PART NO. NVSU219CT

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

### (1) Absolute Maximum Ratings

<table>
<thead>
<tr>
<th>Item</th>
<th>Symbol</th>
<th>Absolute Maximum Rating</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Forward Current</td>
<td>$I_{F}$</td>
<td>1400</td>
<td>mA</td>
</tr>
<tr>
<td>Pulse Forward Current</td>
<td>$I_{FP}$</td>
<td>2000</td>
<td>mA</td>
</tr>
<tr>
<td>Allowable Reverse Current</td>
<td>$I_{R}$</td>
<td>85</td>
<td>mA</td>
</tr>
<tr>
<td>Power Dissipation</td>
<td>$P_{d}$</td>
<td>5.04</td>
<td>W</td>
</tr>
<tr>
<td>Operating Temperature</td>
<td>$T_{opr}$</td>
<td>-10~85</td>
<td>°C</td>
</tr>
<tr>
<td>Storage Temperature</td>
<td>$T_{stg}$</td>
<td>-40~100</td>
<td>°C</td>
</tr>
<tr>
<td>Junction Temperature</td>
<td>$T_{J}$</td>
<td>130</td>
<td>°C</td>
</tr>
</tbody>
</table>

* Absolute Maximum Ratings at $T_{S}=25^\circ$C.
* $I_{FP}$ conditions with pulse width ≤10ms and duty cycle ≤10%.

### (2) Initial Electrical/Optical Characteristics

<table>
<thead>
<tr>
<th>Item</th>
<th>Symbol</th>
<th>Condition</th>
<th>Typ</th>
<th>Max</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Forward Voltage</td>
<td>$V_F$</td>
<td>$I_F=700mA$</td>
<td>3.1</td>
<td>-</td>
<td>V</td>
</tr>
<tr>
<td>Radiant Flux</td>
<td>$\Phi_e$</td>
<td>$I_F=700mA$</td>
<td>1420</td>
<td>-</td>
<td>mW</td>
</tr>
<tr>
<td>Peak Wavelength</td>
<td>$\lambda_p$</td>
<td>$I_F=700mA$</td>
<td>405</td>
<td>-</td>
<td>nm</td>
</tr>
<tr>
<td>Spectrum Half Width</td>
<td>$\Delta \lambda$</td>
<td>$I_F=700mA$</td>
<td>12</td>
<td>-</td>
<td>nm</td>
</tr>
<tr>
<td>Thermal Resistance</td>
<td>$R_{ThS}$</td>
<td>-</td>
<td>2.4</td>
<td>3.1</td>
<td>°C/W</td>
</tr>
</tbody>
</table>

* Characteristics at $T_{S}=25^\circ$C.
* Radiant Flux value as per CIE 127:2007 standard.
* $R_{ThS}$ 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

<table>
<thead>
<tr>
<th>Item</th>
<th>Rank</th>
<th>Min</th>
<th>Max</th>
<th>Unit</th>
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</thead>
<tbody>
<tr>
<td>Forward Voltage</td>
<td>L</td>
<td>3.2</td>
<td>3.6</td>
<td>V</td>
</tr>
<tr>
<td></td>
<td>K2</td>
<td>3.0</td>
<td>3.2</td>
<td></td>
</tr>
<tr>
<td></td>
<td>K1</td>
<td>2.8</td>
<td>3.0</td>
<td></td>
</tr>
<tr>
<td>Radiant Flux</td>
<td>P10d21</td>
<td>1600</td>
<td>1740</td>
<td>mW</td>
</tr>
<tr>
<td></td>
<td>P9d22</td>
<td>1460</td>
<td>1600</td>
<td></td>
</tr>
<tr>
<td></td>
<td>P9d21</td>
<td>1340</td>
<td>1460</td>
<td></td>
</tr>
<tr>
<td></td>
<td>P8d22</td>
<td>1230</td>
<td>1340</td>
<td></td>
</tr>
<tr>
<td>Peak Wavelength</td>
<td>U405</td>
<td>400</td>
<td>410</td>
<td>nm</td>
</tr>
</tbody>
</table>

* Ranking at $T_s=25^\circ C$.
* Forward Voltage Tolerance: ±0.05V
* Radiant Flux Tolerance: ±6%
* Peak Wavelength Tolerance: ±3nm
* LEDs from the above ranks will be shipped. The rank combination ratio per shipment will be decided by Nichia.
This product complies with RoHS Directive.

* 本製品はRoHS指令に適合しております。

**OUTLINE DIMENSIONS**

(單位 Unit: mm, 公差 Tolerance: ±0.2)

<table>
<thead>
<tr>
<th>項目 Item</th>
<th>内容 Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>パッケージ材質 Package Materials</td>
<td></td>
</tr>
<tr>
<td>プリコート材質 Pre-coating Materials</td>
<td>シリコーン樹脂 Silicone Resin</td>
</tr>
<tr>
<td>レンズ材質 Lens Materials</td>
<td>シリコーン樹脂 Silicone Resin</td>
</tr>
<tr>
<td>電極材質 Electrodes Materials</td>
<td>金メッキ Au-plated</td>
</tr>
<tr>
<td>ダイヒートシンク材質 Die Heat Sink Materials</td>
<td>金メッキ Au-plated</td>
</tr>
<tr>
<td>質量 Weight</td>
<td>0.030g (TYP)</td>
</tr>
</tbody>
</table>
SOLDERING

- **Recommended Reflow Soldering Condition** (Lead-free Solder)

  - Pre-heat: 180 to 200°C
  - 120 sec Max
  - 60 sec Max Above 220°C
  - 260°C Max 10 sec Max
  - 1 to 5°C per sec

- **Recommended Soldering Pad Pattern**

  (单位 Unit: mm)

  - 0.5
  - 0.4
  - 0.5
  - 3.3
  - 4.1
  - 1.2

* 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 the LEDs are cooled from the peak reflow temperature, ensure that the cooling is performed very gradually to avoid excessive stress on the LED (e.g. causing cracks in the solder joints). Ensure that sufficient preliminary verification is performed to ensure that there are no issues with the chosen reflow soldering conditions/process.

* 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 internal connection to fail causing a catastrophic failure (i.e. the LED not to illuminate) and/or reliability issues (e.g. the LED to corrode and/or to become dimmer, 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.
* 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.
* The Die Heat Sink should be soldered to customer PCB. If it is difficult or impossible, use high heat-dissipating adhesive.
* 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.
* This LED has all the electrodes on the backside; solder connections will not be able to be seen nor confirmed by a normal visual inspection. Ensure that sufficient verification is performed on the soldering conditions prior to use to ensure that there are no issues.
**TAPE AND REEL DIMENSIONS**

Teaping Tape

- 
  - Cathode Mark
  - Φ 1.5±0.1

- 8±0.1 4.75±0.1

- 0.35±0.05

- 3.7±0.1

Trailer and Leader

- Trailer part / Leader part
- Feeding direction
- Embossed Carrier Tape
- Top Cover Tape

- Trailer part 160mm MIN (Empty Pockets)
- LED loaded pockets
- Leader part 100mm MIN (Empty Pocket)
- Leader part 400mm MIN

Reel

- Reel size: 3500 pcs

- φ 10±0.1

- 13.5±1

- 17.5±1

* The tape packing method complies with JIS C 0806 (Packaging of Electronic Components on Continuous Tapes).

* The LEDs may stick to the top cover tape.

* JIS C 0806 電子部品テープングに準拠しています。
Reels are shipped with desiccants in heat-sealed moisture-proof bags.

警告ラベル

UV LED
- 「UV LEDは紫外領域の光(UV光)を発します。」
- 「UV光は人間の目には見えませんが、光が見えているわけでもないのに目を炎のように煮える可能性があります。」
- 「UV光を直接見ないでください。必ず適切な防具を着用してください。」
- 「UV LEDを含む製品は、適切な警告表示をしてください。」

UV LEDs emit light in the ultraviolet region (UV light).

UV light is invisible and may be harmful to the human eye.

Do not expose the eyes directly to the UV light.

Wear appropriate protective gear when handling.

Use appropriate warning signs/labels on devices using the UV LEDs.

* ****** is the customer part number.
 If not provided, it will not be indicated on the 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。

* For details, see "LOT NUMBERING CODE" in this document.
 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。

* 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.
 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。

* Do not drop or expose the box to external forces as it may damage the products.
 取り扱いに関して、落下させたり、強い衝撃を与えると、製品を破壊させる原因になりますので注意して下さい。

* Do not expose to water. The box is not water-resistant.
 ダンボールには防水加工がされておりませんので、箱包箱が水に濡れないよう注意して下さい。

* Using the original package material or equivalent in transit is recommended.
 輸送、運搬に際して弊社よりの箱包状態あるいは同等の箱包を行って下さい。

* Products shipped on tape and reel are packed in a moisture-proof bag.
 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。

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 取り扱いに関して、落下させたり、強い衝撃を与えると、製品を破壊させる原因になりますので注意して下さい。

* Do not expose to water. The box is not water-resistant.
 ダンボールには防水加工がされておりませんので、箱包箱が水に濡れないよう注意して下さい。

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 輸送、運搬に際して弊社よりの箱包状態あるいは同等の箱包を行って下さい。
**LOT NUMBERING CODE**

Lot Number is presented by using the following alphanumeric code.

YMxxxx - RRR

Y - Year

<table>
<thead>
<tr>
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<tbody>
<tr>
<td>2018</td>
<td>I</td>
</tr>
<tr>
<td>2019</td>
<td>J</td>
</tr>
<tr>
<td>2020</td>
<td>K</td>
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<td>2021</td>
<td>L</td>
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<tr>
<td>2022</td>
<td>M</td>
</tr>
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<td>2023</td>
<td>N</td>
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</table>

M - Month

<table>
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<th>Month</th>
<th>M</th>
</tr>
</thead>
<tbody>
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<td>1</td>
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<table>
<thead>
<tr>
<th>Month</th>
<th>M</th>
</tr>
</thead>
<tbody>
<tr>
<td>7</td>
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<td>9</td>
<td>9</td>
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<tr>
<td>10</td>
<td>A</td>
</tr>
<tr>
<td>11</td>
<td>B</td>
</tr>
<tr>
<td>12</td>
<td>C</td>
</tr>
</tbody>
</table>

xxxx-Nichia's Product Number

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

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

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

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

* The graphs above show the characteristics for U405x LEDs of this product.
本特性はピーク波長ランクU405xに対応しています。
OPTICAL CHARACTERISTICS

* All characteristics shown are for reference only and are not guaranteed.

* The graphs above show the characteristics for U405x LEDs of this product.

---

**Spectrum**

![Spectrum Graph]

---

**Directivity**

![Directivity Graph]

---

Part No. NVSU219C
No. STS-DA7-16138
* All characteristics shown are for reference only and are not guaranteed.

**FORWARD CURRENT CHARACTERISTICS / TEMPERATURE CHARACTERISTICS**

* The graphs above show the characteristics for U405x LEDs of this product.

---

**Forward Voltage vs Forward Current**

![Graph 1](attachment:image1.png)

**Ambient Temperature vs Forward Voltage**

![Graph 2](attachment:image2.png)

**Forward Current vs Relative Radiant Flux**

![Graph 3](attachment:image3.png)

**Ambient Temperature vs Relative Radiant Flux**

![Graph 4](attachment:image4.png)

---

* 本特性は参考です。
FORWARD CURRENT CHARACTERISTICS / TEMPERATURE CHARACTERISTICS

* All characteristics shown are for reference only and are not guaranteed.

* The graphs above show the characteristics for U405x LEDs of this product.

---

**Forward Current vs Peak Wavelength**

顺電流-ピーク波長特性

\[
T_a=25^\circ C
\]

**Ambient Temperature vs Peak Wavelength**

周囲温度-ピーク波長特性

\[
I_p=700 mA
\]

---

Part No. NVSU219C
No. STS-DA7-16140

* 本特性は参考です。
## RELIABILITY

### (1) Tests and Results

<table>
<thead>
<tr>
<th>Test</th>
<th>Reference Standard</th>
<th>Test Conditions</th>
<th>Test Duration</th>
<th>Failure Criteria</th>
<th>#</th>
<th>Units Failed/Tested</th>
</tr>
</thead>
<tbody>
<tr>
<td>Resistance to Soldering Heat</td>
<td>JEITA ED-4701</td>
<td>$T_{\text{ref}}=260^\circ\text{C}, 10\text{sec}, 2\text{reflows},$</td>
<td></td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td>(Reflow Soldering)</td>
<td>300 301</td>
<td>Precondition: $30^\circ\text{C}, 70%\text{RH}, 168\text{hr}$</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temperature Cycle</td>
<td>JEITA ED-4701</td>
<td>$-40^\circ\text{C}(30\text{min})\sim25^\circ\text{C}(5\text{min})\sim$</td>
<td>100cycles</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td>100 105</td>
<td>$100^\circ\text{C}(30\text{min})\sim25^\circ\text{C}(5\text{min})$</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>High Temperature Storage</td>
<td>JEITA ED-4701</td>
<td>$T_A=100^\circ\text{C}$</td>
<td>1000hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td>200 201</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temperature Humidity Storage</td>
<td>JEITA ED-4701</td>
<td>$T_A=60^\circ\text{C}, RH=90%$</td>
<td>1000hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td>100 103</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Low Temperature Storage</td>
<td>JEITA ED-4701</td>
<td>$T_A=-40^\circ\text{C}$</td>
<td>1000hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td>200 202</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Room Temperature Operating Life</td>
<td></td>
<td>$T_A=25^\circ\text{C}, I_F=1400\text{mA}$</td>
<td>1000hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>High Temperature Operating Life</td>
<td></td>
<td>$T_A=85^\circ\text{C}, I_F=1000\text{mA}$</td>
<td>1000hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
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<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temperature Humidity Operating Life</td>
<td></td>
<td>$60^\circ\text{C}, RH=90%, I_F=700\text{mA}$</td>
<td>500hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Low Temperature Operating Life</td>
<td></td>
<td>$T_A=-10^\circ\text{C}, I_F=700\text{mA}$</td>
<td>1000hours</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Vibration</td>
<td>JEITA ED-4701</td>
<td>$200\text{m/s}^2, 100\sim2000\sim100\text{Hz},$</td>
<td>48minutes</td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td>400 403</td>
<td>$4\text{cycles}, 4\text{min},$ each $X, Y, Z$</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Electrostatic Discharges</td>
<td>JEITA ED-4701</td>
<td>HBM, $2\text{kV}, 1.5\text{k}\Omega, 100\text{pF}, 3\text{pulses},$</td>
<td></td>
<td>#1</td>
<td>0/10</td>
<td></td>
</tr>
<tr>
<td></td>
<td>300 304</td>
<td>alternately positive or negative</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

NOTES:
1) $R_{\text{θJA}}\approx 9.9^\circ\text{C/W}$
2) Measurements are performed after allowing the LEDs to return to room temperature.

### (2) Failure Criteria

<table>
<thead>
<tr>
<th>Criteria #</th>
<th>Items</th>
<th>Conditions</th>
<th>Failure Criteria</th>
</tr>
</thead>
<tbody>
<tr>
<td>#1</td>
<td>Forward Voltage($V_F$)</td>
<td>$I_F=700\text{mA}$</td>
<td>$&gt;\text{Initial value}\times1.1$</td>
</tr>
<tr>
<td>#1</td>
<td>Radiant Flux($\Phi_E$)</td>
<td>$I_F=700\text{mA}$</td>
<td>$&lt;\text{Initial value}\times0.7$</td>
</tr>
</tbody>
</table>
CAUTIONS

(1) Storage

<table>
<thead>
<tr>
<th>Conditions</th>
<th>Temperature</th>
<th>Humidity</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>Storage</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Before Opening Aluminum Bag</td>
<td>≤30°C</td>
<td>≤90%RH</td>
<td>Within 1 Year from Delivery Date</td>
</tr>
<tr>
<td>After Opening Aluminum Bag</td>
<td>≤30°C</td>
<td>≤70%RH</td>
<td>≤168 hours</td>
</tr>
<tr>
<td>Baking</td>
<td>65±5°C</td>
<td>-</td>
<td>≥24 hours</td>
</tr>
</tbody>
</table>

- 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.

![Circuits A and B](image)

- 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 ≥ 10% of the sorting current.
- Ensure that transient excessive voltages (e.g. lightning 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 product is stored and/or used constantly under 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 there are no issues for the chosen application.
- Do not design this LED into applications where condensation may occur. If the LEDs are stored/operated in these environments, it may cause issues (e.g. current leaks that cause the radiant flux to decrease).
- 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 as it will contaminate the LED surface and may affect the optical characteristics: it might cause the LED to be deformed and/or the bump to break, which will cause 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 internal connection to fail 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 internal connection to fail causing a catastrophic failure (i.e. the LED not to illuminate).
(4) Design Consideration

- 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.

(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 (≤1mA).
- 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) $T_J = T_A + R_{θJA} \times W$
  2) $T_J = T_S + R_{θJS} \times W$

  *$T_J$ = LED Junction Temperature: °C
  *$T_A$ = Ambient Temperature: °C
  *$T_S$ = Soldering Temperature (Cathode Side): °C
  *$R_{θJA}$ = Thermal Resistance from Junction to Ambient: °C/W
  *$R_{θJS}$ = 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 IATF 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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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.

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.
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.

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.

![Diagram showing in case of high feeding speed and 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.

![Diagram showing in case of low feeding speed]

The LED can be detached from the top cover tape. The nozzle can appropriately pick and place the LED.

For example, the feeding speed can be changed by the screen as follows:
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 peeling angle can be adjusted to its optimal value by some of the mounters as follows:

* 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.
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.
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.

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.