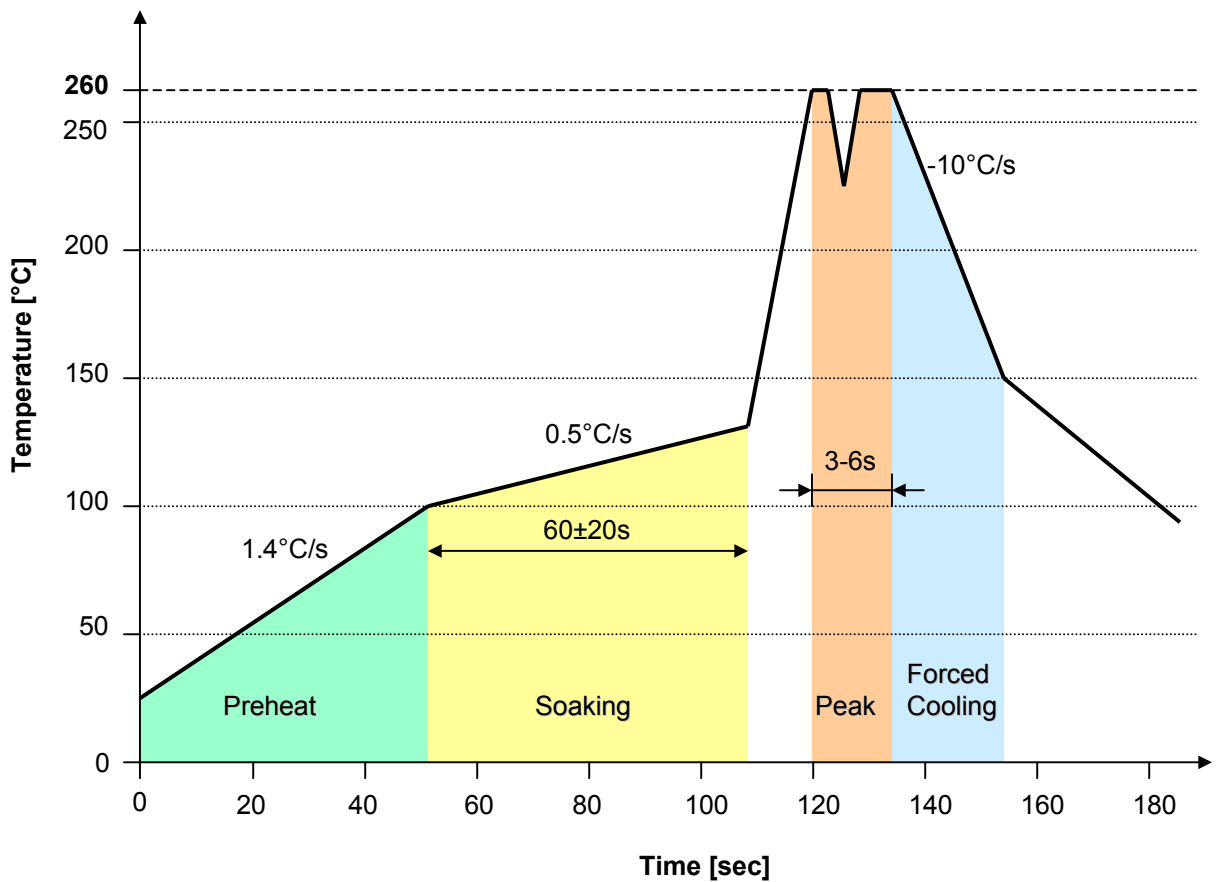


Lead Free Wave Soldering Profile (Through Hole Pinning)

Field of application: Fabrimex' RoHS compliant DC/DC Converters and AC/DC Power Supplies with through hole pinning.

Soldering profile:



Limits:

- Preheat:** Ramp up rate during preheating is 1.4°C / sec; from 50°C to 100°C.
- Soaking:** Ramp up rate during soaking is 0.5°C / sec; from 100°C to 130°C (±20 sec).
- Peak:** Peak Temperature is 260°C and maximum 3-6 sec above 250°C is allowed.
- Cooling:** Ramp down rate during forced cooling is -10°C / sec from 260°C to 150°C.