

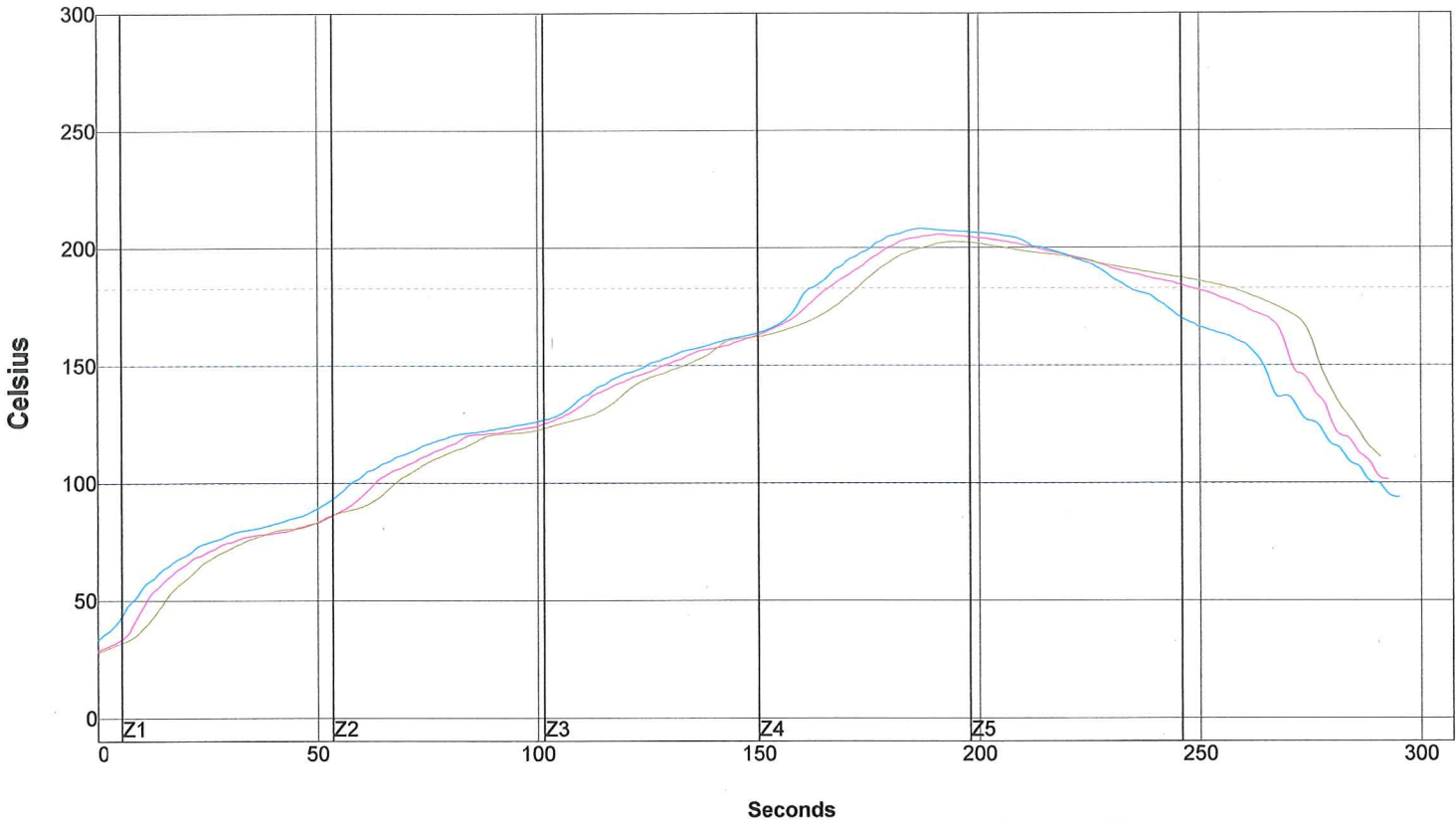


Company: CARLTON INDUSTRIES CORP
Oven Name: HELLER 1500 EXL

Site: HELLER 1500
Process Window Name: HELLER 1500 WS483 Sn63

Setpoints (Celsius)					
Zone	1	2	3	4	5
Top	95	130	160	240	186
Bottom	95	130	160	240	186

Conveyor Speed (inch/min): 17.0



PWI= 84%	Max Rising Slope	Max Falling Slope	Preheat 100-150C	Peak Temp	Tot Time /183C
<TC2>	1.89 32%	-2.84 26%	65.33 -82%	206.00 -66%	82.44 -50%
<TC3>	1.78 21%	-2.16 53%	67.10 -76%	208.43 -52%	72.38 -72%
<TC4>	1.80 22%	-3.07 17%	65.37 -82%	202.88 -84%	84.45 -46%
Delta	0.11	0.91	1.77	5.55	12.07

Process Window:

Solder Paste: AIM WS483 Sn63Pb37 (RSS) OA Air or N			
Statistic Name	Low Limit	High Limit	Units
Max Rising Slope (Target=1.6) (Calculate Slope over 20 Seconds)	0	2.5	Degrees/Second
Max Falling Slope (Calculate Slope over 20 Seconds)	-6	-1	Degrees/Second
Preheat Time 100-150C	60	120	Seconds
Peak Temperature	200	235	Degrees Celsius
Total Time Above - 183C	60	150	Seconds

Description:

