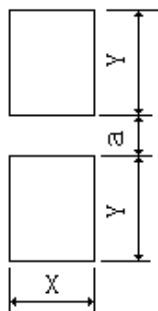


## SMD ALUMINUM ELECTROLYTIC CAPACITOR

### LEAD-FREE REFLOW SOLDERING CONDITIONS

#### • Recommended Pad Size

To optimize the soldering result, we recommend the following pad sizes:

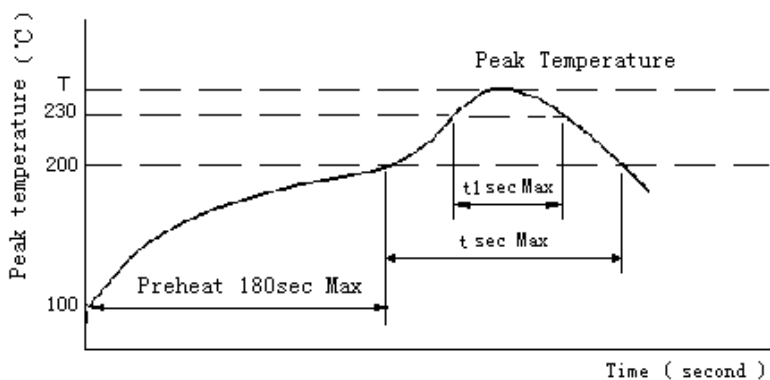


Size	X	Y	a
Ø 4	1.6	2.6	1.0
Ø 5	1.6	3.0	1.4
Ø 6.3	1.6	3.5	2.1
Ø 8 x 10.5	2.5	3.5	3.0
Ø 10 x 10.5	2.5	4.0	4.0

#### • Recommended Soldering Profile

- The time of preheating from 100°C to 200°C shall be within maximum 180 seconds.
- The time of soldering temperature more than 200°C and 230°C measured on capacitors top shall not exceed  $t$  and  $t_1$  seconds, respectively.
- The peak temperature on capacitors top shall not exceed  $T$ (°C).

Temperature / Time-limit Profile



Allowable Range of Peak Temperature

Size	T(°C)	t(second)	$t_1$ (second)
Ø 4 ~ Ø 6.3	250	90	40
Ø 8 x 10.5	240	90	30
Ø 10 x 10.5	235	60	30