

## SOLDERING CONDITIONS

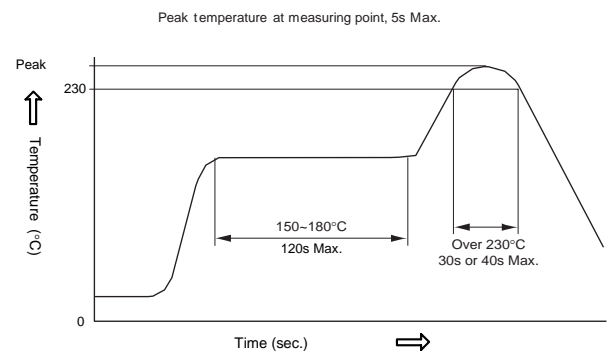
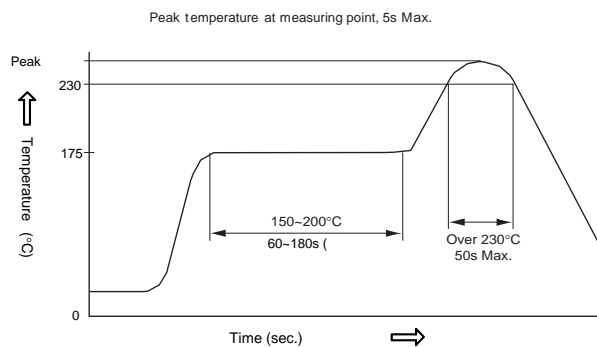
For Chip Type Conductive Polymer Aluminum Solid Electrolytic Capacitors & Chip Type Conductive Polymer Hybrid Aluminum Electrolytic Capacitors

### Recommended Conditions for Reflow Soldering

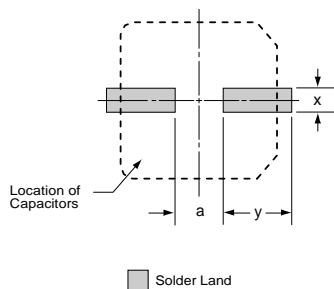
- Conductive Polymer Aluminum Solid Electrolytic Capacitors
  - (1) Preheating shall be done at +150°C to 200°C and for 60 to 180 seconds.
  - (2) The duration for over +230°C temperature at capacitor surface shall not exceed 60 seconds.
  - (3) The standard temperature profile differs by every reflow method.
  - (4) Peak temperature +260°C or below: Reflow shall be done 1 cycle only.
  - (5) Peak temperature +250°C or below: Reflow shall be done within 2 cycles.
  - (6) Please make sure that the parts have enough cooling time between the first and second soldering process.
  - (7) The temperature at capacitor top shall not exceed the peak temperature.
  - (8) Please contact us if your condition is over the maximum.
- Conductive Polymer Hybrid Aluminum Electrolytic Capacitors
  - (1) Preheating shall be done at +150°C to 180°C and for 120 seconds.
  - (2) Peak temperature +260°C or below: Reflow shall be done 1 cycle only.
  - (3) Peak temperature +250°C or below: Reflow shall be done within 2 cycles.
  - (4) Please make sure that the parts have enough cooling time between the first and second soldering process.
  - (5) Please contact us if your condition is over the maximum.

### Classification Reflow Profile

- Conductive Polymer Aluminum Solid Electrolytic Capacitors
- Conductive Polymer Hybrid Aluminum Electrolytic Capacitors



### Recommended Solder Land Size on PC Board (Unit: mm)



Size	a	y	x
Ø4	1.0	2.6	1.6
Ø5	1.4	3.0	1.6
Ø6.3	2.1	3.5	1.6
Ø8 × 6.7~9	2.1	4.0	1.6
Ø8 × 10~12	3.0	3.5	2.5
Ø10	4.0	4.0	2.5