

## RECOMMENDED SOLDERING CONDITIONS 非固体电解电容推荐焊接条件

■ For Aluminum electrolytic capacitors with non-solid electrolyte 适用于非固体铝电解电容

1. Radial lead and Snap-in Type 引线型及大型铝电解电容
  - 1.1. Flow soldering: 260±5°C for 10±1 seconds 波峰焊: 波峰温度 260±5°C, 10±1 秒以内
  - 1.2. Hand soldering: 380±10°C for 3±0.5 seconds 手工焊: 焊枪温度 380±10°C, 3±0.5 秒以内
2. Surface Mount Type 贴片型非固体铝电解电容

The following conditions are recommended for air convection and infrared reflow soldering on the SMD products onto a glass epoxy circuit boards by cream solder. The temperatures shown are the surface temperature values on the top of the can and on the capacitor terminals.

当使用回流焊, 在玻璃环氧树脂基板上进行焊接的时候, 产品顶部及端子部分温度, 时间的推荐范围如下表所示。

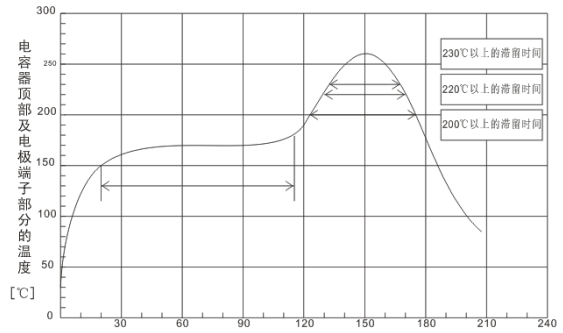
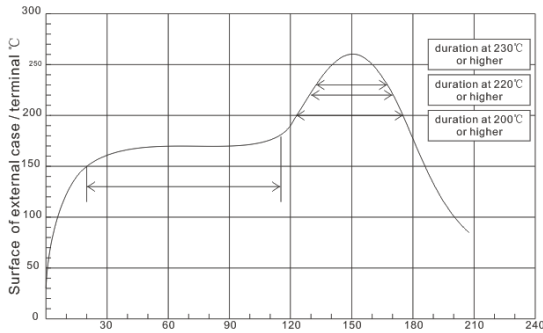
Reflow should be performed twice or less.

推荐回流次数不超过 2 次。

Please ensure that the capacitor became cold enough to the room temperature (5 to 35°C) before the second reflow.

如需要第 2 次焊接, 请在第 1 次回流之后, 必须确保电容器的温度已经完全冷却到室温(5~35°C)后方可进行第 2 次回流。

2.1. Recommended soldering heat conditions 回流焊推荐条件



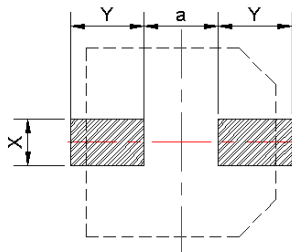
Note: 1). Average ramp-up rate is 5°C/second max. 温度上升平均每秒钟最多 5°C;

2). Ramp-down rate is 6°C/second max. 温度下降平均每秒钟最多 6°C;

3). Time from 25°C to peak temperature is 6 minutes max. 从 25 上升到峰值温度的时间最多 6 分钟。

	Preheat 预热时间	Time maintained above 200°C 200°C 以上时间	Time maintained above 220°C 220°C 以上时间	Time maintained above 230°C 230°C 以上时间	Peak temp. 温度峰值	Reflow number 回流焊次数
Dia. 4~10mm general φ4~10 一般品	120°C to 180°C 120 sec. Max.	60 sec.	50 sec.	30 sec.	250°C Max.	2 times or less 2 次以下
φ8x6.5		50 sec.	40 sec.	25 sec.	245°C Max.	2 times or less 2 次以下
WV 160v-450v 160v~450v 品		60 sec.	50 sec.	30 sec.	240°C Max.	2 times or less 2 次以下
Dia. 12.5~20mm Cap. 直径 φ12.5~20mm 产品		60 sec.	40 sec.	30 sec.	240°C Max.	2 times or less 2 次以下
125°C Category Temp. 125°C 耐温品		60 sec.	40 sec.	30 sec.	250°C Max.	2 times or less 2 次以下

2.2. Recommended Solder Land on PC Board 推荐表面安装尺寸



Size 尺寸	X	Y	a
φ4	1.6	2.6	1.0
φ5	1.6	3.0	1.4
φ6.3	1.6	3.5	2.1
φ8x6.5	1.6	4.5	2.1
φ8x10.5	2.5	3.5	3.0
φ10	2.5	4.0	4.0
φ12.5	3.0	5.7	4.0
φ16	3.5	6.5	6.0

**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: 以上所提供的设计及特性参数仅供参考, 任何修改不作预先通知, 如有使用上任何疑问, 请在采购前与我们联系, 以便提供技术上的协助。