

Lead-free compliant

Package: Metal housing for height fixing

Reference

Soldering should be proceeded within temperature and time shown below.

Parameter	Symbol	Rating	Unit
Soldering Temperature	Tsol	260(Soldering time: 5 s)	°C

This table excerpted from absolute maximum ratings table in specification sheet.

Regarding for soldering

- In case that this product is kept in high humidity condition, it may be hard to solder, please be careful enough about storage method. Depend on the flux you select, there are different solderabilities, so please select a suitable flux and use it.
- Please don't do soldering this product by reflow.

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Package: Resin package for through hole
(Resinous housing)

Reference

Soldering should be proceeded within temperature and time shown below.

Parameter	Symbol	Rating	Unit
Soldering Temperature	Tsol	260(Soldering time: 5 s)	°C

This table excerpted from absolute maximum ratings table in specification sheet.

Soldering

- In case that this product is kept in high humidity condition, it may be hard to solder, please be careful enough about storage method. Depend on the flux you select, there are different solderabilities, so please select a suitable flux and use it.
- Please don't do soldering this product by reflow.
- Please make sure in case of hand soldering that you use the solder iron with less than 45W power and the solder iron point (edge) temperature is less than 320°C within 3 seconds, and also don't add any force to lead frame directly. And please make sure never to touch 2nd mold resin by a soldering.

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Package: Metal housing for through hole

Reference

Soldering should be proceeded within temperature and time shown below.

Parameter	Symbol	Rating	Unit
Soldering Temperature	Tsol	260(Soldering time: 5 s)	°C

This table excerpted from absolute maximum ratings table in specification sheet.

Soldering

- In case that this product is kept in high humidity condition, it may be hard to solder, please be careful enough about storage method. Depend on the flux you select, there are different solderabilities, so please select a suitable flux and use it.
- Please don't do soldering this product by reflow.
- Please make sure in case of hand soldering that you use the solder iron with less than 45W power and the solder iron point (edge) temperature is less than 320°C within 3 seconds, and also don't add any force to lead frame directly.
- Please make sure also you check the mountability prior to the process since the solder portion between the case and the lead frame may be detached due to the heat when soldering.

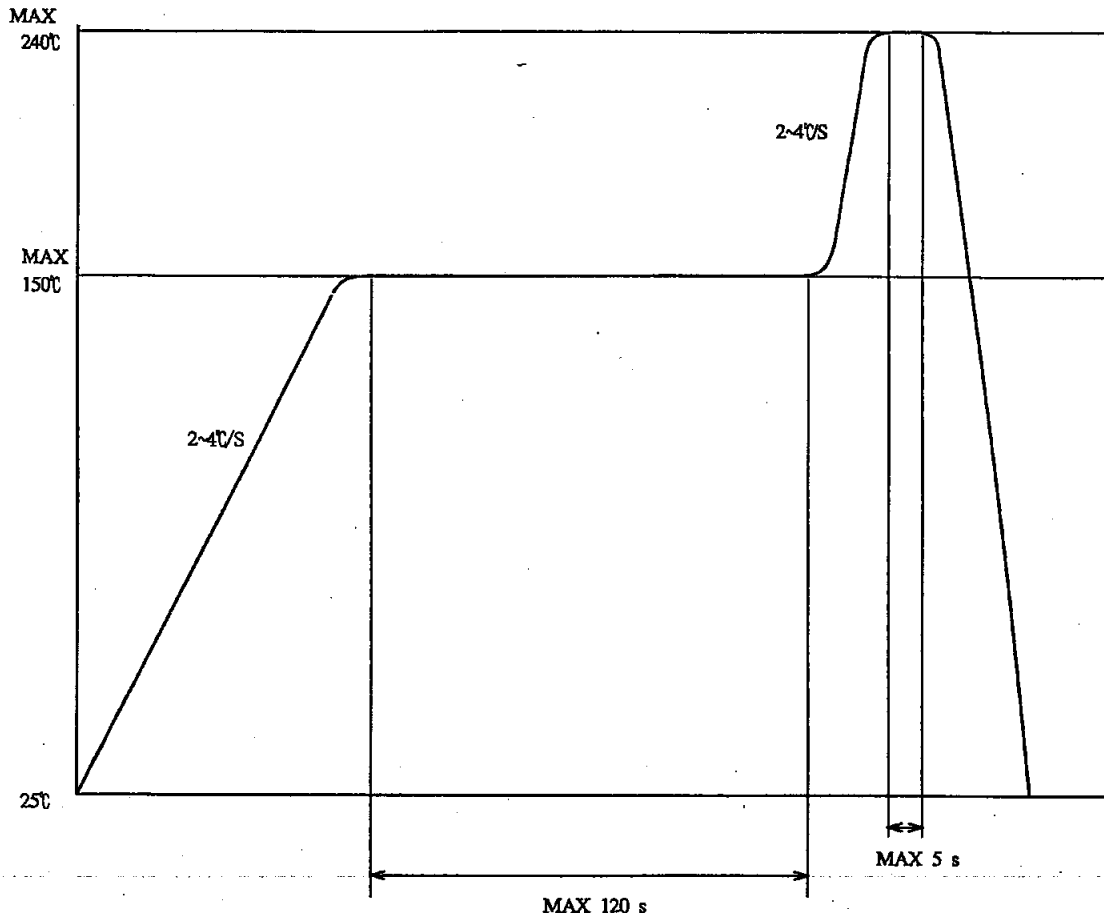
Lead-free compliant

Package: Metal housing SMD

Reference

1. In case of solder reflow

Please do only one soldering at the temperature and the time within the temperature profile as shown in the figure.



2. Other precautions

An infrared lamp used to heat up for soldering may cause a localized temperature rise in the resin. Also avoid immersing the resin part in the soldering. Even if within the temperature profile above, there is the possibility that the gold wire in package is broken in case that the deformation of PCB gives the affection to lead pins. Please use after confirmation the conditions fully actual solder reflow machine.

3. Hand soldering

- Soldering iron shall be less than 25W, and temperature of point soldering iron shall use at less than 260°C.
- Soldering time shall be within 5s.
- Soldered product shall treat at normal temperature.
- Solder : 6/4 solder or included Ag solder.