

CUSTOMER : _____.

DATE : 2011. 11. 29 .

SPECIFICATIONS FOR APPROVAL

PRODUCT NAME : Top View SMD LED (6030 0.8t 2in1 PKG)

MODEL NAME : LEMWS68T◆◆◆◆◆◆

CUSTOMER P/N :

APPROVAL	REMARK
	DRAFT

APPENDIX

The Component complies with ☒RoHS and ☒Halogen Free

Designed	Checked	Approved	LG Innotek Co., Ltd.	
			DOCUMENT No.	CLD-
			PAGE	1/20

REG. DATE : '11.11. 29.

SPECIFICATION

REV.NO : 0.0


REV. DATE :

MODEL NAME : LEMWS68T

PAGE : 2 / 20

Change History of Revision

[illegible]

 LG Innotek		DOCUMENT No : CLD-																																	
REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0																																	
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇	PAGE : 3 / 20																																	
<p style="text-align: center;"><u>CONTENTS</u></p> <table> <tr> <td>1. Features</td><td>-----</td><td>4 / 20</td></tr> <tr> <td>2. Outline dimensions</td><td>-----</td><td>4 / 20</td></tr> <tr> <td>3. Applications</td><td>-----</td><td>5 / 20</td></tr> <tr> <td>4. Absolute Maximum Ratings</td><td>-----</td><td>5 / 20</td></tr> <tr> <td>5. Electro-Optical characteristics</td><td>-----</td><td>5 / 20</td></tr> <tr> <td>6. Rank Sorting Method</td><td>-----</td><td>6~7 / 20</td></tr> <tr> <td>7. Typical Characteristic Curves</td><td>-----</td><td>8~9 / 20</td></tr> <tr> <td>8. Reliability Test Items and Conditions</td><td>-----</td><td>9~10 / 20</td></tr> <tr> <td>9. Package and Marking of Products</td><td>-----</td><td>11~14 / 20</td></tr> <tr> <td>10. Cautions on use</td><td>-----</td><td>15~19 / 20</td></tr> <tr> <td>11. Others</td><td>-----</td><td>20 / 20</td></tr> </table>			1. Features	-----	4 / 20	2. Outline dimensions	-----	4 / 20	3. Applications	-----	5 / 20	4. Absolute Maximum Ratings	-----	5 / 20	5. Electro-Optical characteristics	-----	5 / 20	6. Rank Sorting Method	-----	6~7 / 20	7. Typical Characteristic Curves	-----	8~9 / 20	8. Reliability Test Items and Conditions	-----	9~10 / 20	9. Package and Marking of Products	-----	11~14 / 20	10. Cautions on use	-----	15~19 / 20	11. Others	-----	20 / 20
1. Features	-----	4 / 20																																	
2. Outline dimensions	-----	4 / 20																																	
3. Applications	-----	5 / 20																																	
4. Absolute Maximum Ratings	-----	5 / 20																																	
5. Electro-Optical characteristics	-----	5 / 20																																	
6. Rank Sorting Method	-----	6~7 / 20																																	
7. Typical Characteristic Curves	-----	8~9 / 20																																	
8. Reliability Test Items and Conditions	-----	9~10 / 20																																	
9. Package and Marking of Products	-----	11~14 / 20																																	
10. Cautions on use	-----	15~19 / 20																																	
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REG. DATE : '11.11. 29.

SPECIFICATION

REV.NO : 0.0

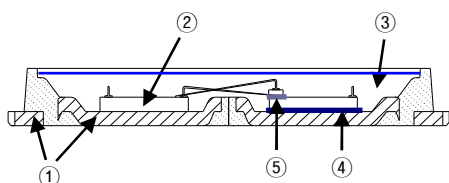
REV. DATE :

MODEL NAME : LEMWS68T

PAGE : 4 / 20

1. Features

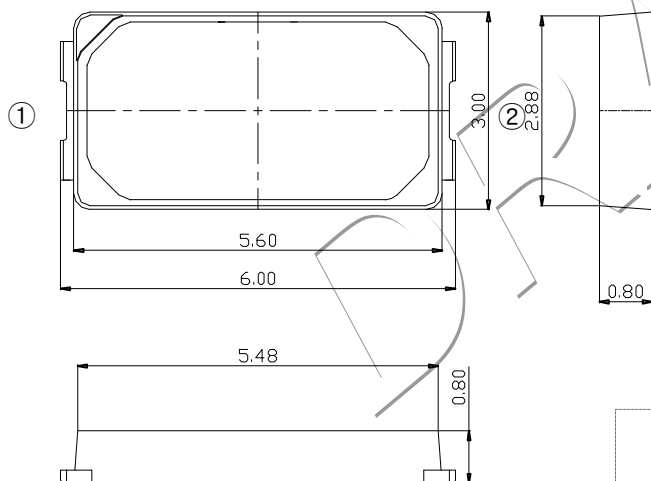
- Lighting Color : White
- Small size surface mount type : $6.0 \times 3.0 \times 0.8$ mm (L×W×H)
- Chip Material : InGaN/Al₂O₃
- Soldering methods : IR reflow soldering
- Taping : 12 mm conductive black carrier tape & antistatic clear cover tape.
4,000pcs/reel, $\Phi 178$ mm wheel
- Structure and Materials :



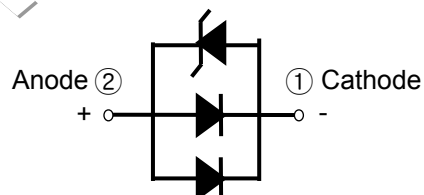
No	Item	Material
①	Frame	Cu + Ag plate
②	LED Chip	InGaN/Al ₂ O ₃
③	Resin	Si + Phosphors
④	Die Paste	Si
⑤	Zener Die Paste	Ag Epoxy

2. Outline Dimensions

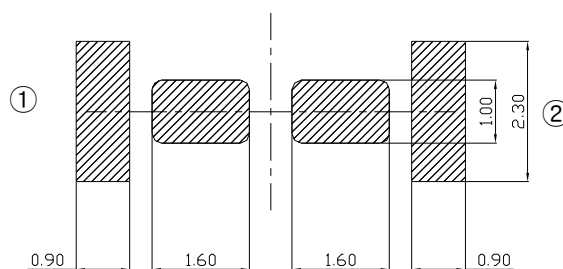
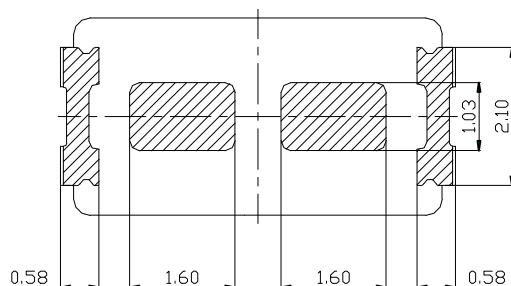
(Unit : mm)




Internal Circuit



Recommendable soldering pattern (For reflow soldering)



◆Tolerances ± 0.15 mm

 LG Innotek		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇	PAGE : 5 / 20

3. Applications

- Backlight for BLU Module
- Interior and Exterior illuminant

4. Absolute Maximum Ratings

Items	Symbol	Ratings	Unit
Forward Current	I_F	240	mA
Power Consumption	P_D	594	mW
Operating Temperature	T_{opr}	-30 ~ +85	°C
Storage Temperature	T_{stg}	-40 ~ +100	°C
Junction Temperature	T_j	110	°C

5. Electro – Optical –Thermal Characteristics

(Ta=25°C)

Items	Symbol	Condition	Min.	Typ.	Max.	Unit
Forward Voltage *1)	V_F	$I_F=186$ [mA]	2.9	-	3.4	V
Reverse voltage (Zener diode)	V_R	$I_R=10$ [mA]	0.6	1.0	1.2	V
Luminous Flux *2)	Φ_V	$I_F=130$ [mA]	45	-	-	lm
CIE *3)	X / Y	$I_F=130$ [mA]	-			-
Color Rendering Index *4)	Ra	$I_F=130$ [mA]	70 or 80	-	-	-
ESD		HBM	± 5	-	-	kV

*1), *2), *3), *4) The values are based on 2-die performance.

※ These values measured by Optical Spectrum Analyzer of LG Innotek Co., LTD and tolerances are followings as below

- Luminous Intensity (lm) : ± 10%, Forward Voltage (V_F) : ± 0.1, CIE Value : ± 0.005, CRI Value : ± 3.0



REG. DATE : '11.11. 29.

SPECIFICATION

REV.NO : 0.0

REV. DATE :

MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇

PAGE : 6 / 20

6. Rank Sorting Method

Rank of Luminous Flux

Lv Rank	Lm (lm, @ 130mA)		
	Min.	Typ.	Max.
T	45	-	-

Rank of Voltage

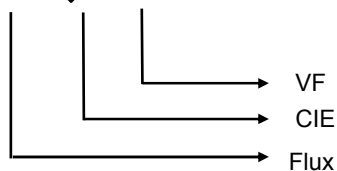
VF Rank	VF (V, @ 186mA)		
	Min.	Typ.	Max.
0	2.9	-	3.0
1	3.0	-	3.1
2	3.1	-	3.2
3	3.2	-	3.3
4	3.3	-	3.4

Rank of CRI

CRI Rank	CRI (CRI, @ 130mA)		
	Min.	Typ.	Max.
-	70	-	-

Method of Rank No indication

T - ◇1 - 1



* Measurement system of Lv & Color rank

- Auto sorting in Manufacturing = TSE社 Test handler, QA out going inspection = CAS140B



REG. DATE : '11.11. 29.

SPECIFICATION

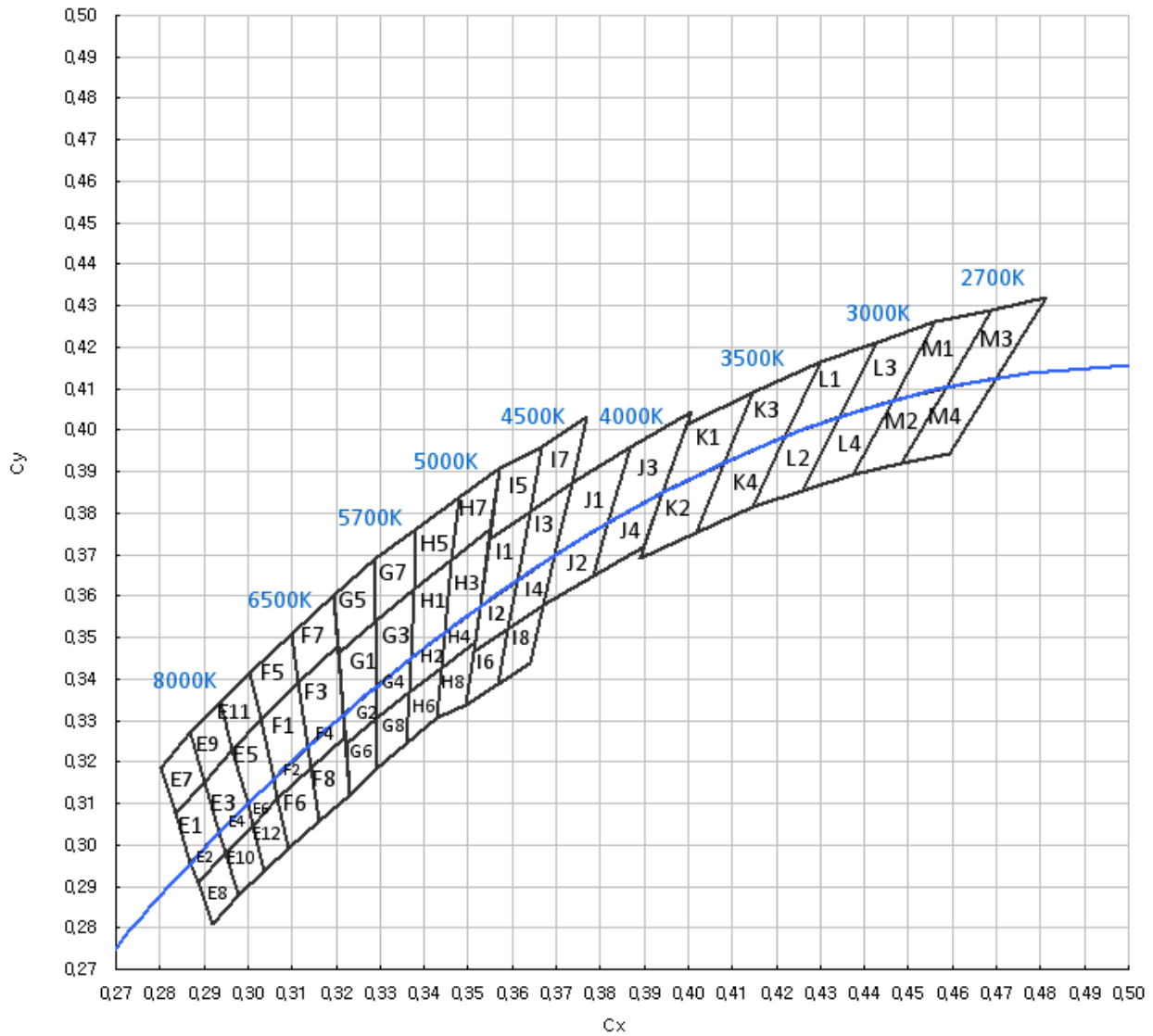
REV.NO : 0.0

REV. DATE :

MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇

PAGE : 7 / 20

■ Rank of CIE (CIE Value @130mA)



* The quantity-ratio of CIE ranks is decided by LGIT

* Color Coordinate is based on the CIE 1931 Chromaticity Diagram

REG. DATE : '11.11. 29.

SPECIFICATION

REV.NO : 0.0

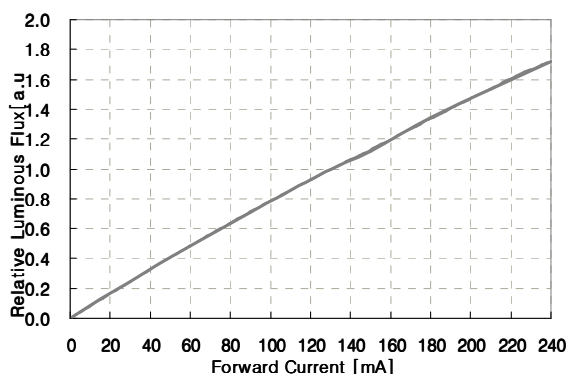
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MODEL NAME : LEMWS68T

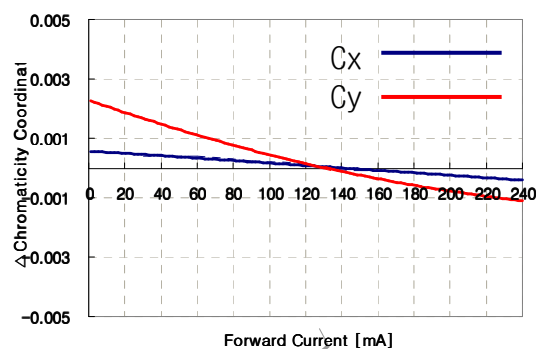
PAGE : 8 / 20

7. Typical Characteristic Curves

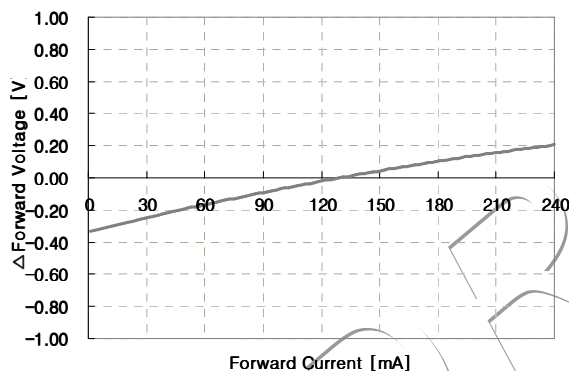
Forward Current vs. Luminous Intensity



Forward Current vs. CIE

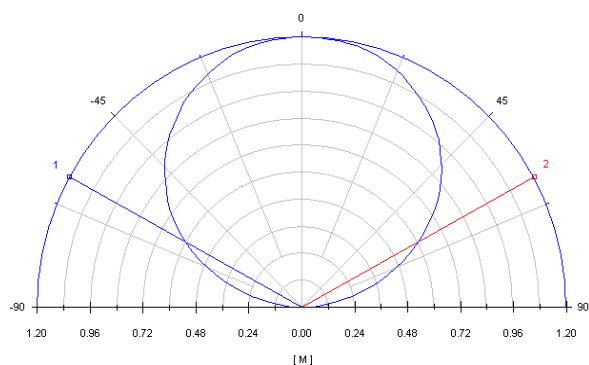


Forward Voltage vs. Forward Current

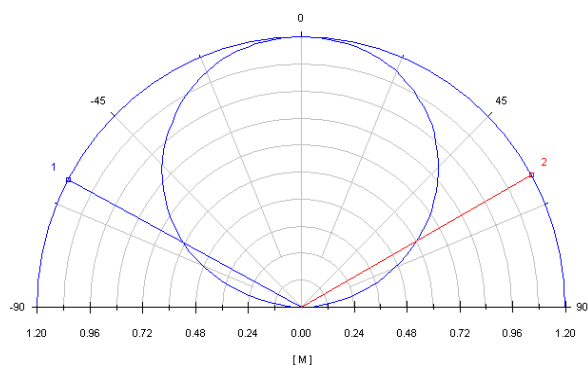


Radiation Characteristics

X-X



Y-Y





REG. DATE : '11.11. 29.

SPECIFICATION

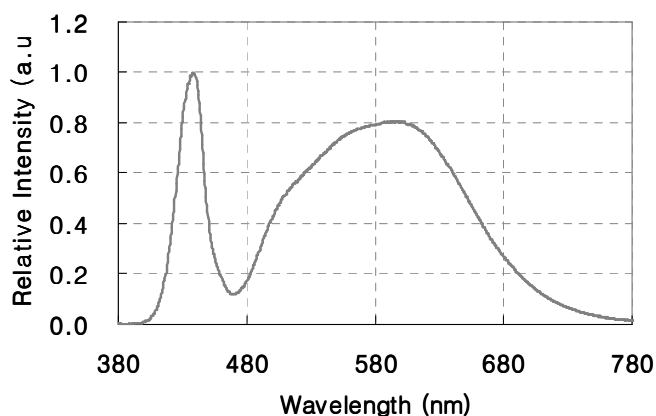
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REV. DATE :

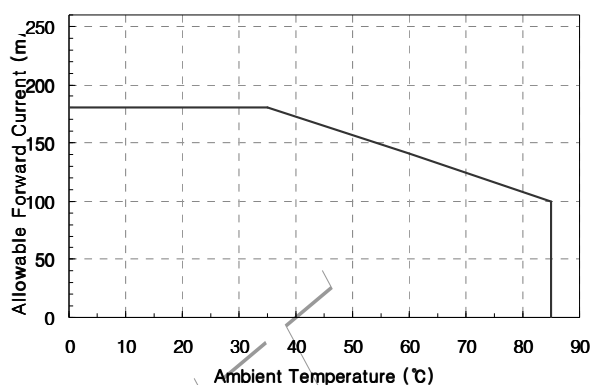
MODEL NAME : LEMWS68T

PAGE : 9 / 20

■ Spectrum (4000K)



■ Derating Curve




8. Reliability Test Items and Conditions

8-1. The Reliability criteria of SMD LED

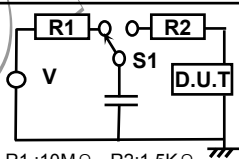
Item	Symbol	Test Condition	Limit	
			Min.	Max.
Forward Voltage	V_F	IF = 130mA	-	*U.S.L. × 1.1
Luminous intensity	Iv	IF = 130mA	**S × 0.70	-

*U.S.L : Upper Spec Limit, *S : Initial Value

※ The Reliability criteria of ESD Test is judged by V_F shift ($\pm 0.2V@8mA$) or impedance(Ω) check data.

 LG Innotek		DOCUMENT No : CLD-	
REG. DATE : '11.11. 29.	SPECIFICATION		REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇		PAGE : 10 / 20

8-2. Results of Reliability Test

No	Item	Test Condition	Test Hours/ Cycles	Sample No	Ac/Re
1	Steady State Operating Life (RTOL)	Ta 25℃, DC 180mA	1,000hr	20 pcs	0 / 1
2	High Temp. Humidity Life (WHTOL)	Ta 60℃, 90% RH, DC 180mA	1,000hr	20 pcs	0 / 1
3	Steady State Operating Life of High Temperature (HTOL)	Ta 85℃, DC 180mA	1,000hr	20 pcs	0 / 1
4	Steady State Operating Life of Low Temperature (LTOL)	Ta -30℃, DC 180mA	1,000hr	20 pcs	0 / 1
5	High Temp. Storage Life (HTSL)	Ta 100℃	1,000hr	20 pcs	0 / 1
6	Low Temp. Storage Life (LTSL)	Ta -40℃	1,000hr	20 pcs	0 / 1
7	High Temp. High Humidity Storage Life (HTHSL)	Ta 85℃, 85% RH	1,000hr	20 pcs	0 / 1
8	Temperature Cycle	-40℃(30min) ~ 25℃(5min) ~ 100℃(30min) ~ 25℃(5min)	100cycles	20 pcs	0 / 1
9	Thermal Shock	-40℃ to 100℃, 30 minutes dwell, <20 seconds transfer	100 cycles	20 pcs	0 / 1
10	ESD (HBM) (± 5 kV)	 <p style="font-size: small;">R1 :10MΩ, R2:1.5KΩ C:100pF</p>	3times	20 pcs	0 / 1
11	Resistance to Soldering Heat (Reflow Soldering)	T _{sld} = 260℃, 10sec (pre treat. 30℃, 70%, 168hr)	3 time	20 pcs	0 / 1



REG. DATE : '11.11. 29.

SPECIFICATION

REV.NO : 0.0

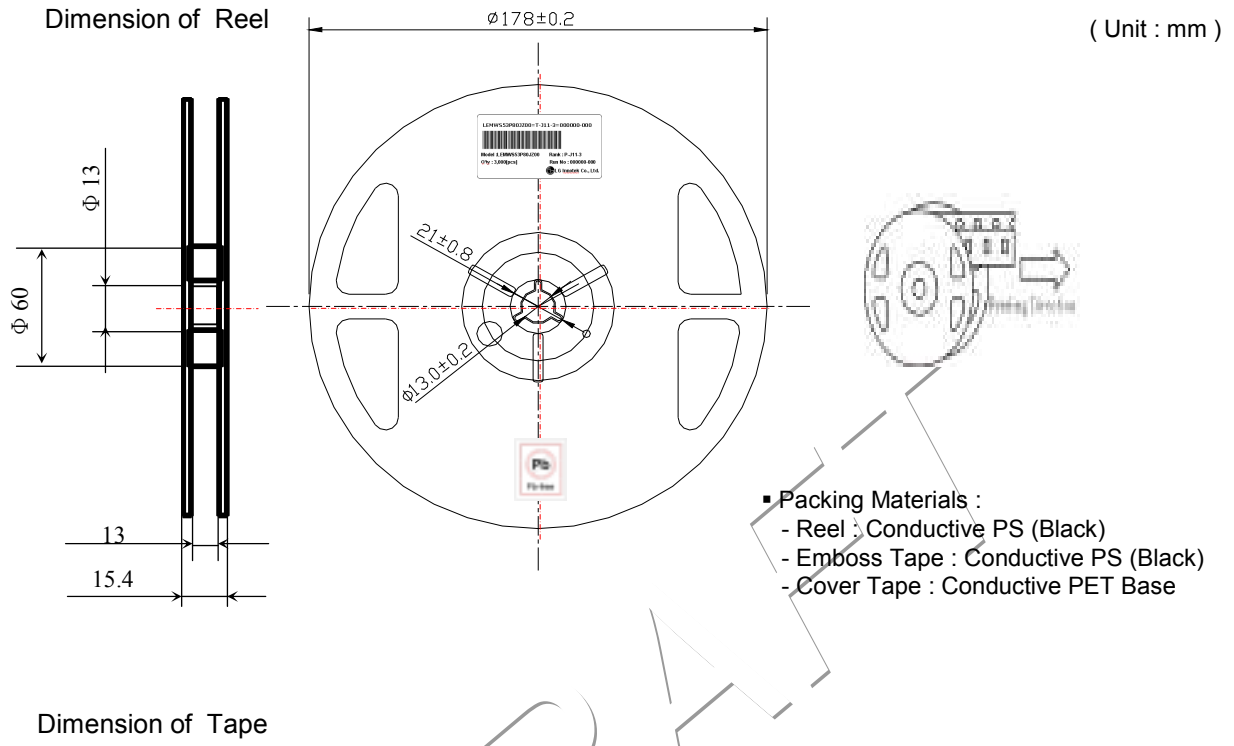
REV. DATE :

MODEL NAME : LEMWS68T

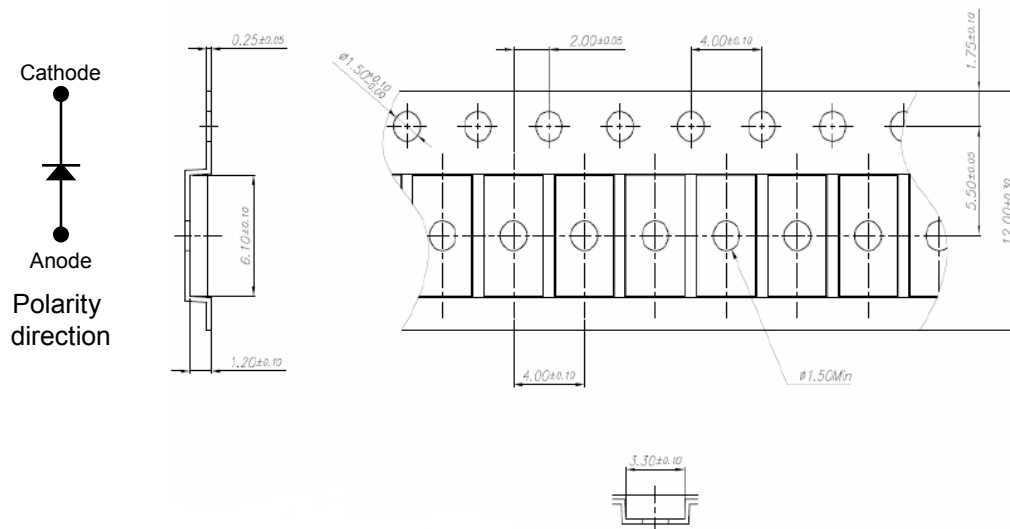
PAGE : 11 / 20

9. Package and Marking of Products

9-1. Taping Outline Dimension




Dimension of Tape



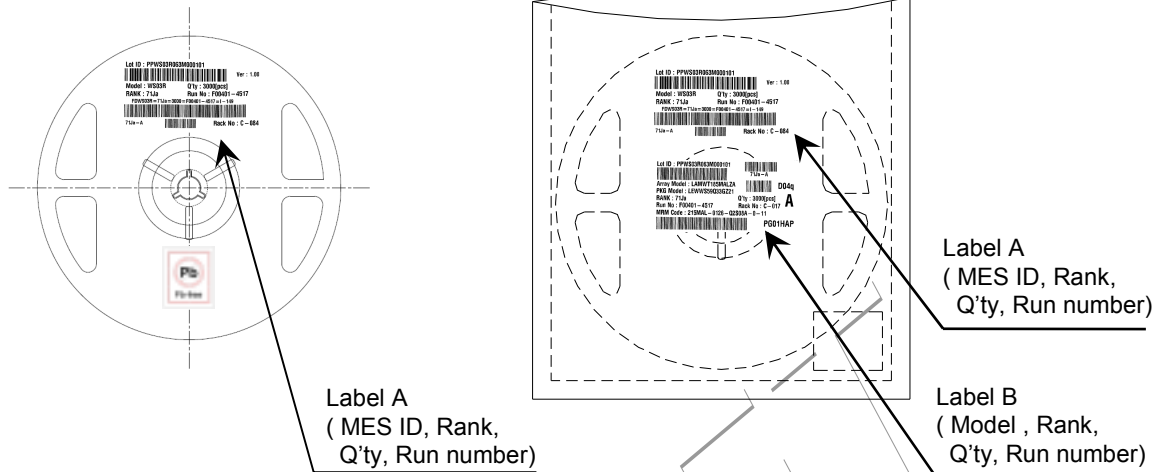
Arrangement of Tape (in case of 4,000ea)



		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T	PAGE : 12 / 20

9-2. Package

Products are packed in one bag of 4,000 pcs (one taping reel) and a label is affixed on each bag specifying Model , Rank, Quantity and Run number.

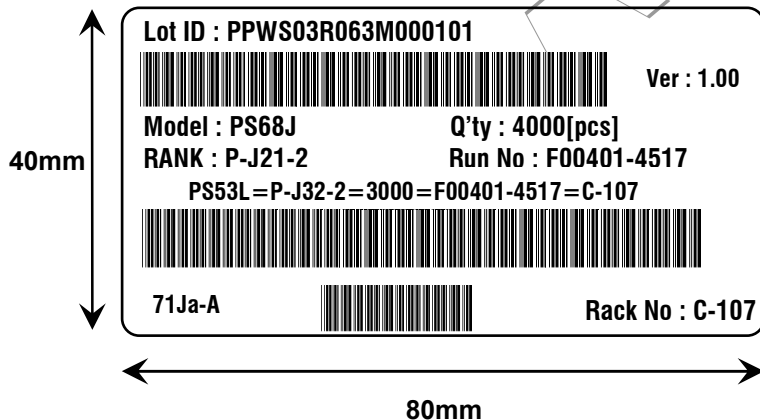


- Package : damp-proof package made of aluminum

RANK- Package : damp-proof package made of aluminum


※ . Label A

Specifying MED Model Name, Rank, Rank, Quantity and Run number




▪ Run No indication


1	2	3	4	5	6	—	7	8	9
Code	Site	Manufacture Year	Manufacture Month	Manufacture date			Serial No		
		(Last number)	(1, 2, 3, 4,	(01 ~ 31)			(001 ~ 999)		
		(1, 2, 3, 4, 5,	5, 6, 7, 8,						
		6, 7, 8, 9, 0)	9, X, Y, Z)						


 LG Innotek		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇	REV.NO : 0.0
		PAGE : 13 / 20

※. Label B

Specifying Product name , Part number, Rank, Quantity and Lot number

Lot ID : PPWS03R063M000101 

 71Ja-A


Array Model :  D04q

PKG Model : LEMWS68T80JZ00

RANK : P-J21-2 Q'ty : 4000[pcs] **A**




Run No : F00401-4517 Rack No : C-107

MRM Code : 215MAL-0126-Q2S08A-0-11

 PG01HAP


※ Label C

Specifying Customer, Model, Customer Part no, Lot No, Quantity

OutBox	Customer	2011.10.10
		
LEMWS68T80JZ00	30,000	N14
		
LEMWS68T80JZ00	F1X04-06	
		

▪ Lot No. indication

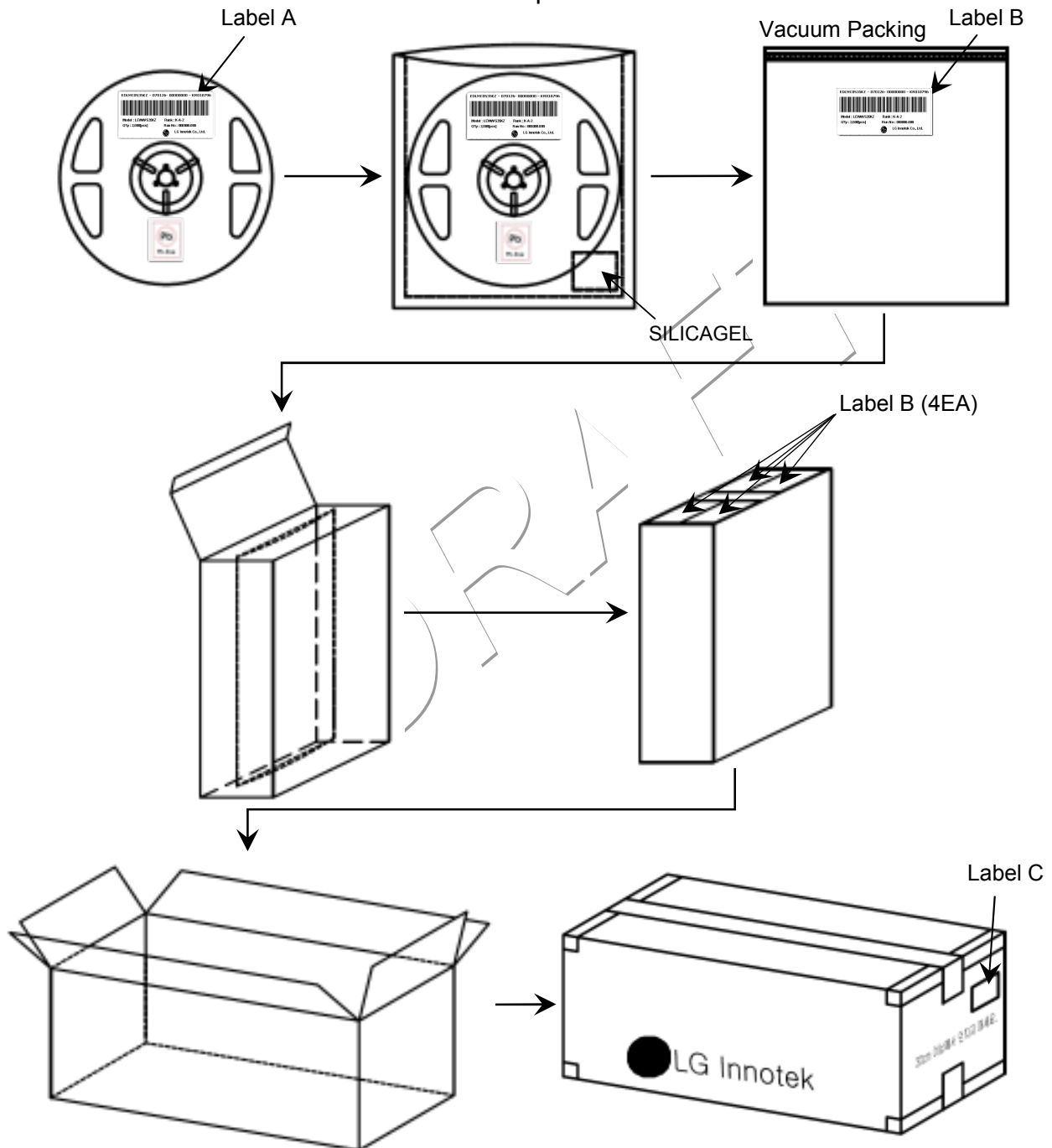
1	2	3	4	5	—	6	7
Code	QA Inspection Year (Last number)	QA Inspection Month	QA Inspection Date			Serial No	
	(1, 2, 3, 4, 5, 6, 7, 8, 9, 0)	(1, 2, 3, 4, 5, 6, 7, 8, 9, X, Y, Z)	(01 ~ 31)			(01 ~ 99)	


 LG Innotek		DOCUMENT No : CLD-	
REG. DATE : '11.11. 29.	SPECIFICATION		REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T	PAGE : 14 / 20	

9-3. Packing Specifications

Reeled products (numbers of products are 4,000 pcs) packed in a seal off aluminum moisture-proof bag along with desiccants (Silica gel).

Four aluminum bags (total maximum number of products are 16,000 pcs) packed in an inner box and Six inner boxes are put into an outer box.



 LG Innotek		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇	PAGE : 15 / 20

10. Cautions on use

10-1. Moisture Proof Package

- When moisture is absorbed into the SMD package it may vaporize and expand during soldering.
- There is possibility that this can cause exfoliation of the contacts and damage the optical characteristics of the LEDs.

10-2. For the Storage

Before opening the package


- Proper temperature and RH conditions for storage are : 5 °C ~35 °C , less than 60% RH
- Do not open Moisture-Proof bag before the products are ready to use.

After opening the package

- Proper temperature and RH conditions for storage are : 5 °C ~35 °C , less than 60% RH
- The LEDs should be soldered within 168 hours (7days) after opening the package.
- If unused LEDs remain, they should be stored in a moisture-proof bag with a absorbent Material. (ex. silica gel)
- If the Moisture absorbent material (ex. silica gel) loses its color or the LEDs have exceeded the storage time, baking treatment should be performed using the following condition.
 Conditions for baking : 60±5°C , 20% RH and 24 hours maximum.

10-3. For the Usage

- LED PKG should not be used in directly exposed environment containing hazardous substances
- The LEDs has silver plated metal parts. The silver plating become tarnished when being exposed to an environment which contains corrosive gases.
- After assembly and during use, silver plating can be affected by the corrosive gases emitted by components and materials in close proximity of the LEDs within an end product, and the gases entering into the product from the external atmosphere.
- Do not expose the LEDs to corrosive atmosphere during storage and using.
- Avoid rapid transitions in ambient temperature, especially in high humidity environments where condensation can occur.
- In designed a circuit, the current through each LED must not exceed the absolute maximum rating

 LG Innotek		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇	PAGE : 16 / 20

10-4. Cleaning


- Please avoid using a brush for cleaning and do not wash the product in organic solvents such as acetone, Organic solvent (TCE, etc..) will damage the resin of the LEDs.
- It is recommended the IPA be used as a solvent for cleaning the LEDs. Please refer to following solvents and conditions.
 Clearing Condition: Solvent : IPA, 25℃ max × 60 sec. max
- Do not clean the LEDs by the ultrasonic, When it is absolutely necessary, the influence of ultrasonic cleaning on the LEDs depends on factors such as ultrasonic power and the assembled condition.
- Before cleaning, a pre-test should be done to confirm whether any damage to the LEDs will occur.

10-5. Heat Generation

- Thermal design of the end product is of paramount importance.
- Please consider the heat generation of the LED when making the system design.
- The coefficient of temperature increase per input electric power is affected by the thermal resistance of the circuit board and density of LED placement on the board, as well as other component.
- It is necessary to avoid intense heat generation and operate within the maximum ratings given in the specification.

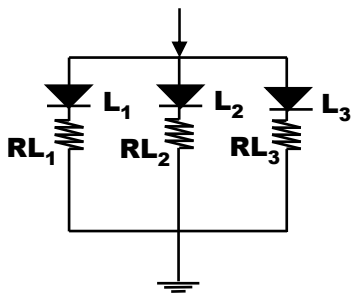
10-6. Static Electricity

- If over-voltage, which exceeds the absolute maximum rating, is applied to the LEDs, it will damage the LEDs and result in destruction. Since the LEDs are sensitive to the static electricity and surge, it is strongly recommended to use a wristband or anti-electrostatic glove when handling the LEDs and all devices, equipment and machinery must be properly grounded.
- It is recommended that precautions be taken against surge voltage to the equipment the mounts the LEDs.
- Damaged LEDs will show some unusual characteristics such as the leak current remarkably increases, the turn-on voltage becomes lower, or the LEDs do not light at the low current.
- When examining the final product, it is recommended to check whether the assembled LEDs are damaged by static electricity or not. Static-damaged LEDs can easily be found by light-on test or the V_F test at a low current.

 LG Innotek		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0
REV. DATE :		PAGE : 17 / 20
	MODEL NAME : LEMWS68T	

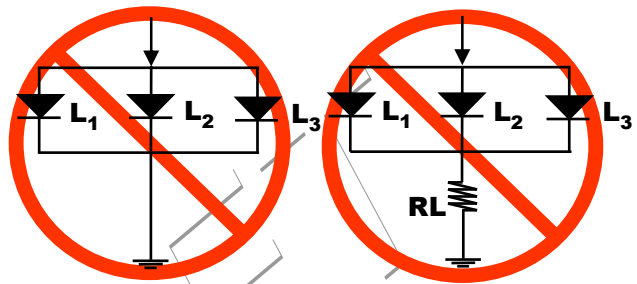
10-7. Recommended Circuit

- In designed a circuit, the current through each LED must not exceed the absolute maximum rating specified for each LED.
- In general, the LEDs have a variation of forward voltage. Using LEDs with different forward voltages in a circuit with on resistor for the complete circuit causes different forward currents for each LED. This may lead to a variation in brightness. In the worst case, some LED may be subjected to the stresses in excesses of the absolute maximum rating. To avoid brightness variation of LEDs, the use of matrix circuit with one resistor for each LED is recommended.



Pic.1 Recommended Circuit in parallel mode

: Separate resistor must be used in each LED




Pic.2. Abnormal Circuit

The Current through the LEDs may vary due to the variation in forward voltage (V_F) of the LEDs.

- LED should be operated in forward bias. A driving Circuit must be designed so that the LED is not subjected to either forward or reverse voltage while it is off. In particular, if a reverse voltage is continuously applied to the LED, such operation can cause migration resulting in LED damage.
- If reverse voltage is applied to the LEDs, it will damage the Zener diode and LEDs and result in destruction.

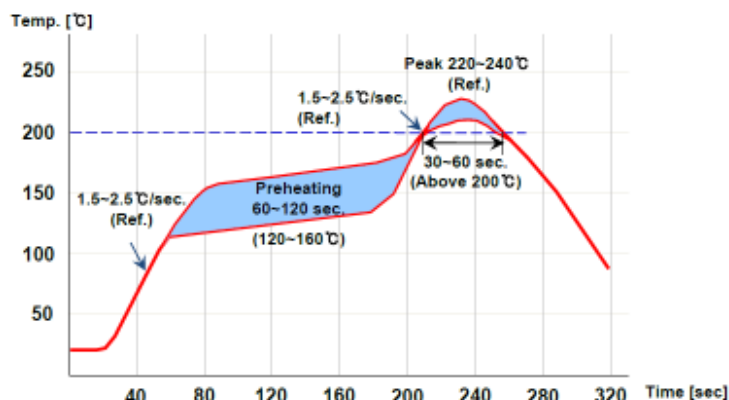
10-8. Application limits of LED Driver IC controller

- GaN based LED is relatively weak to electrical damage (such as static electricity and over current stress). Forward leakage of LED occurred by such damage in the forward low current region may result in turn-on-delay of Lighting Module, which is dependent on a specific function of driver IC.
- For reasons mentioned above, minimum current level (source start-up current) of LED driver IC must be more than 0.3 mA. LGIT cannot make a guarantee on the LED using in Driver IC with start up current level of < 0.3 mA.
- When parallel circuit LED driver IC is applied in Lighting Module, Hot spot may occur in low current operation region (dimming mode) by difference of LED voltage in low current region. So, driver IC with Individual LED controller is recommended.

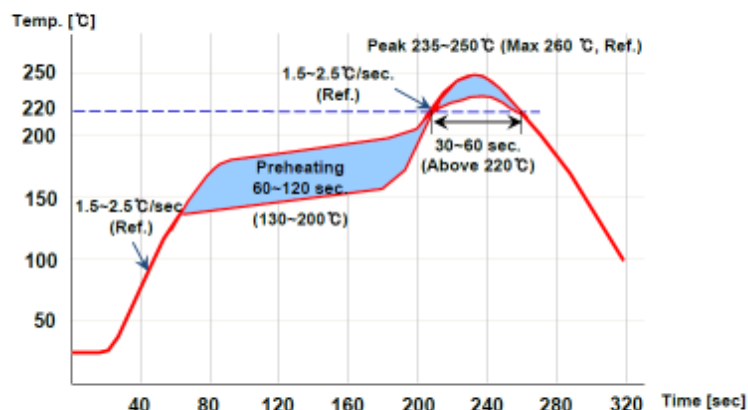
 LG Innotek		DOCUMENT No : CLD-	
REG. DATE : '11.11. 29.	SPECIFICATION		REV.NO : 0.0
REV. DATE :			PAGE : 18 / 20
MODEL NAME : LEMWS68T			

10-9. Soldering Conditions.


- The LEDs can be soldered in place using the reflow soldering method.
- LG Innotek cannot make a guarantee on the LEDs after they have been assembled using dip soldering method.
- Recommended soldering conditions
- Pb Solder



- Pb-free Solder



- Although the recommended soldering conditions are specified in the above diagram, reflow or hand soldering at the lowest possible temperature is desirable for the LEDs.
- A rapid-rate process is not recommended for cooling the LEDs down from the peak temperature.
- Occasionally there is a brightness decrease caused by the influence of heat of ambient atmosphere during air reflow. It is recommended that the customer use the nitrogen reflow method.
- The encapsulated material of the LEDs is silicone, Therefore the LEDs have a soft surface on the top of the package. The pressure to the surface will be influence to the reliability of the LEDs. Precautions should be taken to avoid the strong pressure on the encapsulated part. So When using the chip mounter, the picking up nozzle that does not affect the silicone resin should be used.
- Reflow soldering should not be done more than two times.

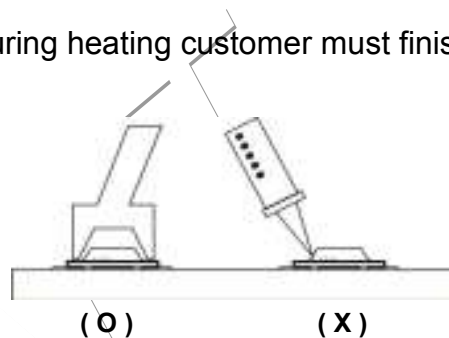
 LG Innotek		DOCUMENT No : CLD-
REG. DATE : '11.11. 29.	SPECIFICATION	
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇◇◇	REV.NO : 0.0
		PAGE : 19 / 20

10-10. Soldering Iron

- Basic spec is $\leq 5\text{sec}$ when 260°C .
- If temperature is higher, time shorter ($+10^{\circ}\text{C} \rightarrow -1\text{sec}$).
- Power dissipation of Iron should be smaller than 15W, and temperature should be controllable. Surface temperature of the device should be under 230°C .

10-11. Repair


- Repairing should not be done after the LEDs have been soldered.
- When repairing is unavoidable, a double-head soldering iron should be used.
- If should be confirmed beforehand whether the characteristics of the LEDs will or will not be damaged by repairing.
- When Soldering, do not put stress on the LEDs during heating customer must finish rework within 5sec. under 245°C .
- The head of Iron can not touch copper foil.
- Twin-head type is preferred.



(O) (X)

10-12. Safety Guideline for Human Eyes.

- Users should be cautioned not to stare at the light of this LED product.
- Great care should be taken when viewing directly the LED driven at high current or the LED with optical instruments, which may greatly increase the hazard to your eyes.

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REG. DATE : '11.11. 29.	SPECIFICATION	REV.NO : 0.0
REV. DATE :	MODEL NAME : LEMWS68T◇◇◇◇◇◇◇◇	PAGE : 20 / 20

11. Others

- . LG Innotek will not be held responsible for any damage to the user that may result from accidents or any other reasons during operation of the user's unit if use to exceed the absolute maximum ratings, or not keep the matters that demand special attention.
- . The LEDs described in this brochure are intended to be used for ordinary electronic equipment.
- . Consult LG Innotek, sales staff in advance for information on the applications in which exceptional quality and reliability are required, particularly when the failure or malfunction of the LEDs, may directly jeopardize life or health.
- . The customer shall not reverse engineer by disassembling or analysis of the LEDs without having prior written consent from LG Innotek. When defective LEDs are found, The customer shall inform LG Innotek disassembling or analysis.
- . The formal specifications must be exchanged and signed by both parties before large volume purchase begins.
- . The appearance and specification of the product may be modified for improvement without notice