for maximum reflow temperature limits– One reflow pass

All parts are soldered internally with solder having a reflow temperature melting point of 235 °C. If the maximum reflow profile does not exceed 228 °C, no special cooling precautions are required. In cases where the application requires the solder profile to exceed 228 °C (Never to exceed 260 °C!), care has to be taken so that the module will not be exposed to any vibration, as the molten solder can shift component placement. The molten solder must be allowed to solidify with no vibration until the device cools down to below 220 °C. This allows for any residual heat trapped in the device to cool below the solder melting temperature, which is usually hotter inside the device.

For technical assistance contact:

Synergy Microwave Corporation
 201 McLean Boulevard
 Paterson, NJ 07504
 Tel. 973-881-8800
 Fax 973-881-8361
 Email: info@synergymwave.com

- Recommended Solder Reflow profile for Pb-Free Process -

