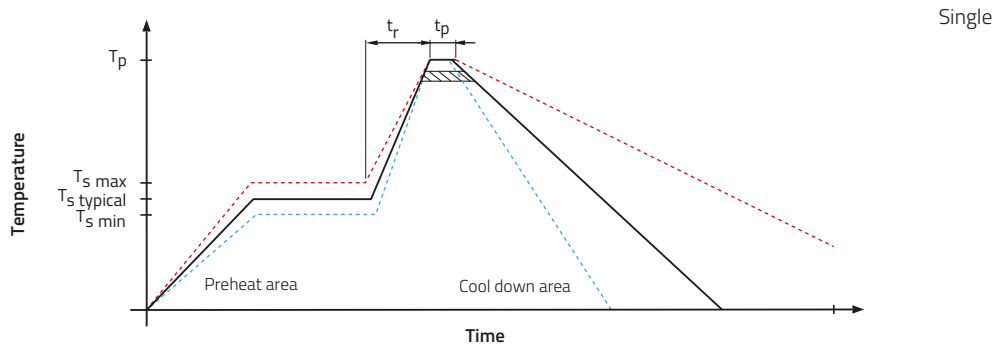
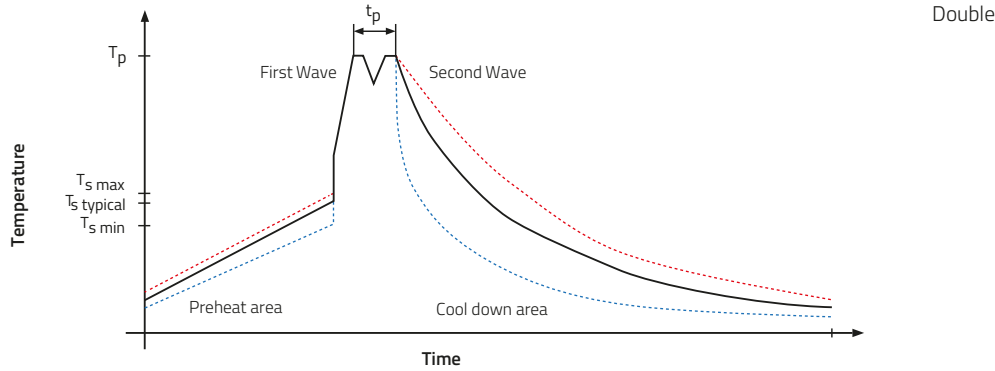


Wave Soldering Profile:



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	$T_{s \text{ min}}$	100 °C	100 °C
Preheat Temperature Typical	$T_{s \text{ typical}}$	120 °C	120 °C
Preheat Temperature Max	$T_{s \text{ max}}$	130 °C	130 °C
Preheat Time t_s from $T_{s \text{ min}}$ to $T_{s \text{ max}}$	t_s	70 seconds	70 seconds
Ramp-up Rate	ΔT	150 °C max.	150 °C max.
Peak Temperature	T_p	250 °C - 260 °C	235 °C - 260 °C
Time of actual peak temperature	t_p	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	$T_{s \text{ min}}$	100 °C	100 °C
Preheat Temperature Typical	$T_{s \text{ typical}}$	120 °C	120 °C
Preheat Temperature Max	$T_{s \text{ max}}$	130 °C	130 °C
Preheat Time t_s from $T_{s \text{ min}}$ to $T_{s \text{ max}}$	t_s	70 seconds	70 seconds
Δ Temperature from $T_{s \text{ typical}}$ to T_p	ΔT	140 °C max.	130 °C max.
Time t_r from $T_{s \text{ typical}}$ to T_p	t_r	15 s - 25 s	15 s - 25 s
Peak Temperature	T_p	260 °C max.	240 °C - 250 °C max.
Time of actual peak temperature	t_p	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



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CHECKED	REVISION	DATE (YYYY-MM-DD)	GENERAL TOLERANCE	PROJECTION METHOD
GMo	001.000	2024-03-06	DIN ISO 2768-1m	
DESCRIPTION				
Wave Soldering Profile				
ORDER CODE				
SIZE/TYPE	BUSINESS UNIT	STATUS	PAGE	
m/m	eiCan	Valid	1/1	