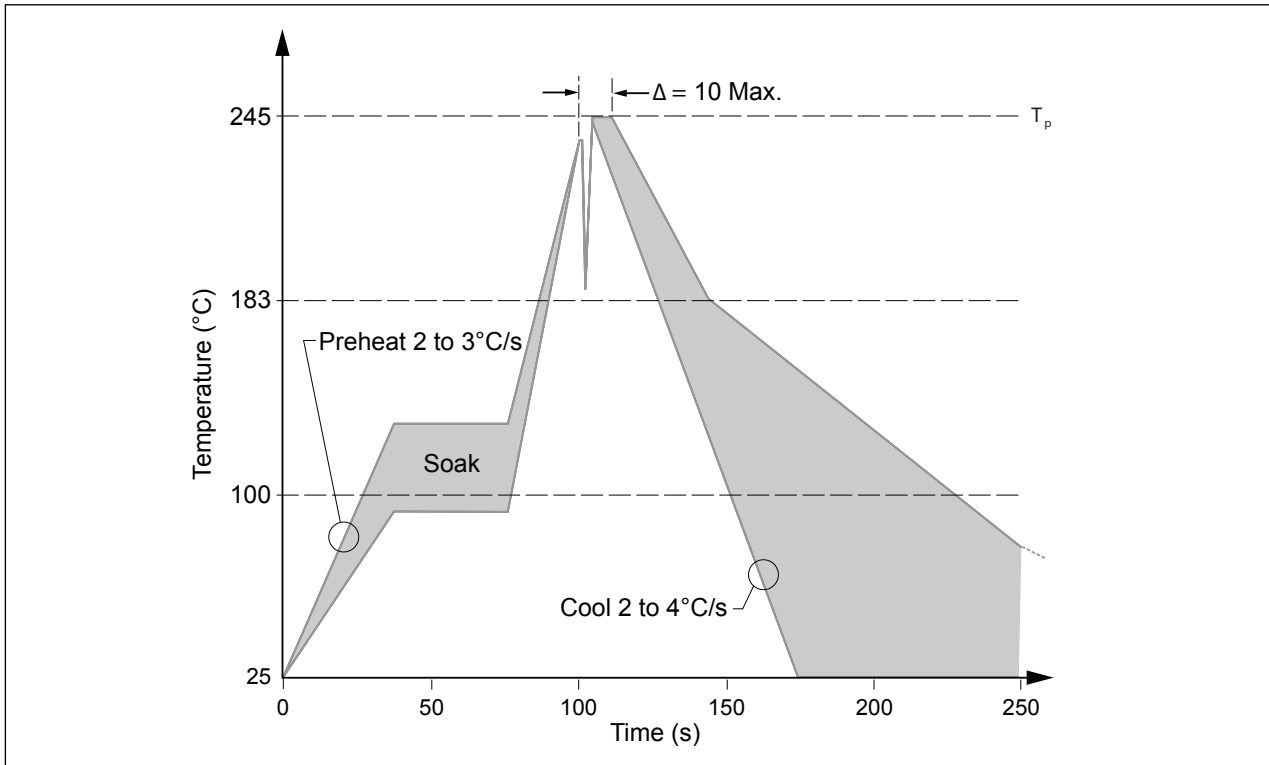


# Wave Soldering Profile for Standard Parts



Profile Feature	Parameter
Average ramp-up rate	~ 200°C/second
Heating rate during preheat	typical 2-3°/second
Peak temperature $T_p$	245°C
Time within +0°C / -5°C of actual peak temperature	10 seconds
Ramp-down rate	4°C/second max.