

## SOLDERING CONDITIONS 焊接條件

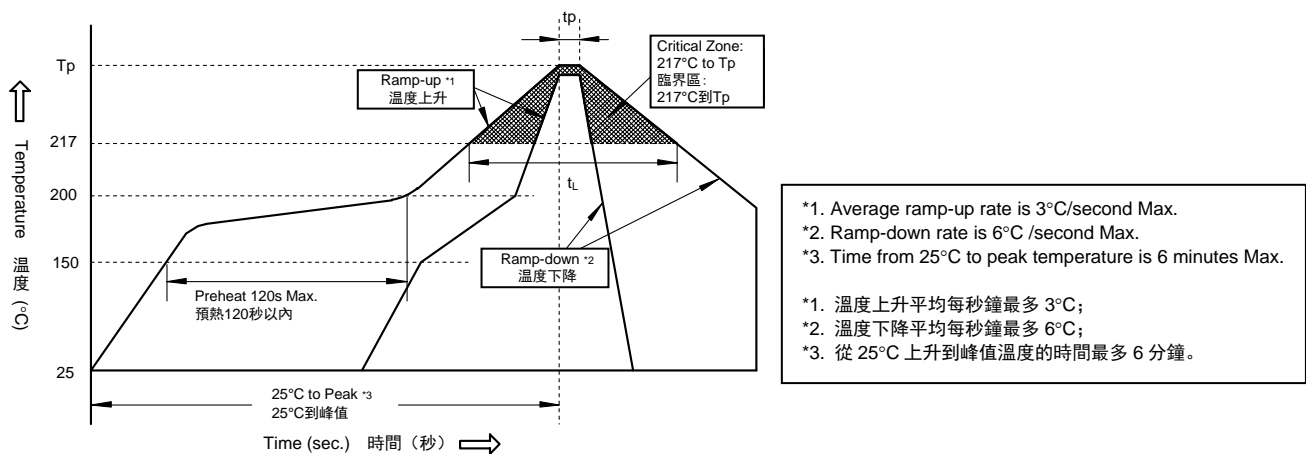
☐ For Chip Type Aluminum Electrolytic Capacitors 適用於貼片式鋁電解電容器 

- Radial lead type and snap-in terminal type aluminum electrolytic capacitors please see titled "Mounting" in "General Information for Application".
- 插件式和導箔式鋁電解電容器請查閱“鋁電解電容器使用注意事項”裡的“安裝”說明。

### ■ Recommended Conditions for Reflow Soldering 推薦回流焊條件

- (1) A thermal condition system such as infrared radiation (IR) or hot blast should be adopted, and vapor heat transfer systems (VPS) are not recommended.  
應採用紅外線或熱風回流焊接，而不宜採用汽相加熱回流焊接。
- (2) Reflow soldering should be within 2 cycles. Please make sure that the parts have enough cooling time between the first and second soldering process.  
回流焊次數最多 2 次，請確保在第 1 次和第 2 次之間產品有足夠的冷卻時間。
- (3)
  - The time of preheating from 150°C to 180°C shall be within maximum 120 seconds;  
從 150°C 到 180°C 的預熱時間應在 120 秒以內；
  - The time of soldering temperature at 217°C measured on capacitors' top shall not exceed  $t_L$  (second);  
電容器頂部溫度超過 217°C 的焊接時間不得超過  $t_L$  (秒)；
  - The peak temperature on capacitors' top shall not exceed  $T_p$ (°C), and the time within 5°C of actual peak temperature shall not exceed  $t_p$  (second).  
電容器頂部的峰值溫度不得超過  $T_p$ (°C)，在 5°C 範圍內的實際峰值溫度時間不得超過  $t_p$  (秒)。

### ■ Classification Reflow Profile 回流焊曲線圖

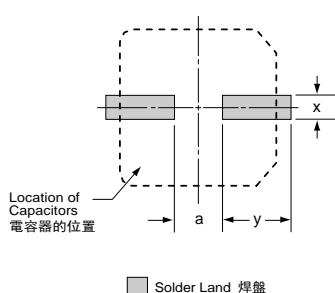


### ■ Classified at Temperature and Time 溫度和時間分類

Size 尺寸	Preheat 預熱	$T_p$ (°C)	$t_L$ (second 秒)	$t_p$ (second 秒)	Reflow number 回流焊次數
∅4~∅6.3, ∅8×6.2	150~180°C 120s Max. (120 秒以內)	255	60	5	2 times or less 最多 2 次
∅8×10.5		250	60	5	
∅10		245	60	5	
∅12.5, ∅16, ∅18		240	40	5	

- Please contact us if your condition is over the maximum.
- 如使用條件超出最大值，請與我們聯繫。

### ■ Recommended Solder Land Size on PC Board 推薦安裝尺寸 (Unit: mm)



Size 尺寸	a	y	x
∅4	1.0	2.6	1.6
∅5	1.4	3.0	1.6
∅6.3	1.9	3.5	1.6
∅8 × 6.2	2.1	4.0	1.6
∅8 × 10.5	3.0	3.5	2.5
∅10	4.0	4.0	2.5
∅12.5	4.0	6.0	3.2
∅16	6.0	7.0	3.2
∅18	6.0	8.0	3.2

**Note:** All design and specifications are for reference only and is subject to change without prior notice. If any doubt about safety for your application, please contact us immediately for technical assistance before purchase.

注：以上所提供的設計及特性參數僅供參考，任何修改不作預先通知。如果在使用上有疑問，請在採購前與我們聯繫，以便提供技術上的協助。