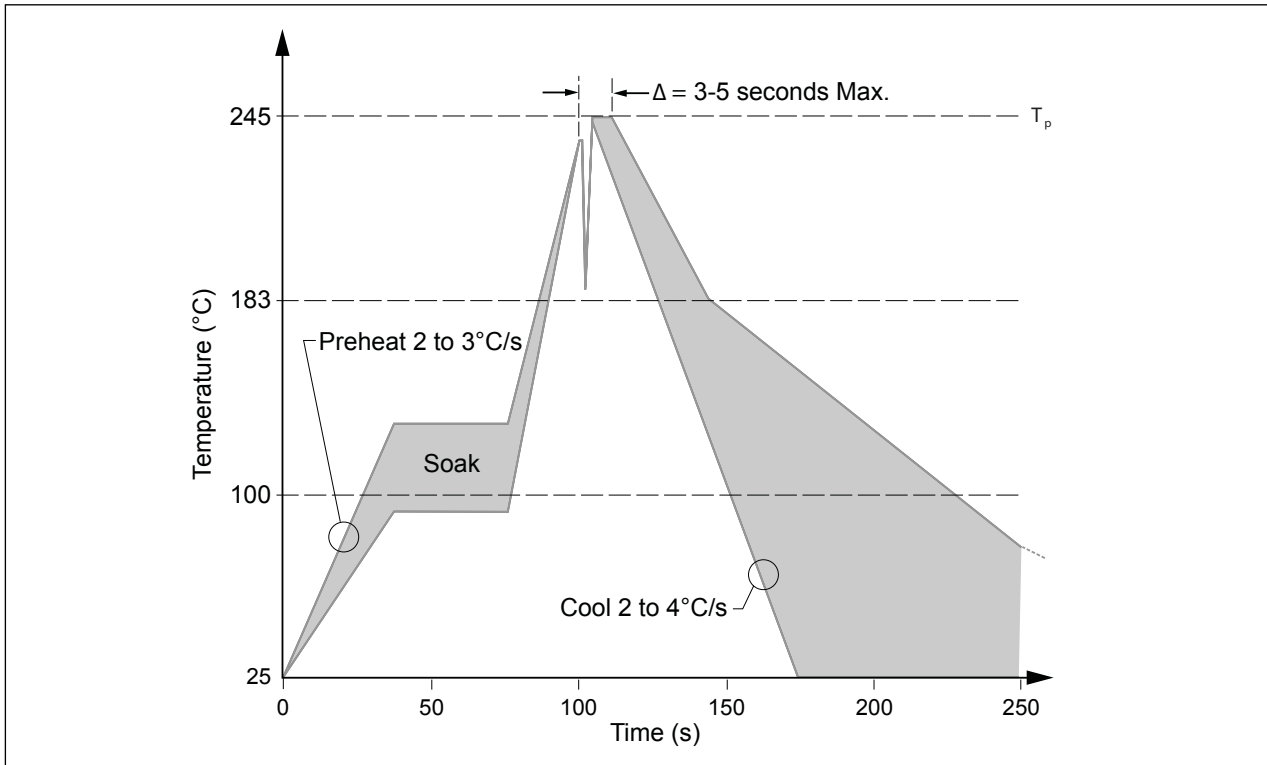


Wave Soldering Profile



Profile Feature	Parameter
Average ramp-up rate	~ 200°C/second
Heating rate during preheat	typical 2-3°C/second
Peak temperature T_p	245°C
Time within +0°C / -5°C of actual peak temperature	3-5 seconds
Ramp-down rate	4°C/second max.