Wave Soldering Profile:



Caption:

— typical temperature procedure

---- min temperature procedure

---- max temperature procedure

Disclaimer:

These two recommended soldering profiles are here for information. Please consider plastic material, circuit board features, connectors ranges... when choosing your soldering parameters / a suitable soldering profile.

Classification Double Wave Soldering Profile:

Profile Feature		Pb-Free Assembly	Sn-Pb Assembly	
Preheat Temperature Min	T _{s min}	100 °C	100 °C	
Preheat Temperature Typical	T _{s typical}	120 °C	120 °C	
Preheat Temperature Max	T _{s max}	130 °C	130 °C	
Preheat Time t_s from $T_{s min}$ to $T_{s max}$	ts	70 seconds	70 seconds	
Ramp-up Rate	ΔΤ	150 °C max.	150 °C max.	
Peak Temperature	Тр	250 °C - 260 °C	235 °C - 260 °C	
Time of actual peak temperature	tp	max. 10 seconds max. 5 seconds each wave	max. 10 seconds max. 5 seconds each wave	
Ramp-down Rate, Min		~ 2 K/ second	~ 2 K/ second	
Ramp-down Rate, Typical		~ 3.5 K/ second	~ 3.5 K/ second	
Ramp-down Rate, Max		~ 5 K/ second	~ 5 K/ second	
Time 25 °C to 25 °C		4 minutes	4 minutes	

refer to EN61760-1:2006

Classification Single Wave Soldering Profile:

Profile Feature		Pb-Free Assembly	Sn-Pb Assembly	
Preheat Temperature Min	T _{s min}	100 °C	100 °C	
Preheat Temperature Typical	T _{s typical}	120 °C	120 °C	
Preheat Temperature Max	T _{s max}	130 °C	130 °C	
$\label{eq:preheat} \textbf{Preheat Time } \textbf{t}_{\textbf{s}} \textbf{from } \textbf{T}_{\textbf{s}} \textbf{min} \textbf{to } \textbf{T}_{\textbf{s}} \textbf{max} \qquad \textbf{t}_{\textbf{s}}$		70 seconds	70 seconds	
Δ Temperature from $T_{stypical}$ to T_{p}	ΔТ	140 °C max.	130 °C max.	
Time t _r from T _{s typical} to T _p	tr	15 s - 25 s	15 s - 25 s	
Peak Temperature	Тр	260 °C max.	240 °C - 250 °C max.	
Time of actual peak temperature	tp	max. 10 seconds	max. 10 seconds	
Ramp-down Rate, Min		~ 2 K/ second	~ 2 K/ second	
Ramp-down Rate, Typical		~ 3 K/ second	~ 3 K/ second	
Ramp-down Rate, Max		~ 4 K/ second	~ 4 K/ second	
Time 25 °C to 25 °C		4 minutes	4 minutes	

ROMS COMPLIANT COMPLIANT		checked GMo	REVISION 001.000	DATE (YYYY-MM-DD) 2024-03-06	GENERAL TOLERANCE DIN ISO 2768-1m		PROJECTION METHOD	_
		Wave	- Wave Soldering Profile					
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