

Advice for soldering LC-Displays with pins

The regulations of RoHS and the thereby related change from leaded to lead-free pins presume higher soldering temperatures.

Therefore it has to be taken care that:

- pulling or pressing exposures may lead to failures at the contact area, glass to pins.
- the contact pins have to be soldered principally without any mechanical tension.
- pins with a length <6 mm do require special precautions.
Under certain circumstances the LCD's have to be soldered manually.
- the top and bottom polarizer of the LCD will get damaged if the temperature exceeds +70°C~75°C.
- the LCD is covered for the wave soldering process.

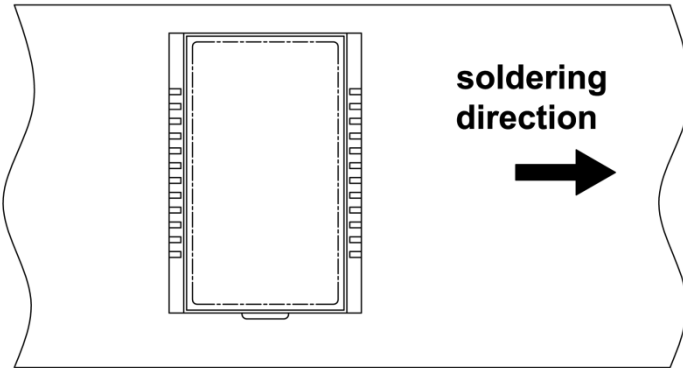
For wave soldering, please find the subsequent pages:

- a.) solder direction
- b.) temperature profile

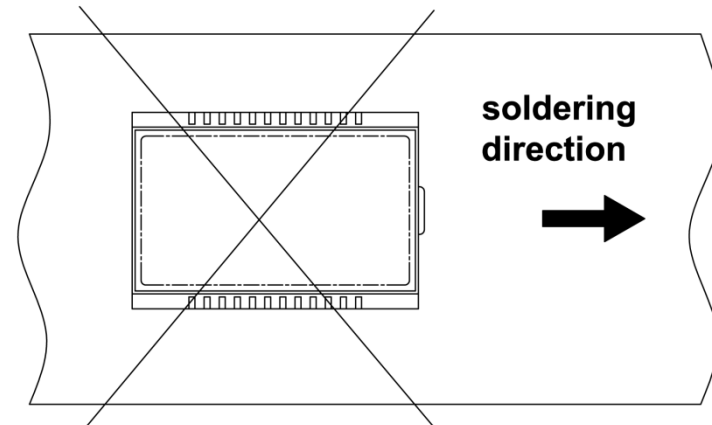
Drawing: Solder direction

Solder direction for wave soldering.

RIGHT



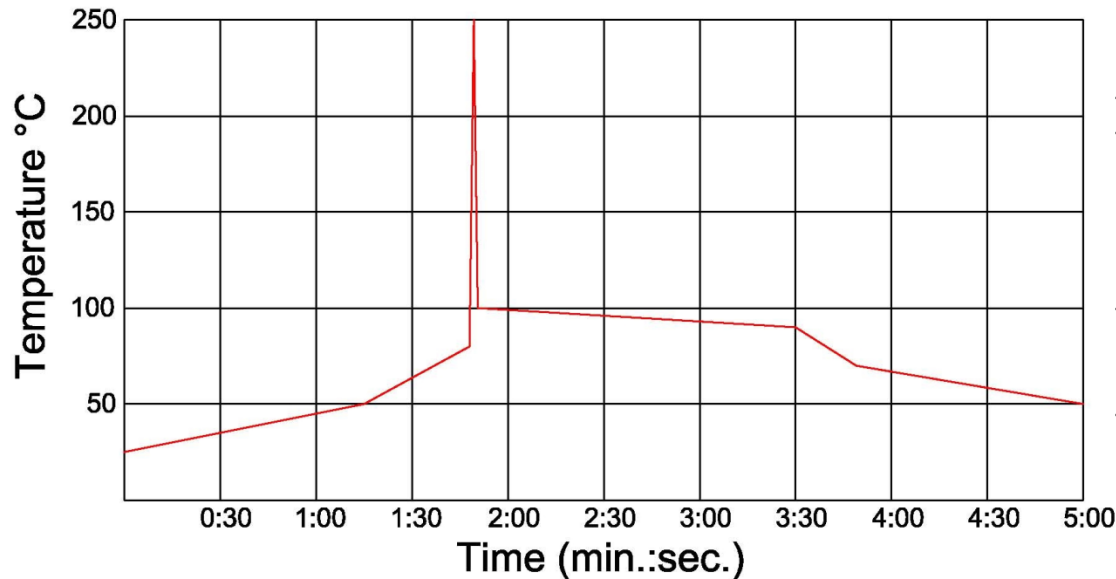
WRONG



Drawing Temperature profile

Temperature profile for wave soldering

Soldering profile for bottom side of PCB



Bottom side of PCB:

Max. temperature: 250°C

Time above 140°C: 3 Sec.

Time above 70°C: 2Min.:20 Sec.

Max. acceptable temperature at
Top and bottom polarizor
+70...75°C.

Covering arrangements for a
Temperature protection are
Strongly recommended.