

Part Number	LSUC PCB Type cell
Date	211208

Technical Guideline

Soldering Guideline

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■ GENERAL INFORMATION

Depending on the types and the size of wiring boards, excessive heat stress may result in deterioration of the electrical characteristics of capacitors such as loss of air-tightness or electrolyte leakage due to the increase of internal pressure.

■ FORWARD

1. Hand soldering : Use the general reference table below to set proper soldering temperature and time

Temperature (°C)	Maximum Exposure Time (sec)
360	3

2. Wave soldering : Use the below table for recommended temperature and time

Temperature (°C)	Exposure Time (SEC)
220	7
240	7
250	5
260	3

For single-sided circuit boards 1.6 mm or more, the recommended temperature is within 260°C, the duration shorter than 5 seconds.

3. Using equipment : When using equipment such as a UV curing oven for pre-heating and adhesive hardening, the recommended temperature is below 150°C. If not, it may cause the sleeve to crack or the product life to be shortened

■ ACTION TO BE AVOIDED

Do not directly contact the body, the sleeve, or the circuit board of the capacitor with the soldering iron