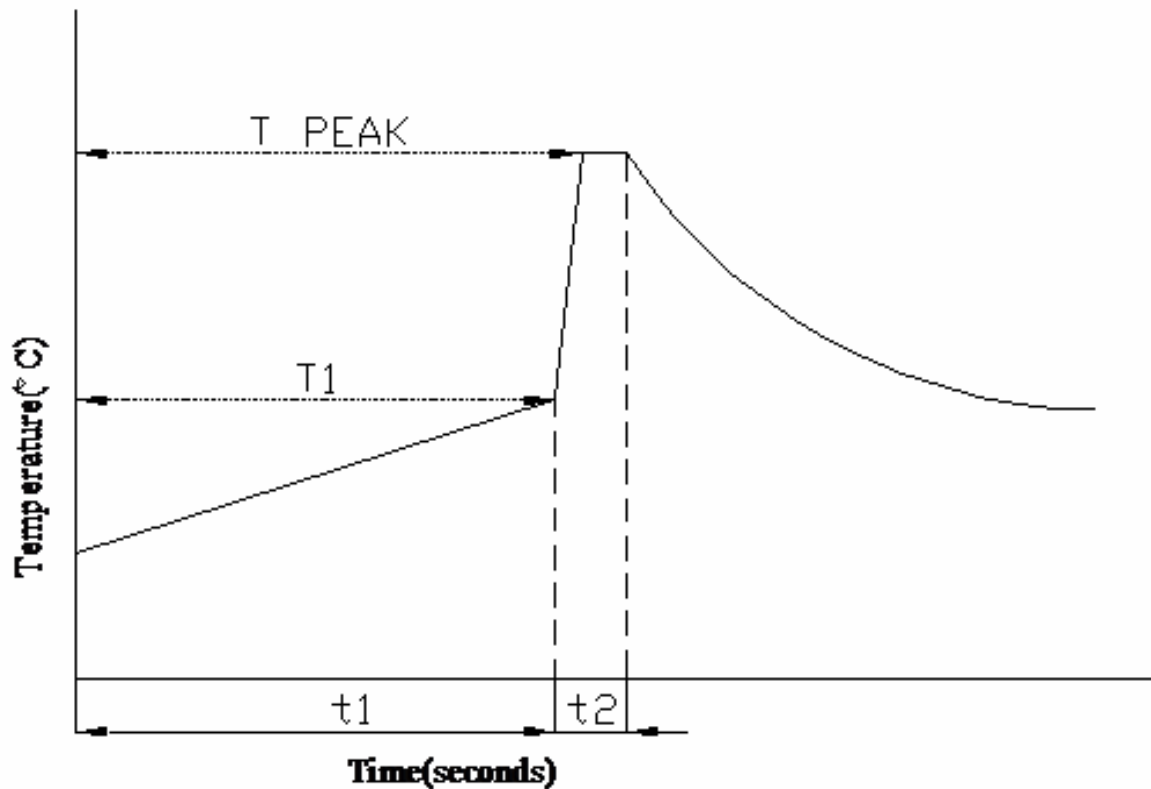


NYLON Recommend Wave Soldering Profile



Parameter	Preference	Lead Free Spec
Preheat Temp Gradient		+1~4°C/sec
Preheat Time	t1	2~3 Min
Preheat Temp	T1	>100°C
Solder Pot Temp	T PEAK	260 +0 / -5°C
Dwell Time	t2	5~7 sec
Peak Board Top Temp		200 °C Max
Cooling Temp Gradient		6°C/sec Max