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Basics Solder paste - Solder process - Process zone - Portfolio - Plus concept - Example PCB - Profiles Reflow Systems High Temperature Temper System HTT Vacuum Plus N2

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How to choose the right system – Product portfolio and selection of oven

All reflow soldering systems of SMT have a ratio of 3:1 in pre-heating zones to peak zone

Reflow syste Type	em			ng/	mbers Peak /	Length of heating chamber	L. of heat. chamber / 4 min. solder.process = production speed	Possible nos. Of PCBs per minute	Possible cycle-time of PCBs	Sample of profile
SMT	xxs	2	1	1	/ 1	1.2 m	0.30 m / min. Depend. on process (0.20 – 0.40m / min.)	1.5	40 sec.	
SMT	xs	3	,	1	/ 1	1.6 m	0.40 m / min. Depend. on process (0.30 – 0.60m / min.)	2.0	30 sec.	
SMT Quattro Peak	S	3 /	2	1	1 (1-5)	2.0 m	0.50 m / min. Depend. on process (0.40 – 0.70m / min.)	2.5	25 sec.	The state of the s
SMT Quattro Peak	М	3 /	2	1	1 (1-5)	2.6 m	0.65 m / min. Depend. on process (0.50 – 0.85m / min.)	3.0	20 sec.	
SMT Quattro Peak	L	4 /	2	1	2 (1-5)	3.2 m	0.80 m / min. Depend. on process (0.65 – 1.05m / min.)	4.0	15 sec.	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
SMT Quattro Peak	L plus	5 /	3	1	2 (1-5)	3.8 m	0.95 m / min. Depend. on process (0.75 – 1.25m / min.)	4.5	13 sec.	5
SMT Quattro Peak	XL	5 /	3	1	3 (1-5)	4.2 m	1.05 m / min. Depend. on process (0.85 – 1.40m / min.)	5.0	12 sec.	
SMT Quattro Peak	XL plus	6 /	4	1	3 (1-5)	4.8 m	1.20 m / min. Depend. on process (0.95 – 1.60m / min.)	6.0	10 sec.	

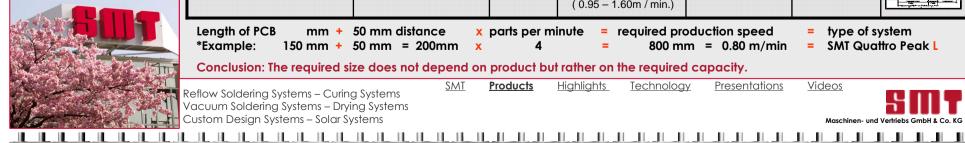
Length of PCB *Example:

mm + 50 mm distance 150 mm + 50 mm = 200mm

x parts per minute = required production speed 800 mm = 0.80 m/min

type of system = SMT Quattro Peak L

Conclusion: The required size does not depend on product but rather on the required capacity.



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How to choose the right system

Quattro Peak L & XL in the expansion stage Plus

All reflow systems in the version "PLUS" have been developed for extremely complex componentry in high-volume production facilities. The "PLUS"-version guarantees highest system availability, max. stability of processes by highest operational capacity.

Reflow system Type	Nos. Of chambers Pre-heating / Peak / Cooling	Length of heating chamber	Length of heating chamber / 4 min. Soldering process = production speed	Possible nos. of PCB's per minute	Possible cycle-time for PCB's
SMT Quattro Peak L	4 / 2 / 2 (1-5)	3,0 m	0,80 m / min. depending on process (0,60 – 1,00m / min.)	4	15 sec.
SMT Quattro Peak L Plus	5 / 3 / 2 (1-5)	3,3 m	0,85 m / min. depending on process (0,60 – 1,00m / min.)	4,5	14 sec.
SMT Quattro Peak XL	5 / 3 / 3 (1-5)	4,2 m	1,05 m / min. depending on process (0,85 – 1,40m / min.)	5,0	12 sec.
SMT Quattro Peak XL Plus	6 / 4 / 3 (1-5)	4,8 m	1,20 m / min. depending on process (0,95 – 1,60m / min.)	6,0	10 sec.

Length of PCB mm + 50mm distance x nos. per minute

= required production speed = type of system

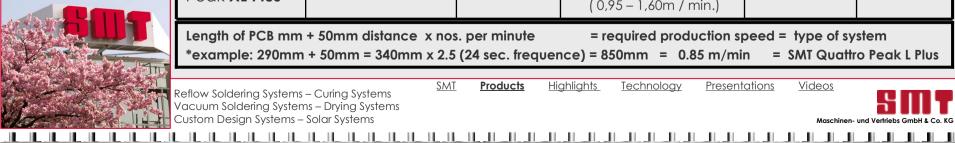
*example: 290mm + 50mm = 340mm x 2.5 (24 sec. frequence) = 850mm = 0.85 m/min = SMT Quattro Peak L Plus

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