



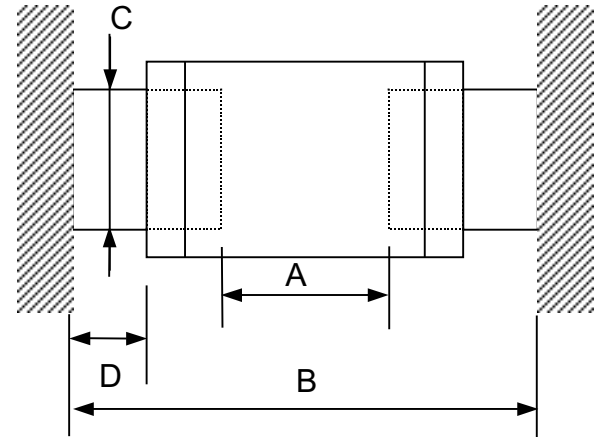
SMD Transient Voltage Suppressors

RECOMMENDATION FOR SOLDERING

Recommended Solder Pad Layout

(Unit: mm)

Type	Solder pad layout			
	A	B	C	D
0402	0.4~0.6	1.6~1.8	0.5~0.52	0.2~0.4
0603	0.8~1.2	2.5~3.0	0.6~1.0	0.3~0.6
0805	1.0~1.5	3.2~3.8	1.2~1.4	0.3~0.6
1206	1.8~2.5	4.2~5.8	1.2~1.6	0.4~0.8
1210	1.8~2.5	4.2~5.8	1.8~2.5	0.5~1.0
1812	2.5~3.5	5.5~6.1	2.3~3.2	0.6~1.1
2220	3.5~4.6	6.0~7.2	4.8~5.5	1.2~2.3

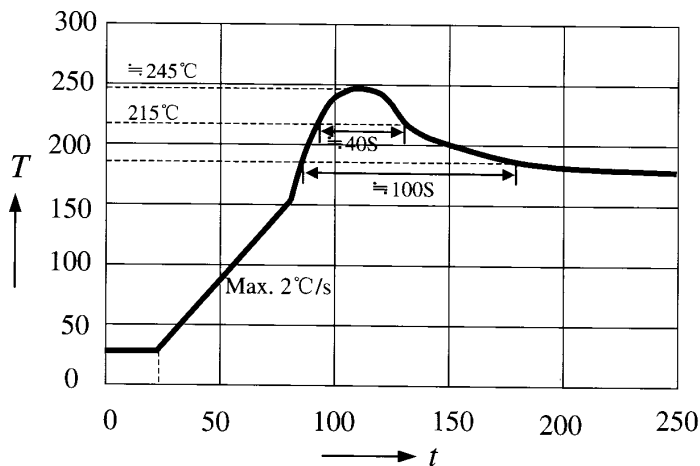


Recommended Soldering Material

Material	62/36/2 Sn/Pb/Ag or equivalent
Temperature	260°C, 5 seconds max
Flux	Non Activated.

Recommended soldering temperature profile

1. Vapor Phase Solder Profile



T = Temperature t = time seconds

Vapor Phase Soldering has the second highest heat transfer rate so care must be taken. It is needed that preheating the assembly and minimizing the dwell time above the solder liquidus temperature to avoid defects.