

**SOLDERING GUIDANCE  
(VPC Series)**

## 1. Manual Soldering

### 1) Operating Condition

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

### 2) Cautions

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

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

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

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### [Head Office]

15 Unam-ro, Deokjin-gu, Jeonju-si, Jeollabuk-do, 561-202, Korea(837-1 Palbok-Dong 2-ga)  
Tel : 82-63-715-3020(Rep.) Fax : 82-63-715-3021

### [Sales Office]

(AcroTower) B-607, Simindae-ro 230, Dongan-gu, Anyang-si, Gyeonggi-do, 14067, Korea  
E-mail: [hycap@vina.co.kr](mailto:hycap@vina.co.kr) Tel : 82-31-448-3066(Rep.) Fax : 82-31-448-3067