

Packaging of components for automatic handling —

Part 5: Matrix trays

ICS 31.020

National foreword

This British Standard is the UK implementation of EN 60286-5:2004+A1:2009. It is identical with IEC 60286-5:2003 incorporating amendment 1:2009. It supersedes BS EN 60286-5:2004 which is withdrawn.

The start and finish of text introduced or altered by amendment is indicated in the text by tags. Tags indicating changes to IEC text carry the number of the IEC amendment. For example, text altered by IEC amendment 1 is indicated by **A1** **A1**.

The UK participation in its preparation was entrusted to Technical Committee EPL/40X, Capacitors and resistors for electronic equipment.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

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English version

Packaging of components for automatic handling
Part 5: Matrix trays
(IEC 60286-5:2003)

Emballage de composants
pour opérations automatisées
Partie 5: Supports matriciels
(CEI 60286-5:2003)

Gurtung und Magazinierung
von Bauelementen für automatische
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Teil 5: Flachmagazine
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CENELEC

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

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Foreword

The text of document 40/1341/FDIS, future edition 2 of IEC 60286-5, prepared by IEC TC 40, Capacitors and resistors for electronic equipment, was submitted to the IEC-CENELEC parallel vote and was approved by CENELEC as EN 60286-5 on 2004-05-01.

This European Standard supersedes EN 60286-5:1997.

Significant technical changes from EN 60286-5:1997 are:

- a) The generic rules for the design of matrix trays are given in this standard. Newly developed trays which follow these rules will not be listed individually. Only those trays which conform to the design rules set forth herein are classified as "standard trays" and are thus preferred for use.
- b) An update of the matrix trays, which do not conform to the design rules set forth herein, are considered as "non-standard trays" and are not preferred for use, is listed in Annex A.

The following dates were fixed:

- latest date by which the EN has to be implemented
at national level by publication of an identical
national standard or by endorsement (dop) 2005-02-01
- latest date by which the national standards conflicting
with the EN have to be withdrawn (dow) 2007-05-01

Endorsement notice

The text of the International Standard IEC 60286-5:2003 was approved by CENELEC as a European Standard without any modification.

Foreword to amendment A1

The text of document 40/1942/FDIS, future amendment 1 to IEC 60286-5:2003, prepared by IEC TC 40, Capacitors and resistors for electronic equipment, was submitted to the IEC-CENELEC parallel vote and was approved by CENELEC as amendment A1 to EN 60286-5:2004 on 2009-03-01.

The following dates were fixed:

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- latest date by which the national standards conflicting
with the amendment have to be withdrawn (dow) 2012-03-01

Endorsement notice

The text of amendment 1:2009 to the International Standard IEC 60286-5:2003 was approved by CENELEC as an amendment to the European Standard without any modification.

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PACKAGING OF COMPONENTS FOR AUTOMATIC HANDLING –

Part 5: Matrix trays

1 Scope

This part of IEC 60286 describes the common dimensions, tolerances and characteristics of the tray. It includes only those dimensions which are essential for the handling of the trays for the stated purpose and for placing or removing components from the trays.

Matrix trays are designed to facilitate the transport and handling of electronic components during their testing, baking, transport/storage, and final mounting by automatic placement equipment.

The generic rules for their design are given in this standard.. Newly developed trays which follow these rules will not be listed individually . Only those trays which conform to the design rules set forth herein are classified as “standard trays” and are thus preferred for use.

NOTE Matrix trays listed in Annex A which do not conform to the design rules set forth herein shall be considered as “non-standard trays” and are not preferred for use.

2 Material

2.1 Electrostatic dissipative requirements

A1 Trays shall be moulded from material that meets the ESD dissipative requirements with surface resistance equal to or greater than $1,0 \times 10^5$ ohms/square but less than $1,0 \times 10^{11}$ ohms/square. **A1**

2.2 Effect of properties

The tray material shall not adversely affect the mechanical, electrical characteristics, solderability, or marking of the component during or after transport, baking or storage in the tray.

2.3 Recycling and rigidity

The tray material shall be reusable or recyclable and shall be rigid enough to avoid damage to the components during handling, loading, baking, testing, shipping and placement operations.

There should be space for a recycle logo and material code or material declaration close to ‘Detail B’.

3 Mechanical stability

3.1 Loaded tray

Mechanical stability of loaded trays shall be such that the components are adequately retained, without lead damage, and can be easily removed from the tray.

3.2 Empty tray

The empty tray shall withstand normal environmental conditions (including component baking temperatures, if required) without distorting, warping, expanding, shrinking or any other physical change outside the specified dimensions of the trays.

3.3 Outer edges

The outer edges of the tray shall be of sufficient thickness and strength to allow mechanical positioning and clamping.

4 Tray design, dimensions and other physical properties

4.1 Tray design

4.1.1 Number of pockets

All new tray proposals should maximize the number of pockets in each tray-family variation without violating the pocket-density design rules specified in 4.1.3.

4.1.2 Orientation of pockets

When designing a tray for a rectangular package, the longest dimension (D) of the package is oriented parallel to the length of the tray to maximize tray pocket density.

4.1.3 Design rules for pocket density

4.1.3.1 Formulas

- DT is Dmax + strengthening pocket rib width W
- ET is Emax + strengthening pocket rib width W
- M is (135,9 mm - M3(N1 - 1))/2
- M1 is (315,0 mm - M2(N2 - 1))/2
- M2 is [(315,0 mm - 2P mm) - W(N2 - 1)]/N2 + W
- M3 is [(135,9 mm - 2P mm) - W(N1 - 1)]/N1 + W
- N1 is (135,9 mm - 2P mm)/ET (rounded down to a whole number)
- N2 is (315,0 mm - 2P mm)/DT (rounded down to a whole number)

NOTE After the maximum matrix has been established by the above calculation using a minimum W value, N1 and N2 may not have resulted in even numbers and may therefore have been rounded down to the nearest whole number. This means we may have fractions of millimetres extra that should be added back to M2 and M3 to maximize the pitch between the pockets while minimizing the edge of the tray to the centre line of the first pocket M and M1.

The dimensions P and W are given in Table 1.

Table 1 – P and W dimension

Table with 4 columns: Dimension, Thin tray (Normal stacking tray, Low stacking tray), Thick tray. Rows for P and W dimensions in mm.

4.1.3.2 Constituents of the design rules, formulas and drawings

- $D_{\max}$ is determined by appropriate specification
- DT is the max. length D + strengthening pocket rib width W
- $E_{\max}$ is determined by appropriate specification
- ET is the max. width E + strengthening pocket rib width W
- M is the edge of the tray width to the centre line of the first pocket
- $M1$ is the edge of the tray length to the centre line of the first pocket
- $M2$ is the pitch of the tray pocket in the tray length
- $M3$ is the pitch of the tray pocket in the tray width
- N is the package lead counts supported
- $N1$ is the number of columns in the tray
- $N2$ is the number of rows in the tray
- $N3$ is the total number of pockets in the tray ($N1 \times N2 = N3$)
- $N4$ is the package type accommodated
- $N5$ is the end vacuum pick-up area(s)
- $N6$ is the centre vacuum pick-up area(s)
- $\boxed{A_1}P$ is the edge of the tray to the edge of the pocket $\boxed{A_1}$
- W is the strengthening pocket rib width

NOTE The tray sponsor will determine W from the latest manufacturing capabilities and design feature needs at the time of the new tray-family design.

$\boxed{A_1}W$ should not exceed the target value of Table 1 in order to achieve the maximum tray density unless required by application. $\boxed{A_1}$

4.2 Overall tray dimensions

Overall tray dimensions shall be 322,6 mm in length and 135,9 mm in width. Overall height A , stacking step height $A1$ and edge height $A2$ are given in $\boxed{A_1}$ Table 2 $\boxed{A_1}$.

$\boxed{A_1}$ Table 2 – Height dimensions

Dimension	Thin tray		Thick tray mm
	Normal stacking tray mm	Low stacking tray mm	
A	7,62	7,62	12,19
$A1$	6,35	5,62	10,16
$A2$	1,27 typically	2,00 typically	2,03 typically

Measurement methodology of the tray outline dimensions, height, stacking feature dimensions and warpage are described in Annex B. $\boxed{A_1}$

4.3 Cell dimensions

Cell dimensions are derived from package dimensions. The information given in this section is intended for reference only. Package types shown in Figures 1 and 2 are not intended in any way to limit types of present or future designs which may require matrix trays.

D and E dimensions represent the largest overall features of a package (lead or body).

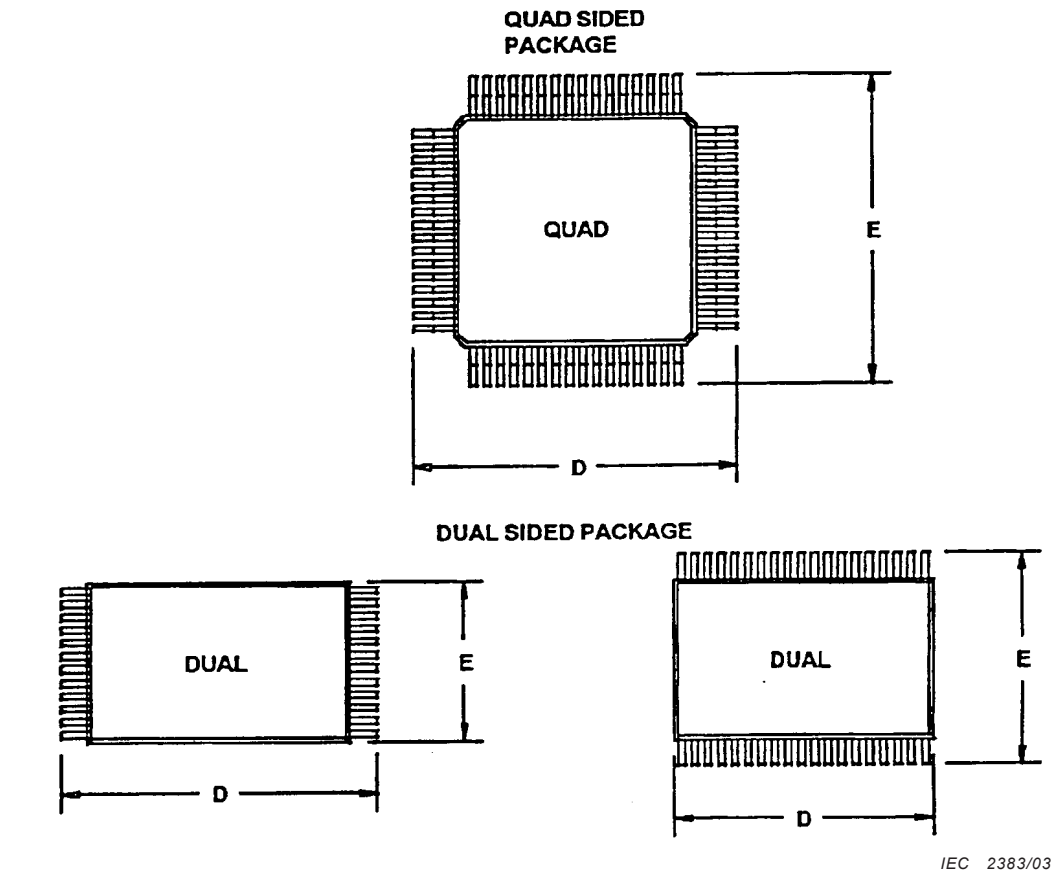


Figure 1 – Sample of leaded packages

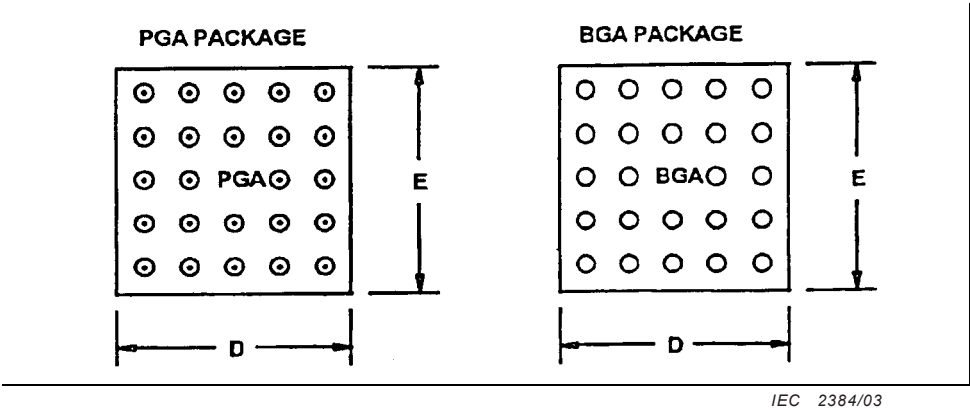


Figure 2 – Sample of grid array packages

4.4 Tray vacuum pick-up sites

4.4.1 Size

The closed walled vacuum pick-up area should be at least 28 mm × 28 mm.

4.4.2 Centre

A minimum of one walled vacuum pick-up area should be located as close to the centre as possible.

4.4.3 Perimeter

A minimum of one perimeter vacuum pick-up area should be located at each end of the tray.

4.5 Detail features

A1 All cavity detail features must begin at a minimum distance of $P = 3,2$ mm [Thin tray(normal tray)] or $P = 5,0$ mm [Thin tray(Low stack tray) and Thick tray)]. **A1**

NOTE The straightness call-out of 0,80 mm may have to be reduced when designing trays for thinner packages.

4.6 Weight

The empty tray weight shall not exceed 300 g.

4.7 Movement of components

The tray cell design shall minimize the component movement. The component shall not rotate more than 2,5° in any direction.

****A1** 4.8 Dimensional information**

Figures 3 and 4 state dimensions for the tray main view and for the tray stacking details.