

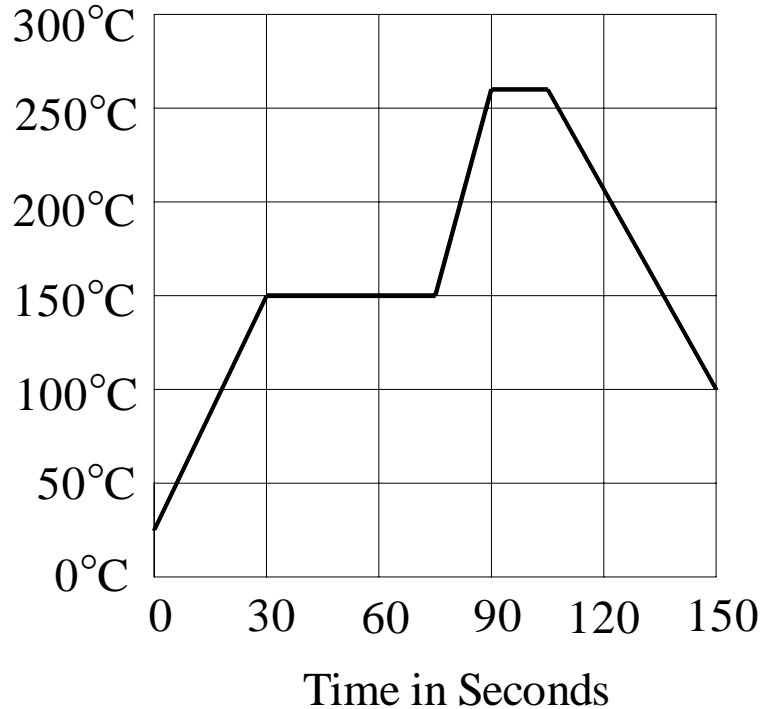
REFLOW DIAGRAM

SOLDER REFLOW METHOD (SRM)

IR/C = Infrared/Convection

HS = Hand Soldering

WS = Wave Solder



| SERIES | SRM | PRE-HEAT TIME | REFLOW TEMPERATURE/TIME |
|--|------|-----------------|---|
| All Thru Hole 8 Pin Dip or 14 Pin Dip Oscillators | WS | 30-60 Seconds | 245°C Maximum for 5 Seconds Maximum, 1 Time; 235°C Maximum for 15 Seconds Maximum, 2 Times. |
| Any Thru Hole Device with Gull Wing Option | WS | 30-60 Seconds | 185°C Maximum for 10 Seconds Maximum, 2 Times. |
| | HS | None | |
| Any Plastic Injection Molded Oscillator | IR/C | 30-60 Seconds | 245°C Maximum for 10 Seconds Maximum, 2 Times; 230°C Maximum for 80 Seconds Maximum, 1 Times. |
| Any Ceramic Oscillator | IR/C | 60-120 Seconds | 240°C Maximum for 10 Seconds Maximum, 2 Times; 230°C Maximum for 80 Seconds Maximum, 1 Times. |
| Any Thru Hole Crystal | WS | 30-60 Seconds | 245°C Maximum for 10 Seconds Maximum, 2 Time; 230°C Maximum for 80 Seconds Maximum, 1 Times. |
| Any Plastic Injection Molded Crystal, Ceramic SMD or Metal SMD Crystal | IR/C | | |
| 6X3.5mm Ceramic Crystal | | 120-140 Seconds | |
| Plastic Injection Molded Watch Crystals | | 30-60 Seconds | 230°C Maximum for 10 Seconds Maximum, 2 Times. |