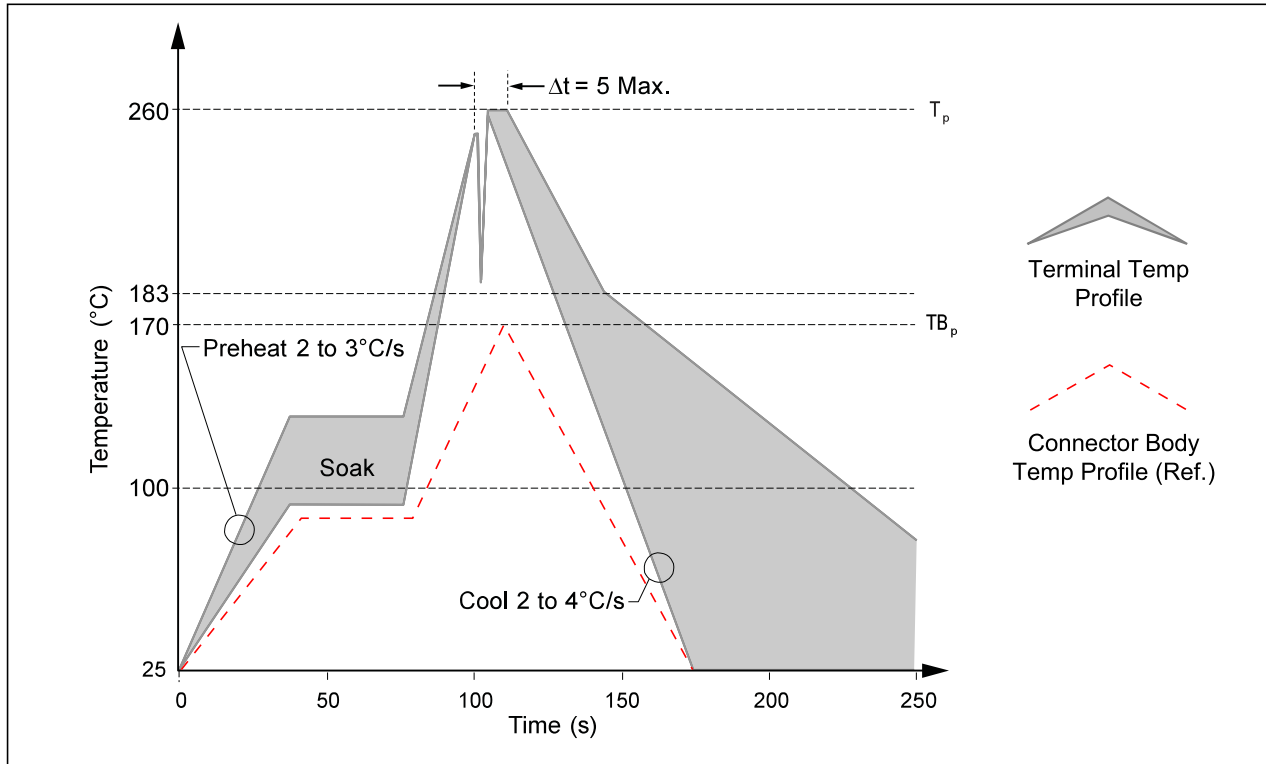


High Temperature Wave Soldering Profile for Low Temperature THT Parts*



Profile Feature	Parameter
Average ramp-up rate	~ 200°C/second
Heating rate during preheat	typical 2-3°/second
Peak temperature T_p	260°C Max.
Peak Body temperature TB_p	170°C Max.
Time within +0°C / -5°C of actual peak temperature Δt	5 seconds max.
Ramp-down rate	4°C/second max.

*Wave solder profile shown not applicable to all low temperature parts. Contact Kycon for specific details.