

Lead Forming
Taping Specifications

Fig.1 code: X

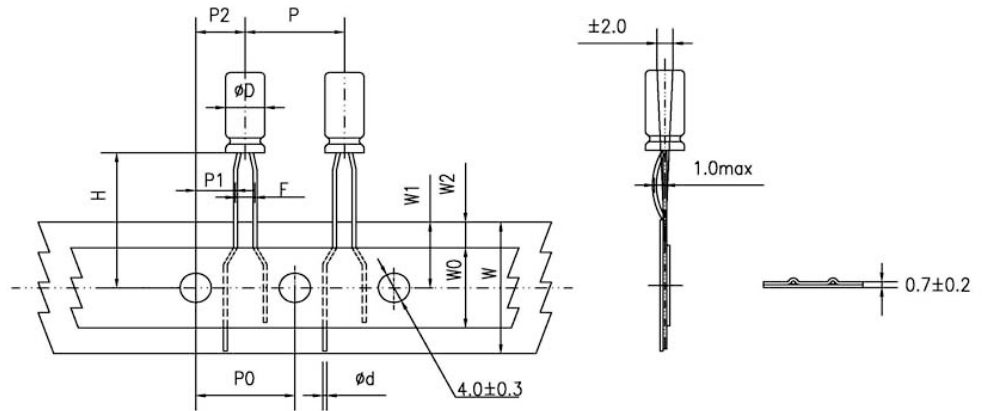


Fig.2 code: B

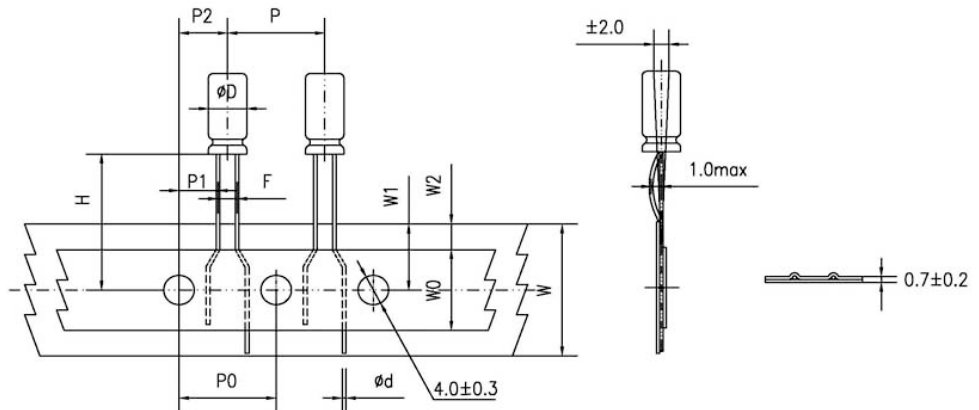


Fig.3 code: B

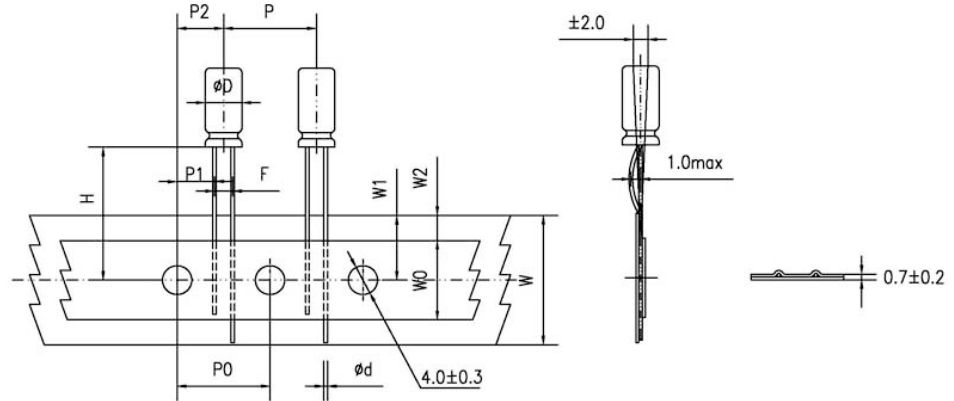
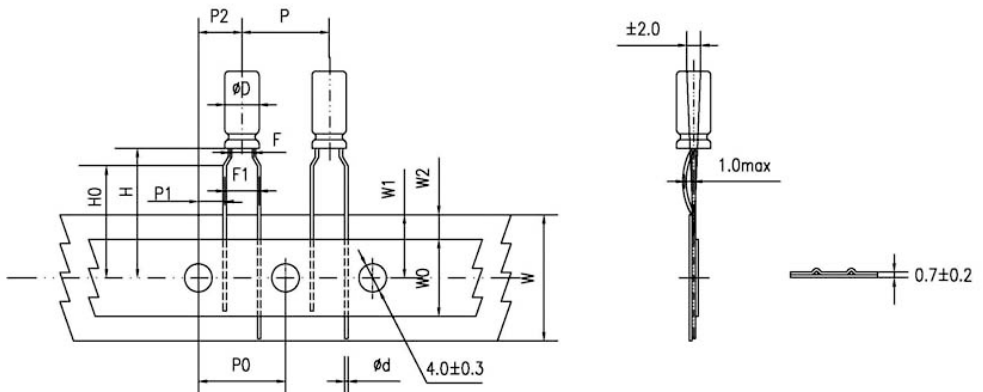
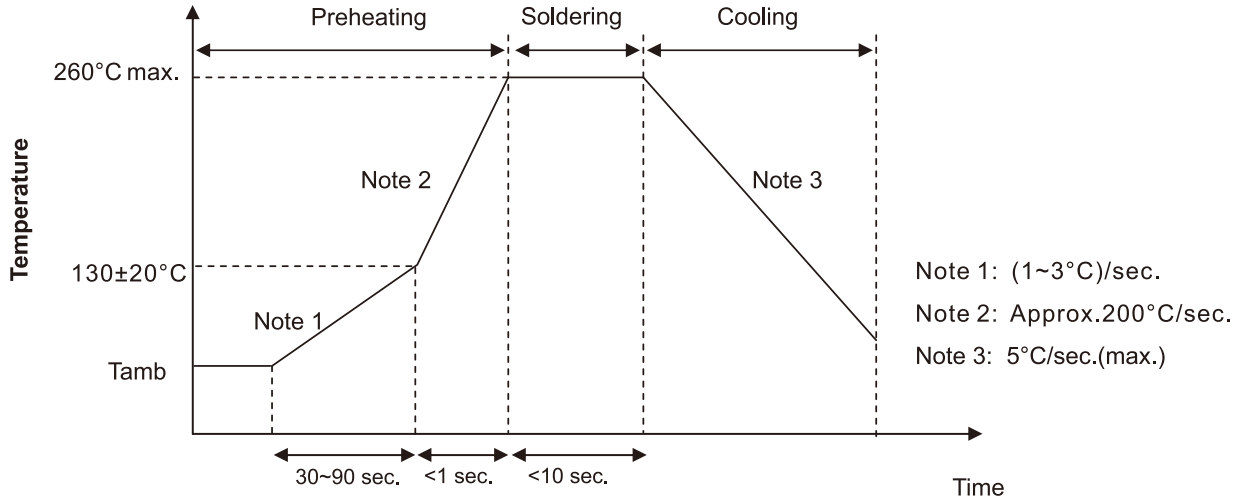


Fig.4 code: P



Solering Recommendation

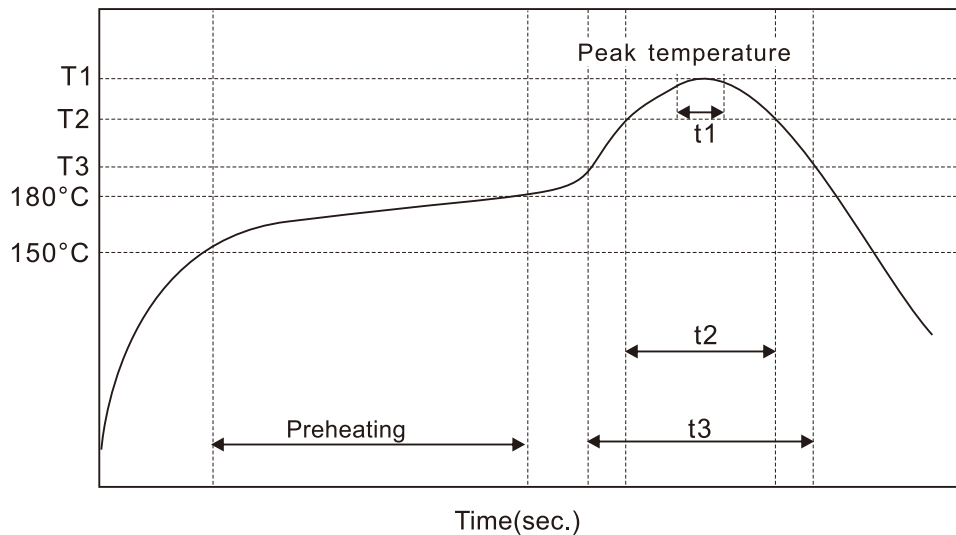
■ Flow Soldering(Radial Lead Type)



■ Reflow Soldering

- (For Polymer SMD Type)

Recommended Reflow Profile

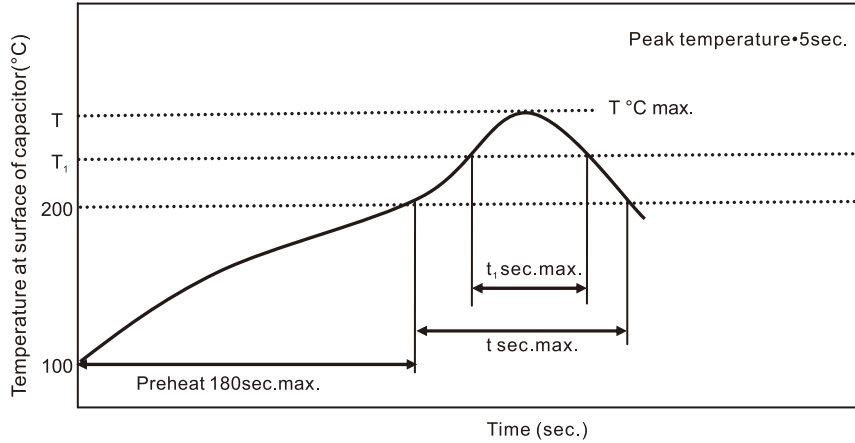


Item	Preheating	T1(°C)	T2(°C)	T3(°C)	t1(sec.)	t2(sec.)	t3(sec.)	Reflow cycle
Condition 1	150°C to 180°C Within 90sec.	≤260	230	200	≤10	≤40	≤60	1
Condition 2		≤250	230	200	≤10	≤40	≤60	2

● (For Liquid SMD Type)

Case size: $\Phi 6.3$ – $\Phi 10$ mm:

- Temperature at surface of capacitor shall not exceed $T^{\circ}\text{C}$.
- The duration for over 200°C temperature and $T_1^{\circ}\text{C}$ at surface of capacitor shall not exceed t and t_1 seconds, respectively.
- Preheat shall be done at 100°C to 200°C and for Maximum 180 seconds.

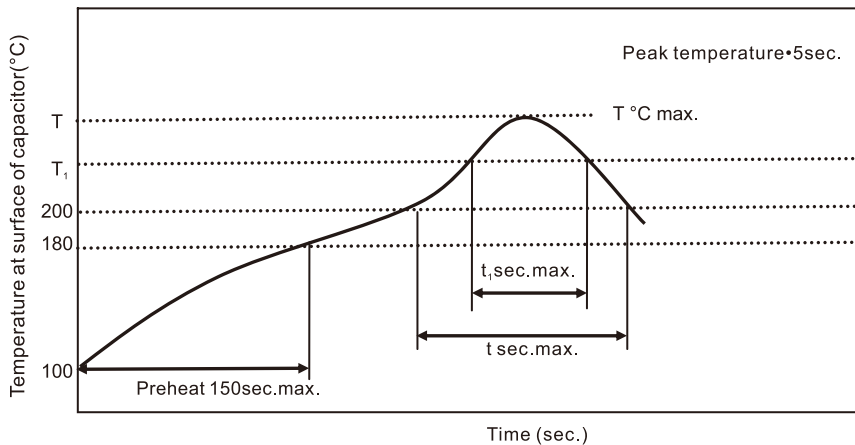


Case size (mm)	$T(^{\circ}\text{C})$ ①	$T_1(^{\circ}\text{C})$	$t(\text{sec.})$ ②	$t_1(\text{sec.})$ ③	Reflow cycle
$\Phi 6.3$	250	230	90	40	1
$\Phi 8$	240	230	90	30	1
$\Phi 10$	235	230	60	30	1

- ① Peak temperature
- ② The duration over 200°C (max.)
- ③ The duration over $T_1^{\circ}\text{C}$
- Please contact us if capacitors are subject to the conditions other than the allowable range of reflow.

Case size: $\Phi 12.5$ – $\Phi 18$ mm:

- Temperature at surface of capacitor shall not exceed $T^{\circ}\text{C}$.
- The duration for over 200°C temperature and $T_1^{\circ}\text{C}$ at surface of capacitor shall not exceed t and t_1 seconds, respectively.
- Preheat shall be done at 100°C to 180°C and for Maximum 150 seconds.



Case size (mm)	$T(^{\circ}\text{C})$ ①	$T_1(^{\circ}\text{C})$	$t(\text{sec.})$ ②	$t_1(\text{sec.})$ ③	Reflow cycle
$\Phi 12.5$ – $\Phi 18$	240	230	60	30	1

- ① Peak temperature
- ② The duration over 200°C (max.)
- ③ The duration over $T_1^{\circ}\text{C}$
- Please contact us if capacitors are subject to the conditions other than the allowable range of reflow.

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