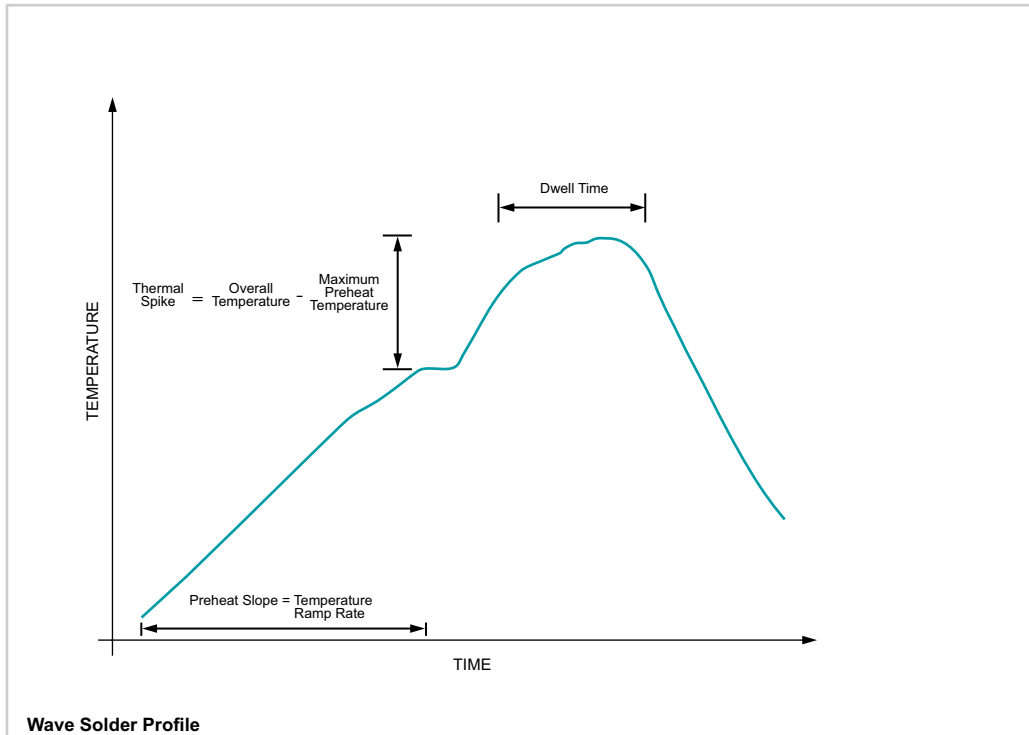


# SUGGESTED WAVE SOLDERING PROFILE



## Properties Table

Peak Temperature	260+/-5°C
Dwell Time	5 seconds max.
Preheat Temperature	140°C max.
Preheat Duration	2 mins.
Conveyor Speed	1 m/min.
Allowable Passes Through Wave Solder	2

**Reference Standard:**

- JESD22-B106D\_Resistance to Solder Shock for Through-Hole Mounted Devices