

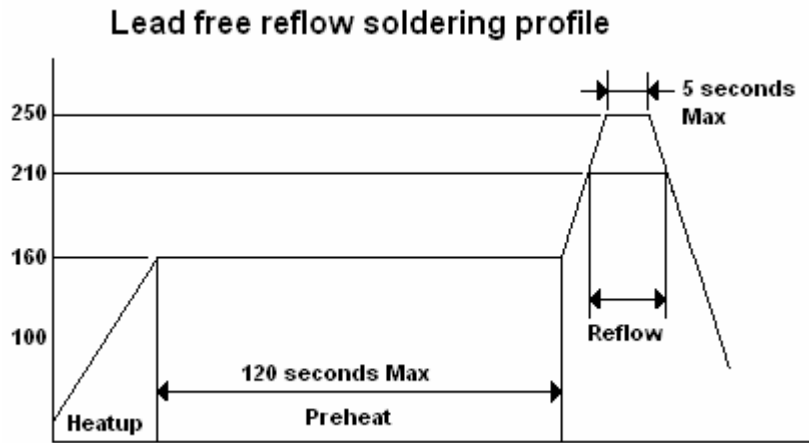


**ILLINOIS CAPACITOR, INC.**

3757 W. Touhy Ave., Lincolnwood, IL 60712 • (847) 675-1760 • Fax (847) 673-2850 • www.illcap.com



## Lead Free Reflow Soldering Profile



**Heat up: 1-3°C**  
**Preheat: 160C for 120 Seconds Maximum**  
**Reflow: 210°C for 30 to 60 Seconds**  
**Peak Reflow: 250°C for 5 Seconds Maximum**  
**Cool Down: 1 to 4°C/Second**  
**Number of cycles: 1**



3757 W. Touhy Ave., Lincolnwood, IL 60712 • (847)675-1760 • Fax (847) 675-2850 • www.illcap.com