

AN-2029 Handling and Process Recommendations

Application Report



Literature Number: SNOA550E
June 2010–Revised May 2016

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ABSTRACT

This application report provides recommendations for handling, storing, and mounting Texas Instruments' surface mount IC packages.

1 Introduction

The final manufacturing yield and board level reliability are influenced by various factors and processes outside the control of the IC manufacturer. This application note is intended only as a guideline or reference. Due to the variety of possible board assembly materials and equipments, Texas Instruments advises the user to consult their individual suppliers and vendors.

2 Moisture Sensitivity Level

Due to the hygroscopic nature of the plastic encapsulants, the plastic ICs absorb a certain amount of moisture. When subjecting a SMT device to a reflow soldering process (such as infrared, convection, or vapor phase), the moisture inside the package can create excessive internal pressure resulting in delamination or even a cracked package (popcorn effect).

TI's components that are considered moisture sensitive are sealed in moisture barrier bags (MBB) together with a desiccant and a Humidity Indicator Card (HIC). Texas Instruments generally follows Industry Standards IPC/JEDEC J-STD-020 and J-STD-033 to determine the moisture sensitivity level and corresponding floor life time for TI's plastic package types. For details on absolute maximum ratings for soldering, see *Absolute Maximum Ratings for Soldering* ([SNOA549](#)).

The floor life time is the maximum time period from the opening of the MBB to the final reflow soldering process. The MSL Level and floor life time as per [Table 1](#) is provided on TI's immediate and intermediate packing container label. Additionally, the MSL level and the maximum peak package temperature for TI's devices can be found within the Product Folder of TI's website.

Table 1. Moisture Sensitivity Levels (According to IPC-JEDEC J-STD-033C; Section 4)

MSL Level	Floor Life (out of MBB)	
	Time	Conditions
1	Unlimited (no moisture barrier bag)	≤ 30°C / 85% RH
2	1 year	≤ 30°C / 60% RH
2A	4 weeks	≤ 30°C / 60% RH
3	168 hours	≤ 30°C / 60% RH
4	72 hours	≤ 30°C / 60% RH
5	48 hours	≤ 30°C / 60% RH
5A	24 hours	≤ 30°C / 60% RH
6	Mandatory bake before use. After bake, must be reflowed within the time limit specified on the label	≤ 30°C / 60% RH

3 Storage and Shelf Life

Solderability tests were conducted on components after long term storage in warehouse conditions and after exposure to accelerated aging environment. Based upon the results, TI's shelf life of dry-packaged moisture sensitive devices inside the unopened moisture barrier bag is 3 (SSL: Standard Shelf life) or 6 (ESL: Extended Shelf Life) years from the time it was manufactured when stored in an environment not exceeding 30°C / 40%-85% RH per TI's recommendation. MBB has 40°C / 90% RH capability maximum per JEDEC.

Component storage outside the MBB should be soldered within floor life specification on the moisture bag for SMT instruction or placed in a dry storage cabinet at < 25°C and < 10% RH to prevent moisture absorption.

The shelf life with regard to soldering of non dry-packed devices, that is, the MSL1 product has the capability of 3 years for SSL or 6 years for ESL product. To quickly locate shelf life information (SSL or ESL), search by part number using the shelf life search tool (<http://www.ti.com/quality/docs/productshelflife.jsp>).

4 Reflow Soldering

The most popular soldering method for surface mount devices is forced convection reflow and therefore the topic of this chapter. Other possible solder processes for surface mount devices are, with restrictions, infrared reflow (IR) and vapor phase.

NOTE: SMD (Surface Mount Device) is not recommended for flow soldering (wave soldering). TI cannot guarantee device quality if customer applies flow soldering. TI devices are qualified to J-STD-020 standard.

It is not possible for an IC manufacturer to provide a general reflow profile recommendation for a customer in charge of board assembly. Reflow furnace settings depend, for example, on the number of heating and cooling zones, type of solder paste/flux used, board and component size as well as component density.

The actual temperature setting needs to be above the liquidus temperature (solder melting point) of the solder paste in order to form a reliable solder joint, while the upper limit is clearly defined by the maximum peak package body temperature depending on package thickness and volume as provided by IPC /JEDEC J-STD-020; see [Table 2](#) and [Table 3](#).

**Table 2. Maximum Peak Package Body Temperature T_p
(According to IPC-JEDEC J-STD-020E for Pb-Free Process; Section 4)**

Package Thickness	Volume < 350 mm ³	Volume 350-2000 mm ³	Volume > 2000 mm ³
<1.6 mm	260 °C	260 °C	260 °C
1.6 to 2.5 mm	260 °C	250 °C	245 °C
>2.5 mm	250 °C	245 °C	245 °C

Table 3. For SnPb Eutectic Process; Section 4

Package Thickness	Volume < 350 mm ³	Volume ≥ 350 mm ³
<2.5 mm	235 °C	220 °C
≥2.5 mm	220 °C	220 °C

NOTE: Package volume excludes external terminals (such as balls, bumps, lands, leads) and nonintegral heat sinks.

It is important to understand that the temperature profile provided within IPC/JEDEC J-STD-020 reflects the profile used for device (MSL) classification; see [Figure 1](#) and [Table 4](#) with the temperature measured on the top package surface during the reflow soldering process and subject to three cycles of the appropriate reflow conditions as defined in [Table 2](#) and [Table 3](#).

The actual board assembly reflow furnace settings need to be developed separately depending on furnace characteristics and board design. The selected temperatures should not exceed the parameters used for MSL classification.

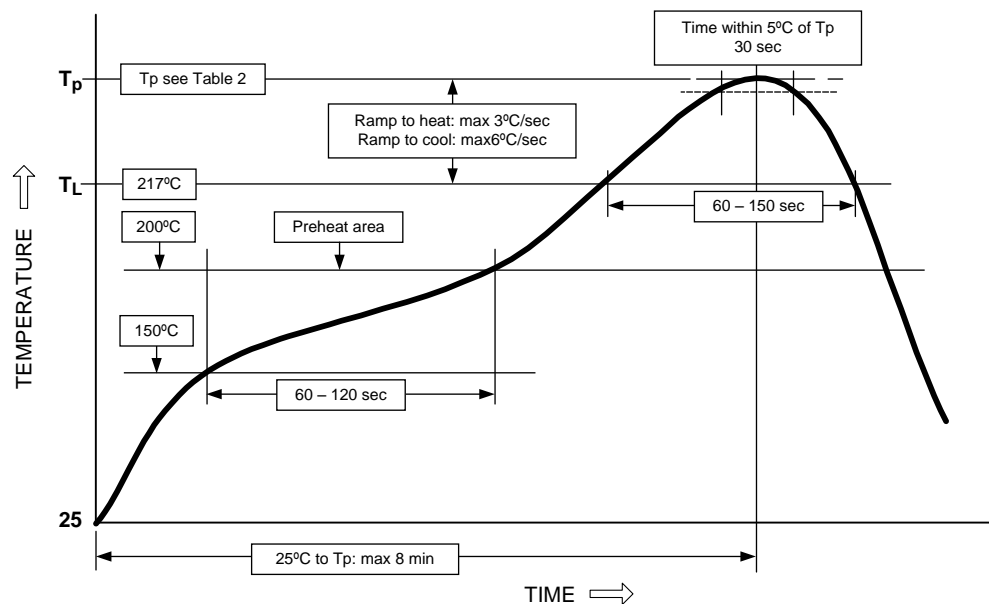


Figure 1. Classification Reflow Profile (Peak Package Body Temperature) for Pb-Free Reflow Soldering

Table 4. Classification Reflow Profile Parameters (according to IPC-JEDEC J-STD-020E Section 5)

Profile Parameter	Pb-Free Assembly	SnPb Assembly
Preheat temperature range	150°C to 200°C	100°C to 150°C
Duration	60 to 120 sec	60 to 120 sec
Ramp-up rate	Max 3°C/sec	Max 3°C/sec
Liquidus temperature T_L	217°C	183°C
Time above T_L	60 to 150 sec	60 to 150 sec
T_P peak package body temperature	See Table 2	See Table 3
Dwell time within 5°C of TP	Max 30 sec	Max 20 sec
Ramp-down rate	Max 6°C/sec	Max 6°C/sec

5 Flow Soldering (Wave Soldering)

The most popular soldering method for through hole devices is forced flow soldering (wave soldering). It is not possible for an IC manufacturer to provide a general soldering recommendation for a customer in charge of board assembly. It is important to understand that the solder temperature should be within J-STD-22 B106 for SnPb and Pb-free solder. The temperature should not exceed the solder heating condition and only devices' leads should be immersed in solder.

5.1 Flux Selection

The key function of flux is to dissolve the oxides on the metal surface to facilitate the wetting of the molten solder. The most commonly used flux is Rosin based with low flux residue activity (ROL0 and ROL1 per IPC-J-STD-004B). Certain active and aggressive fluxes are easy to use but may cause corrosion and contamination if not cleaned properly.

TI recommends using ROL0 or ROL1 type flux with a minimum level of corrosive elements, mild activity level and a pH value close to 7. Fluxes containing chloride should be avoided.

5.2 Wave Soldering Profile

Below are two examples of wave soldering profiles using Eutectic (tin-lead solder) and lead free solder. Neither example is intended to be used as is. Actual wave soldering profiles should be optimized based on PCB thickness, component density and guidelines provided by the solder material supplier.

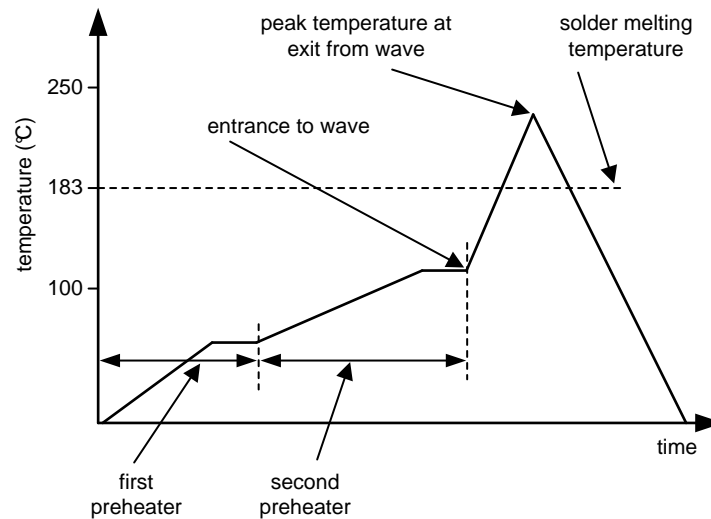


Figure 2. Example of Eutectic (SnPb) Wave Soldering Profile

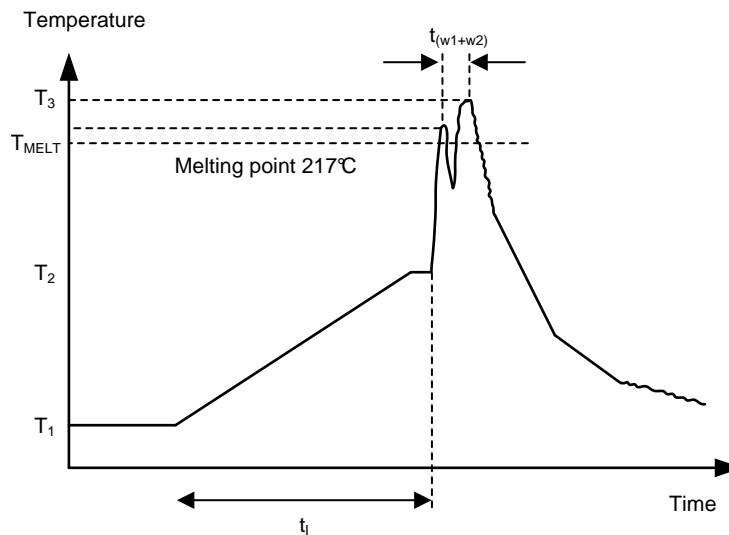


Figure 3. Example of Lead Free Wave Soldering Profile

6 Drying of Components

If the Floor Life time is exceeded or the Humidity Indicator Card indicates excessive moisture after opening the MBB (the color change is described on the HIC card; see [Figure 4](#)), baking is required prior to the reflow process in order to remove any moisture out of the plastic package.

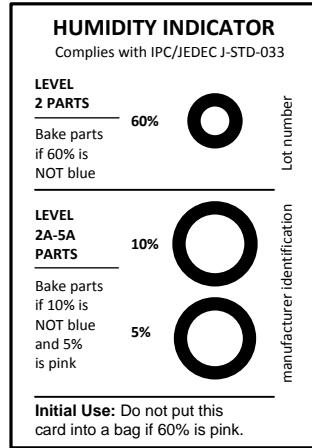


Figure 4. Humidity Indicator Card as per IPC/JEDEC J-STD-033C Section 4

Conditions for drying components depend on package thickness, MSL Level, and baking temperature. [Table 5](#) provides an excerpt of IPC/JEDEC J-STD-033B.1 on drying mounted or unmounted SMD packages. Please note that standard packing material such as tape, reel, and tubes are considered low temperature carriers, and SMD packages may not be baked in these carriers at any temperatures higher than 40° C. Only high temperature trays are able to withstand baking process at 125 °C.

Table 5. Reference Conditions for Drying Mounted and Unmounted SMD Packages (as per IPC-JEDEC J-STD-033C Section 4)

Package Body	Level	Bake at 125°C		Bake at 90°C ≤5% RH		Bake at 40°C ≤5% RH	
		Exceeding Floor Life by >72 h	Exceeding Floor Life by ≤72 h	Exceeding Floor Life by >72 h	Exceeding Floor Life by ≤72 h	Exceeding Floor Life by >72 h	Exceeding Floor Life by ≤72 h
Thickness ≤1.4 mm	2	5 hours	3 hours	17 hours	11 hours	8 days	5 days
	2a	7 hours	5 hours	23 hours	13 hours	9 days	7 days
	3	9 hours	7 hours	33 hours	23 hours	13 days	9 days
	4	11 hours	7 hours	37 hours	23 hours	15 days	9 days
Thickness >1.4 mm ≤2.0 mm	2	18 hours	15 hours	63 hours	2 days	25 days	20 days
	2a	21 hours	16 hours	3 days	2 days	29 days	22 days
	3	27 hours	17 hours	4 days	2 days	37 days	23 days
	4	34 hours	20 hours	5 days	3 days	47 days	28 days
Thickness >2.0 mm ≤4.5 mm	2	48 hours	48 hours	10 days	7 days	79 days	67 days
	2a	48 hours	48 hours	10 days	7 days	79 days	67 days
	3	48 hours	48 hours	10 days	8 days	79 days	67 days
	4	48 hours	48 hours	10 days	10 days	79 days	67 days

Note: For BGA package types >17x17 mm, stacked die packages, or packages with thickness > 4.5 mm, please contact your local TI sales representative.

7 Repair

In case repair or even replacement of a component is needed, it is important that the temperature used for repairing, desoldering, or replacing the component is selected as low as possible to avoid any damage to the adjacent components or PC board. The repair profile should be similar to the actual reflow profile. Common rework tools are either hot gun or available rework machines.

In addition, depending on the MSL level of the component and if the floor life time from initial reflow soldering process to the repair process is exceeded, a baking process is required with parameters provided in IPC/JEDEC J-STD-033B.1. Otherwise, the accumulated moisture can cause damage as described in the previous chapters.

Proper handling practices are required to prevent any ESD damages during any handling of the components.

8 Manual Repair Procedure

Definition of repair: To fix missing solder or solder bridging on PCB after SMT for production soldering methods.

Scope: This is applied to all surface mount packages without solder balls attached, and 8- to 20-pin DIP and TO packages.

1. Solder wire with flux core is used for repair.
2. Solder iron temperature setting: $<360^{\circ}\text{C} \pm 10^{\circ}\text{C}$.
3. Solder iron should be contacting to the lead.
4. Contact duration: 4 ± 2 seconds per lead x 2 times.
5. The package surface temperature should be less than their peak reflow temperature (245°C , 250°C , or 260°C).
6. Follow shelf life/floor life specification on the moisture bag for SMT instruction.
7. The repaired part should be baked at 125°C for 48 hours or per J-STD-033 if the shelf life of the part has exceeded the MSL specification or if it is unknown.

9 Manual Rework Procedure

Definition of rework: To remove or replace IC package on PCB after SMT for production soldering methods.

Scope: This is applied to all surface mount packages without solder balls attached, and 8- to 20-pin DIP and TO packages.

1. Solder wire with flux core is used for rework.
2. Solder iron temperature setting: $<360^{\circ}\text{C} \pm 10^{\circ}\text{C}$.
3. Solder iron should be contacting to the lead.
4. Contact duration: 4 ± 2 seconds per lead x 2 times.
5. The package surface temperature should be less than their peak reflow temperature (245°C , 250°C , or 260°C).
6. Follow shelf life/floor life specification on the moisture bag for SMT instruction.
7. The rework part and PCB should be baked at 125°C for 48 hours or per J-STD-033 if the shelf life of the part has exceeded the MSL specification or if it is unknown.
8. Hot gas rework station should be used for removing and placing package on PCB during rework.
(a) Example: [MetCal website](#) for equipment, techniques and procedures.

10 PCB Assembly Cleaning

If the printed circuit boards were assembled using a rosin based or other flux system which requires removal from the board surface after reflow, the subsequent cleaning operation should be performed as shortly after reflow as possible. The timely initiation of the cleaning operation is dictated by the ability of the flux to collect and harden with additional residues under and around traces and the bodies of components. The lack of attention to the timely removal of this residue present additional and unneeded removable difficulties, with the possibility that some contaminants may be trapped in flux and remain on the surface of the board, potentially compromising quality of the finished product. TI recommends that the customer works with their supplier of flux or cleaning solvent to determine the optimum cleaning conditions.

Pre-Wash Section	Top	30 – 50 psi
	Bottom	30 – 50 psi
Wash Section	Top	30 – 50 psi
	Bottom	30 – 50 psi
Pre-Rinse Section	Top	90 – 110 psi
	Bottom	100- 120 psi
Rinse Section	Top	90 – 110 psi
	Bottom	100 – 120 psi
Final Rinse Section	Top	5 – 30 psi
	Bottom	10 – 35 psi

Dryer Temperature:

	170 - 190°F
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Pre-Wash, Wash, and Rinse Tank Temperature:

	140 - 160°F
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Conveyor Speed:

	2.8 - 3.2 ft/min
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Figure 5. Example of In-Line Cleaning Set Up Conditions

11 Permissions

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Revision History

NOTE: Page numbers for previous revisions may differ from page numbers in the current version.

Changes from D Revision (March 2016) to E Revision	Page
• Revised Storage and Shelf Life section	4
Changes from C Revision (July 2015) to D Revision	Page
• Added <i>Flux Selection</i>	6
• Added <i>Wave Soldering Profile</i>	6
• Added <i>Example of In-Line Cleaning Set UP Conditions</i> graphic	9
Changes from B Revision (June 2014) to C Revision	Page
• Changed to IPC-JEDEC J-STD-033C throughout document.....	3
• Added information to <i>Reflow Soldering</i>	4
• Changed to IPC-JEDEC J-STD-020E throughout document.....	4
• Added <i>Flow Soldering (Wave Soldering)</i>	5
• Added <i>PCB Assembly Cleaning</i>	9
Changes from A Revision (June 2012) to B Revision	Page
• Changed format from National Semiconductor to Texas Instruments.....	3
• Changed link to SNOA549 IN <i>Moisture Sensitivity Level</i>	3
• Added <i>Manual Repair Procedure</i> and <i>Manual Rework Procedure</i>	8

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