



EMS Forum

on Lead-Free PCB Assembly

EMS Position on IPC J-STD-020B

December 20, 2001

	020B	EMS
Average ramp-up rate (217°C to peak)	3°C/s	OK
Preheat temperature (150-200°C)	60-180s	OK
Temperature maintained above 217°C	60-150s	OK <i>With the following note: Time above 217°C in actual PCBA solder joints < 150s</i>
Time within 5°C of actual peak temperature	10-30s	OK
Peak temperature range		
Pkg. Volume >= 350 mm ³	245 +0/-5°C	255 +0/-5°C
Pkg. Volume < 350 mm ³	250 +0/-5°C	265 +0/-5°C
Ramp down rate	6°C/second max.	OK
Time (25°C to peak temperature)	8 minutes max	OK

EMS Steering Committee

Celestica:	Matthew Kelly	Linda Scala
Flextronics:	Dongkai Shangguan	Sammy Yi
Jabil:	Quyen Chu	Tom Ciplewski
Sanmina-SCI:	Frank Grano	Eamon O'Keeffe
Solectron:	Jasbir Bath	Kim Hyland

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