

## **SOLDERING GUIDANCE (VPC Series)**

## 1. Manual Soldering

### 1) Operating Condition

- Soldering type: Sn-3Ag-0.5Cu
- Soldering temperature:  $390\pm 5^{\circ}\text{C}$
- Soldering time: 3sec.
- VEL should be soldered at the lead wire position 1mm away from the cell body under the above conditions.

### 2) Cautions

- If the soldering temperature is higher or the soldering time is longer than operating condition, the specification of products may be worse or swollen.
- If the soldering temperature is higher or the soldering time is longer than the operating condition, the sleeve may be crushed, cracked or melted.
- Soldering process should be done after connecting PCB and products.
- The products must be covered by sleeve when connecting the products to the PCB.
- Do not immerse the products in molted lead
- Molten lead in soldering process must only contact the terminals of the product.

**\* Wave Soldering and Reflow soldering is forbidden.**

## 2. It is recommended to connect and use harness connector.

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