

# SPECIFICATION



Mass Product



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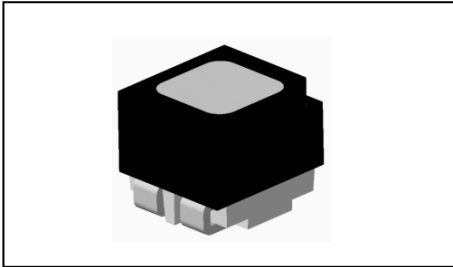


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# 1. Description

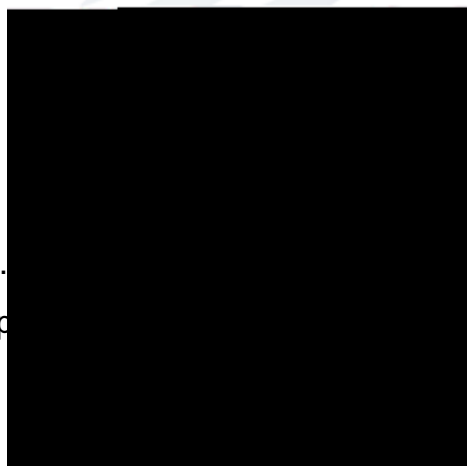
## 1.1 General Description



The product is a full-color LED device, Common anode RGB SMD, High contrast (Surface brush ink technology),The product size: 2.05mmX2.15mmX1.9mm.

LED

2.05mmX2.15mmX1.9mm



( )

## 1.2 Features

Extremely wide viewing angle.

High luminous Intensity, Low power consumption and Long life.

Water-resistant (IPX6).

Moisture sensitivity level: 5a. :5a

RoHS compliant. RoHS

Matte surface.

Pb-free reflow soldering application.

## 1.3 Application

Outdoor full-color video screen.

Indoor and outdoor decorative lighting.

Amusement.

General use.



## 1.4 Package Dimension

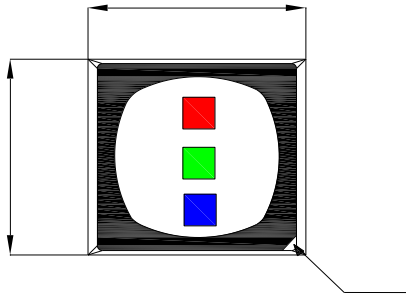


Fig.1-1 Top view

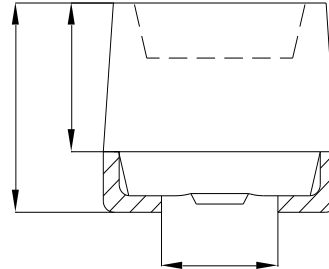


Fig.1-2 Side view

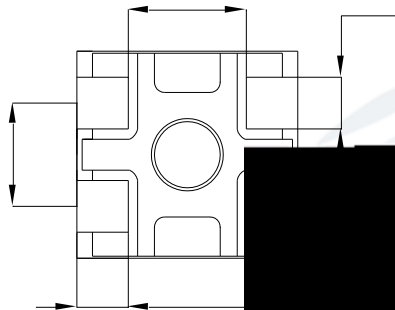


Fig.1-3 Bottom view

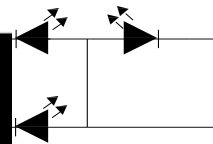


Fig.1-4 Polarity

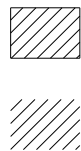


Fig.1-5 Soldering patterns

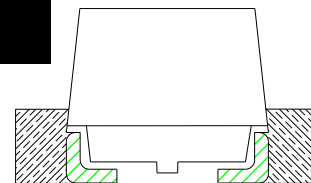
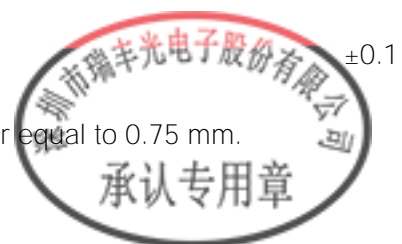


Fig.1-6 Glue filling

### Notes

1. All dimensions units are millimeters.
2. All dimensions tolerances are  $\pm 0.1$ mm unless otherwise noted.
3. Recommendation for glue filling: filling height must be higher than or equal to 0.75 mm.

0.75 mm





Notes

1. The above forward voltage measurement allowance tolerance is  $\pm 0.1V$ .  $\pm 0.1V$
2. The above Tolerance of measurement of dominant wavelength  $\pm 1nm$ .  $\pm 1nm$
3. The above luminous intensity measurement allowance tolerance  $\pm 10\%$ .  $\pm 10\%$
4. G[Tm0 g0 G[Tm0 g1027.91 655.66 Tm0 g0 G6 Tf g10h0.00003C2 0 55dsurem)-7(0.0b(y)-10( 55dsurak-5(erID 19(al



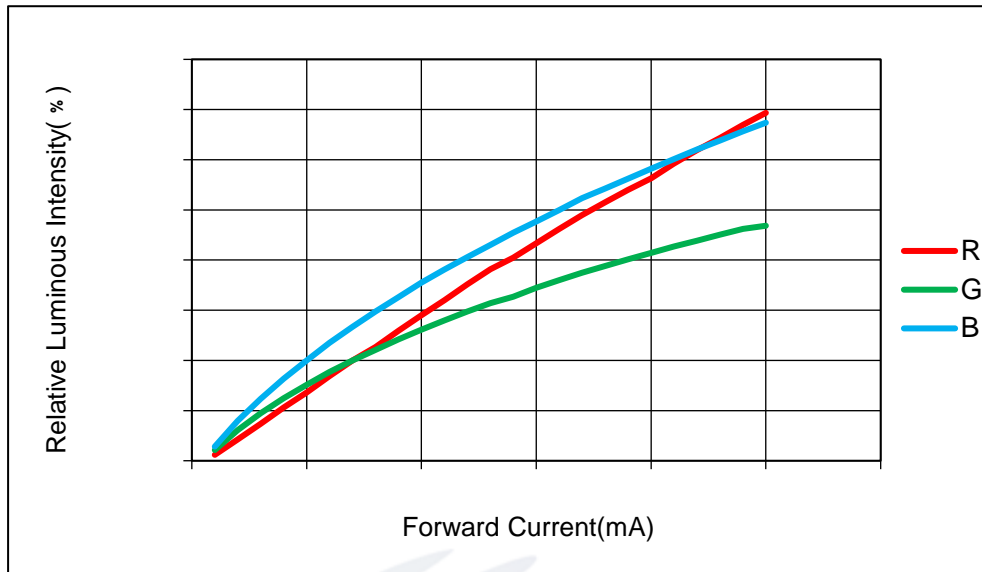


Fig 1-7 Forward

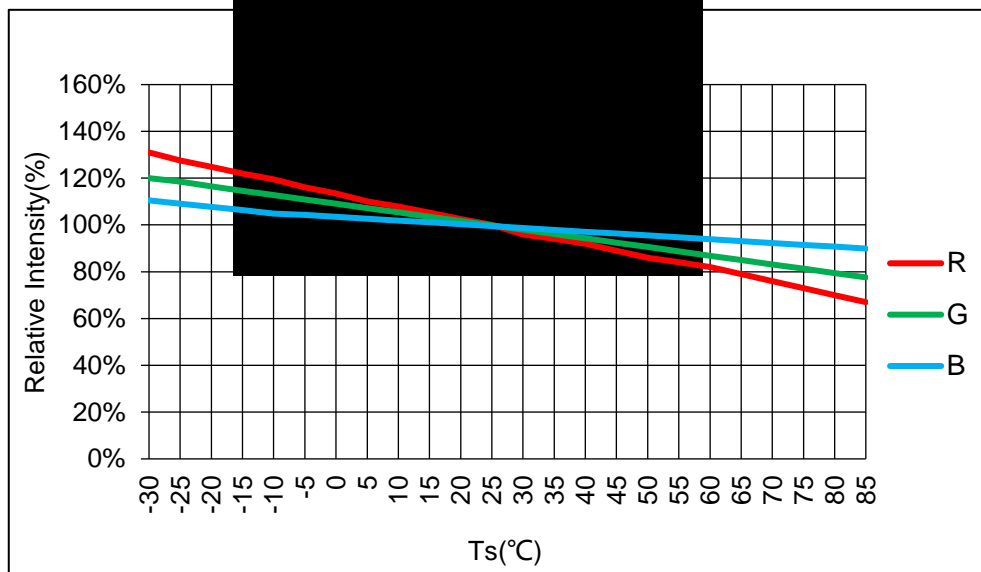


Fig 1-8 Luminous Intensity VS Ambient Temperature





Fig 1-9 Solder Te

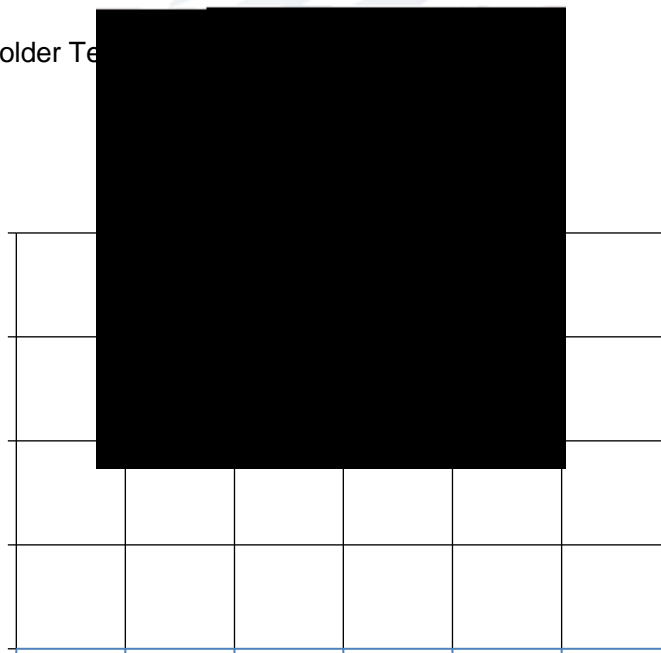
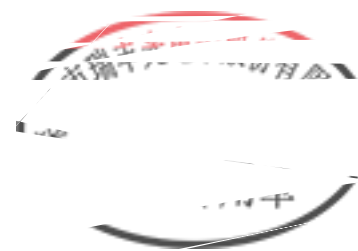


Fig 1-10 Spectrum Distribution



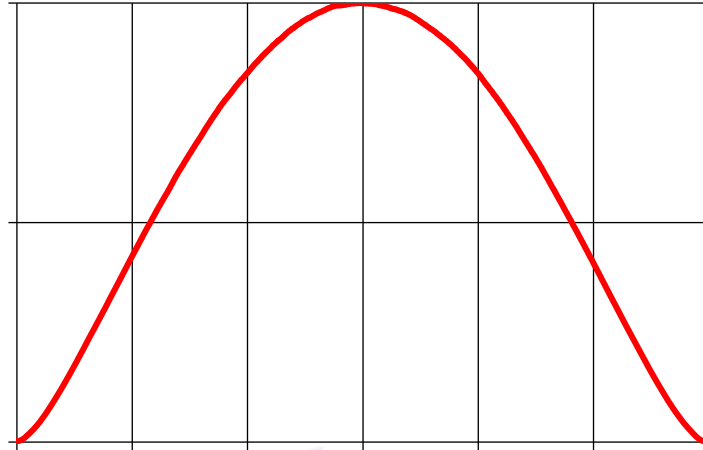
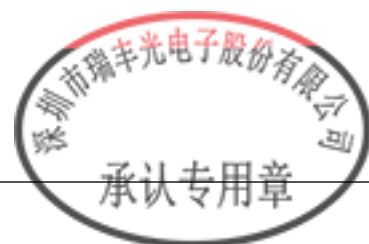


Fig 1-11



Fig 1-12 Directivity Y-Y radiation angle Y

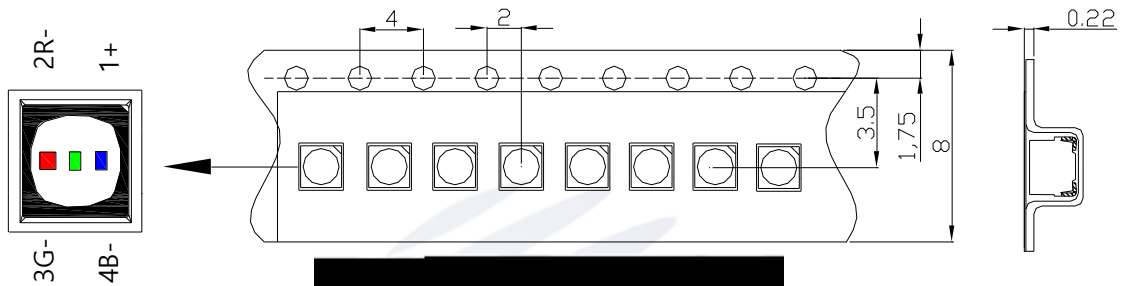


## 2. Packaging

### 2.1 Packaging Specification

Package:13000pcs/reel. 13000pcs

#### 2.1.1 Carrier Tape Dimension



#### 2.1.2 Reel Dimension

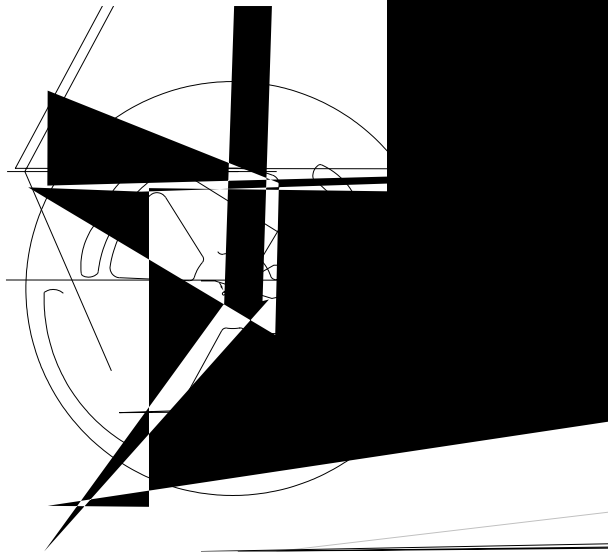


Fig.2-2 Reel

Table 2-1 Dimension

A	400±2mm
B	100.0±0.4mm
C	14.3±0.3mm
D	2.6±0.2mm
E	12.4±0.3mm
F	8.6 0.2/-0.3 mm
T	1.9±0.2mm

#### Notes

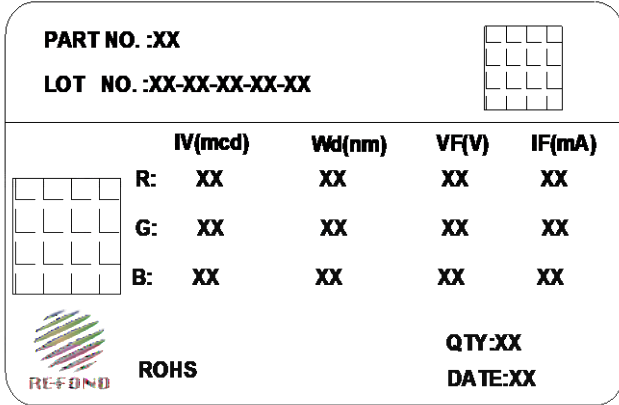
The tolerances unless mentioned ±0.1mm. Unit : mm

±0.1



### 2.1.3 Label Form Specification

Table 2-2 Description



PART NO.	Part Number
LOT NO.	Lot Number + Packing Machine No. + Serial Number +BIN No. + Quantity (K)
	+ + +BIN + K
IV	Light intensity
VF	Forward Voltage
Wd	Wavelength
IF	Forward current
QTY	Packing Quantity
DATE	Made Date

Fig 2-3 Label

### 2.2 Moisture Resistant Pack

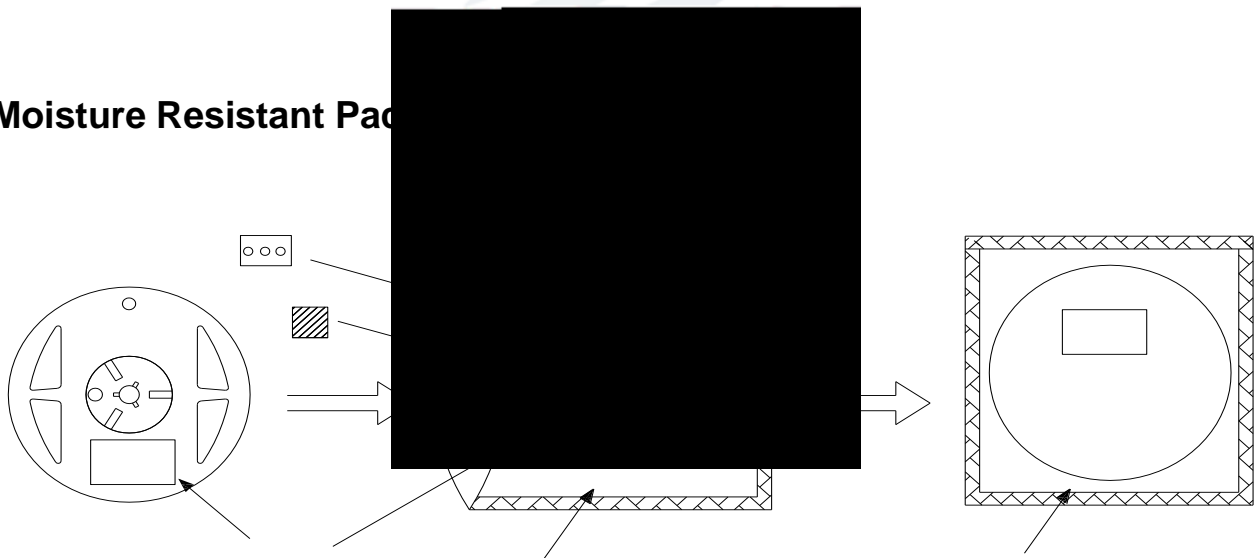


Fig.2-4 Pack



### 2.3 Cardboard Box

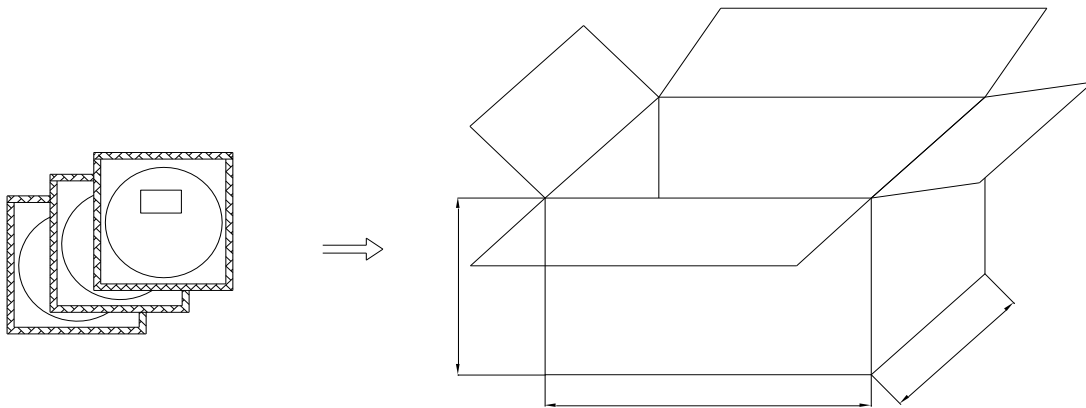
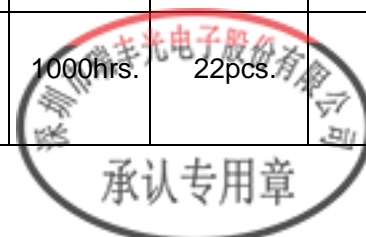


Fig.2-5 Box

### 2.4 Reliability Test Items And Quantity

Table

Test Items	Ref.Standard	Test Condition	Time	Quantity	Ac/Re /
Resistance to Soldering Heat	JEDEC		3times	22pcs.	0/1
Thermal Shock	JEITAED-4701 300 307	10s 100 15min	500cycle	22pcs.	0/1
Moisture Resistance	IPC/JEDEC J-STD-020D.1	1. Moisture Absorption Ta=85 / RH=85%/12HR 2. Tsol=250 , T=10s Reflow Soldering	3times	22pcs.	0/1
High Temperature Storage	JEITAED-4701 200 201	Temp:100	1000hrs.	22pcs.	0/1



Low Temperature Storage	JEITA ED-4701 200 202	Temp:-40	1000hrs.	22pcs.	0/1
Room Temperature Operating Life	JESD22-A108	T <sub>A</sub> =25 I <sub>F</sub> =10mA	1000hrs.	22pcs.	0/1
High Temperature High Humidity Life Test	JESD22-A101	85 / 85%RH I <sub>F</sub> =5mA	500hrs.	22pcs.	0/1
Temperature Humidity Storage	JEITA ED-4701 100 103	T <sub>A</sub> =85 R <sub>H</sub> =85%	1000hrs.	22pcs.	0/1
Low Temperature Life Test	JES		1000hrs.	22pcs.	0/1

## 2.5 Criteria For Judging Data

Test Items	Symbol
------------	--------

Notes

1. The Reliability tests are based on Refond existing test platform.
2. The above reliability tests is based on the verification of a single/strip LED of Refond's existing experimental platform, the reliability experiment was taken under good heat dissipation conditions. when customers applies the LED to the series and parallel circuit, should take consideration of all the factors such as the current, voltage distribution, heat dissipation and others.

LED

/ LED

### 3. SMT Reflow Soldering Instructions SMT

#### 3.1 SMT Reflow Soldering

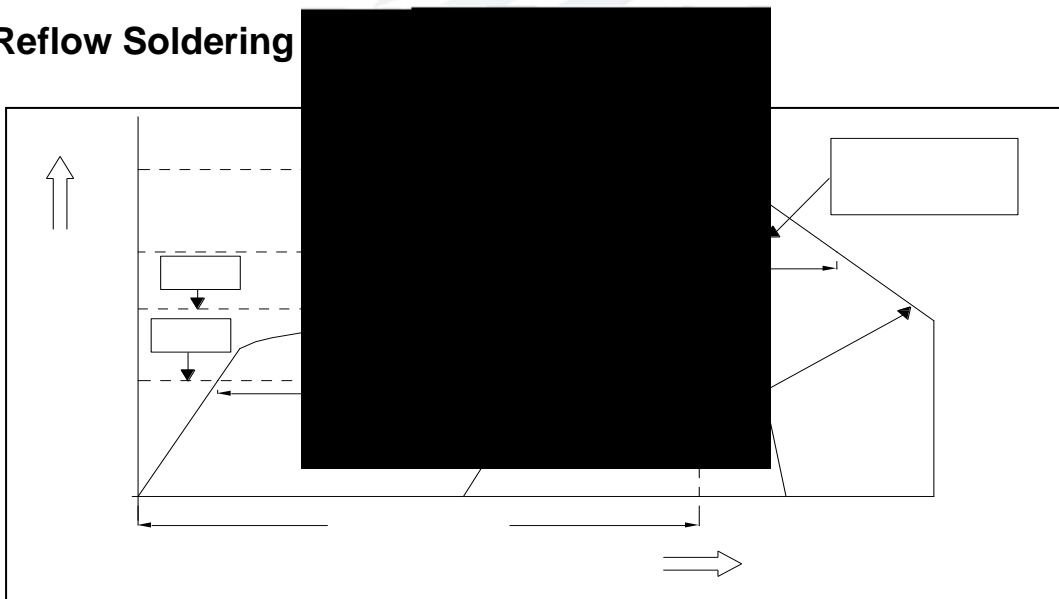


Fig.3-1 Profile

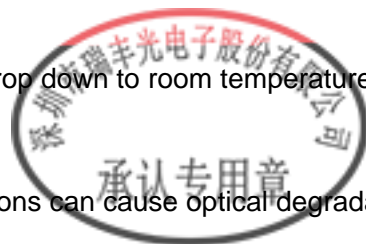


Table 3-1 Description

Average temperature rise speed	$T_{smax}$ $T_P$	Max 4 °C/ s	4 °C/
Preheating: minimum temperature	( $T_{smin}$ )	150 °C	
Preheating: Max temperature	( $T_{smax}$ )	200 °C	
Preheating: Time	$T_{smin}$ $T_{smax}$	60s-120s	60 - 120
Time limited to maintain high temperature: the temperature	( $T_L$ )	217 °C	
Time limited to maintain high temperature: The Time	( $t_L$ )	Max 60s	60
Peak /Classification of temperature:	( $T_P$ )	245 °C	
Time limit classification of peak temperature		Max 10s	10
Hold time within 5 °C with the temperature	( $T_P$ )	Max 30s	30
Cooling speed		Max 6 °C/ s	6 °C/
Needed time from 25 °C to 25 °C		Max 8 minutes	8

Notes

- 1.Reflow soldering should not be done more than one times.
- 2.It is recommended that use the middle temperature solder paste.
- 3.Stress on the LEDS should be avoided during heating in soldering process. LED
- 4.After soldering ,do not deal with the product before its temperature drop down to room temperature.
5. Nitrogen reflow soldering is recommended. Air flow soldering conditions can cause optical degradation,





caused by heat or atmosphere.

6. This product can differ in optical characteristics depending on the number of reflow cycles. In a single display, only LEDs with same number of reflow cycles should be used regardless of the application type, such as rental and/or permanent installations.

LED.

7. This LED is designed to be reflow soldered on to a PCB. If dip soldered, cannot guarantee its reliability.

LED PCB

### 3.1.1 Soldering Iron

(1) When hand soldering, keep the temperature of iron below less 300 less than 3 seconds

300 3

(2) The hand solder should be done



### 3.1.2 Repairing

Repair should not be done after... when repairing is unavoidable, a double-head soldering iron should... should be confirmed in advance whether the characteristics of LED... repairing.

LED

LED

### 3.1.3 Cleaning

The LEDs should not be cleaned with water, benzene, and/or thinner. ...  
 ...  
 ...  
 ...  
 ...

/ led

LED "CI" "S"



## 4.Handling Precautions

### 4.1Handling Precautions

#### 4.1.1 Storage

(1) Moisture proof and anti-electrostatic package with moisture absorbent material is used, Suggest storage time is less than 6 months.

(2) Storage condition: temperature  $\leq 30^{\circ}\text{C}$ , humidity  $\leq 60\% \text{ RH}$ .

(3) Before opening the package, please check the package for air leaks, if there exists any air leaks, please return the product to the manufacturer for dehumidification by baking before your second use.

(4) After the package is opened, please store in the specified environment of temperature below  $30^{\circ}\text{C}$ /humidity below  $60\% \text{ RH}$  within 12HR. Unused material must be stored in the environment of temperature below  $30^{\circ}\text{C}$  and humidity below  $10\% \text{ RH}$ , These surplus products should be baked

12 hours at  $65 \pm 5^{\circ}\text{C}$  /24H

(5) Before SMT, LEDs need to be baked , baking requirement as below :



## Customer pre-treatment conditions before use

Condition before use	undamped	Production	undamped	Production
	date	2 months	date	2-6 months
		2		2-6

### 4.1.2 Static Electricity

Static electricity and surge voltage damage the LEDs. Damaged LEDs will show some unusual characteristics such as the forward voltage becomes lower, or the LEDs do not light at the low current and even not light. All devices, equipment and machinery must be properly grounded. At the same time, it is also recommended to use anti-static bands, pads, uniforms, gloves or containers can be used as effective protection for the LEDs.

### 4.1.3 Reverse voltage protection

In generally the reverse current of LED is very small, it can't effect using the component normally, but when it often suffered the reverse voltage which exceed the limits of the component than it will be damaged, the reverse current increases rapidly causing the string light display gray scale so when designing, please pay attention to control the reverse voltage we suggest the reverse voltage less than 5V.

LED , , .  
 ,LED , , .  
 , LED 5V.

#### 4.1.4 The safe temperature for LEDs working

(1) Luminous Intensity decreased radically, if LEDs worked in hot environment for a long time, they will be disabled easily. When LEDs are working in surface temperature should be lower than 55 and the temperature should be lower than 75 .

LED , , , , , .  
55 , 75 .

(2) Proper thermal management is an important when designing products with LEDs. LED die temperature is affected by PCB thermal resistance and LED spacing on the board. Please design products in a way that the LED die temperature does not exceed the maximum junction temperature (T<sub>J</sub>).

(3) Drive current should be determined by ambient temperature (T<sub>A</sub>) to dissipate the heat from the product.

#### 4.1.5 Directions for Use

(1) During designing a circuit, the LED chip must not exceed the Absolute Max Rating current specified in the LED

LED

(2) It is recommended that each LED chip is driven by a constant current.

LED

(3) When having the two or more dices within this product at the same time, the total power dissipation for the LED package must be within the max value specified in this specification.

LED

(4) This product should be operated with forward current. Make sure the product is not subjected

continuous reverse voltage because it may cause damage to the LED chip. If the display will not be



used for a long time, the main power should be switched off, Dehumidification is necessary before using the screen again.

### LED

(5) Make sure that the reverse voltage will not exceed the Absolute MaxRating when using the LEDs with matrix drive. Ensure that excessive voltages such as lightning surges are not applied to the LEDs.

### LED

### LED

(6) Aging is recommended in order to detect manufacturing and assembly defects. Particularly, make sure that excessive current and/or voltage is not applied to the LEDs. This aging should be conducted in environments where the following conditions occur.

(7) when the LEDs are used in the following environments, incorporate sufficient measures into the display to prevent debris, water, etc. from entering the display and adversely affect the product.

- where water vapor is abundant

- where water condensation is likely to occur

- where water is likely to splash onto the LEDs

- where frost is likely to form on the surface of the LEDs (e.g. freezer, ice skating rink, etc.)

- where dust, dirt, debris, loose metallic materials and/or gases that will adversely affect the product are present

### LED

-

-

-

### LED

-LED



-

(8) In



(2) Do not handle the LEDs with bare hands as it will contaminate the LED surface and may affect the optical characteristics: it might cause the LED to be deformed and/or the wire to break, which will cause the LED not to illuminate. The lead could also cause an injury.

LED

LED

LED

LED

(3) Do not stack assembled PCBs together. Otherwise, it may cause damage to the resin (e.g. cut,









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Declare

This specification is written both in English and in Chinese and the latter is formal.

