1. Wave Soldering Profile

<table>
<thead>
<tr>
<th>Profile Feature</th>
<th>SnPb eutectic assembly</th>
<th>Pb-free assembly</th>
</tr>
</thead>
<tbody>
<tr>
<td>Average ramp-up rate</td>
<td>~ 200°C/s</td>
<td>~ 200°C/s</td>
</tr>
<tr>
<td>Heating rate during preheat</td>
<td>typical 1-2°C/s, max 4°C/s</td>
<td>typical 1-2°C/s, max 4°C/s</td>
</tr>
<tr>
<td>Final preheat temperature (Tₛ)</td>
<td>~ 130°C</td>
<td>~ 130°C</td>
</tr>
<tr>
<td>Peak temperature (Tₚ)</td>
<td>235°C</td>
<td>260°C</td>
</tr>
<tr>
<td>Time within peak temperature (tₚ)</td>
<td>10s</td>
<td>10s</td>
</tr>
<tr>
<td>Ramp-down rate</td>
<td>5°C/s maximum</td>
<td>5°C/s maximum</td>
</tr>
</tbody>
</table>
Revision history

<table>
<thead>
<tr>
<th>Rev</th>
<th>Date</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>v.1</td>
<td>20191104</td>
<td>New format update</td>
</tr>
</tbody>
</table>

Contact information

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