



Data Sheet

Customer:

Part No:

Sample No:

Description:

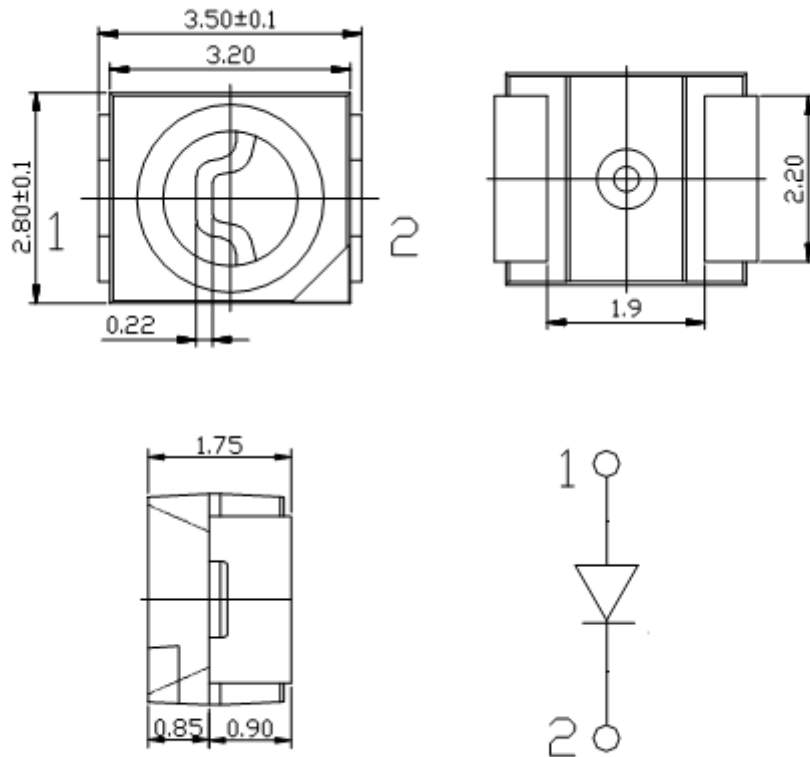
Item No:

CL-SF681USD-650-02

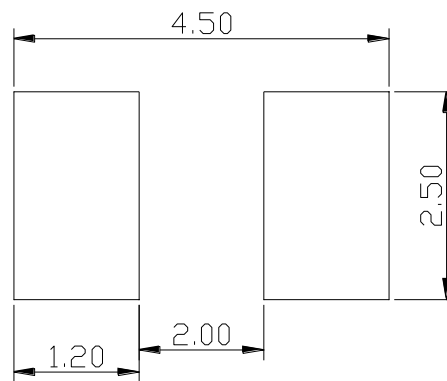
3528 SMD Red Color

Customer			
Check	Inspection	Approval	Date

Package Dimensions



Recommended Soldering Patter (n)

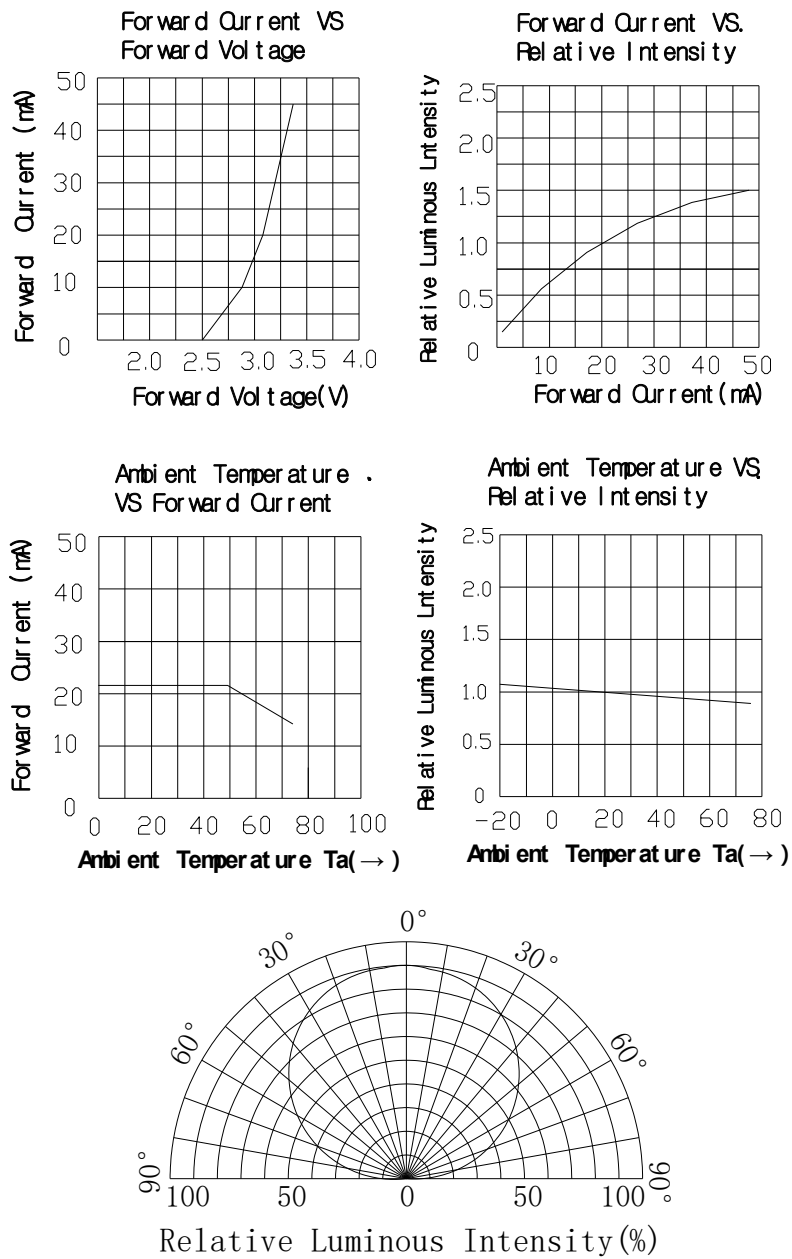


NOTES:

- 1、 All dimensions are in millimeters
- 2、 Tolerances are ± 0.1 mm unless otherwise note.

Absolute maximum ratings								(Ta=25℃)		
Parameter				Symbol		Value		Unit		
Forward current				If		20		mA		
Reverse voltage				Vr		5		V		
Power dissipation				Pd		60		MW		
Operating temperature range				Top		-25~+80		℃		
Storage temperature range				Tstg		-30~+85		℃		
Peak pulsing current（1/8 duty f=1KHz）				Ifp		50		mA		
Junction Temperature				Tj		125		℃		
Electrostatic Discharge(HBM)				ESD		4000		V		
Electro-Optical characteristics								(TA=25℃)		
Parameter		Test Condition	Symbol	Color	Value			Unit		
					Min	Typ	Max			
Color Temperature		IF=20mA	CCT	--	---	--	---	K		
Forward voltage		IF=20mA	Vf	R	1.8	--	2.2	V		
luminous flux		IF=20mA	φ	R	2	--	4	LM		
Viewing angle at 50% IV		IF=20mA	2θ1/2	R	--	120	--	Deg		
Dominant wavelength		IF=20mA	λd	R	640	--	660	nm		
Reverse current		Vr=5V	Ir	R	--	5	--	μA		
Color Rendering Index		IF=20mA	CRI	R	--	--	--	Ra		

Typical photo-electricity characteristic curve chart



Test items and results of reliability

Type	Test item	JY. Standard	Test Conditions	Note	Quantity	Number of Damaged
Environmental Sequence	Temperature Cycle	JIS C 7021 (1977)A-4	-40°C 30min ↑↓5min 120°C 30min	100 cycle	22	0
	Thermal Shock	MIL-SLD-107D	-40°C 15min ↑↓5min 120°C 15min	50 cycle	22	0
	High Humidity Heat Cycle	JIS C 7021 (1977)A-5	30°C ≪=≫ 65°C 90%RH 24hrs/1cycle	10 cycle	22	0
	High Temperature Storage	JIS C 7021 (1977)B-10	T _a =80°C	1000hrs	22	0
	Humidity Heat Storage	JIS C 7021 (1977)B-11	T _a =60°C RH=90%	1000hrs	22	0
	Low Temperature Storage	JIS C 7021 (1977)B-12	T _a =-30°C	1000hrs	22	0
Operation Sequence	Life Test	JIS C 7035 (1985)	T _a =25°C I _F =20mA	1000hrs	22	0
	High Humidity Heat Life Test	*	60°C RH=90% I _F =20mA	500hrs	22	0
	Low Temperature Life Test	*	T _a =-25°C I _F =20mA	1000hrs	22	0

* Refer to reliability test standard specification for in this line.

Criteria For Judging Damage

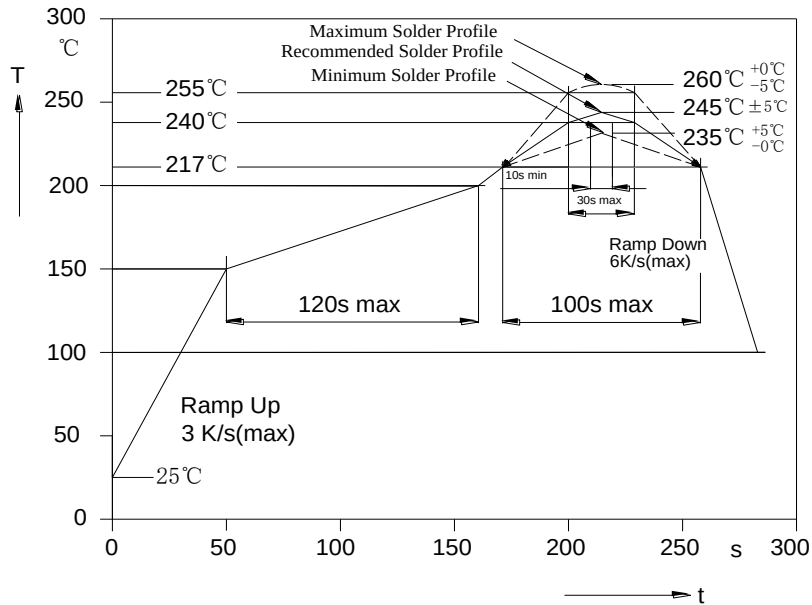
Test Item	Symbol	Test Conditions	Judgement Standard
Forward Voltage	V _F	I _F =I _{FT}	Initial Data±10%
Reverse Current	I _R	V _R =5V	I _R ≤10μA
Luminous Intensity	I _V	I _F =I _{FT}	Average I _V degradation ≦ 30% Single LED I _V degradation ≦ 50%
Resistance to Soldering Heat	--	--	Material without internal cracks, no material between stripped, no dead light.

*The technical information shown in the data sheets are limited to the typical characteristics and circuit examples of the referenced products. It does not constitute the warranting of industrial property nor the granting of any license.

Guideline for Soldering

- 1、 **Reflow Soldering:** Use the conditions shown in the under Figure of Pb-Free Reflow Soldering.

SMD-Reflow Soldering Profile for lead free soldering(Acc.to J-STD-020B)



Remark: If not lead free soldering, the recommended solder profile is 230°C and max solder profile is 245°C.

2、 Hand Soldering

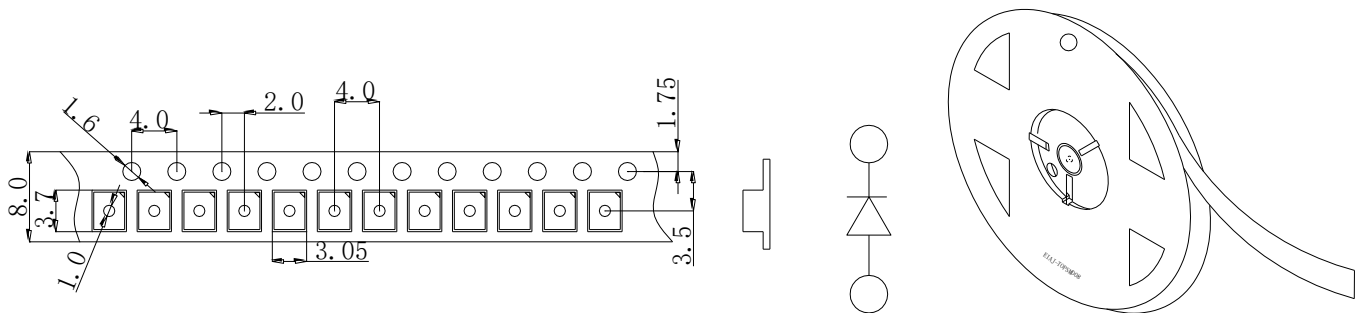
- 1)、 A soldering iron of less than 20W is recommended to be used in Hand Soldering. Please keep the temperature of the soldering iron under 360°C while soldering. Each terminal of the LED is to go for less than 3 seconds and for onetime only.
- 2)、 Be careful because the damage of the product is often started at the time of the hand soldering.

3、 Cleaning

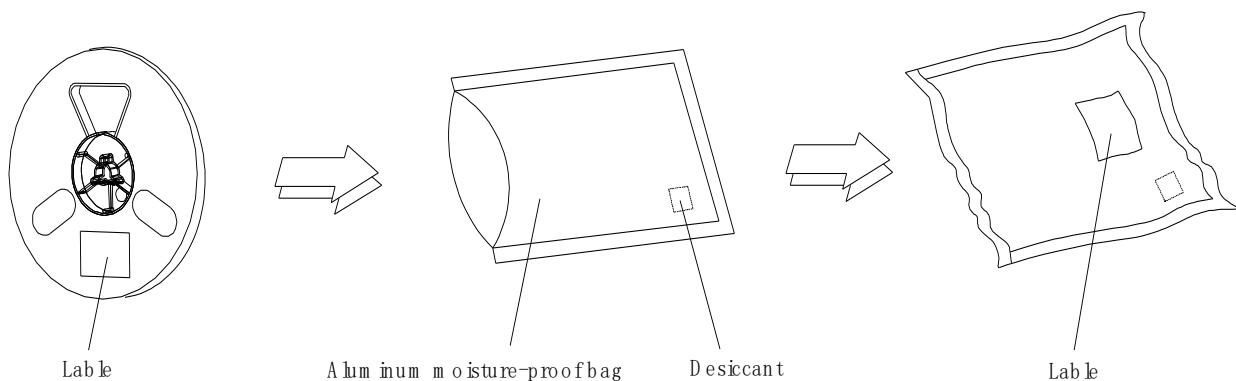
- 1)、 It is recommended that alcohol be used as a solvent for cleaning after soldering. Cleaning is to go under 30°C for 3 minutes or 50°C for 30 seconds. When using other solvents, it should be confirmed beforehand whether the solvents will dissolve the package and the resin or not.
- 2)、 Ultrasonic cleaning is also an effective way for cleaning. But the influence of Ultrasonic cleaning on LED depends on factors such as ultrasonic power. Generally, the ultrasonic power should not be higher than 300W. Before cleaning, a pre-test should be done to confirm whether any damage to LEDs will occur.

Tape and Packaging

1、Tape leader and reel



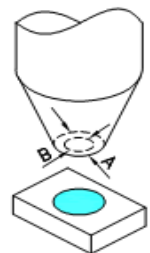
2、Moisture Resistant Packaging



3、Cautions

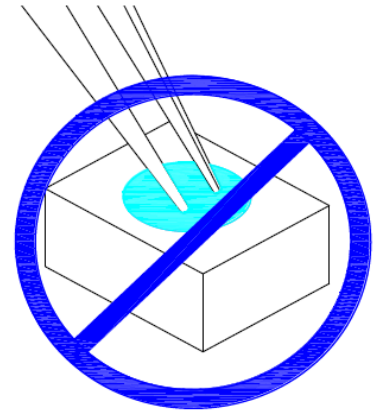
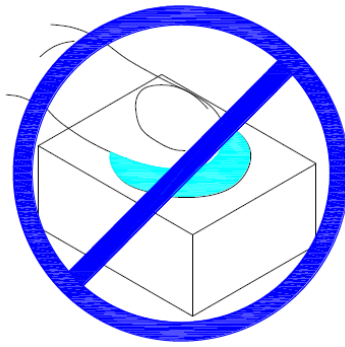
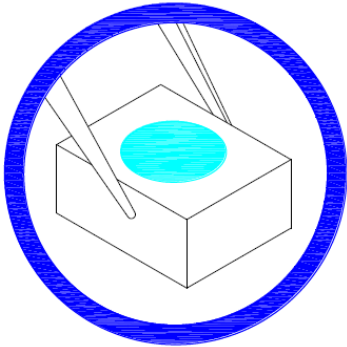
1)、The encapsulated material of the LEDs is silicone. Therefore the LEDs have a soft surface on the top of package. The pressure to the top surface will be influence to the reliability of the LEDs. Precautions should be taken to avoid the strong pressure on the encapsulated part. So when use the picking up nozzle, the pressure on the silicone resin should be proper.

2)、The outer diameter of the SMD pickup nozzle should not exceed the size of the LED to prevent air leaks. The inner diameter of the nozzle should be as large as possible. pliable material is suggested for the nozzle tip to avoid scratching or damaging the LED surface during pickup.



Handling Precautions

- 1、 Handle the component along the side surface by using forceps or appropriate tools; do not directly touch or Handle the silicone lens surface, it may damage the internal circuitry.



Do not stack together assembled PCBs containing LEDs.

Not suitable to operate in acidic environment, $\text{PH} < 7$

Impact may scratch the silicone lens or damage the internal circuitry

