

下列条件适用于 SMD 产品系列内的所有零件:

- 请参照技术手册中的建议设计电路板。
- 必须根据回流焊/波峰焊技术规范选择合格的焊料，严格控制焊接温度、时间。
- 焊接工艺会导致产品表面变色。
- 爬锡现象会导致内孔堵塞，因此通孔产品不适用波峰焊，建议采用回流焊。
- 所有产品应在出厂 12 个月内使用，超出有效期会影响可焊性。
- 必须在密封、干燥环境下保存。
- 零件与 PCB 的连接强度由产品、焊盘、焊接效果等因素综合决定
- 必须控制最大锁附扭力，防止元件和 PCB 受到机械破坏。
- 工作电流由 PCB、电缆接头、电缆横截面等因素综合决定。
- 手册中如有标注参考电流，零件使用材料为黄铜 C3604(H59) ， 钢 Steel 1215

### Cautions and Warnings:

The following conditions apply to all goods within the product series of yiyuan PCB SMD

General:

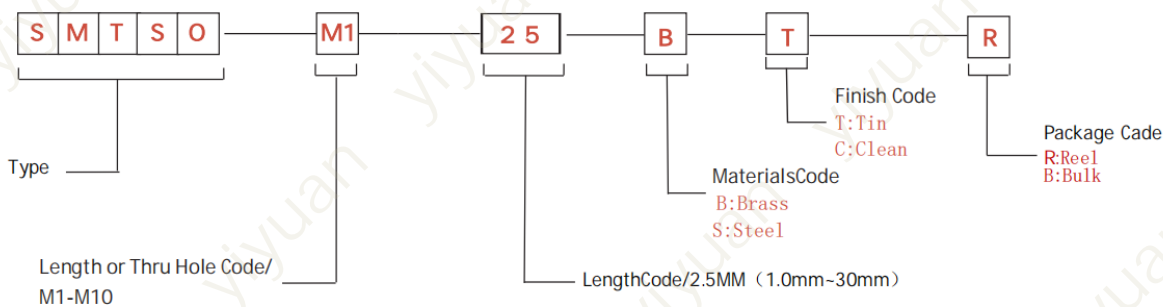
All recommendations according to the general technical specifications of the data-sheet have to be complied with.

The responsibility for the applicability of customer specific products and use in a particular customer design is always within the authority of the customer. All technical specifications for standard products do also apply for customer specific products.

Product Specific:

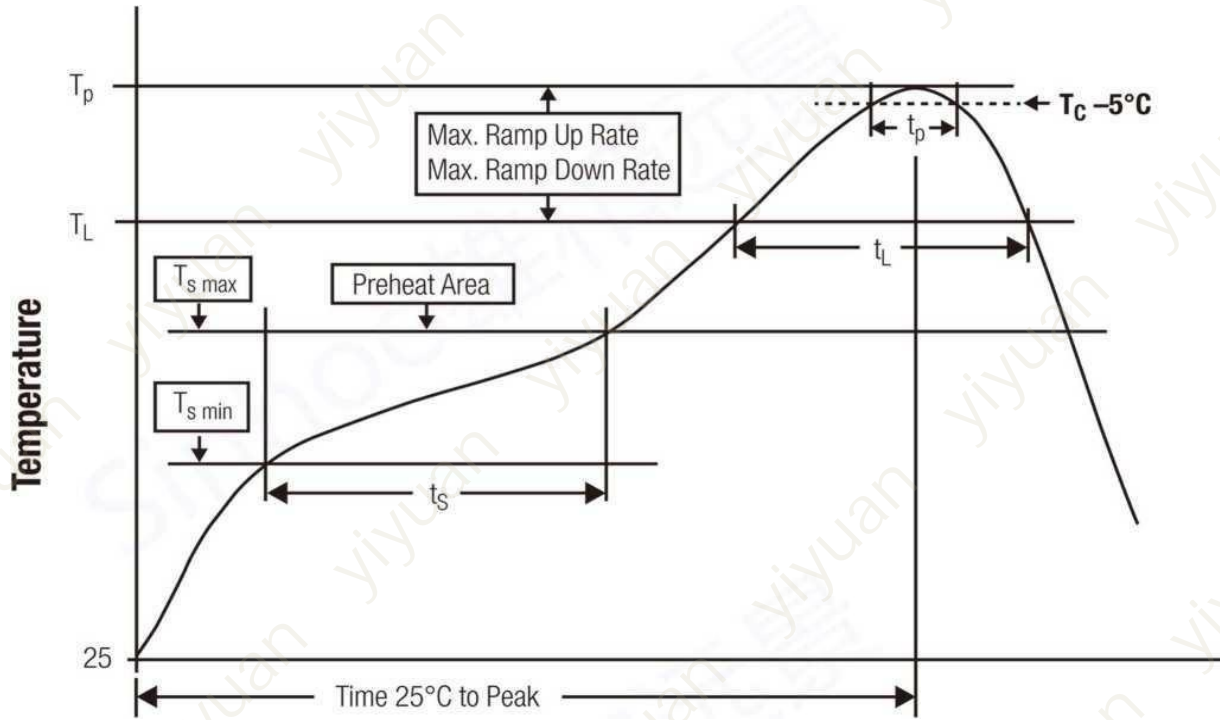
Follow all instructions in the datasheet, especially:

- The solder profile has to be complied with according to the technical reflow soldering specification, otherwise no warranty will be sustained.
- Surface discoloration due to reflow processing is permitted.
- Wave soldering is not applicable. Reflow soldering is recommended.
- All products shall be used before the end of the period of 12 months based on the product date-code, if not a 100% solderability can't be ensured.
- The maximum permissible torques must be complied with to prevent mechanical destruction of the elements and PCB.
- Operating current depends on PCB, cable lug and cross section of the cable.
- The connection strength between parts and PCB is determined by product, pad and welding effect
- If the operating current is marked in the manual, the material used for the parts is brass C3604(H59)



- Customized according to customer requirements





### Classification Reflow Profile for SMT components:

#### Classification Reflow Soldering Profile:

Profile Feature		Value
Preheat Temperature Min ( )	$T_{s \min}$	150 °C
Preheat Temperature Max	$T_{s \max}$	200 °C
Preheat Time $t_s$ from $T_{s \min}$ to $T_{s \max}$	$t_s$	60-120 seconds
Ramp-up Rate ( $T_L$ to $T_p$ )		3 °C/ second max.
Liquidous Temperature	$T_L$	217 °C
Time $t_L$ maintained above $T_L$	$t_L$	60-150 seconds
Peak package body temperature		see table
Time within 5°C of actual peak temperature	$t_p$	20 - 30 seconds
Ramp-down Rate ( $T_L$ to $T_p$ )		6 °C/ second max.
Time 25°C to peak temperature		8 minutes max.

#### Package Classification Reflow Temperature:

##### Time

Properties	Volume mm <sup>3</sup> <350	Volume mm <sup>3</sup> 350-2000	Volume mm <sup>3</sup> >2000
PB-Free Assembly I Package Thickness < 1.6 mm	260 °C	260 °C	260 °C
PB-Free Assembly I Package Thickness 1.6 mm - 2.5 mm	260 °C	250 °C	245 °C
PB-Free Assembly I Package Thickness > 2.5 mm	250 °C	245 °C	245 °C

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