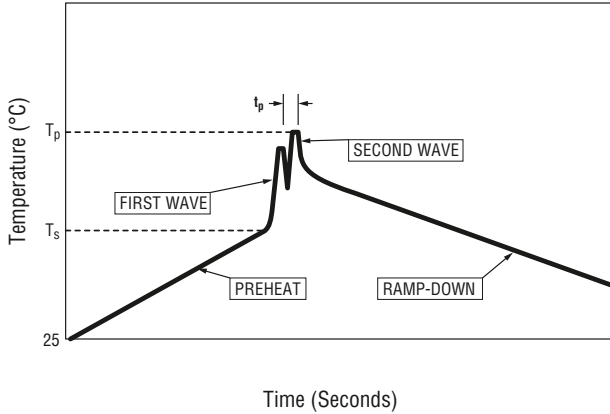


Soldering Parameters - Wave Soldering



Profile Condition	SnPb Eutectic Assembly	Pb-free Assembly
Average Ramp-up Rate	~ 200 °C/s	
Heating Rate during Preheat	typical 1-2 °C/s, max 4 °C/s	
Final Preheat Temperature (T_s)	~ 130 °C	
Peak Temperature (T_p)	235 °C	260 °C
Time Within Peak Temperature (t_p)	10 seconds	
Ramp-down Rate	5 °C / second max.	

Specifications are subject to change without notice.

Users should verify actual device performance in their specific applications.

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