

DATA SHEET

THROUGH-HOLE RESISTORS

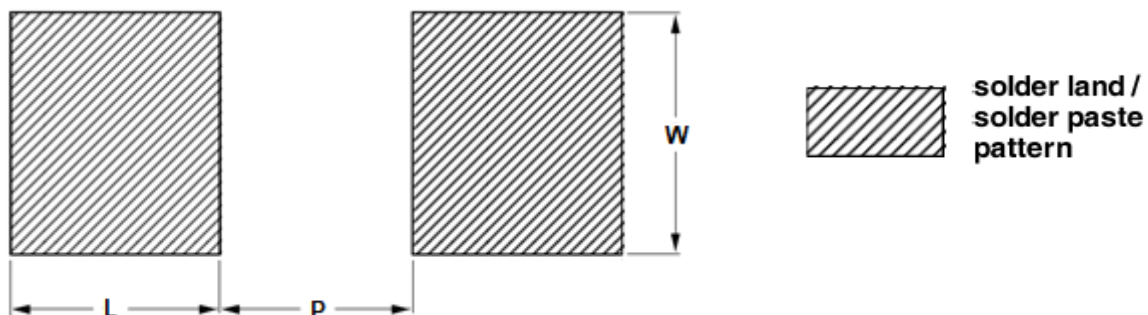
Recommended soldering profile



YAGEO

Product specification – February 7, 2023 V.0



SUGGESTED PAD LAYOUT DIMENSIONS

Unit: mm

Normal	Miniature	Ultra Miniature	Soldering Mode	L Min.	P	W Min.
MMF-12 MCF-12	MMF25S MCF25S		Reflow	1.3	1.6 ± 0.1	1.6
	MMF204 MCF204		Wave	1.5	1.5 ± 0.1	1.8
MMF-25 MCF-25	MMF50S MCF50S	MMP100 MCP100	Reflow	2.0	3.0 ± 0.1	3.0
	MMF207 MCF207		Wave	2.5	3.0 ± 0.1	3.0
MMF-50 MCF-50	MMF1WS MCF1WS	MMP200 MCP200	Reflow	2.3	5.5 ± 0.2	4.0
			Wave	2.8	5.5 ± 0.2	4.0
MWP100	MWP2WS		Reflow	3.0	4 ± 0.3	2.8
			Wave			
MWP200	MWP3WS		Reflow	3.5	7 ± 0.3	3.0
			Wave			
MWP300	MWP5WS		Reflow	3.8	8.2 ± 0.3	3.0
			Wave			

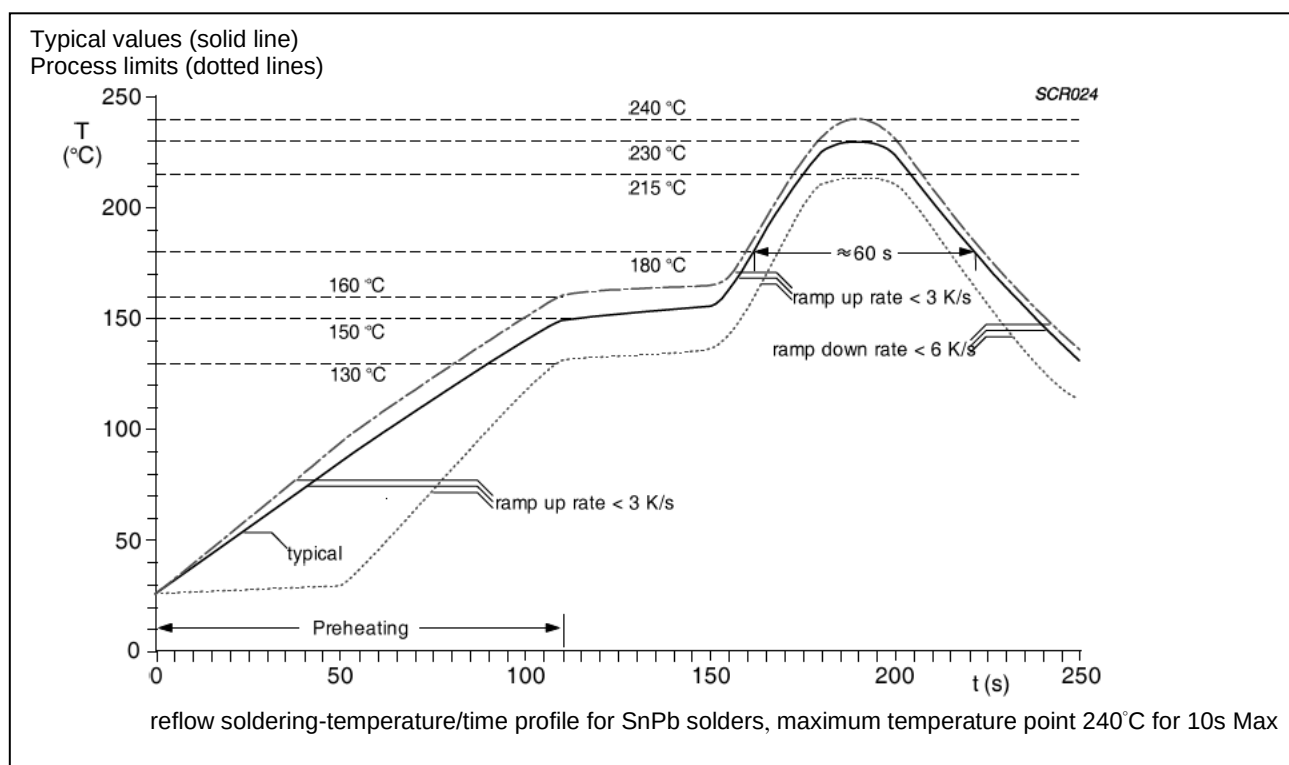
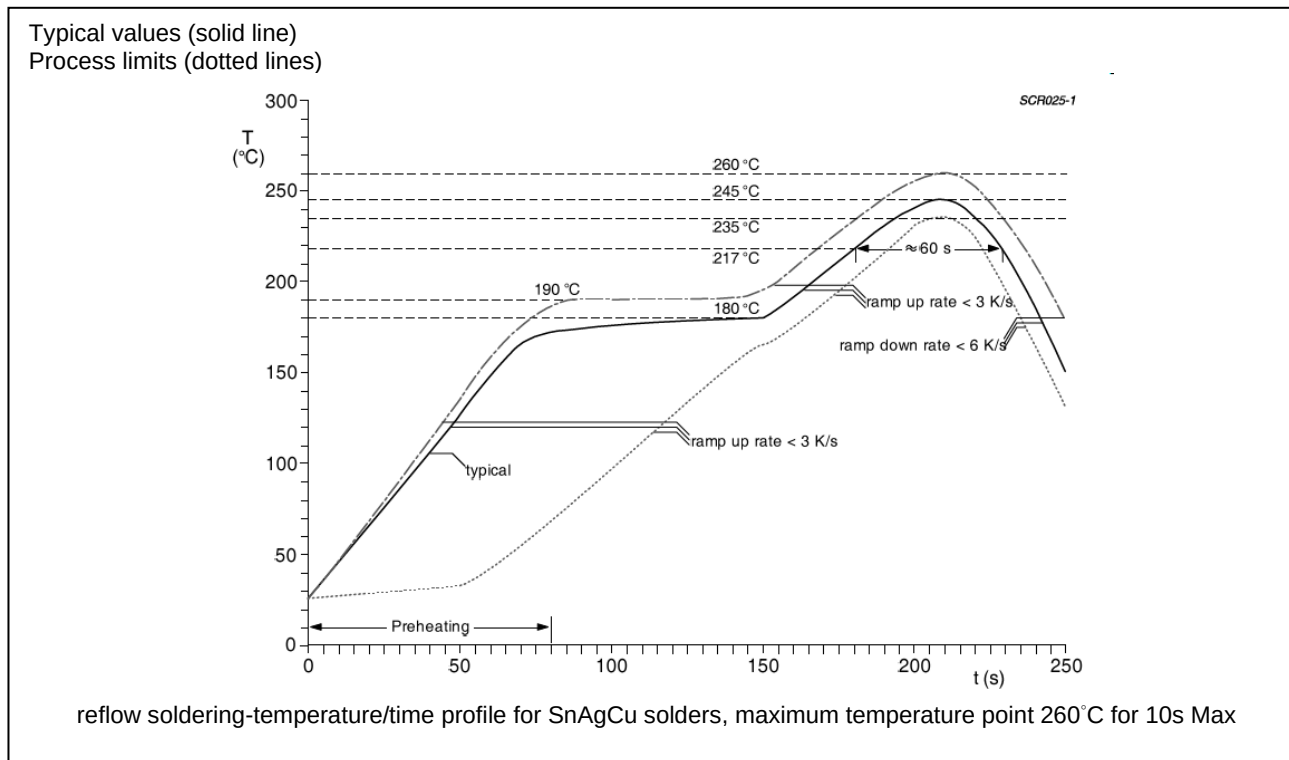
SOLDERING CONDITIONS

The graph below represents the recommended wave soldering profile and reflow soldering according to IEC61760-1.

Reflow soldering profile

The lead free Surface Mount Resistors are able to stand the reflow soldering conditions as below:

- Temperature: above 220 °C
- Endurance: 95 to 120 seconds
- Cycles: 3 times

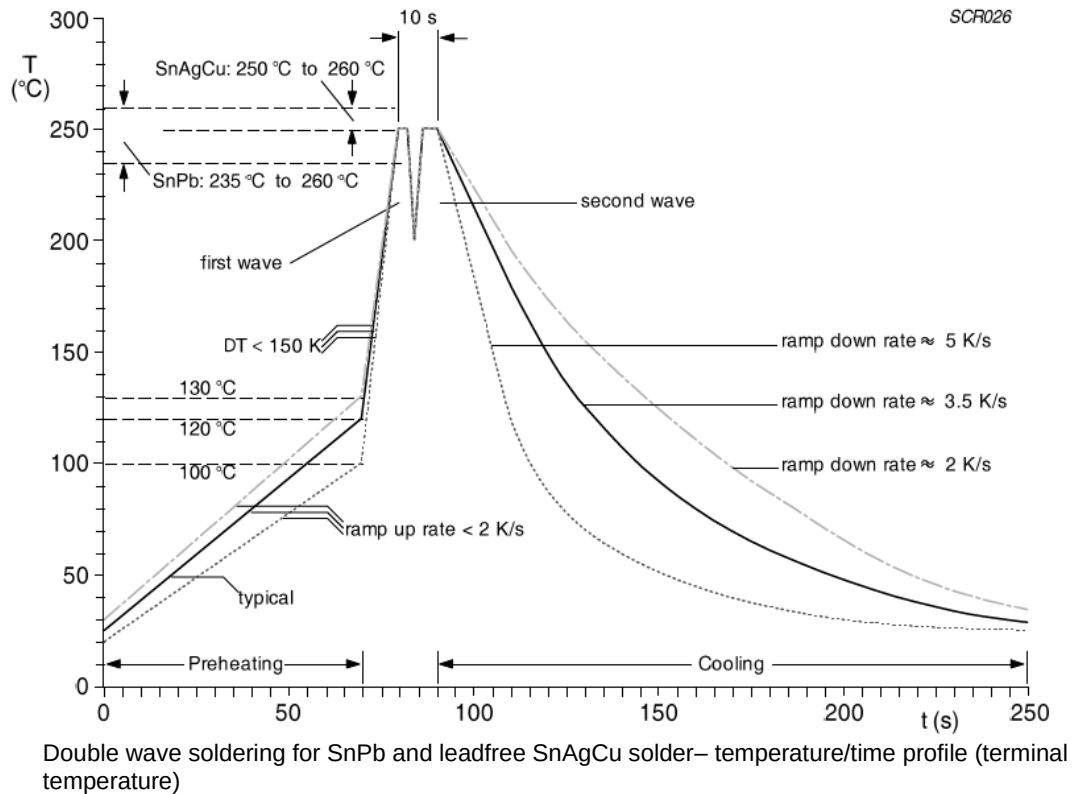


Wave soldering profile

Typical values (solid line)

Process limits (dotted lines)

The resistors may be soldered twice in accordance with this method if desired

**Hand Soldering profile**

Tip temperature when using a soldering iron : $350 \pm 10^\circ\text{C}$ for 3 s

REVISION HISTORY

REVISION	DATE	CHANGE NOTIFICATION	DESCRIPTION
Version 0	Jan. 13, 2023	-	- First issue of this specification