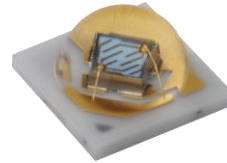


NICHIA CORPORATION

SPECIFICATIONS FOR UV LED

NCSU276AT

- Pb-free Reflow Soldering Application
- Built-in ESD Protection Device
- RoHS Compliant



SPECIFICATIONS

(1) Absolute Maximum Ratings

Item	Symbol	Absolute Maximum Rating	Unit
Forward Current	I_F	700	mA
Pulse Forward Current	I_{FP}	1000	mA
Allowable Reverse Current	I_R	85	mA
Power Dissipation	P_D	3.08	W
Operating Temperature	T_{opr}	-10~85	°C
Storage Temperature	T_{stg}	-40~100	°C
Junction Temperature	T_J	90	°C

* Absolute Maximum Ratings at $T_S=25^\circ\text{C}$.

* I_{FP} conditions with pulse width $\leq 10\text{ms}$ and duty cycle $\leq 10\%$.

(2) Initial Electrical/Optical Characteristics

Item		Symbol	Condition	Typ	Max	Unit
U365	Forward Voltage	V_F	$I_F=500\text{mA}$	3.8	-	V
	Radiant Flux	Φ_e	$I_F=500\text{mA}$	780	-	mW
	Peak Wavelength	λ_p	$I_F=500\text{mA}$	365	-	nm
	Spectrum Half Width	$\Delta \lambda$	$I_F=500\text{mA}$	9.0	-	nm
Thermal Resistance		$R_{\theta JS}$	-	11.0	13.5	°C/W

* Characteristics at $T_S=25^\circ\text{C}$.

* Radiant Flux value as per CIE 127:2007 standard.

* $R_{\theta JS}$ is the thermal resistance from the junction to the T_S measurement point.

* It is recommended to operate the LEDs at a current greater than 10% of the sorting current to stabilize the LED characteristics.

RANKS

Item	Rank	Min	Max	Unit
Forward Voltage	H2	4.2	4.4	V
	H1	4.0	4.2	
	M2	3.8	4.0	
	M1	3.6	3.8	
	L2	3.4	3.6	
	L1	3.2	3.4	
Radiant Flux	P37d22	990	1080	mW
	P37d21	910	990	
	P36d22	835	910	
	P36d21	765	835	
	P35d22	700	765	
	P35d21	640	700	
Peak Wavelength	U365	360	370	nm

* Ranking at $T_s=25^{\circ}\text{C}$.

* Forward Voltage Tolerance: $\pm 0.05\text{V}$

* Radiant Flux Tolerance: $\pm 6\%$

* Peak Wavelength Tolerance: $\pm 3\text{nm}$

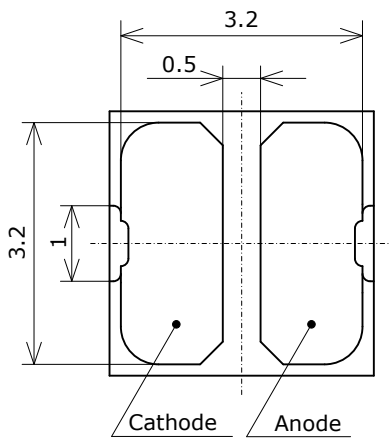
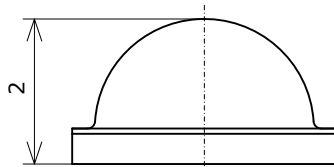
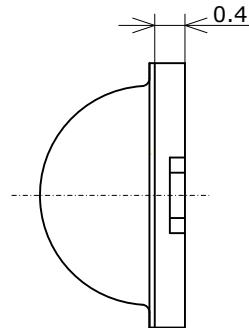
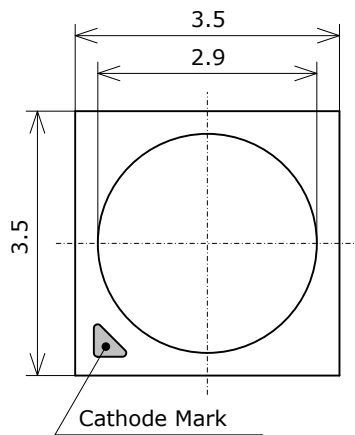
* LEDs from the above ranks will be shipped. The rank combination ratio per shipment will be decided by Nichia.

OUTLINE DIMENSIONS

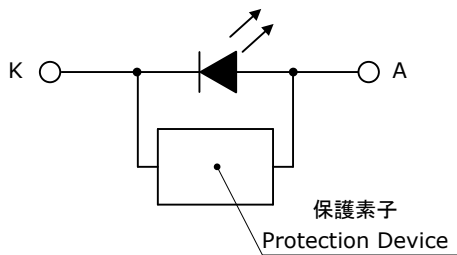
* 本製品はRoHS指令に適合しております。
This product complies with RoHS Directive.

NCSU276A
管理番号 No. STS-DA7-5335A

(単位 Unit: mm, 公差 Tolerance: ±0.2)

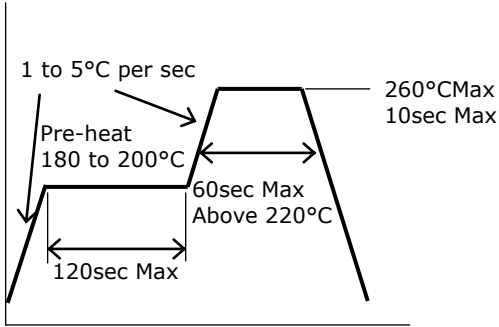


項目 Item	内容 Description
パッケージ材質 Package Materials	セラミックス Ceramics
レンズ材質 Lens Materials	シリコン樹脂 Silicone Resin
電極材質 Electrodes Materials	金メッキ Au-plated
質量 Weight	0.034g (TYP)

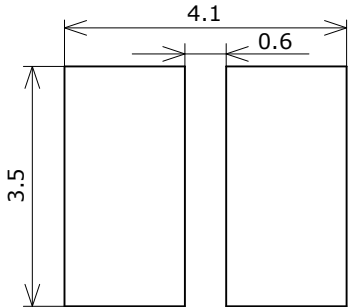


SOLDERING

• Recommended Reflow Soldering Condition(Lead-free Solder)



• Recommended Soldering Pad Pattern



(単位 Unit: mm)

- * This LED is designed to be reflow soldered to a PCB. If dip soldered or hand soldered, Nichia will not guarantee its reliability.
- * Reflow soldering must not be performed more than twice.
- * When cooling the LEDs from the peak temperature a gradual cooling slope is recommended; do not cool the LEDs rapidly.
- * During reflow soldering, the heat and atmosphere in the reflow oven may cause the optical characteristics to degrade. In particular, reflow soldering performed with an air atmosphere may have a greater negative effect on the optical characteristics than if a nitrogen atmosphere is used; Nichia recommends using a nitrogen reflow atmosphere.
- * This LED uses a silicone resin for the lens and internal pre-coating resin; the silicone resin is soft. If pressure is applied to the lens, it may cause the lens to be damaged, chipped, and/or delaminated. If the resin is damaged, chipped, delaminated and/or deformed, it may cause the wire to break causing a catastrophic failure (i.e. the LED not to illuminate) and/or reliability issues (e.g. the LED to corrode, the radiant flux to decrease, the color/directivity to change, etc.). Ensure that pressure is not applied to the lens.

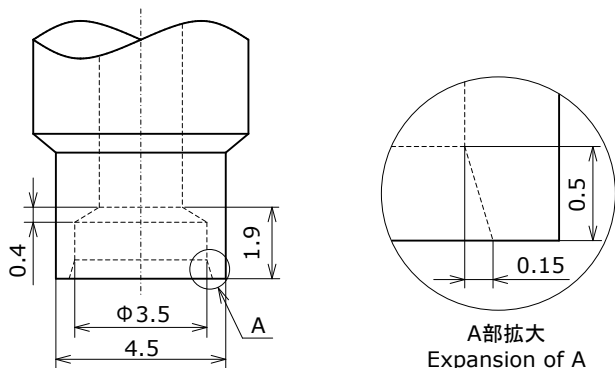
If an automatic pick and place machine is used for the LEDs, use a pick up nozzle that does not affect the lens.

Recommended conditions:

Using a nozzle specifically designed for the LEDs is recommended (See the nozzle drawing below).

- * Ensure that the nozzle does not come in contact with the lens when it picks up an LED.

If this occurs, it may cause internal disconnection causing the LED not to illuminate.



A部拡大
Expansion of A

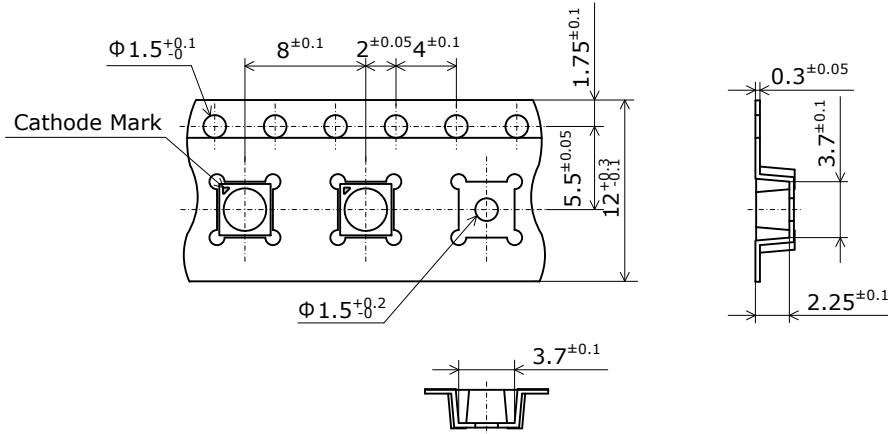
(単位 Unit: mm)

- * Repairing should not be done after the LEDs have been soldered. It should be confirmed beforehand whether the characteristics of the LEDs will or will not be damaged by repairing.
- * When soldering, do not apply stress to the LED while the LED is hot.
- * The soldering pad pattern above is a general recommendation for LEDs to be mounted without issues; if a high degree of precision is required for the chosen application (i.e. high-density mounting), ensure that the soldering pad pattern is optimized.
- * When flux is used, it should be a halogen free flux. Ensure that the manufacturing process is not designed in a manner where the flux will come in contact with the LEDs.
- * Ensure that there are no issues with the type and amount of solder that is being used.

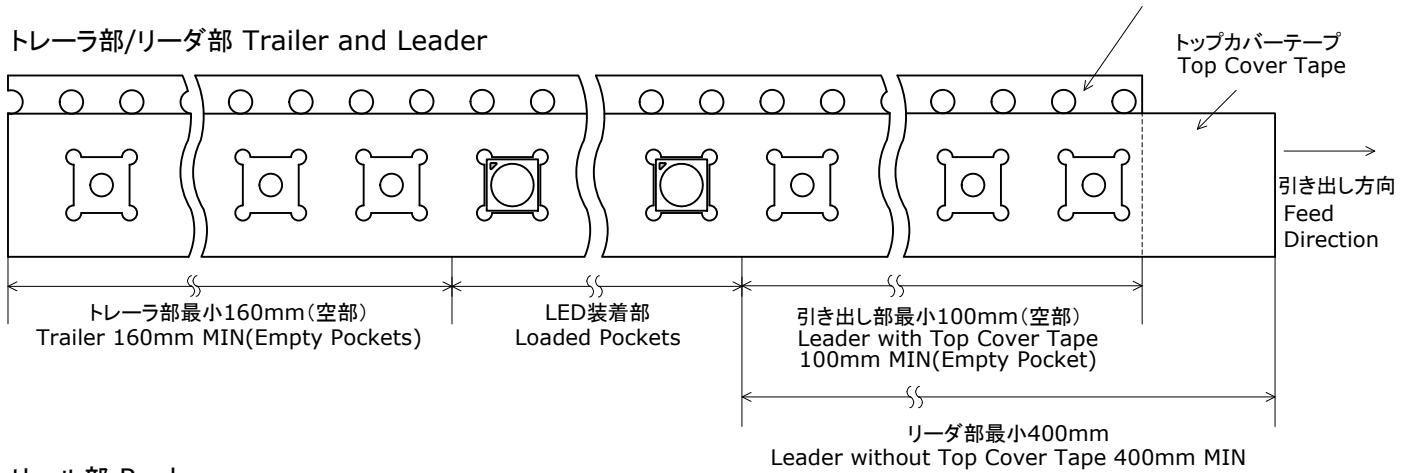
TAPE AND REEL DIMENSIONS

テーピング部 Tape

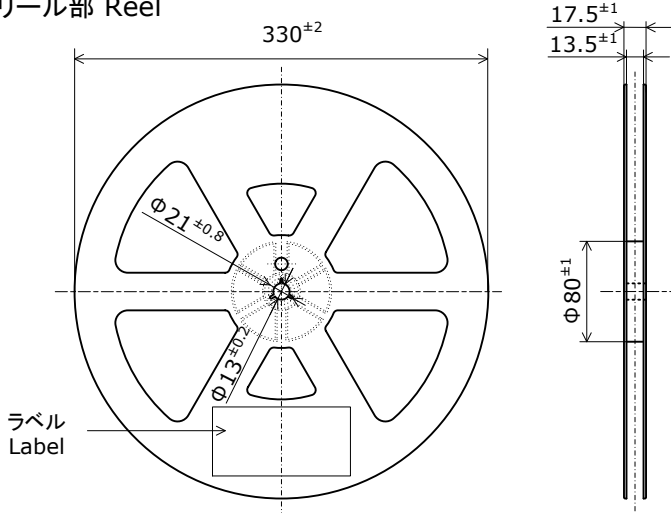
Nxxx276x
 管理番号 No. STS-DA7-5755
 (単位 Unit: mm)



トレーラ部/リーダ部 Trailer and Leader



リール部 Reel

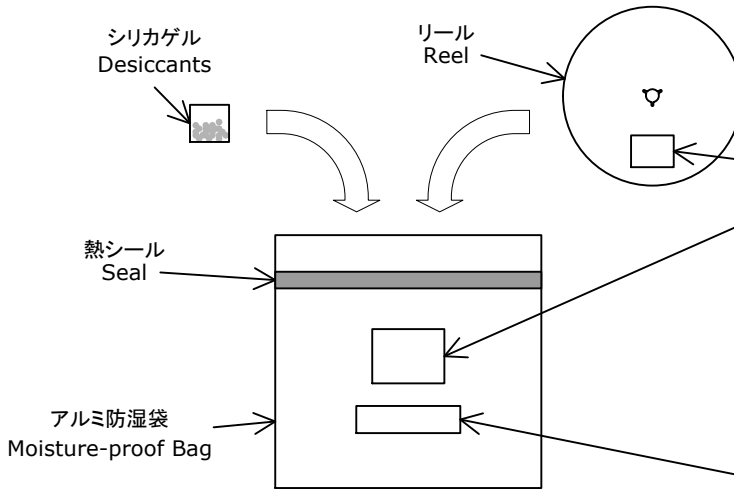


- * 数量は1リールにつき 3500個入りです。
Reel Size: 3500pcs
- * JIS C 0806電子部品テーピングに準拠しています。
The tape packing method complies with JIS C 0806 (Packaging of Electronic Components on Continuous Tapes).
- * 実装作業の中断などでエンボスキャリアテープをリールに巻き取る場合、エンボスキャリアテープを強く(10N以上)締めないで下さい。LEDがカバーテープに貼り付く可能性があります。
When the tape is rewound due to work interruptions, no more than 10N should be applied to the embossed carrier tape.
The LEDs may stick to the top cover tape.

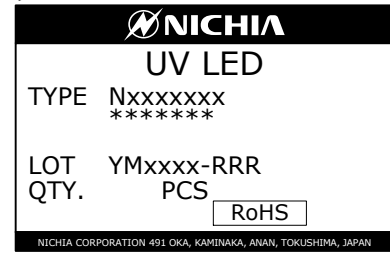
PACKAGING - TAPE & REEL

シリカゲルとともにリールをアルミ防湿袋に入れ、熱シールにより封をします。
 Reels are shipped with desiccants in heat-sealed moisture-proof bags.

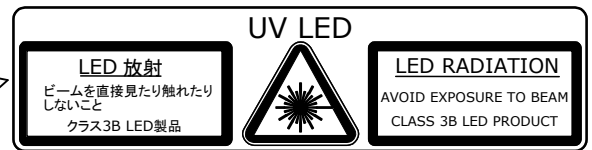
Nxxxxxxx
 管理番号 No. STS-DA7-1109B



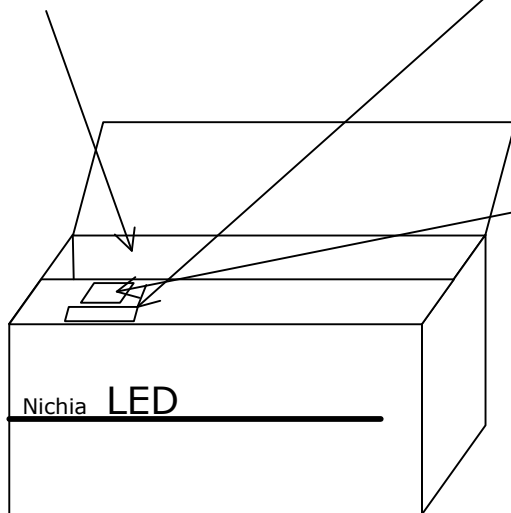
ラベル Label



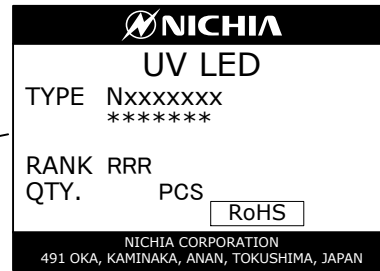
警告ラベル Warning and Explanatory Labels



アルミ防湿袋を並べて入れ、ダンボールで仕切ります。
 Moisture-proof bags are packed in cardboard boxes with corrugated partitions.



ラベル Label



- * 客先型名を*****で示します。
 客先型名が設定されていない場合は空白です。
 ***** is the customer part number.
 If not provided, it will not be indicated on the label.
- * ロット表記方法についてはロット番号の項を参照して下さい。
 For details, see "LOT NUMBERING CODE" in this document.

- * 本製品はテーピングしたのち、輸送の衝撃から保護するためダンボールで梱包します。
 Products shipped on tape and reel are packed in a moisture-proof bag.
 They are shipped in cardboard boxes to protect them from external forces during transportation.
- * 取り扱いに際して、落下させたり、強い衝撃を与えたりしますと、製品を損傷させる原因になりますので注意して下さい。
 Do not drop or expose the box to external forces as it may damage the products.
- * ダンボールには防水加工がされておきませんので、梱包箱が水に濡れないよう注意して下さい。
 Do not expose to water. The box is not water-resistant.
- * 輸送、運搬に際して弊社よりの梱包状態あるいは同等の梱包を行って下さい。
 Using the original package material or equivalent in transit is recommended.

LOT NUMBERING CODE

Lot Number is presented by using the following alphanumeric code.

YMxxxx - RRR

Y - Year

Year	Y
2017	H
2018	I
2019	J
2020	K
2021	L
2022	M

M - Month

Month	M	Month	M
1	1	7	7
2	2	8	8
3	3	9	9
4	4	10	A
5	5	11	B
6	6	12	C

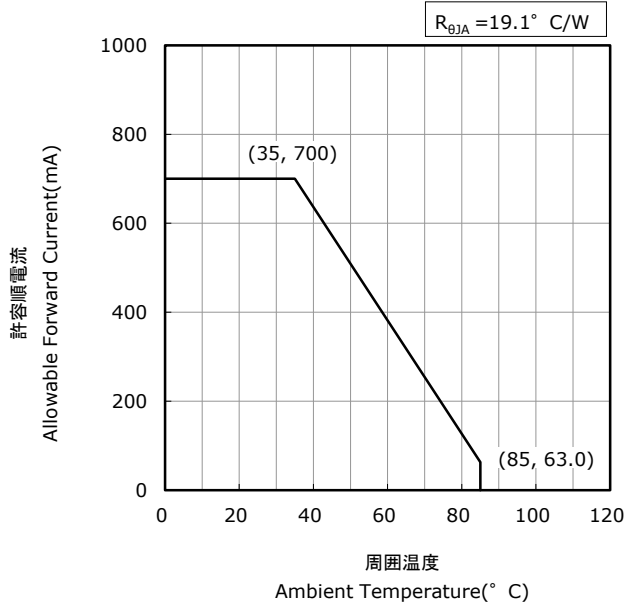
xxxx-Nichia's Product Number

RRR-Ranking by Wavelength, Ranking by Radiant Flux, Ranking by Forward Voltage

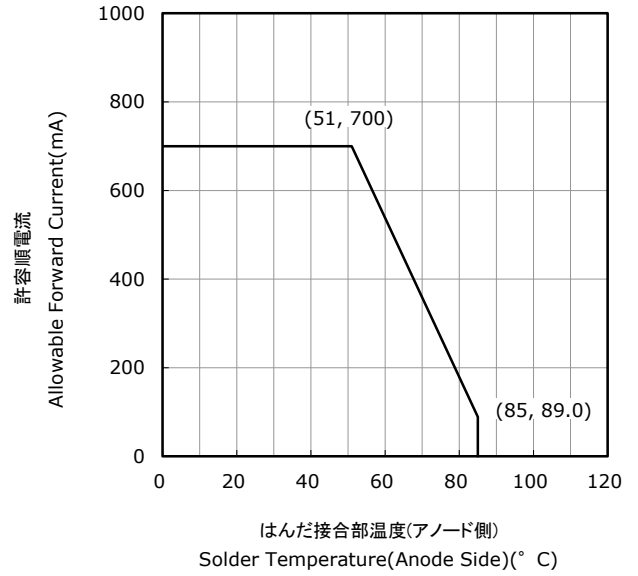
DERATING CHARACTERISTICS

NCSU276A
管理番号 No. STS-DA7-5336A

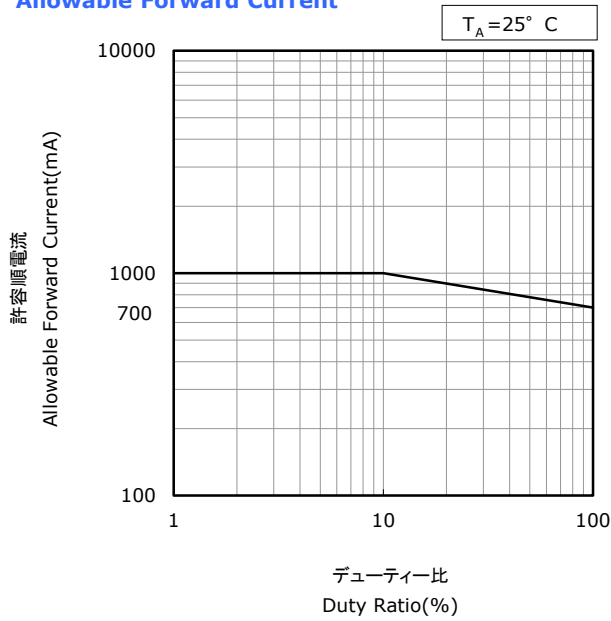
周囲温度-許容順電流特性
Ambient Temperature vs
Allowable Forward Current



はんだ接合部温度(アノード側)-許容順電流特性
Solder Temperature (Anode Side) vs
Allowable Forward Current



デューティー比-許容順電流特性
Duty Ratio vs
Allowable Forward Current

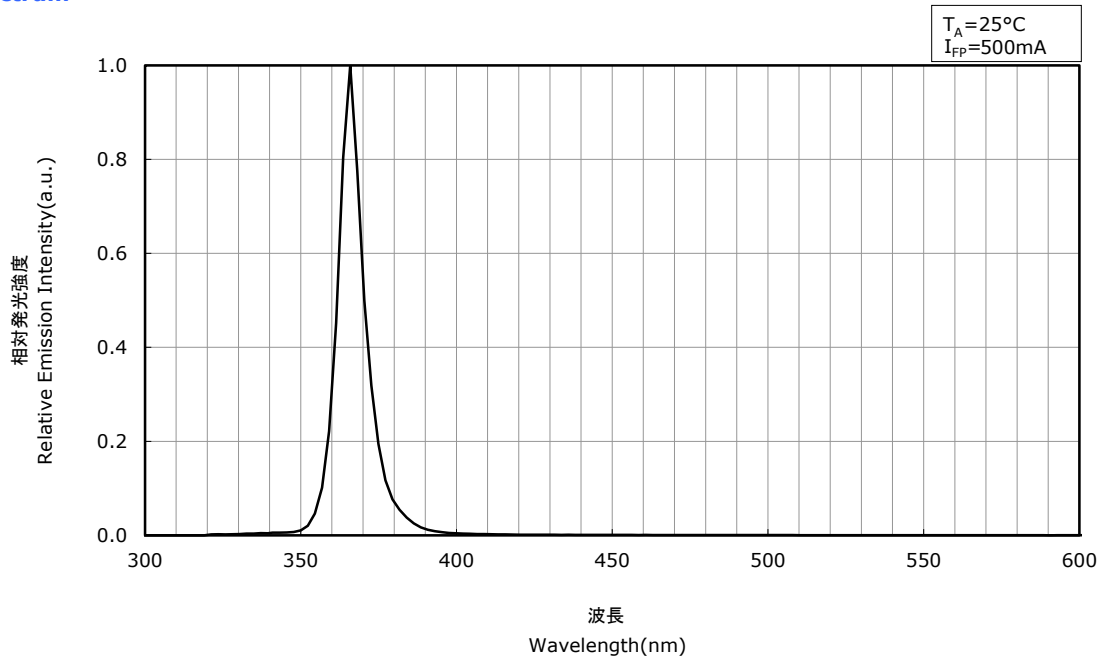


OPTICAL CHARACTERISTICS

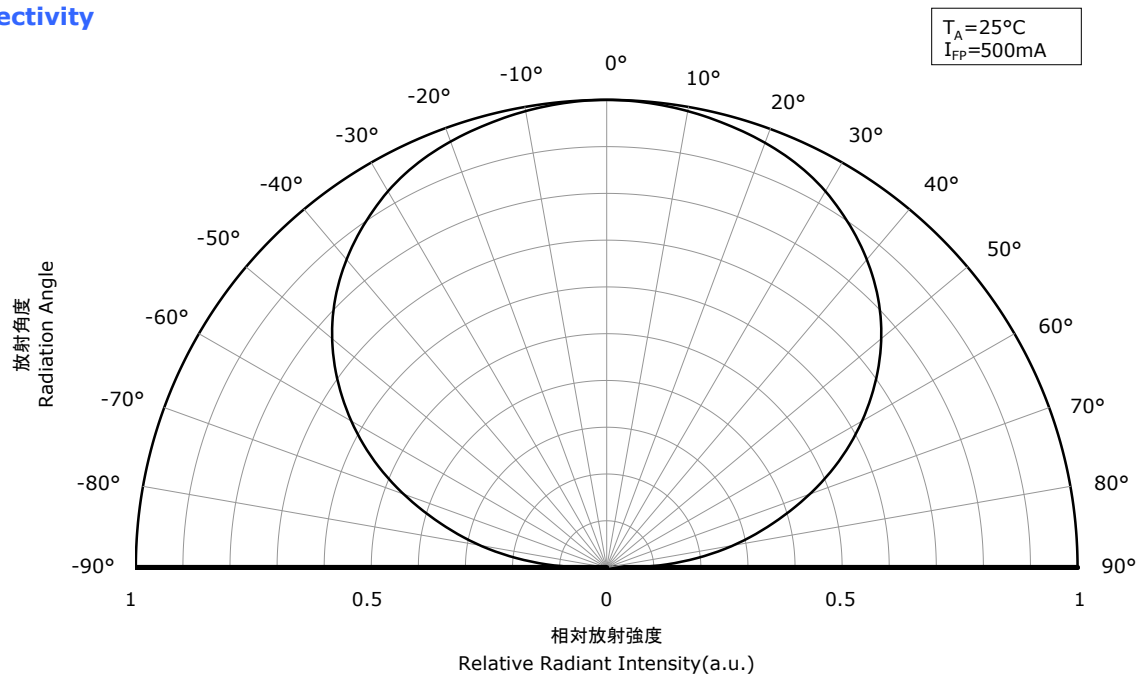
* 本特性は参考です。
All characteristics shown are for reference only and are not guaranteed.

NCSU276A
管理番号 No. STS-DA7-5728A

発光スペクトル Spectrum



指向特性 Directivity



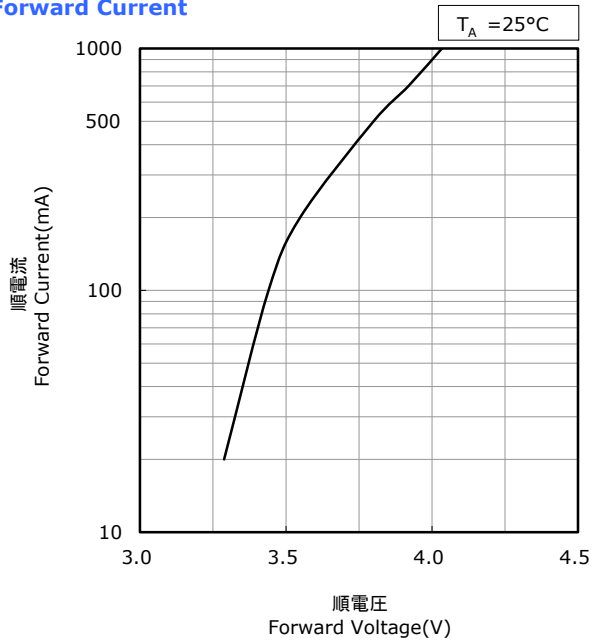
* 本特性はピーク波長ランクU365xに対応しています。
The graphs above show the characteristics for U365x LEDs of this product.

FORWARD CURRENT CHARACTERISTICS / TEMPERATURE CHARACTERISTICS

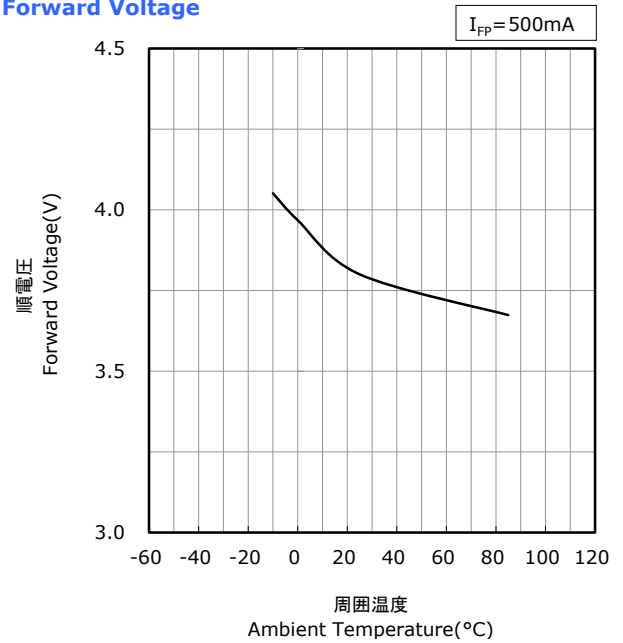
* 本特性は参考です。
All characteristics shown are for reference only and are not guaranteed.

NCSU276A
管理番号 No. STS-DA7-5731A

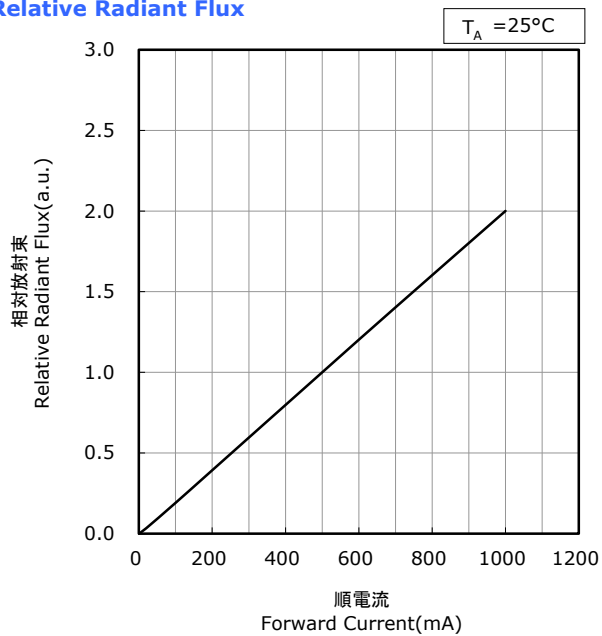
順電圧-順電流特性
Forward Voltage vs Forward Current



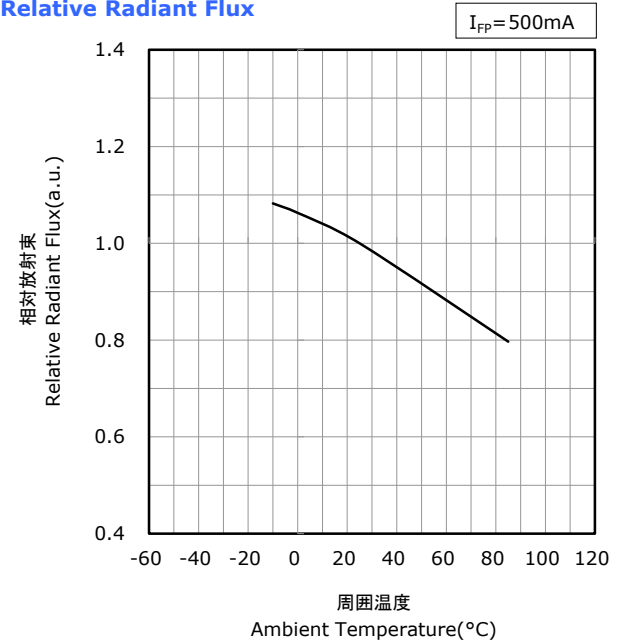
周囲温度-順電圧特性
Ambient Temperature vs Forward Voltage



順電流-相対放射束特性
Forward Current vs Relative Radiant Flux



周囲温度-相対放射束特性
Ambient Temperature vs Relative Radiant Flux



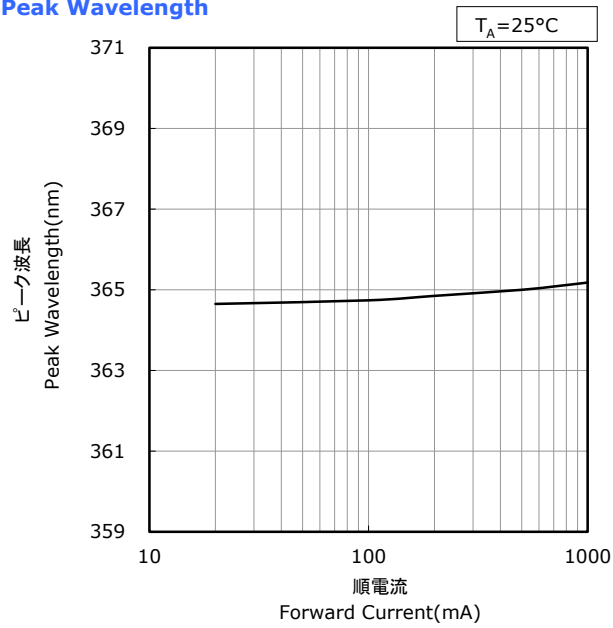
* 本特性はピーク波長ランクU365xに対応しています。
The graphs above show the characteristics for U365x LEDs of this product.

FORWARD CURRENT CHARACTERISTICS / TEMPERATURE CHARACTERISTICS

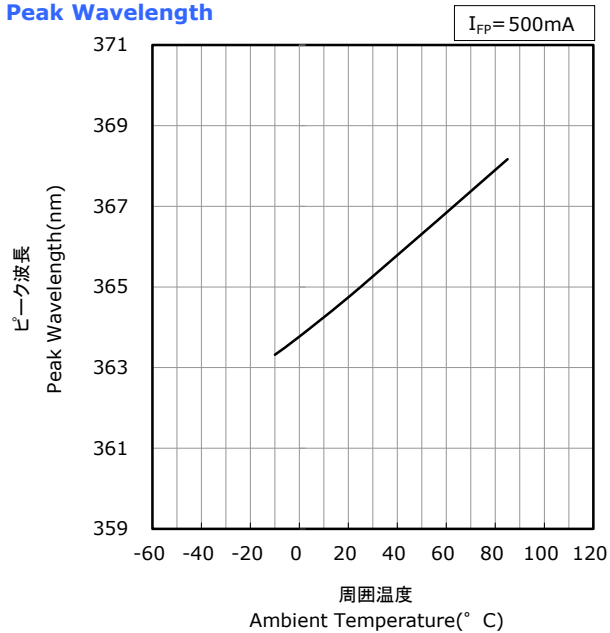
* 本特性は参考です。
All characteristics shown are for reference only and are not guaranteed.

NCSU276A
管理番号 No. STS-DA7-5734A

順電流-ピーク波長特性
Forward Current vs
Peak Wavelength



周囲温度-ピーク波長特性
Ambient Temperature vs
Peak Wavelength



* 本特性はピーク波長ランクU365xに対応しています。
The graphs above show the characteristics for U365x LEDs of this product.

RELIABILITY

(1) Tests and Results

Test	Reference Standard	Test Conditions	Test Duration	Failure Criteria #	Units Failed/Tested
Resistance to Soldering Heat (Reflow Soldering)	JEITA ED-4701 300 301	$T_{\text{slid}}=260^{\circ}\text{C}$, 10sec, 2reflows, Precondition: 30°C , 70%RH, 168hr		#1	0/10
Temperature Cycle	JEITA ED-4701 100 105	$-40^{\circ}\text{C}(30\text{min})\sim 25^{\circ}\text{C}(5\text{min})\sim 100^{\circ}\text{C}(30\text{min})\sim 25^{\circ}\text{C}(5\text{min})$	100cycles	#1	0/10
High Temperature Storage	JEITA ED-4701 200 201	$T_A=100^{\circ}\text{C}$	1000hours	#1	0/10
Low Temperature Storage	JEITA ED-4701 200 202	$T_A=-40^{\circ}\text{C}$	1000hours	#1	0/10
Room Temperature Operating Life		$T_A=25^{\circ}\text{C}$, $I_F=700\text{mA}$	1000hours	#1	0/10
High Temperature Operating Life		$T_A=85^{\circ}\text{C}$, $I_F=60\text{mA}$	1000hours	#1	0/10
Temperature Humidity Operating Life		60°C , RH=90%, $I_F=350\text{mA}$	500hours	#1	0/10
Low Temperature Operating Life		$T_A=-10^{\circ}\text{C}$, $I_F=500\text{mA}$	1000hours	#1	0/10
Vibration	JEITA ED-4701 400 403	200m/s^2 , 100~2000~100Hz, 4cycles, 4min, each X, Y, Z	48minutes	#1	0/10
Electrostatic Discharges	JEITA ED-4701 300 304	HBM, 2kV, 1.5k Ω , 100pF, 3pulses, alternately positive or negative		#1	0/10

NOTES:

- 1) $R_{\theta JA} \approx 19.1^{\circ}\text{C/W}$
- 2) Measurements are performed after allowing the LEDs to return to room temperature.

(2) Failure Criteria

Criteria #	Items	Conditions	Failure Criteria
#1	Forward Voltage(V_F)	$I_F=500\text{mA}$	$>\text{Initial value} \times 1.1$
	Radiant Flux(Φ_E)	$I_F=500\text{mA}$	$<\text{Initial value} \times 0.7$

CAUTIONS

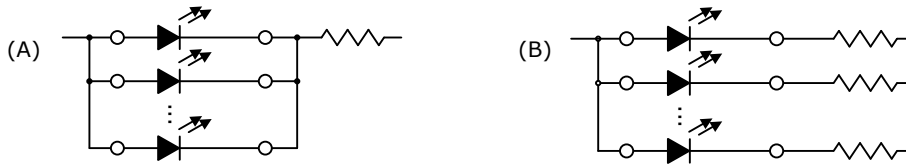
(1) Storage

Conditions		Temperature	Humidity	Time
Storage	Before Opening Aluminum Bag	≤30°C	≤90%RH	Within 1 Year from Delivery Date
	After Opening Aluminum Bag	≤30°C	≤70%RH	≤168hours
Baking		65±5°C	-	≥24hours

- The storage/packaging requirements for this LED are comparable to JEDEC Moisture Sensitivity Level (MSL) 3 or equivalent. Nichia used IPC/JEDEC STD-020 as a reference to rate the MSL of this LED.
- This LED uses a package that could absorb moisture; if the package absorbs moisture and is exposed to heat during soldering, it may cause the moisture to vaporize and the package to expand and the resulting pressure may cause internal delamination. This may cause the optical characteristics to degrade. To minimize moisture absorption in storage/transit, moisture-proof aluminum bags are used for the LEDs with a silica gel packet to absorb any air moisture in the bag. The silica gel beads turn blue to red as they absorb moisture.
- Once the moisture-proof aluminum bag is open, ensure that the LED is soldered to a PCB within the range of the conditions above. To store any remaining unused LEDs, use a hermetically sealed container with silica gel desiccants. Nichia recommends placing them back to the original moisture-proof bag and reseal it.
- If the "After Opening" storage time has been exceeded or any pink silica gel beads are found, ensure that the LED are baked before use. Baking should only be done once.
- This LED has gold-plated electrodes. If the LEDs are exposed to a corrosive environment, it may cause the plated surface to tarnish causing issues (i.e. solderability). Ensure that when storing LEDs, a hermetically sealed container is used. Nichia recommends placing them back to the original moisture-proof bag and reseal it.
- To prevent substances/gases from affecting the plated surface, ensure that the parts/materials used with the LEDs in the same assembly/system do not contain sulfur (e.g. gasket/seal, adhesive, etc.). If the plating is contaminated, it may cause issues (e.g. electric connection failures). If a gasket/seal is used, silicone rubber gaskets/seals are recommended; ensure that this use of silicone does not result in issues (e.g. electrical connection failures) caused by low molecular weight volatile siloxane.
- To avoid condensation, the LEDs must not be stored in areas where temperature and humidity fluctuate greatly.
- Do not store the LEDs in a dusty environment.
- Do not expose the LEDs to direct sunlight and/or an environment over a long period of time where the temperature is higher than normal room temperature.

(2) Directions for Use

- The circuit must be designed to ensure that the Absolute Maximum Ratings are not exceeded for each LED. The LEDs should be operated at a constant current per LED. In the case of operating at a constant voltage, Circuit B is recommended. If Circuit A is used, it may cause the currents flowing through the LEDs to vary due to the variation in the forward voltage characteristics of the LEDs on the circuit.



- This LED is designed to be operated at a forward current. Ensure that no voltage is applied to the LED in the forward/reverse direction while the LED is off. If the LEDs are used in an environment where reverse voltages are applied to the LED continuously, it may cause electrochemical migration to occur causing the LED to be damaged. When not in use for a long period of time, the system's power should be turned off to ensure that there are no issues/damage.
- To stabilize the LED characteristics while in use, Nichia recommends that the LEDs are operated at currents $\geq 10\%$ of the sorting current.
- Ensure that transient excessive voltages (e.g. lighting surge) are not applied to the LEDs.
- If the LEDs are used for outdoor applications, ensure that necessary measures are taken (e.g. protecting the LEDs from water/salt damage and high humidity).
- Although this LED is specifically designed to emit invisible light, a small amount of light in the visible region exists in the emission spectrum. Ensure that when using the LEDs for sensors, verification is performed to ensure that the emission spectrum is fit for the intended use.
- If this LED is stored and/or used constantly under high temperature and high humidity conditions, it may accelerate the deterioration of the die; this may cause the radiant flux to decrease. If the LEDs are stored and/or used under these conditions, sufficient verification must be done prior to use to ensure that there are no issues for the chosen application.
- This LED uses a silicone resin for the lens. Depending on the operating/environmental conditions the silicone lens may have issues (e.g. cracks) due to deterioration resulting from being exposed to the UV light; this may have an adverse effect on the optical characteristics; ensure that sufficient verification is performed to ensure that there are no issues for the chosen application.

(3) Handling Precautions

- Do not handle the LEDs with bare hands:
 - this may contaminate the LED surface and have an effect on the optical characteristics,
 - this may cause the LED to deform and/or the wire to break causing a catastrophic failure (i.e. the LED not to illuminate).
- Ensure that when handling the LEDs with tweezers, excessive force is not applied to the LED. Otherwise, it may cause damage to the resin (e.g. cut, scratch, chip, crack, delamination and deformation) and the wire to break causing a catastrophic failure (i.e. the LED not to illuminate).
- Dropping may cause damage to the LED (e.g. deformation).
- Do not stack assembled PCBs together. Otherwise, it may cause damage to the resin (e.g. cut, scratch, chip, crack, delamination and deformation) and the wire to break causing a catastrophic failure (i.e. the LED not to illuminate).

(4) Design Consideration

- To operate the LEDs, using a copper-core PCB is recommended; this may cause issues (e.g. cracks in the glass cover/solder joints due to thermal stress) depending on the reflow soldering conditions. Ensure that sufficient verification is performed prior to use to ensure that there are no issues with the PCB/soldering conditions for the chosen application.
- If the LEDs are soldered to a PCB and the PCB assembly is bent (e.g. PCB depaneling process), it may cause the LED package to break. The PCB layout should be designed to minimize the mechanical stress on the LEDs when the PCB assembly is bent/warped.
- The amount of mechanical stress exerted on the LED from depaneling may vary depending on the LED position/orientation on the PCB assembly (e.g. especially in areas near V-groove scores). The PCB layout should be designed to minimize the mechanical stress on the LEDs when the PCB is separated into individual PCB assemblies.
- To separate a PCB populated with the LEDs, use a specially designed tool. Do not break the PCB by hand.
- If an aluminum-core PCB is used to operate the LEDs, it may cause thermal stress during operation causing damage to the solder joints (e.g. crack). Ensure that sufficient verification is performed prior to use.
- Volatile organic compounds that have been released from materials present around the LEDs (e.g. housing, packing, adhesive, secondary lens, lens cover, etc.) may penetrate LED lens and/or internal pre-coating resin. If the LEDs are being used in a hermetically sealed environment, these volatile compounds can discolor after being exposed to heat and/or photon energy and it may greatly reduce the LED light output and/or cause a color shift. In this case, ventilating the environment may improve the reduction in light output and/or color shift. Perform a light-up test of the chosen application for optical evaluation to ensure that there are no issues, especially if the LEDs are planned to be used in a hermetically sealed environment.
- When substances commonly found in ink adhere to the resin of this LED, it may change the material properties of the resin causing the radiant flux to decrease. Materials (e.g. dustproof glass cover) should be used to protect the LEDs.

(5) Electrostatic Discharge (ESD)

- This LED is sensitive to transient excessive voltages (e.g. ESD, lightning surge). If this excessive voltage occurs in the circuit, it may cause the LED to be damaged causing issues (e.g. the LED to have a reduction in the radiant flux or not to illuminate [i.e. catastrophic failure]).

Ensure that when handling the LEDs, necessary measures are taken to protect them from an ESD discharge. The following examples are recommended measures to eliminate the charge:

- Grounded wrist strap, ESD footwear, clothes, and floors
 - Grounded workstation equipment and tools
 - ESD table/shelf mat made of conductive materials
 - Ensure that all necessary measures are taken to prevent the LEDs from being exposed to transient excessive voltages (e.g. ESD, lightning surge):
 - tools, jigs, and machines that are used are properly grounded
 - appropriate ESD materials/equipment are used in the work area
 - the system/assembly is designed to provide ESD protection for the LEDs
 - If the tool/equipment used is an insulator (e.g. glass cover, plastic, etc.), ensure that necessary measures have been taken to protect the LED from transient excessive voltages (e.g. ESD). The following examples are recommended measures to eliminate the charge:
 - Dissipating static charge with conductive materials
 - Preventing charge generation with moisture
 - Neutralizing the charge with ionizers
 - To detect if an LED was damaged by transient excess voltages (i.e. an ESD event during the system's assembly process), perform a characteristics inspection (e.g. forward voltage measurement) at low current ($\leq 1\text{mA}$).
 - Failure Criteria: $V_F < 2.0\text{V}$ at $I_F = 0.5\text{mA}$
- If the LED is damaged by transient excess voltages (e.g. ESD), it will cause the Forward Voltage (V_F) to decrease.

(6) Thermal Management

- The Absolute Maximum Junction Temperature (T_J) must not be exceeded under any circumstances. The increase in the temperature of an LED while in operation may vary depending on the PCB thermal resistance and the density of LEDs on the PCB assembly. Ensure that when using the LEDs for the chosen application, heat is not concentrated in an area and properly managed in the system/assembly.
- The operating current should be determined by considering the temperature conditions surrounding the LED (i.e. T_A). Ensure that when operating the LED, proper measures are taken to dissipate the heat.
- The following two equations can be used to calculate the LED junction temperature:

$$1) T_J = T_A + R_{\theta JA} \cdot W \quad 2) T_J = T_S + R_{\theta JS} \cdot W$$

* T_J =LED Junction Temperature: °C

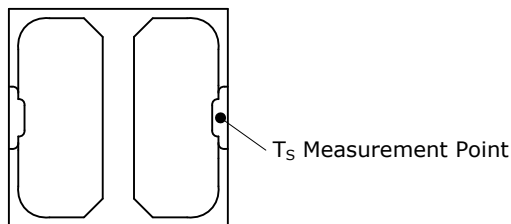
T_A =Ambient Temperature: °C

T_S =Soldering Temperature (Anode Side): °C

$R_{\theta JA}$ =Thermal Resistance from Junction to Ambient: °C/W

$R_{\theta JS}$ =Thermal Resistance from Junction to T_S Measurement Point: °C/W

W =Input Power($I_F \times V_F$): W



(7) Cleaning

- Do not clean the LEDs with water, benzine and/or thinner.
- To clean the LEDs, use isopropyl alcohol (IPA). If another solvent is used, it may cause the LED package/resin to be damaged causing issues; ensure that sufficient verification is performed prior to use. Additionally, ensure that the solvent being used does not cause any other issues (e.g. CFC-based solvents are heavily regulated).
- If an LED is contaminated (e.g. dust/dirt), use a cloth soaked with isopropyl alcohol (IPA). Ensure that the cloth is firmly squeezed before wiping the LED.
- Do not clean the LEDs with an ultrasonic cleaner. If cleaning must be done, ensure that sufficient verification is performed by using a finished assembly with LEDs to determine cleaning conditions (e.g. ultrasonic power, LED position on the PCB assembly) that do not cause an issue.

(8) Eye Safety

- There may be two important international specifications that should be noted for safe use of the LEDs: IEC 62471:2006 Photobiological safety of lamps and lamp systems and IEC 60825-1:2001 (i.e. Edition 1.2) Safety of Laser Products - Part 1: Equipment Classification and Requirements. Ensure that when using the LEDs, there are no issues with the following points:
 - LEDs have been removed from the scope of IEC 60825-1 since IEC 60825-1:2007 (i.e. Edition 2.0) was published. However, depending on the country/region, there are cases where the requirements of the IEC 60825-1:2001 specifications or equivalent must be adhered to.
 - LEDs have been included in the scope of IEC 62471:2006 since the release of the specification in 2006.
 - Most Nichia LEDs will be classified as the Exempt Group or Risk Group 1 according to IEC 62471:2006. However, in the case of high-power LEDs containing blue wavelengths in the emission spectrum, there are LEDs that will be classified as Risk Group 2 depending on the characteristics (e.g. radiation flux, emission spectrum, directivity, etc.)
 - If the LED is used in a manner that produces an increased output or with an optic to collimate the light from the LED, it may cause damage to the human eye.
- If an LED is operated in a manner that emits a flashing light, it may cause health issues (e.g. visual stimuli causing eye discomfort). The system should be designed to ensure that there are no harmful effects on the human body.
- This LED emits light in the ultraviolet (UV) region. The UV light from an LED while in operation is intense and harmful; if human eyes are exposed to this light, it may cause damage to them. Do not look directly or indirectly (e.g. through an optic) at the UV light. Ensure that if there is a possibility that the UV light reflects off objects and enters the eyes, appropriate protection gear (e.g. goggles) is used to prevent the eyes from being exposed to the light.
- Ensure that appropriate warning signs/labels are provided both on each of the systems/applications using the UV LEDs, in all necessary documents (e.g. specification, manual, catalogs, etc.), and on the packaging materials.

(9) Miscellaneous

- Nichia warrants that the discrete LEDs will meet the requirements/criteria as detailed in the Reliability section within this specification. If the LEDs are used under conditions/environments deviating from or inconsistent with those described in this specification, the resulting damage and/or injuries will not be covered by this warranty.
- Nichia warrants that the discrete LEDs manufactured and/or supplied by Nichia will meet the requirements/criteria as detailed in the Reliability section within this specification; it is the customer's responsibility to perform sufficient verification prior to use to ensure that the lifetime and other quality characteristics required for the intended use are met.
- The applicable warranty period is one year from the date that the LED is delivered. In the case of any incident that appears to be in breach of this warranty, the local Nichia sales representative should be notified to discuss instructions on how to proceed while ensuring that the LED in question is not disassembled or removed from the PCB if it has been attached to the PCB. If a breach of this warranty is proved, Nichia will provide the replacement for the non-conforming LED or an equivalent item at Nichia's discretion. **FOREGOING ARE THE EXCLUSIVE REMEDIES AVAILABLE TO THE CUSTOMER IN RESPECT OF THE BREACH OF THE WARRANTY CONTAINED HEREIN, AND IN NO EVENT SHALL NICHIA BE RESPONSIBLE FOR ANY INDIRECT, INCIDENTAL OR CONSEQUENTIAL LOSSES AND/OR EXPENSES (INCLUDING LOSS OF PROFIT) THAT MAY BE SUFFERED BY THE CUSTOMER ARISING OUT OF A BREACH OF THE WARRANTY.**
- **NICHIA DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**
- This LED is intended to be used for general lighting, household appliances, electronic devices (e.g. mobile communication devices); it is not designed or manufactured for use in applications that require safety critical functions (e.g. aircraft, automobiles, combustion equipment, life support systems, nuclear reactor control system, safety devices, spacecraft, submarine repeaters, traffic control equipment, trains, vessels, etc.). If the LEDs are planned to be used for these applications, unless otherwise detailed in the specification, Nichia will neither guarantee that the LED is fit for that purpose nor be responsible for any resulting property damage, injuries and/or loss of life/health. This LED does not comply with ISO/TS 16949 and is not intended for automotive applications.
- The customer will not reverse engineer, disassemble or otherwise attempt to extract knowledge/design information from the LED.
- All copyrights and other intellectual property rights in this specification in any form are reserved by Nichia or the right holders who have granted Nichia permission to use the content. Without prior written permission from Nichia, no part of this specification may be reproduced in any form or by any means.
- Both the customer and Nichia will agree on the official specifications for the supplied LEDs before any programs are officially launched. Without this agreement in writing (i.e. Customer Specific Specification), changes to the content of this specification may occur without notice (e.g. changes to the foregoing specifications and appearance, discontinuation of the LEDs, etc.).

Mounting Techniques for LEDs with a Lens

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1. Introduction
2. Mounting Failures in LEDs with a Lens
3. Mounting Techniques
4. Caution
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Mounting Techniques for LEDs with a Lens

1. Introduction

As LEDs have recently been miniaturized and highly-functional, higher mounting technologies are necessary for them. It has been difficult to mount such advanced LEDs because of the lenses and the smaller absorption area. Improper mounting will affect the function and the reliability of the performance from the end product. To manufacture high-performance lighting fixtures with high functional LEDs, it is critical to develop the mounting technology.

We have seen many mounting problems in highly-functional LEDs with a lens. This document provides the mounting techniques for such LEDs, exhibiting some mounting failures. Please note that this document recommends a modular mounter to be used.



2. Mounting Failures in LEDs with a Lens

Many LEDs with a lens have been developed for higher performance. Such lenses are mostly made of resin; when external stress is applied to the lens, some are susceptible to damage, leading to abnormal optical characteristics, and others are susceptible to wire breakage, leading to abnormal electrical characteristics. Therefore, applying external stress to the lens has to be avoided as much as possible.

Moreover, the contact area of a pick-and-place nozzle and the lens is limited by the presence of the lens, which sometimes causes air leak, resulting in absorption error.

- Problem 1: Damage to the lens during the mounting process
- Problem 2: Absorption error due to air leak

An LED lens sometimes sticks to the top cover tape due to the resin's adhesive property, resulting in LED tilting within the cavity.

Also, the center of gravity of an LED with a lens is located higher. When the emboss carrier tape is exposed to an excessive vibration, the LED may be tilted within the cavity.

- Problem 3: LED tilting within the cavity due to its adhesion to the top cover tape
- Problem 4: LED tilting within the cavity due to vibration of the emboss carrier tape

Please refer to the following sheets for the countermeasures against Problems 1 to 4.

3. Mounting Techniques

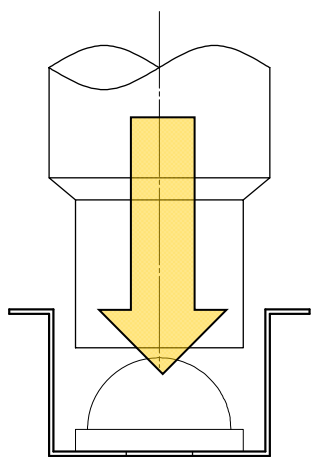
3-1. Problem 1: Damage to the lens during the mounting process

Nichia establishes the optimal absorption method and the optimal cavity shape/size for each LED with a lens.

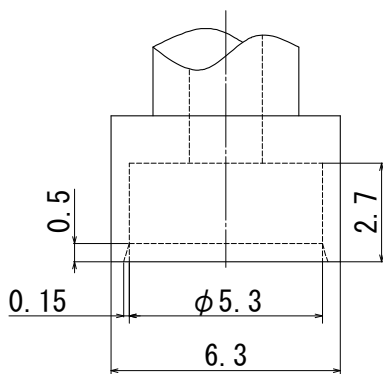
In general, there are two absorption methods; one is the “nozzle insertion system” and the other is the “non-insertion nozzle system.”

3-1-1. Nozzle Insertion System

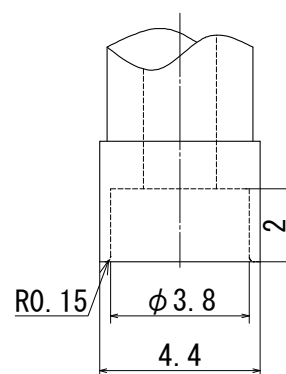
The nozzle insertion system is optimal for the 383/385 series, considering the LED shape/tolerance and the cavity shape/size. The LEDs can be absorbed in a stable condition, when the nozzle is inserted into the cavity and brought close to the lens. Please take care not to insert the nozzle too close to the lens. Therefore, please refer to Nichia’s specifications for the insertion depth.



Inserted into the Cavity



Outline Dimension of the Nozzle
for NS9x383



Outline Dimension of the Nozzle
for NFSx385

The pick-and-place nozzle is chamfered so as to form a “C Surface” (a sloped surface) and an “R Surface” (a curved surface), enabling a smooth mounting of the LEDs. Such design of the nozzle can prevent the LEDs from tilting in the cavities.

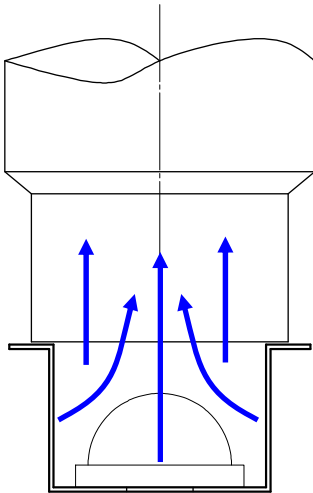
3-1-2. Non-Insertion Nozzle System

When the nozzle insertion system is used for the x19 series, the nozzle may touch the lens and apply excessive stress to it, considering the LED’s shape/tolerance and the dimensional tolerance of the nozzle. If the clearance is left between the nozzle and the lens to avoid the contact with each other, it may be impossible to insert the nozzle into the cavity due to the oversized nozzle.

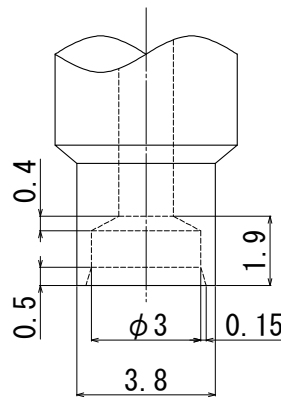
Then, Nichia recommends that the “Non-Insertion Nozzle system” be used for the x19 series. With this system, the nozzle reaches at the top surface of the cavity and absorbs the LEDs.

With the nozzle insertion system, the lens can get damaged due to the insertion pressure of the nozzle. On the other hand, with the non-insertion nozzle system, the nozzle is less likely to apply stress to the lens; only a slight absorption stress is applied to the lens.

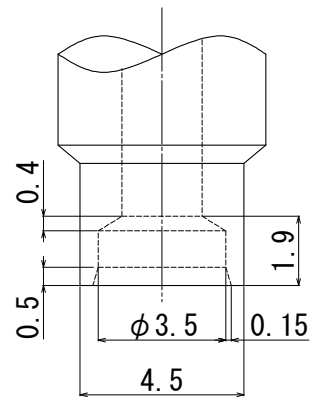
Also, superior durability of the nozzle is achieved because of its sufficient thickness, since it does not have to be inserted into the cavities.



Absorbed by air



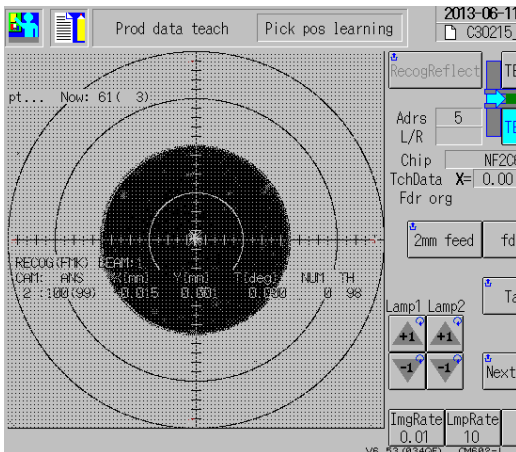
Outline Dimension of the Nozzle
for x19A series



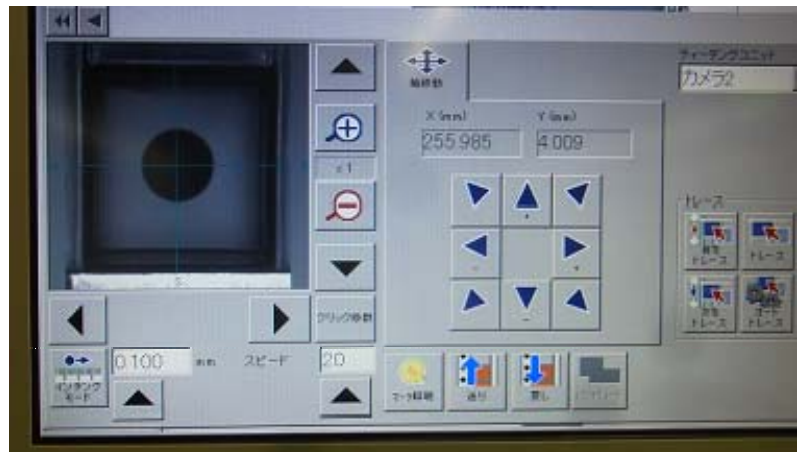
Outline Dimension of the Nozzle
for x19B series

Correction of the Absorption Point

Please adjust the mounter to ensure that the nozzle should absorb the correct point on the LEDs. The absorption point can be corrected with the image recognition unit by aiming at the center of the hole on the bottom surface of the cavity. Please refer to the following pictures for the image recognition unit.



for ref. Panasonic CM Mounter



for ref. Yamaha YS Mounter

3-2. Problem 2: Absorption error due to air leak

By the presence of the lens, the contact area of a pick-and-place nozzle and the lens is limited, which sometimes causes air leak, resulting in absorption error. In such cases, please change the absorption power into a more appropriate value. Judging from Nichia's evaluation results, the LEDs can be properly mounted by adjusting the absorption power from -40 to -90 kpa.

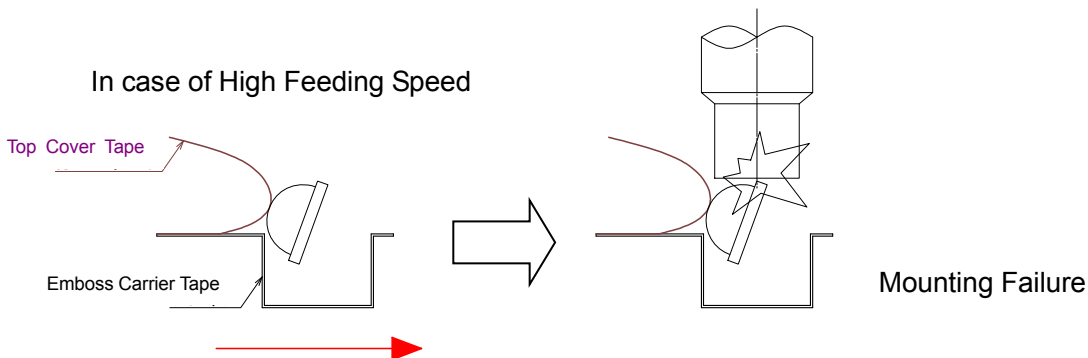
3-3. Problem 3: LED tilting within the cavity due to its adhesion to the top cover tape

LED lenses are made of resin. Therefore, the lenses sometimes adhere to the top cover tape due to the resin's stickiness. When the cover tape is peeled from the carrier tape, the LEDs tilt within their cavities, resulting in mounting failure.

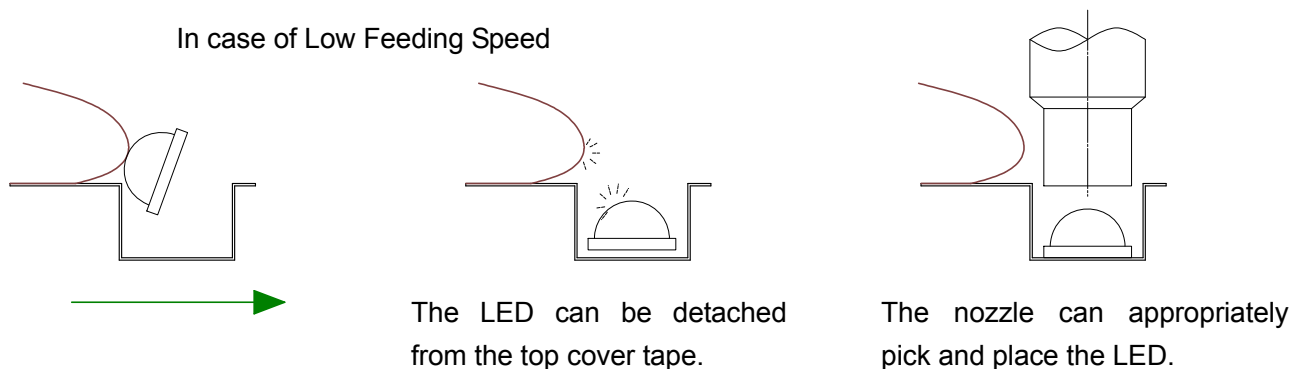
It is impossible to eliminate the stickiness of the lens. Please refer to the following pages for the countermeasures against the LED tilting.

3-3-1. Slow down the feeding speed.

When the feeding speed is fast, the pick-and-place nozzle absorbs the LED before the lens is detached from the top cover tape, resulting in mounting failure.



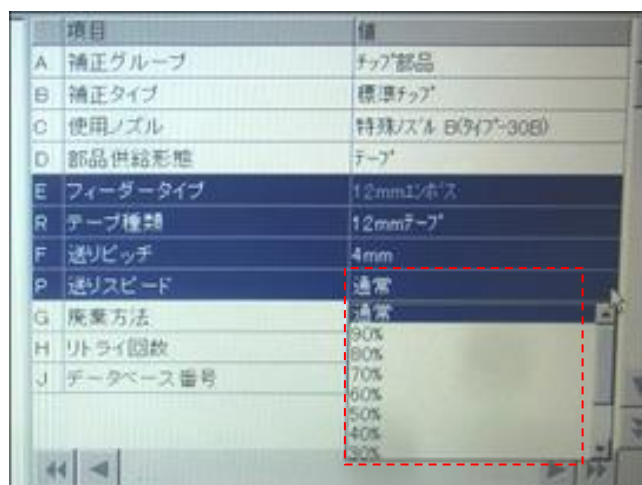
Even when the LED is in contact with the top cover tape; however, by lowering the feeding speed, it can be detached from the tape before absorbed by the nozzle.



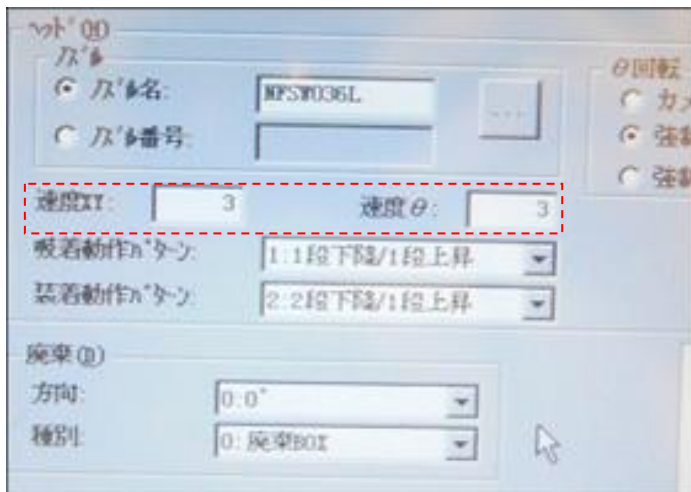
For example, the feeding speed can be changed by the screen as follows:



for ref. Panasonic CM Mounter



for ref. Yamaha YS Mounter

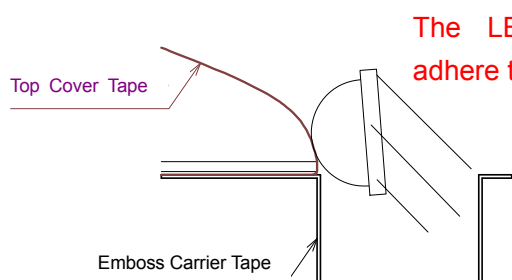


* It is impossible to change the feeding speed of Panasonic BM Mounter. Instead, the operation speed of the head can be lowered, lengthening the absorption pitch.

for ref. Panasonic BM Mounter

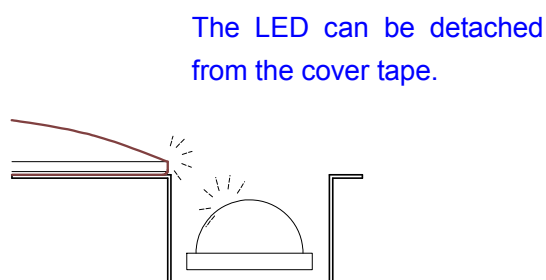
3-3-2. Change the peeling angle.

As the following figures show, when the top cover tape is peeled off from the emboss carrier tape in an acute angle, the LED can be easily detached from the top cover tape, preventing it from tilting within the cavity.



The LED continues to adhere to the cover tape.

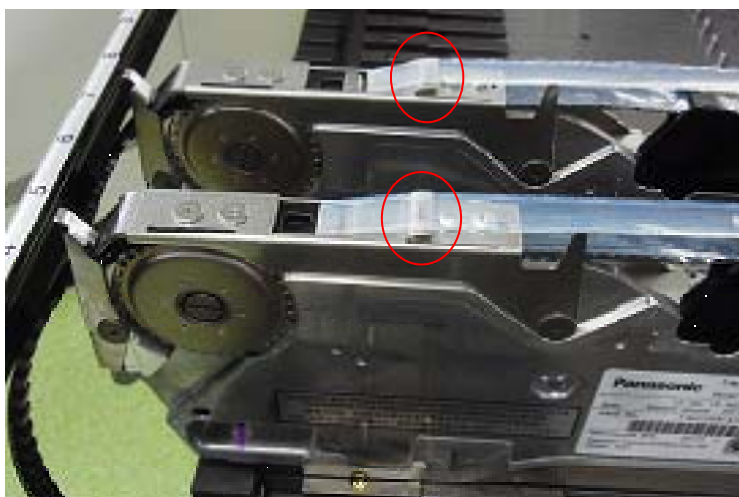
Peeling Angle: Obtuse



The LED can be detached from the cover tape.

Peeling Angle: Acute

The peeling angle can be adjusted to its optimal value by some of the mounters as follows:



for ref. Panasonic CM Mounter

3-4. Problem 4: LED tilting within the cavity due to vibration of the emboss carrier tape

When an excessive vibration is applied to the emboss carrier tape, LEDs may tilt within the cavities.

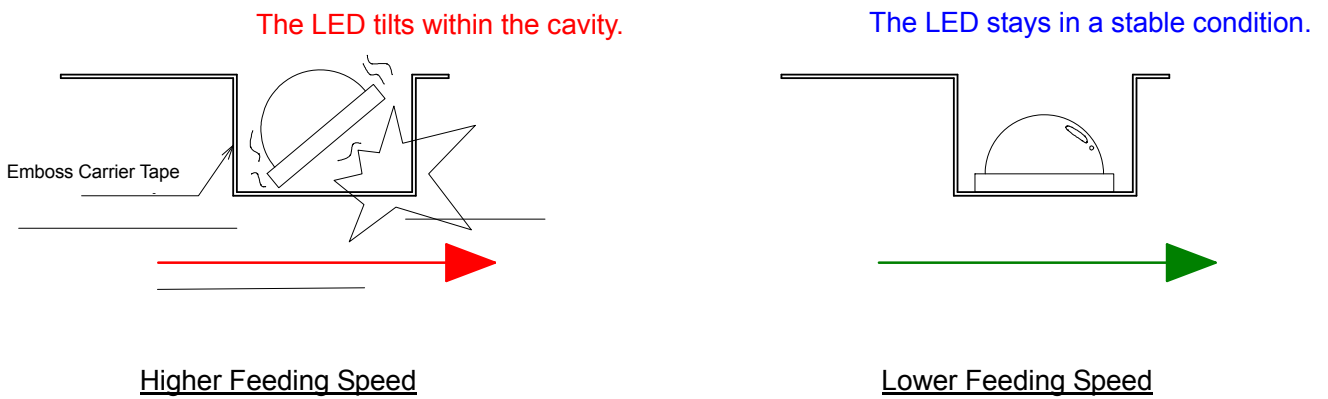
LEDs with a lens are susceptible to vibration, resulting in tilting, since its center of gravity is located higher.

3-4-1. Slow down the feeding speed.

The higher the feeding speed is, the more the vibration affects the LEDs within the cavities. When LEDs tilt within the cavities, please lower the feeding speed to decrease the vibration.

(For ref. Nichia recommends that the feeding speed should be a little slower than high speed.)

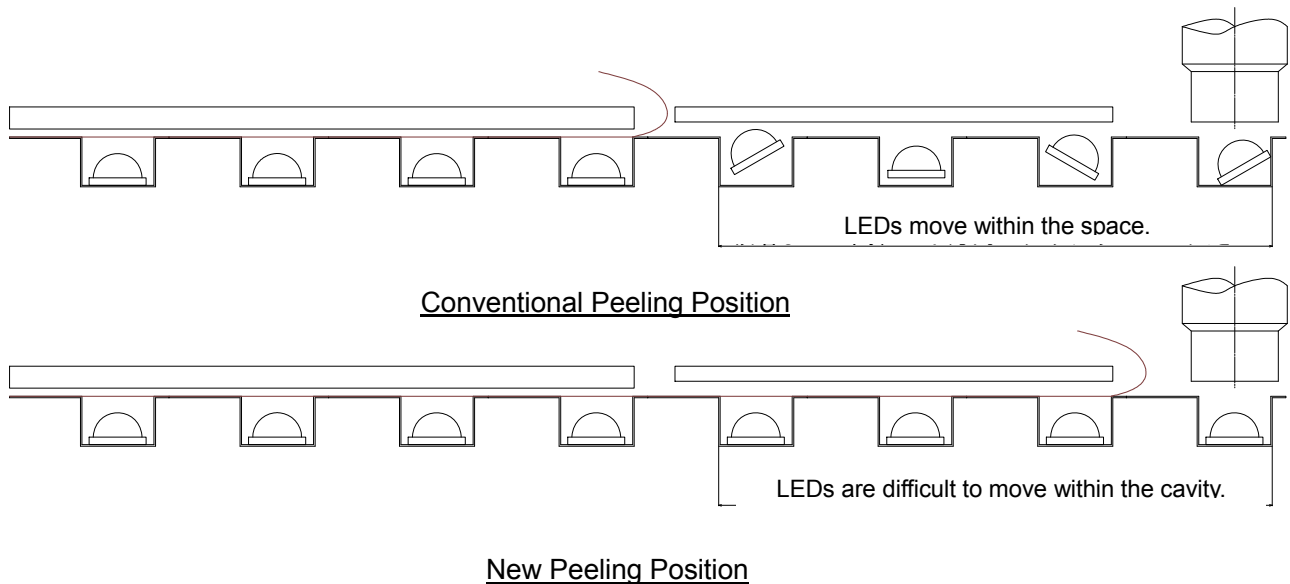
The carrier tape may be vibrated by an air feeder much more than an electric feeder. Please select the feeder depending on the LEDs to ensure that they are properly mounted.

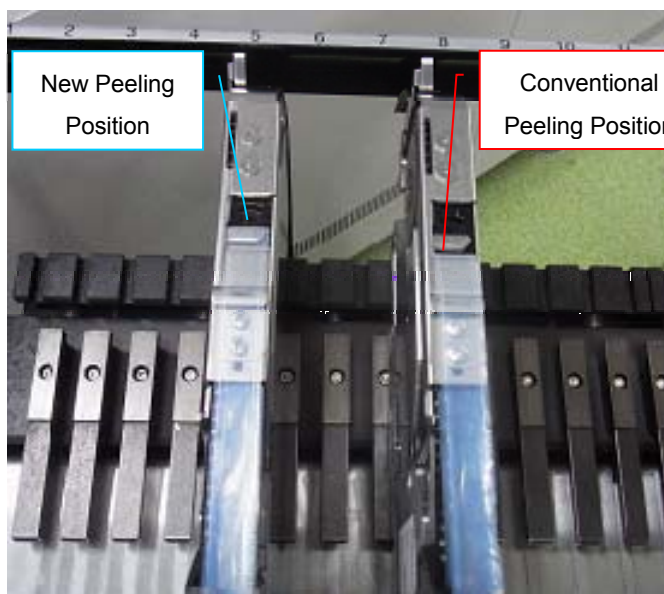


3-4-2. Change the peeling point.

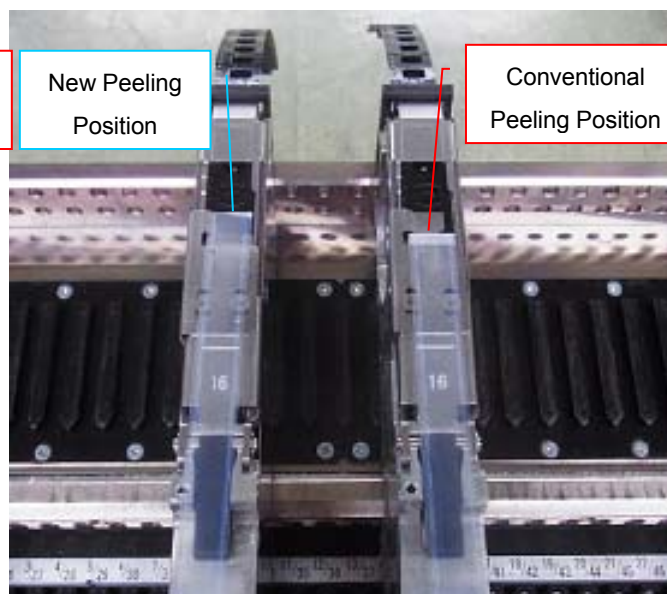
When the top cover tape is peeled off from the emboss carrier tape long before the nozzle comes down to absorb an LED, some of the LEDs move around within the space between the feeder cover and the carrier tape, leading to LED tilting.

Please peel off the cover tape just before the nozzle comes down to absorb an LED. Then, LED's up-and-down movement can be restricted, preventing from LED tilting.

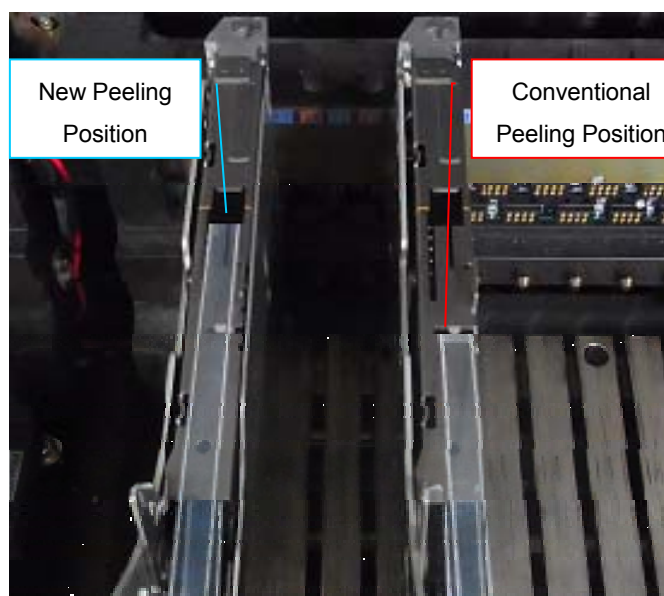




for ref. Panasonic CM Mounter



for ref. Yamaha YS Mounter



for ref. Panasonic BM Mounter

Comparison of the Peeling Positions

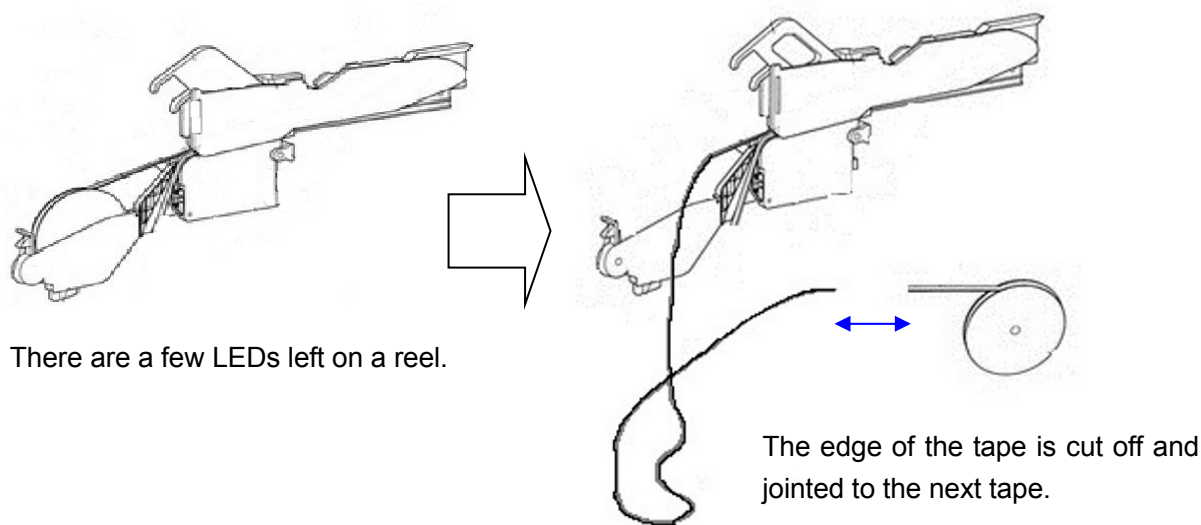
* Please note that some of the mounters are equipped with a shutter. In such cases, it is impossible to change the peeling position of the top cover tape.

4. Caution

Please refrain from splicing the tape together.

“Splicing” stands for the tape joint process while the mounter is operated. When there are a few LEDs left on the reel which is loaded on the mounter, some customers cut off and joint the edge of the tape to the next tape without detaching the feeder from the device. The splicing is to raise the machine utilization without bringing the device to a halt.

The splicing, however, may lead to the LED mounting failure; the LEDs may be tilted within the cavities due to the external stress applied to the carrier tape.



Splicing

5. Notice

Some mounting techniques for LEDs with a lens are described herein; however, they don't fit in with all the mounters. Please select the optimal mounting techniques depending on the LED model and the mounter.

Nichia will aim to continue collecting data concerning the mounting techniques and offering beneficial information to our customers.

When you are concerned about any mounting technique, please contact us.

We would appreciate your cooperation.