

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)

Cautions and Warnings:

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

General:

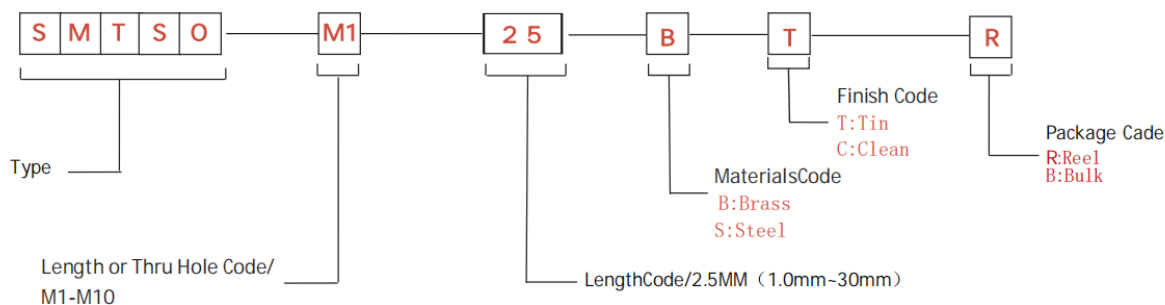
All recommendations according to the general technical specifications of the data-sheet have to be complied with.

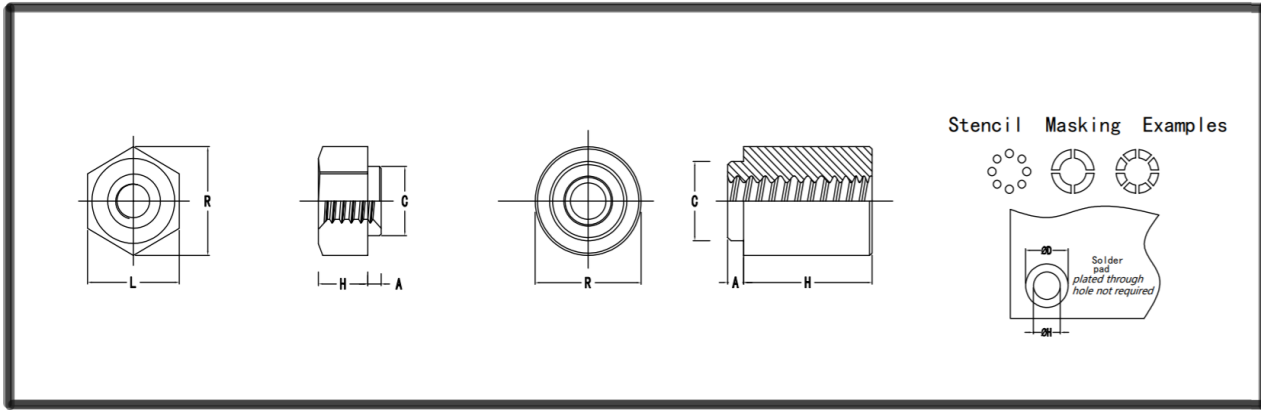
The responsibility for the applicability of customer specific products and use in a particular customer design is always within the authority of the customer. All technical specifications for standard products do also apply for customer specific products.

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)





Thread sizes 080, S1, S1.2, S1.4 and M1.6

Thread/thru hole sizes M2, M2.5, M3, M3.5, M4, 3.6, 4.2

All dimensions are in millimeters.

Thread Size x Pitch	Thru Hole +0.10 -0.08	Type	Thread or Thru Hole Code	Length Code "H"±0.13 (Length code in millimeters)																Min. Sheet Thickness	A Max.	C Max.	R Ref.±0.13	L Nom.	Hole Size In Sheet +0.08	OD Min. Solder Pad	Rated Current (A)	Tightening Torque (Kgf.cm)										
				0.5	1	1.5	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9										10	11	12	13	15	18	20	25	30	
M 1x0.25	—	SMTSO	M1	0.5	1	1.5	2	2.5	3																		0.5	0.48	2.41	3.66	—	3.18	2.5	4.19	15	0.3		
M1.2x0.25	—	SMTSO	M1.2	0.5	1	1.5	2	2.5	3																		0.5	0.48	2.41	3.66	—	3.18	2.5	4.19	15	0.6		
M1.4x0.3	—	SMTSO	M1.4	0.5	1	1.5	2	2.5	3																		0.5	0.48	2.41	3.66	—	3.18	2.5	4.19	15	1		
M1.6x0.35	—	SMTSO	M1.6	0.5	1	1.5	2	2.5	3																		0.5	0.48	2.41	3.66	—	3.18	2.5	4.19	15	1.5		
M2x0.4	—	SMTSO	M2	0.5	1	1.5	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10	11	12	13	15	18	20	25	30	1.53	1.53	3.6	—	5.56	—	3.73	6.2	30	1.5
M2.5x0.45	—	SMTSO	M2.5	—	1	1.5	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10	11	12	13	15	18	20	25	30	1.53	1.53	4.09	—	5.56	—	4.22	6.2	30	3
M3x0.5	—	SMTSO	M3	—	1	1.5	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10	11	12	13	15	18	20	25	30	1.53	1.53	4.09	—	5.56	—	4.22	6.2	30	5
M3.5x0.6	—	SMTSO	M3.5	—	—	—	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10	11	12	13	15	18	20	25	30	1.53	1.53	5.28	—	7.14	—	5.41	7.77	40	6
M4x0.7	—	SMTSO	M4	—	—	—	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10	11	12	13	15	18	20	25	30	1.53	1.53	6.22	—	8.74	—	6.35	9.37	50	8
—	3.2	SMTSO	K	—	1	1.5	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10								1.53	1.53	4.09	—	5.56	—	4.22	6.2	20	—	
—	3.6	SMTSO	L	—	—	—	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10								1.53	1.53	5.28	—	7.14	—	5.41	7.77	30	—	
—	4.2	SMTSO	M	—	—	—	2	2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	8	9	10								1.53	1.53	6.22	—	8.74	—	6.35	9.37	40	—	

*更多"L"尺寸未列在表中, 请略我们确认! MORE "L" SIZES ARE NOT LISTED IN THE TABLE, PLEASE CONTACT US FOR CONFIRMATION

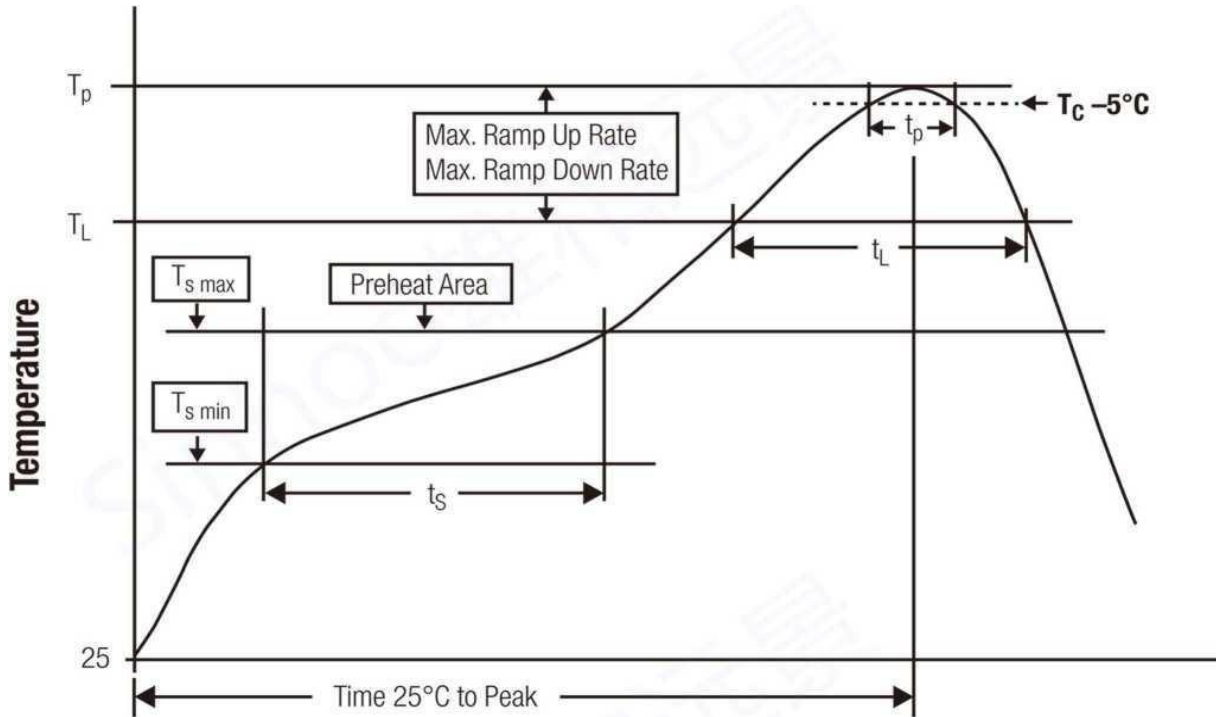
Thread sizes 0, S1, S1.2, S1.4 and M1.6

Thread/thru hole sizes M2, M.5, M3, M3.5, M4, 3.6, 4.2

2, 4, 6, 8, 116 and 143

All dimensions are in inches.

Thread Size	Thru Hole +.004 -.003	Type	Thread or Thru Hole Code	Length Code "H"±.005 (Length code in 32nds of an inch)									Min. Sheet Thickness	A Max.	C Max.	R		L Nom.	OH Hole Size In Sheet +.003-.000	OD Min. Solder Pad	Rated Current (A)	Tightening Torque (Kgf.cm)
				.062	.125	.187	.250	.312	.375	.437	.500	.562				.625	Ref.					
.060-80 (#0-80)	—	SMTSO	0	.062	.125	—	—	—	—	.020	.019	.095	.144	—	.125	.098	.165	15	1.5			
.086-56 (#2-56)	—	SMTSO	2	.062	.125	.187	.250	.312	.375	.060	.060	.142	—	.219	—	.147	.244	30	1.5			
.112-40 (#4-40)	—	SMTSO	4	.062	.125	.187	.250	.312	.375	.060	.060	.161	—	.219	—	.166	.244	30	5			
.060-80 (#6-32)	—	SMTSO	6	.062	.125	.187	.250	.312	.375	.060	.060	.208	—	.281	—	.213	.306	40	6			
.164-32 (#8-32)	—	SMTSO	8	.062	.125	.187	.250	.312	.375	.060	.060	.245	—	.344	—	.250	.369	50	8			
—	.116	SMTSO	9	.062	.125	.187	.250	.312	.375	.060	.060	.161	—	.219	—	.166	.244	30	—			
—	.143	SMTSO	10	.062	.125	.187	.250	.312	.375	.060	.060	.208	—	.281	—	.213	.306	40	—			



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 ³ <350	Volume mm ³ 350-2000	Volume mm ³ >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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