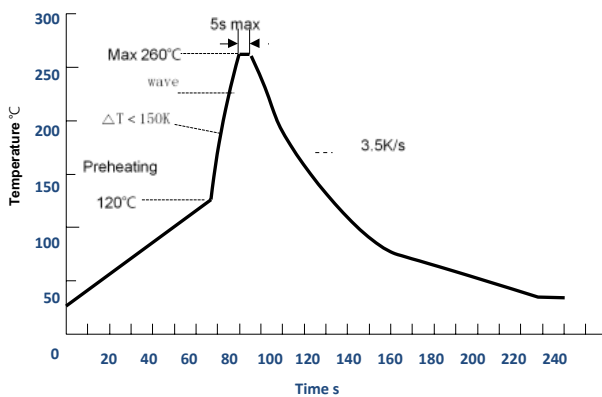


## Wave Soldering Recommendations:

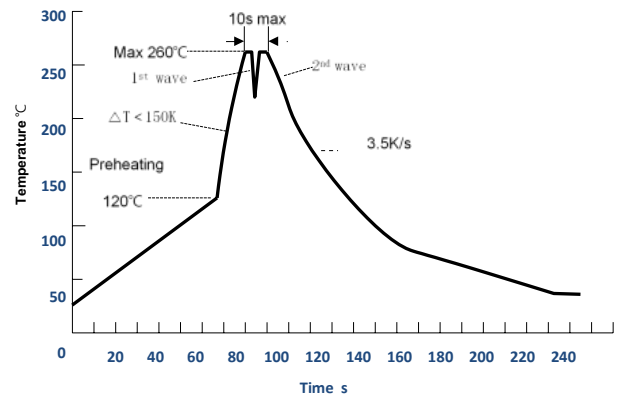
### Wave solder simulation conditions

Test conditions	Wave solder	Solder DIP
Preheat Temperature	25 to 140 °C	145 °C
Preheat Time	80 seconds min.	40 seconds min.
Ramp-up Rate (preheat only)	3 °C/second max.	3 °C/second max.

260 °C Classification (Pb-free solder)		260 °C +5/-0 °C	260 °C +5/-0 °C
Solder Immersion Time	Single Wave Simulation	5 +2/-01 seconds	5 +2/-0 seconds
	Extended Single Wave Simulation	10 +2/-0 seconds	10 +2/-0 seconds
Ramp-down Rate		6 °C/second max	6 °C/second max



Single wave soldering profile



Double wave soldering profile

Note: The temperature curve is reference only

## Hand soldering recommendations:

Temperature (Heat Supply)	Below 350 °C	Below 260 °C
Max. Temperature Duration (Heat Supply)	≤3 s	≤10 s
Soldering Times	2 Times	2 Times