

Recommendation for lead free wave soldering process

Recommendation:

1. Warm-up Temperature is 100 ~ 120°C, for 86 ~ 100sec,
Rising Temperature Speed 1 ~ 2 K / sec.
2. Tin Stove Peak Value Temperature: 250 ~ 258°C for 3 ~ 4sec.
3. Soldering Process Cooling Speed: 1 ~ 3 K / sec.
4. The time for whole wave soldering should be limited to be not longer than 3.5min.

