

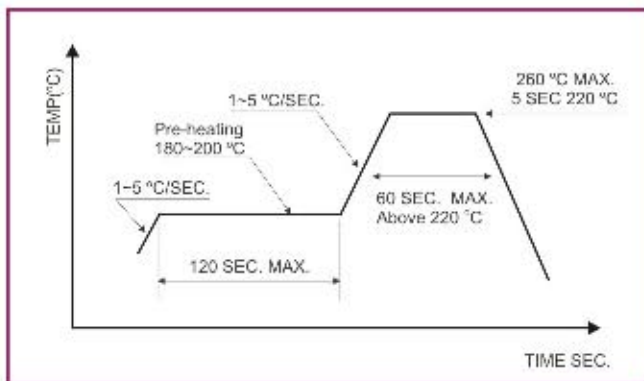
CAUTIONS OF APPLICATION (Assembly)

1) Soldering

- 1.1) Manual soldering (We do not recommend this method strongly.)
 - 1.1.1) Soldering tin material: tin 6/4 alloy or contained Ag.
 - 1.1.2) To prevent cracking, please bake before manual soldering.
 - 1.1.3) Keep the temperature on the edge of iron at 300±5 ℃ Max. (25W) and apply for 3 Seconds. If the temperature becomes higher, apply in a shorter time (1 sec per 10 ℃).
 - 1.1.4) In manual soldering, take care not to damage the package especially terminal or resin. (Do not give stress to the product when soldering.)
 - 1.1.5) Do not use again it you remove the soldered product.
 - 1.1.6) It is recommended using an iron with a temperature control.

1.2) Reflow Soldering

- 1.2.1) Never take next process until the component is cooled down to room temperature after reflow.
- 1.2.2) The recommended reflow soldering profile (measuring on the surface of the LED resin) is following.



1.3) Rework

- 1.3.1) Customer must finish rework within 5 sec under 260 ℃.
- 1.3.2) The head of iron cannot touch copper foil.
- 1.3.3) Twin-head type is preferred.

1.4) Cleaning

The conditions of cleaning after soldering:

- 1.4.1) An alcohol-based solvent such as Isopropyl Alcohol (IPA) is recommended.
- 1.4.2) Temperature X Time: < 50 ℃ X 30sec, or < 30 ℃ X 3min.
- 1.4.3) Ultra sonic cleaning: < 15W/ bath; Bath volume: 1liter max.
- 1.4.4) Curing: 100 ℃ max, < 3min

1.5) Cautions of Pick and Place

- 1.5.1) It should be avoided to load stress on the resin during high temperature.
- 1.5.2) Avoid rubbing or scraping the resin by any object.
- 1.5.3) Electric-static may cause damage to the component. Please confirm that the equipment is grounding well. Using an ionizer fan is recommended.

1.6) Cautions of Design and Applications

- 1.6.1) It should be done to connect with a current-limiting serial resistor. Avoid to drive reverse voltage over the specifications on LED when ON/OFF.
- 1.6.2) Any application should refer to the specifications of absolute maximum ratings.
- 1.6.3) The dimensions of the recommended soldering pattern may not meet every user. Please confirm and study first before designing the soldering pattern in order to obtain the best performance of soldering.
- 1.6.4) Do not contact with any component on the assembly board.