

<b>STN</b>	<b>Polovodičové súčiastky Mechanické a klimatické skúšobné metódy Časť 20: Odolnosť plastových puzzier SMD proti kombinovanému pôsobeniu vlhka a spájkovacieho tepla</b>	<b>STN EN IEC 60749-20</b>
		35 8799

Semiconductor devices - Mechanical and climatic test methods - Part 20: Resistance of plastic encapsulated SMDs to the combined effect of moisture and soldering heat

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 12/20

Obsahuje: EN IEC 60749-20:2020, IEC 60749-20:2020

Oznámením tejto normy sa od 05.10.2023 ruší  
STN EN 60749-20 (35 8799) z apríla 2010

**132100**



**EUROPEAN STANDARD**  
**NORME EUROPÉENNE**  
**EUROPÄISCHE NORM**

**EN IEC 60749-20**

October 2020

ICS 31.080.01

Supersedes EN 60749-20:2009 and all of its  
amendments and corrigenda (if any)

English Version

**Semiconductor devices - Mechanical and climatic test methods -  
Part 20: Resistance of plastic encapsulated SMDs to the  
combined effect of moisture and soldering heat  
(IEC 60749-20:2020)**

Dispositifs à semiconducteurs - Méthodes d'essais  
mécaniques et climatiques - Partie 20 : Résistance des  
CMS à boîtier plastique à l'effet combiné de l'humidité et de  
la chaleur de brasage  
(IEC 60749-20:2020)

Halbleiterbauelemente - Mechanische und klimatische  
Prüfverfahren - Teil 20: Beständigkeit kunststoffverkappter  
oberflächenmontierbarer Bauelemente (SMD) gegenüber  
der kombinierten Beanspruchung von Feuchte und  
Lötwärme  
(IEC 60749-20:2020)

This European Standard was approved by CENELEC on 2020-10-05. CENELEC members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CENELEC member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CENELEC member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CENELEC members are the national electrotechnical committees of Austria, Belgium, Bulgaria, Croatia, Cyprus, the Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, the Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.



European Committee for Electrotechnical Standardization  
 Comité Européen de Normalisation Electrotechnique  
 Europäisches Komitee für Elektrotechnische Normung

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

**EN IEC 60749-20:2020 (E)****European foreword**

The text of document 47/2634(F)/FDIS, future edition 3 of IEC 60749-20, prepared by IEC/TC 47 "Semiconductor devices" was submitted to the IEC-CENELEC parallel vote and approved by CENELEC as EN IEC 60749-20:2020.

The following dates are fixed:

- latest date by which the document has to be implemented at national level by publication of an identical national standard or by endorsement (dop) 2021-07-05
- latest date by which the national standards conflicting with the document have to be withdrawn (dow) 2023-10-05

This document supersedes EN 60749-20:2009 and all of its amendments and corrigenda (if any).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CENELEC shall not be held responsible for identifying any or all such patent rights.

**Endorsement notice**

The text of the International Standard IEC 60749-20:2020 was approved by CENELEC as a European Standard without any modification.

## **Annex ZA** (normative)

### **Normative references to international publications with their corresponding European publications**

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

NOTE 1 Where an International Publication has been modified by common modifications, indicated by (mod), the relevant EN/HD applies.

NOTE 2 Up-to-date information on the latest versions of the European Standards listed in this annex is available here: [www.cenelec.eu](http://www.cenelec.eu).

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN/HD</u>	<u>Year</u>
IEC 60068-2-20	2008	Environmental testing - Part 2-20: Tests - Test T: Test methods for solderability and resistance to soldering heat of devices with leads	EN 60068-2-20	2008
IEC 60749-3	-	Semiconductor devices - Mechanical and climatic test methods - Part 3: External visual examination	EN 60749-3	-
IEC 60749-30	-	Semiconductor devices - Mechanical and climatic test methods - Part 30: Preconditioning of non-hermetic surface mount devices prior to reliability testing	EN IEC 60749-30	-
IEC 60749-35	-	Semiconductor devices - Mechanical and climatic test methods - Part 35: Acoustic microscopy for plastic encapsulated electronic components	EN 60749-35	-



IEC 60749-20

Edition 3.0 2020-08

# INTERNATIONAL STANDARD

## NORME INTERNATIONALE

**Semiconductor devices – Mechanical and climatic test methods –  
Part 20: Resistance of plastic encapsulated SMDs to the combined effect of  
moisture and soldering heat**

**Dispositifs à semiconducteurs – Méthodes d'essais mécaniques  
et climatiques –  
Partie 20: Résistance des CMS à boîtier plastique à l'effet combiné  
de l'humidité et de la chaleur de brasage**





**THIS PUBLICATION IS COPYRIGHT PROTECTED**  
**Copyright © 2020 IEC, Geneva, Switzerland**

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either IEC or IEC's member National Committee in the country of the requester. If you have any questions about IEC copyright or have an enquiry about obtaining additional rights to this publication, please contact the address below or your local IEC member National Committee for further information.

Droits de reproduction réservés. Sauf indication contraire, aucune partie de cette publication ne peut être reproduite ni utilisée sous quelque forme que ce soit et par aucun procédé, électronique ou mécanique, y compris la photocopie et les microfilms, sans l'accord écrit de l'IEC ou du Comité national de l'IEC du pays du demandeur. Si vous avez des questions sur le copyright de l'IEC ou si vous désirez obtenir des droits supplémentaires sur cette publication, utilisez les coordonnées ci-après ou contactez le Comité national de l'IEC de votre pays de résidence.

IEC Central Office  
 3, rue de Varembé  
 CH-1211 Geneva 20  
 Switzerland

Tel.: +41 22 919 02 11  
[info@iec.ch](mailto:info@iec.ch)  
[www.iec.ch](http://www.iec.ch)

#### About the IEC

The International Electrotechnical Commission (IEC) is the leading global organization that prepares and publishes International Standards for all electrical, electronic and related technologies.

#### About IEC publications

The technical content of IEC publications is kept under constant review by the IEC. Please make sure that you have the latest edition, a corrigendum or an amendment might have been published.

##### **IEC publications search - [webstore.iec.ch/advsearchform](http://webstore.iec.ch/advsearchform)**

The advanced search enables to find IEC publications by a variety of criteria (reference number, text, technical committee,...). It also gives information on projects, replaced and withdrawn publications.

##### **IEC Just Published - [webstore.iec.ch/justpublished](http://webstore.iec.ch/justpublished)**

Stay up to date on all new IEC publications. Just Published details all new publications released. Available online and once a month by email.

##### **IEC Customer Service Centre - [webstore.iec.ch/csc](http://webstore.iec.ch/csc)**

If you wish to give us your feedback on this publication or need further assistance, please contact the Customer Service Centre: [sales@iec.ch](mailto:sales@iec.ch).

##### **Electropedia - [www.electropedia.org](http://www.electropedia.org)**

The world's leading online dictionary on electrotechnology, containing more than 22 000 terminological entries in English and French, with equivalent terms in 16 additional languages. Also known as the International Electrotechnical Vocabulary (IEV) online.

##### **IEC Glossary - [std.iec.ch/glossary](http://std.iec.ch/glossary)**

67 000 electrotechnical terminology entries in English and French extracted from the Terms and Definitions clause of IEC publications issued since 2002. Some entries have been collected from earlier publications of IEC TC 37, 77, 86 and CISPR.

#### A propos de l'IEC

La Commission Electrotechnique Internationale (IEC) est la première organisation mondiale qui élabore et publie des Normes internationales pour tout ce qui a trait à l'électricité, à l'électronique et aux technologies apparentées.

#### A propos des publications IEC

Le contenu technique des publications IEC est constamment revu. Veuillez vous assurer que vous possédez l'édition la plus récente, un corrigendum ou amendement peut avoir été publié.

##### **Recherche de publications IEC - [webstore.iec.ch/advsearchform](http://webstore.iec.ch/advsearchform)**

La recherche avancée permet de trouver des publications IEC en utilisant différents critères (numéro de référence, texte, comité d'études,...). Elle donne aussi des informations sur les projets et les publications remplacées ou retirées.

##### **IEC Just Published - [webstore.iec.ch/justpublished](http://webstore.iec.ch/justpublished)**

Restez informé sur les nouvelles publications IEC. Just Published détaille les nouvelles publications parues. Disponible en ligne et une fois par mois par email.

##### **Service Clients - [webstore.iec.ch/csc](http://webstore.iec.ch/csc)**

Si vous désirez nous donner des commentaires sur cette publication ou si vous avez des questions contactez-nous: [sales@iec.ch](mailto:sales@iec.ch).

##### **Electropedia - [www.electropedia.org](http://www.electropedia.org)**

Le premier dictionnaire d'électrotechnologie en ligne au monde, avec plus de 22 000 articles terminologiques en anglais et en français, ainsi que les termes équivalents dans 16 langues additionnelles. Egalement appelé Vocabulaire Electrotechnique International (IEV) en ligne.

##### **Glossaire IEC - [std.iec.ch/glossary](http://std.iec.ch/glossary)**

67 000 entrées terminologiques électrotechniques, en anglais et en français, extraites des articles Termes et Définitions des publications IEC parues depuis 2002. Plus certaines entrées antérieures extraites des publications des CE 37, 77, 86 et CISPR de l'IEC.



# INTERNATIONAL STANDARD

# NORME INTERNATIONALE

---

**Semiconductor devices – Mechanical and climatic test methods –  
Part 20: Resistance of plastic encapsulated SMDs to the combined effect of  
moisture and soldering heat**

**Dispositifs à semiconducteurs – Méthodes d'essais mécaniques  
et climatiques –  
Partie 20: Résistance des CMS à boîtier plastique à l'effet combiné  
de l'humidité et de la chaleur de brasage**

INTERNATIONAL  
ELECTROTECHNICAL  
COMMISSION

COMMISSION  
ELECTROTECHNIQUE  
INTERNATIONALE

**Warning! Make sure that you obtained this publication from an authorized distributor.  
Attention! Veuillez vous assurer que vous avez obtenu cette publication via un distributeur agréé.**

## CONTENTS

FOREWORD .....	4
1 Scope .....	6
2 Normative references .....	6
3 Terms and definitions .....	6
4 General description .....	7
5 Test apparatus and materials .....	7
5.1 Humidity chamber .....	7
5.2 Reflow soldering apparatus .....	8
5.3 Holder .....	8
5.4 Wave-soldering apparatus .....	8
5.5 Solvent for vapour-phase reflow soldering .....	8
5.6 Flux .....	8
5.7 Solder .....	8
6 Procedure .....	9
6.1 Initial measurements .....	9
6.1.1 Visual inspection .....	9
6.1.2 Electrical measurement .....	9
6.1.3 Internal inspection by acoustic tomography .....	9
6.2 Drying .....	9
6.3 Moisture soak .....	9
6.3.1 General .....	9
6.3.2 Conditions for non-dry-packed SMDs .....	9
6.3.3 Moisture soak for dry-packed SMDs .....	10
6.4 Soldering heat .....	11
6.4.1 General .....	11
6.4.2 Method of heating by infrared convection or convection reflow soldering .....	12
6.4.3 Method of heating by vapour-phase reflow soldering .....	13
6.4.4 Method of heating by wave-soldering .....	13
6.5 Recovery .....	14
6.6 Final measurements .....	15
6.6.1 Visual inspection .....	15
6.6.2 Electrical measurement .....	15
6.6.3 Internal inspection by acoustic tomography .....	15
7 Information to be given in the relevant specification .....	15
Annex A (informative) Details and description of test method on resistance of plastic encapsulated SMDs to the combined effect of moisture and soldering heat .....	17
A.1 Description of moisture soak .....	17
A.1.1 Guidance for moisture soak .....	17
A.1.2 Considerations on which the condition of moisture soak is based .....	17
A.2 Procedure for moisture content measurement .....	22
A.3 Soldering heat methods .....	23
A.3.1 Temperature profile of infrared convection and convection reflow soldering .....	23
A.3.2 Temperature profile of vapour-phase soldering .....	25
A.3.3 Heating method by wave-soldering .....	26

Figure 1 – Method of measuring the temperature profile of a specimen.....	8
Figure 2 – Heating by wave-soldering .....	14
Figure A.1 – Process of moisture diffusion at 85 °C, 85 % RH.....	18
Figure A.2 – Definition of resin thickness and the first interface .....	18
Figure A.3 – Moisture soak time to saturation at 85 °C as a function of resin thickness.....	18
Figure A.4 – Temperature dependence of saturated moisture content of resin .....	19
Figure A.5 – Dependence of moisture content of resin at the first interface on resin thickness under various soak conditions .....	20
Figure A.6 – Dependence of moisture content of resin at the first interface on resin thickness related to method A of moisture soak .....	20
Figure A.7 – Dependence of the moisture content of resin at the first interface on resin thickness related to method B of moisture soak .....	21
Figure A.8 – Dependence of moisture content of resin at the first interface on resin thickness related to condition B2 of method B of moisture soak .....	22
Figure A.9 – Temperature profile of infrared convection and convection reflow soldering for Sn-Pb eutectic assembly .....	23
Figure A.10 – Temperature profile of infrared convection and convection reflow soldering for lead-free assembly .....	24
Figure A.11 – Classification profile.....	25
Figure A.12 – Temperature profile of vapour-phase soldering (condition II-A) .....	25
Figure A.13 – Immersion method into solder bath .....	26
Figure A.14 – Relation between the infrared convection reflow soldering and wave-soldering.....	27
Figure A.15 – Temperature in the body of the SMD during wave-soldering.....	27
Table 1 – Moisture soak conditions for non-dry-packed SMDs .....	9
Table 2 – Moisture soak conditions for dry-packed SMDs (method A) .....	10
Table 3 – Moisture soak conditions for dry-packed SMDs (method B) .....	11
Table 4 – SnPb eutectic process – Classification reflow temperatures ( $T_c$ ) .....	12
Table 5 – Pb-free process – Classification reflow temperatures ( $T_c$ ) .....	13
Table 6 – Heating condition for vapour-phase soldering .....	13
Table 7 – Immersion conditions for wave-soldering .....	14
Table A.1 – Comparison of actual storage conditions and equivalent moisture soak conditions before soldering heat .....	19
Table A.2 – Classification profiles .....	24

## INTERNATIONAL ELECTROTECHNICAL COMMISSION

### SEMICONDUCTOR DEVICES – MECHANICAL AND CLIMATIC TEST METHODS –

#### Part 20: Resistance of plastic encapsulated SMDs to the combined effect of moisture and soldering heat

#### FOREWORD

- 1) The International Electrotechnical Commission (IEC) is a worldwide organization for standardization comprising all national electrotechnical committees (IEC National Committees). The object of IEC is to promote international co-operation on all questions concerning standardization in the electrical and electronic fields. To this end and in addition to other activities, IEC publishes International Standards, Technical Specifications, Technical Reports, Publicly Available Specifications (PAS) and Guides (hereafter referred to as "IEC Publication(s)"). Their preparation is entrusted to technical committees; any IEC National Committee interested in the subject dealt with may participate in this preparatory work. International, governmental and non-governmental organizations liaising with the IEC also participate in this preparation. IEC collaborates closely with the International Organization for Standardization (ISO) in accordance with conditions determined by agreement between the two organizations.
- 2) The formal decisions or agreements of IEC on technical matters express, as nearly as possible, an international consensus of opinion on the relevant subjects since each technical committee has representation from all interested IEC National Committees.
- 3) IEC Publications have the form of recommendations for international use and are accepted by IEC National Committees in that sense. While all reasonable efforts are made to ensure that the technical content of IEC Publications is accurate, IEC cannot be held responsible for the way in which they are used or for any misinterpretation by any end user.
- 4) In order to promote international uniformity, IEC National Committees undertake to apply IEC Publications transparently to the maximum extent possible in their national and regional publications. Any divergence between any IEC Publication and the corresponding national or regional publication shall be clearly indicated in the latter.
- 5) IEC itself does not provide any attestation of conformity. Independent certification bodies provide conformity assessment services and, in some areas, access to IEC marks of conformity. IEC is not responsible for any services carried out by independent certification bodies.
- 6) All users should ensure that they have the latest edition of this publication.
- 7) No liability shall attach to IEC or its directors, employees, servants or agents including individual experts and members of its technical committees and IEC National Committees for any personal injury, property damage or other damage of any nature whatsoever, whether direct or indirect, or for costs (including legal fees) and expenses arising out of the publication, use of, or reliance upon, this IEC Publication or any other IEC Publications.
- 8) Attention is drawn to the Normative references cited in this publication. Use of the referenced publications is indispensable for the correct application of this publication.
- 9) Attention is drawn to the possibility that some of the elements of this IEC Publication may be the subject of patent rights. IEC shall not be held responsible for identifying any or all such patent rights.

International Standard IEC 60749-20 has been prepared by IEC technical committee 47: Semiconductor devices.

This third edition cancels and replaces the second edition published in 2008. This edition constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- a) incorporation of a technical corrigendum to IEC 60749-20:2008 (second edition );
- b) inclusion of new Clause 3;
- c) inclusion of explanatory notes.

The text of this International Standard is based on the following documents:

FDIS	Report on voting
47/2634/FDIS	47/2646/RVD

Full information on the voting for the approval of this International Standard can be found in the report on voting indicated in the above table.

This document has been drafted in accordance with the ISO/IEC Directives, Part 2.

A list of all parts in the IEC 60749 series, published under the general title *Semiconductor devices – Mechanical and climatic test methods*, can be found on the IEC website.

The committee has decided that the contents of this document will remain unchanged until the stability date indicated on the IEC website under "<http://webstore.iec.ch>" in the data related to the specific document. At this date, the document will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

## **SEMICONDUCTOR DEVICES – MECHANICAL AND CLIMATIC TEST METHODS –**

### **Part 20: Resistance of plastic encapsulated SMDs to the combined effect of moisture and soldering heat**

#### **1 Scope**

This part of IEC 60749 provides a means of assessing the resistance to soldering heat of semiconductors packaged as plastic encapsulated surface mount devices (SMDs). This test is destructive.

#### **2 Normative references**

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60068-2-20:2008, *Environmental testing – Part 2-20: Tests – Test T: Test methods for solderability and resistance to soldering heat of devices with leads*

IEC 60749-3, *Semiconductor devices – Mechanical and climatic test methods – Part 3: External visual examination*

IEC 60749-30, *Semiconductor devices – Mechanical and climatic test methods – Part 30: Preconditioning of non-hermetic surface mount devices prior to reliability testing*

IEC 60749-35, *Semiconductor devices – Mechanical and climatic test methods – Part 35: Acoustic microscopy for plastic encapsulated electronic components*

koniec náhľadu – text d'alej pokračuje v platenej verzii STN