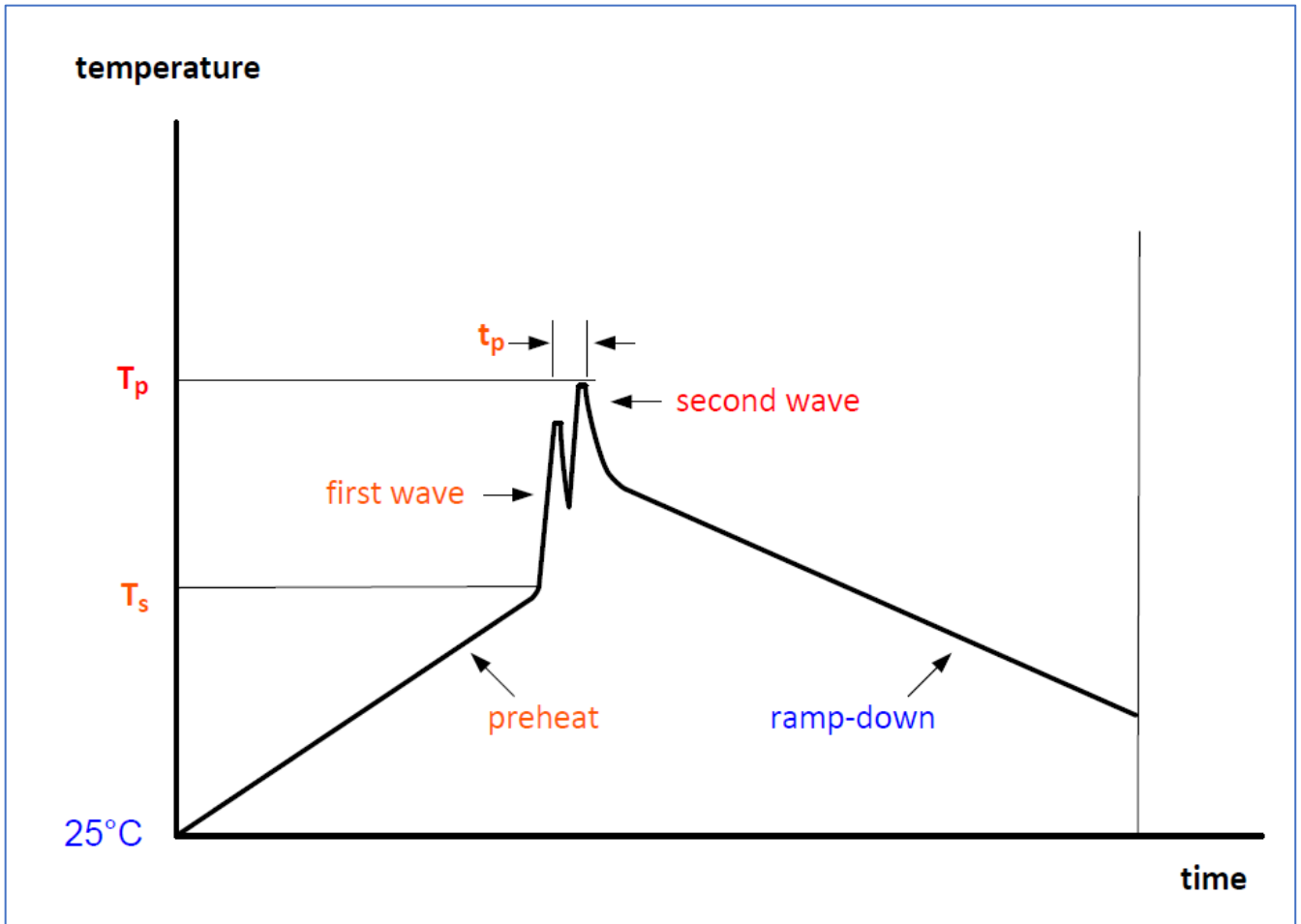




## 1. Wave Soldering Profile



Profile Feature	SnPb eutectic assembly	Pb-free assembly
Average ramp-up rate	~ 200°C/s	~ 200°C/s
Heating rate during <b>preheat</b>	typical 1-2°C/s, max 4°C/s	typical 1-2°C/s, max 4°C/s
Final preheat temperature ( $T_s$ )	~ 130°C	~ 130°C
Peak temperature ( $T_p$ )	235°C	260°C
Time within peak temperature ( $t_p$ )	10s	10s
<b>Ramp-down</b> rate	5°C/s maximum	5°C/s maximum

## Revision history

Rev	Date	Description
v.1	20191104	New format update

## Contact information

For more information and sales office addresses please visit: <http://www.ween-semi.com>

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