



## SMD LED CAUTIONS

### (1) Moisture Proof Package

- When moisture is absorbed into the SMT package it may vaporize and expand during soldering. There is a possibility that this can cause exfoliation of the contacts and damage to the optical characteristics of the LEDs. For this reason, the moisture proof package is used to keep moisture to a minimum in the package.
- The moisture proof package is made of an aluminum moisture proof bag. A package of a moisture absorbent material (silica gel) is inserted into the aluminum moisture proof bag. The silica gel changes its color from blue to pink as it absorbs moisture.

### (2) Storage

#### · Storage Conditions

Before opening the package:

The LEDs should be kept at 30°C or less and 60%RH or less. The LEDs should be used within a year. When storing the LEDs, moisture proof packaging with absorbent material (silica gel) is recommended.

After opening the package:

Soldering should be done right after opening the package (within 24hrs).

Keeping of a fraction,

-Sealing

-Temperature :5~30°C Humidity :Less than 30%.

If the package has been opened more than 24 hours, components should be dried for 12hrs, at 60±5

°C .

- Optosupply LED electrode sections are comprised of a silver plated copper alloy. The silver surface may be affected by environments which contain corrosive gases and so on. Please avoid conditions which may cause the LED to corrode, tarnish or discolor. This corrosion or discoloration may cause difficulty during soldering operations. It is recommended that the User use the LEDs as soon as possible.
- Please avoid rapid transitions in ambient temperature, especially in high humidity environments where condensation can occur.

### (3) Heat Generation

- Thermal design of the end product is of paramount importance. Please consider the heat generation of the LED when making the system design. The coefficient of temperature increase per input electric power is affected by the thermal resistance of the circuit board and density of LED placement on the board, as well as other components. It is necessary to avoid intense heat generation and operate within the maximum ratings given in this specification.
- The operating current should be decided after considering the ambient maximum temperature of LEDs.

#### (4) Soldering Conditions

- The LEDs can be soldered in place using the reflow soldering method and the dip soldering method.
- Recommended soldering conditions

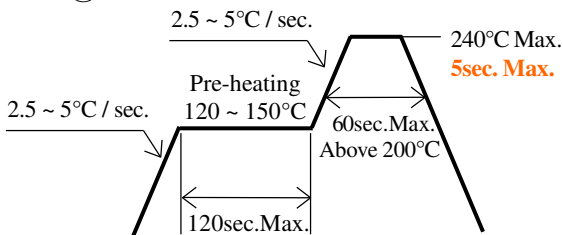
	Reflow Soldering		Dip Soldering	Hand Soldering	
	Lead Solder	Lead-free Solder		Temperature	Soldering time
Pre-heat	120 ~ 150°C	180 ~ 200°C	Pre-heat	100°C Max.	350°C Max.
Pre-heat time	120 sec. Max.	120 sec. Max.	Pre-heat time	60 sec. Max.	3 sec. Max.
Peak temperature	240°C Max.	260°C Max.	Solder bath temperature	260°C Max.	(one time only)
Soldering time	<b>5 sec. Max.</b>	<b>5 sec. Max.</b>	Dipping time	<b>5 sec. Max.</b>	
Condition	refer to Temperature - profile ①.	refer to Temperature - profile ②. (N <sub>2</sub> reflow is recommended.)			

- \* Although the recommended soldering conditions are specified in the above table, reflow, dip or hand soldering at the lowest possible temperature is desirable for the LEDs.
- \* A rapid-rate process is not recommended for cooling the LEDs down from the peak temperature.

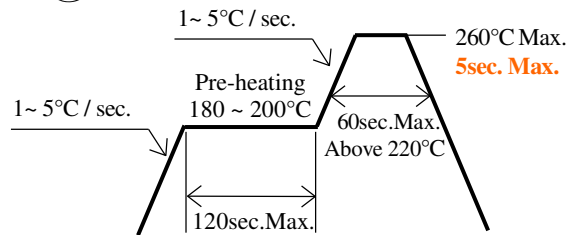
#### [Temperature-profile (Surface of circuit board)]

Use the conditions shown to the under figure.

<① : Lead Solder>

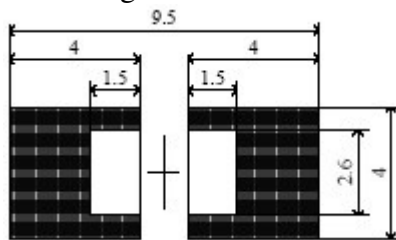


<② : Lead-free Solder>



#### [Recommended soldering pad design]

Use the following conditions shown in the figure.



■ : Solder resist

(Unit : mm)

- Occasionally there is a brightness decrease caused by the influence of heat or ambient atmosphere during air reflow. It is recommended that the User use the nitrogen reflow method.
- Repairing should not be done after the LEDs have been soldered. When repairing is unavoidable, a double-head soldering iron should be used. It should be confirmed beforehand whether the characteristics of the LEDs will or will not be damaged by repairing.
- Reflow soldering should not be done more than two times.
- Dip soldering should not be done more than one time.
- When soldering, do not put stress on the LEDs during heating.
- After soldering, do not warp the circuit board.



#### (5) Cleaning

- It is recommended that isopropyl alcohol be used as a solvent for cleaning the LEDs. When using other solvents, it should be confirmed beforehand whether the solvents will dissolve the package and the resin or not. Freon solvents should not be used to clean the LEDs because of worldwide regulations.
- Do not clean the LEDs by the ultrasonic. When it is absolutely necessary, the influence of ultrasonic cleaning on the LEDs depends on factors such as ultrasonic power and the assembled condition. Before cleaning, a pre-test should be done to confirm whether any damage to the LEDs will occur.

#### (6) Static Electricity

- Static electricity or surge voltage damages the LEDs.  
It is recommended that a wrist band or an anti-electrostatic glove be used when handling the LEDs.
- All devices, equipment and machinery must be properly grounded.  
It is recommended that measures be taken against surge voltage to the equipment that mounts the LEDs.
- When inspecting the final products in which LEDs were assembled, it is recommended to check whether the assembled LEDs are damaged by static electricity or not. It is easy to find static-damaged LEDs by a light-on test or a VF test at a lower current (below 1mA is recommended).
- Damaged LEDs will show some unusual characteristics such as the forward voltage becomes lower, or the LEDs do not light at the low current.

Criteria : (VF > 2.0V at IF=0.5mA)

#### (7) Others

- The LED complies with RoHS Directive.
- The LED light output is strong enough to injure human eyes. Precautions must be taken to prevent looking directly at the LEDs with unaided eyes for more than a few seconds.
- Flashing lights have been known to cause discomfort in people; you can prevent this by taking precautions during use. Also, people should be cautious when using equipment that has had LEDs incorporated into it.
- The LEDs described in this brochure are intended to be used for ordinary electronic equipment (such as office equipment, communications equipment, measurement instruments and household appliances). Consult Optosupply's sales staff in advance for information on the applications in which exceptional quality and reliability are required, particularly when the failure or malfunction of the LEDs may directly jeopardize life or health (such as for airplanes, aerospace, submersible repeaters, nuclear reactor control systems, automobiles, traffic control equipment, life support systems and safety devices).
- User shall not reverse engineer by disassembling or analysis of the LEDs without having prior written consent from Optosupply. When defective LEDs are found, the User shall inform Optosupply directly before disassembling or analysis.
- The formal specifications must be exchanged and signed by both parties before large volume purchase begins.
- The appearance and specifications of the product may be modified for improvement without notice.