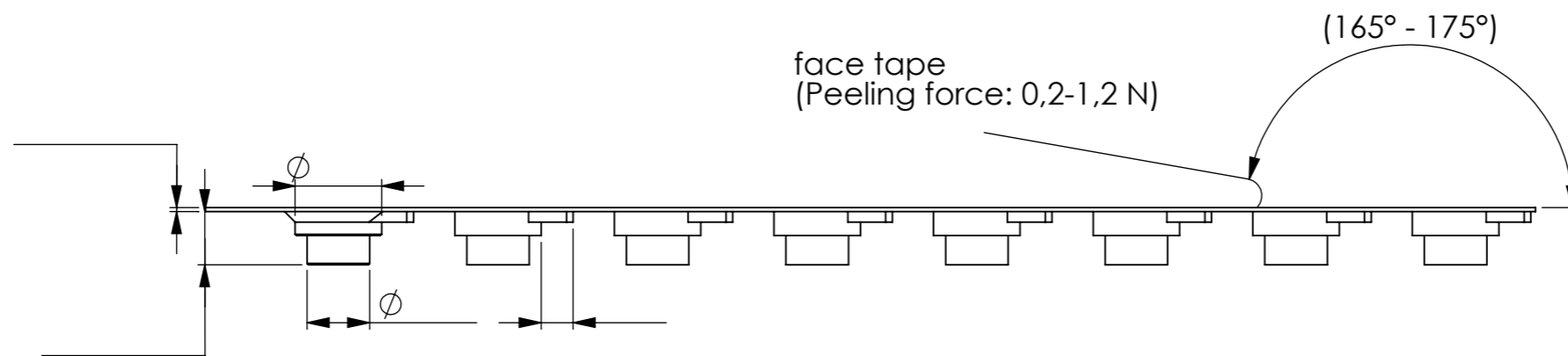
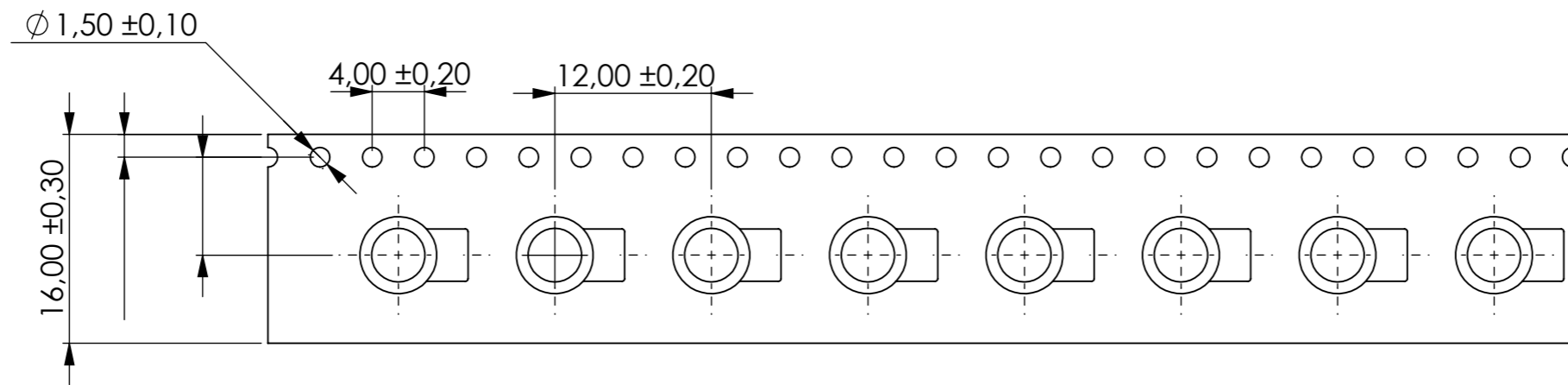


RoHS Compliant	GENERAL TOLERANCES: X.±0.30 X.°±5° X.X±0.2 .X°±2° X.XX±0.15 .XX°±1° X.XXX±0.10 .XXX°±0.5°		SURFACE Tin	SCALE 10:1	PROJECTION	
	MATERIAL: Steel	WEIGHT	TITLE: 3,5*6*L2+1,25mm			
REV	FILE	DATE	NAME	PARTNUMBER: SMTWAM3520MTJ (1.25)		A3
Smytronic GmbH info@smytronic.de www.smytronic.de 				UNIT MM		
				SHEET 1 OF 3		



RoHS Compliant	GENERAL TOLERANCES:		SURFACE	SCALE 10:1	PROJECTION	
	X.±0.30	X.°±5°		MATERIAL: PS	WEIGHT	
				TITLE: XH253 SMTWE-M3/3.3-2, PKH01-006		
	CREATED	S.R.	27.Nov.22			
	CHECKED	K.M.	27.Nov.22			
				PARTNUMBER:		A3
				SMTWAM3520MTJ (1.25)		UNIT MM
REV	FILE	DATE	NAME	Quantity: 1500 pcs/reel		SHEET 2 OF 3

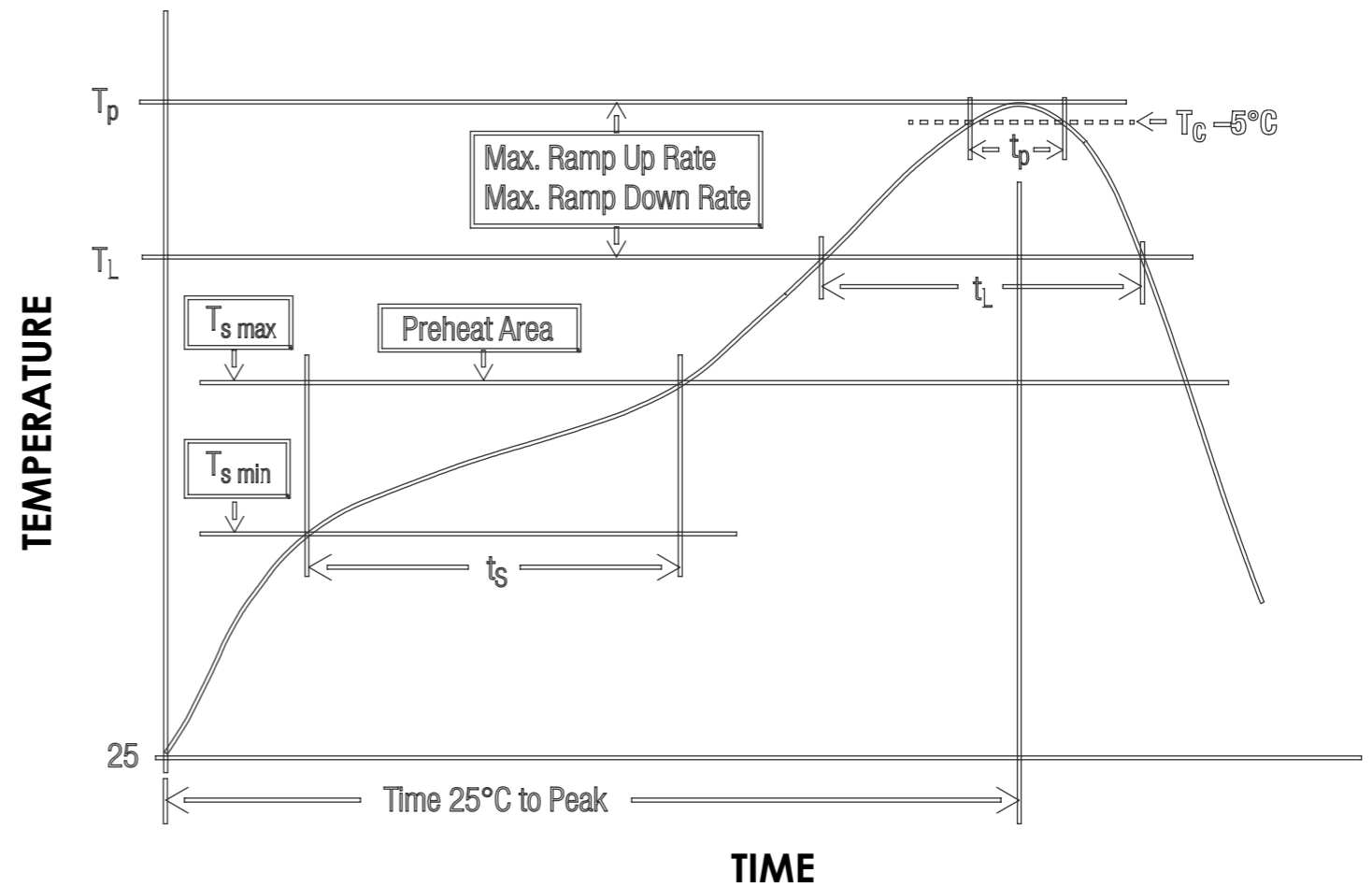


CLASSIFICATION REFLOW PROFILE

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

RoHS Compliant	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°		SURFACE	SCALE 3:1	PROJECTION	
	MATERIAL			WEIGHT		
REV	FILE	DATE	NAME	DATE	TITLE:	
			CREATED	S.R.	27.Nov.22	
			CHECKED	K.M.	27.Nov.22	
Samytronic GmbH info@samytronic.de www.samytronic.de 				PARTNUMBER:		A3
				SMTWAM3520MTJ (1.25)		UNIT MM
						SHEET 3 OF 3