

## Handling and Mounting of RCA Molded-Plastic Transistors and Thyristors

by W.J. Hepp, J.S. Vara, and J. Gaylord

RCA power transistors and thyristors (SCR's and triacs) in molded-silicone-plastic packages are available in a wide range of power-dissipation ratings and a variety of package configurations. This Note provides detailed guidelines for handling and mounting of these plastic-package devices, and shows different types of packages and suggested mounting hardware to accommodate various mounting arrangements. Recommendations are made for handling of the packages during the forming of leads to meet specific mounting requirements. Various mounting arrangements, thermal considerations, and cleaning methods are described. This information is intended to augment the data on electrical characteristics, safe operating area, and performance capabilities in the technical bulletin for each type of plastic-package transistor or thyristor. (Data on mechanical and environmental capabilities of RCA plastic-package transistors are also available in a periodically updated **Reliability Report**, RCA Publication No. HBT-600.)

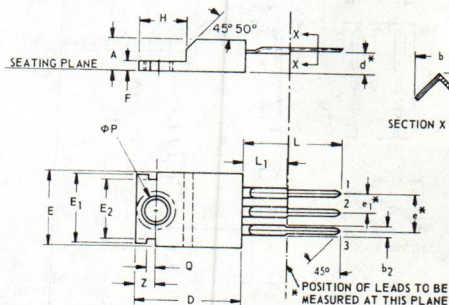
### TYPES OF PACKAGES

Two basic types of molded-plastic packages are used for RCA solid-state power devices. These types include the RCA Versawatt packages for medium-power applications and the RCA high-power plastic packages, both of which are specifically designed for ease of use in many applications. Each basic type offers several different package options, and the user can select the configuration best suited to his particular application.

Figs. 1 through 3 show the options currently available for devices in RCA Versawatt packages. The JEDEC Type TO-220AB in-line-lead version, shown in Fig. 1, represents the basic style. This configuration features leads that can be formed to meet a variety of specific mounting requirements. Fig. 2 shows a package configuration that allows a Versawatt package to be mounted on a printed-circuit board with a 0.100-inch grid and a minimum lead spacing of 0.200 inch. Fig. 3 shows a JEDEC Type TO-220AA version of the Versawatt package. The dimensions of this type of transistor package are such that it can replace the JEDEC TO-66 transistor package in a commercial socket or printed-circuit board without retooling. The pin-connection arrangement

of thyristors supplied in TO-220AA packages, however, differs from that of thyristors supplied in conventional TO-66 packages so that some hardware changes are required to effect a replacement. The TO-220AA Versawatt package is also supplied with an integral heat sink. Fig. 4 shows the dimensional outline for this heat sink. The use of the integral heat sink reduces the junction-to-air thermal resistance of the package from 70°C per watt to 35°C per watt.

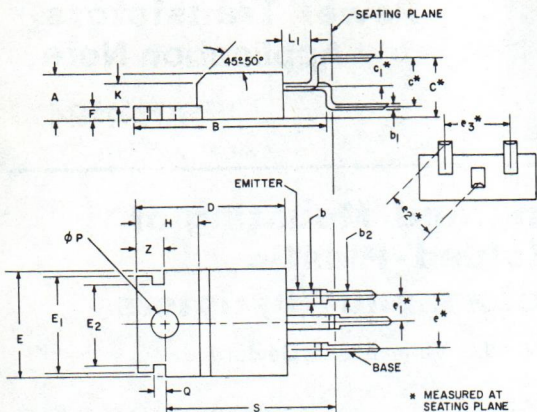
The RCA molded-plastic high-power packages are also supplied in several configurations for flexibility of application. The JEDEC Type TO-219AB, shown in Fig. 5, is the basic high-power plastic package. Fig. 6 shows a JEDEC Type TO-219AA version of the high-power plastic package. With the addition of an NR193B top clamp, the TO-219AA



SYMBOL	INCHES	
	MIN.	MAX.
A	.140	.190
b	.020	.038
b <sub>1</sub>	.012	.045
b <sub>2</sub>	.045	.070
D	.560	.625
d	.080	.115
E	.330	.420
E <sub>1</sub>	.365	.385
E <sub>2</sub>	.300	.320

SYMBOL	INCHES	
	MIN.	MAX.
e	.190	.210
e <sub>1</sub>	.090	.110
F	.045	.055
H	.230	.270
L	.500	.562
L <sub>1</sub>		.250
φP	.139	.147
Q	.040	.060
Z	.100	.120

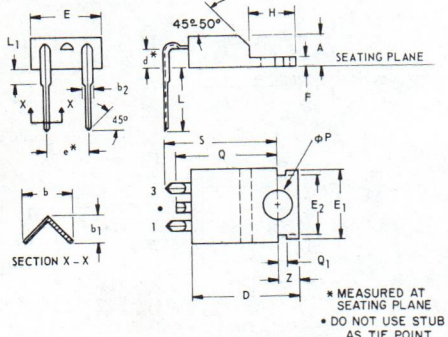
Fig. 1 - Dimensional outline of the JEDEC TO-220AB in-line-lead Versawatt transistor package.



SYMBOL	INCHES	
	MIN.	MAX.
A	.140	.190
B	.045	.085
b	.045	.070
b <sub>1</sub>	.015	.030
b <sub>2</sub>	.020	.038
C	.230	.270
c	.180	.220
c <sub>1</sub>	.130	.170
D	.560	.625
E	.330	.410
E <sub>1</sub>	.365	.385
E <sub>2</sub>	.300	.320

SYMBOL	INCHES	
	MIN.	MAX.
e	.190	.210
e <sub>1</sub>	.090	.110
e <sub>2</sub>	.203	.243
e <sub>3</sub>	.190	.200
F	.045	.070
H	.230	.270
K	.080	.085
L <sub>1</sub>	.070	.090
φP	.139	.147
Q	.040	.060
S	.655	.685
Z	.100	.120

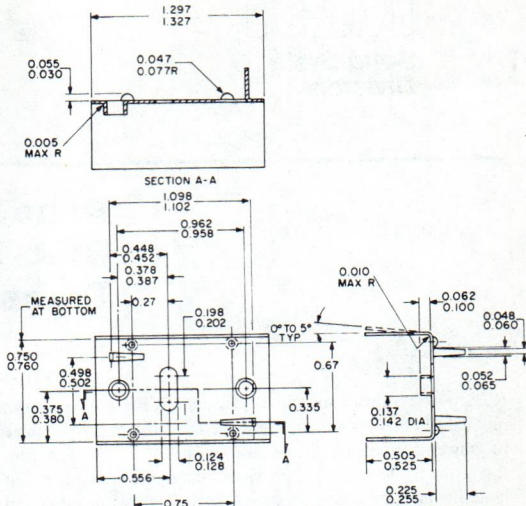
Fig. 2 - Dimensional outline of Versawatt transistor package designed for mounting on printed-circuit boards.



SYMBOL	INCHES	
	MIN.	MAX.
A	.140	.190
b	.020	.038
b <sub>1</sub>	.012	.045
b <sub>2</sub>	.045	.070
D	.560	.625
d	.080	.115
E	.330	.420
E <sub>1</sub>	.365	.385
E <sub>2</sub>	.300	.320
e	.190	.210

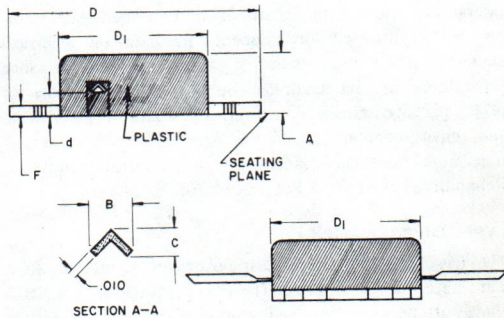
SYMBOL	INCHES	
	MIN.	MAX.
F	.045	.055
H	.230	.270
L	.360	.422
L <sub>1</sub>	.050	
φP	.139	.147
Q	.610	
Q <sub>1</sub>	.040	.060
S	.580	.610
Z	.100	.120

Fig. 3 - JEDEC TO-220AA Versawatt transistor package designed for direct replacement of the JEDEC TO-66 package.



ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SHOWN. TOLERANCES ARE: ±0.02 FOR 2ND PLACE; ±0.005 FOR 3RD PLACE AND ±1/2° FOR ANGULAR DIMENSION.

Fig. 4 - Integral heat sink used with the TO-220AA Versawatt package shown in Fig. 3.



SYMBOL	INCHES	
	MIN.	MAX.
A	.160	.200
B	.045	.060
C	.025	.045
D	.890	.910
D <sub>1</sub>	.480	.515
d	.100	.120
E	.480	.520
F	.055	.070
L <sub>1</sub>	.415	.560
p	.128	.150
q	.740	.760
S	.500	.520

Fig. 5 - JEDEC TO-219AB high-power molded-plastic transistor package.

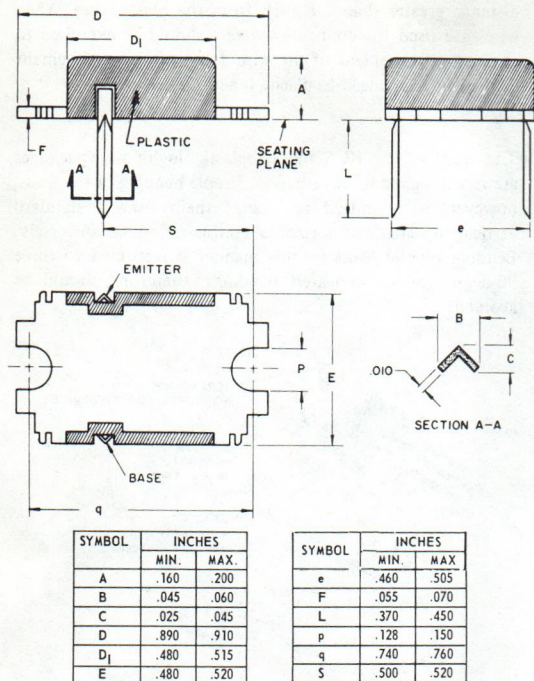


Fig. 6 - JEDEC TO-219AA plastic package designed for use (with the addition of an NR193B clamp) as a direct replacement for the hermetically sealed JEDEC TO-3 transistor package.

package can be used as a direct replacement for the hermetically sealed JEDEC TO-3 package. [The NR193B clamp is shown in the section on Mounting, Fig. 11(c), later in this Note.] The RCA high-power plastic package is also available with an attached header-case lead, as shown in Fig. 7. This three-lead package is designed for mounting on a printed-circuit board.

#### LEAD-FORMING TECHNIQUES

RCA Versawatt plastic packages are both rugged and versatile within the confines of commonly accepted standards for such devices. Although these versatile packages lend themselves to numerous arrangements, provision of a wide variety of lead configurations to conform to the specific requirements of many different mounting arrangements is highly impractical. However, the leads of the Versawatt in-line package can be formed to a custom shape, provided that they are not indiscriminately twisted or bent. Although these leads can be formed, they are not flexible in the general sense, nor are they sufficiently rigid for unrestrained wire wrapping.

Before an attempt is made to form the leads of an in-line package to meet the requirements of a specific application, the desired lead configuration should be determined, and a lead-bending fixture should be designed and constructed. The

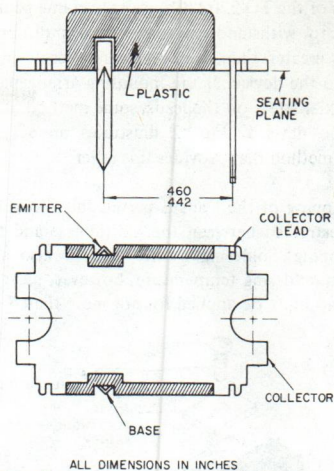


Fig. 7 - TO-219AA plastic transistor package designed for mounting on printed-circuit boards.

use of a properly designed fixture for this operation eliminates the need for repeated lead bending. When the use of a special bending fixture is not practical, a pair of long-nosed pliers may be used. The pliers should hold the lead firmly between the bending point and the case, but should not touch the case. Fig. 8 illustrates the use of long-nosed pliers for lead bending. Fig. 8(a) shows techniques that should be avoided; Fig. 8(b) shows the correct method.

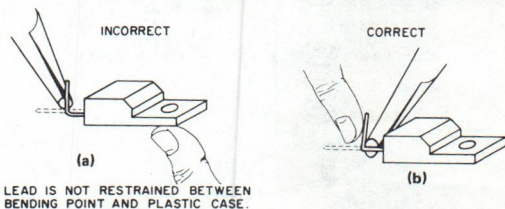


Fig. 8 - Use of long-nosed pliers for lead bending: (a) incorrect method; (b) correct method.

When the leads of an in-line plastic package are to be formed, whether by use of long-nosed pliers or a special bending fixture, the following precautions must be observed to avoid internal damage to the device:

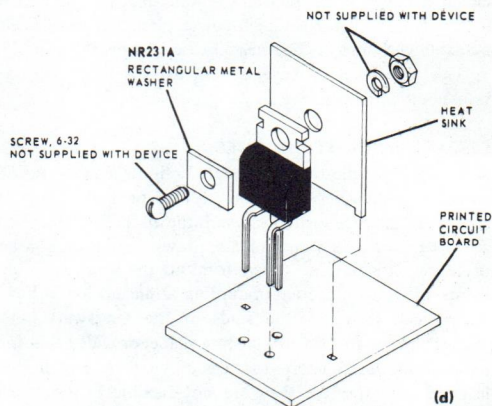
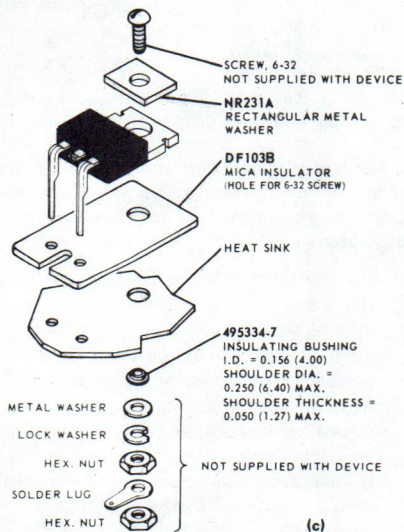
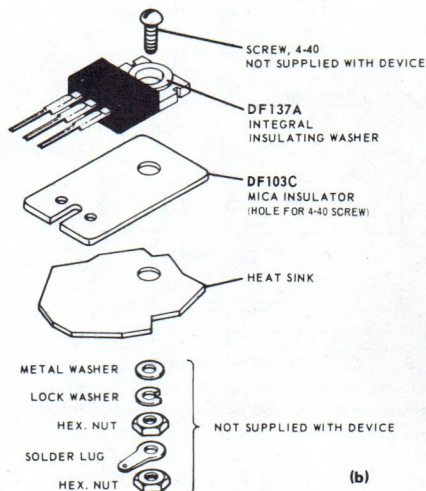
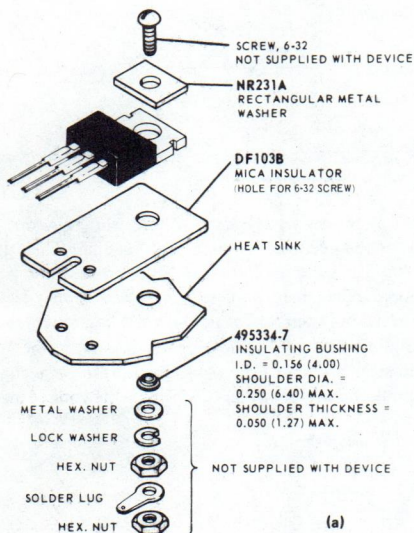
1. Restrain the lead between the bending point and the plastic case to prevent relative movement between the lead and the case.
2. When the bend is made in the plane of the lead (spreading), bend only the narrow part of the lead.
3. When the bend is made in the plane perpendicular to that of the leads, make the bend at least 1/8 inch from the plastic case.
4. Do not use a lead-bend radius of less than 1/16 inch.
5. Avoid repeated bending of leads.

The leads of the TO-220AB Versawatt in-line package are not designed to withstand excessive axial pull. Force in this direction greater than 4 pounds may result in permanent damage to the device. If the mounting arrangement tends to impose axial stress on the leads, some method of strain relief should be devised. Fig. 2 illustrates an acceptable lead-forming method that provides this relief.

Wire wrapping of the leads is permissible, provided that the lead is restrained between the plastic case and the point of the wrapping. Soldering to the leads is also allowed; the maximum soldering temperature, however, must not exceed 275°C and must be applied for not more than 5 seconds at a

distance greater than 1/8 inch from the plastic case. When wires are used for connections, care should be exercised to assure that movement of the wire does not cause movement of the lead at the lead-to-plastic junctions.

The leads of the RCA molded-plastic high-power packages are not designed to be reshaped. Simple bending of the leads, however, is permitted to change them from a standard vertical to a standard horizontal configuration, or conversely. Bending of the leads in this manner is restricted to three 90-degree bends; repeated bendings, therefore, should be avoided.



Dimensions in parentheses are in millimeters and are derived from the basic inch dimensions as indicated.

Fig. 9 - Mounting arrangements for Versawatt transistors: (a) and (b) methods of mounting in-line-lead types; (c) chassis mounting; (d) mounting on printed-circuit boards.

## MOUNTING

Fig. 9 shows recommended mounting arrangements and suggested hardware for the Versawatt transistors. The rectangular washer (NR231A) shown in Fig. 9(a) is designed to minimize distortion of the mounting flange when the transistor is fastened to a heat sink. Excessive distortion of the flange could cause damage to the transistor. The washer is particularly important when the size of the mounting hole exceeds 0.140 inch (6-32 clearance). Larger holes are needed to accommodate insulating bushings; however, the holes should not be larger than necessary to provide hardware clearance and, in any case, should not exceed a diameter of 0.250 inch. Flange distortion is also possible if excessive torque is used during mounting. A maximum torque of 8 inch-pounds is specified. Care should be exercised to assure that the tool used to drive the mounting screw never comes in contact with the plastic body during the driving operation. Such contact can result in damage to the plastic body and internal device connections. An excellent method of avoiding this problem is to use a spacer or combination spacer-insulating bushing which raises the screw head or nut above the top surface of the plastic body, as shown in Fig. 10. The material used for such a spacer or spacer-insulating bushing should, of course, be carefully selected to avoid "cold flow" and consequent reduction in mounting force. Suggested materials for these bushings are diallphthalate, fiberglass-filled nylon, or fiberglass-filled polycarbonate. Unfilled nylon should be avoided.

Modification of the flange can also result in flange distortion and should not be attempted. The transistor should not be soldered to the heat sink by use of lead-tin solder because the heat required with this type of solder will cause the junction temperature of the transistor to become excessive.

The TO-220AA plastic transistor can be mounted in commercially available TO-66 sockets, such as UID Electronics Corp. Socket No. PTS-4 or equivalent. For testing purposes, the TO-220AB in-line package can be mounted in a Jetron Socket No. CD74-104 or equivalent. Regardless of the mounting method, the following precautions should be taken:

1. Use appropriate hardware.
2. Always fasten the transistor to the heat sink before the leads are soldered to fixed terminals.
3. Never allow the mounting tool to come in contact with the plastic case.
4. Never exceed a torque of 8 inch-pounds.
5. Avoid oversize mounting holes.
6. Provide strain relief if there is any probability that axial stress will be applied to the leads.
7. Use insulating bushings to prevent hot-creep problems. Such bushings should be made of diallphthalate, fiberglass-filled nylon, or fiberglass-filled polycarbonate.

Fig. 11 shows the recommended hardware and mounting arrangements for RCA high-power molded-plastic transistors. These types can be mounted directly in a socket similar to that shown in Fig. 11(b) or they can be mounted in a standard TO-3 socket with the NR193B clamp. The precautions listed for the Versawatt packages should also be followed in the mounting of the high-power molded-plastic packages.

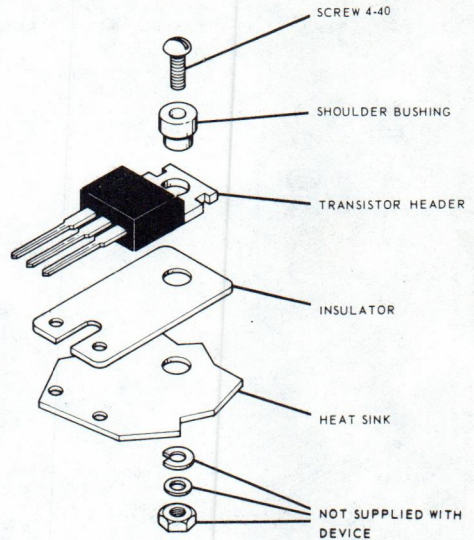
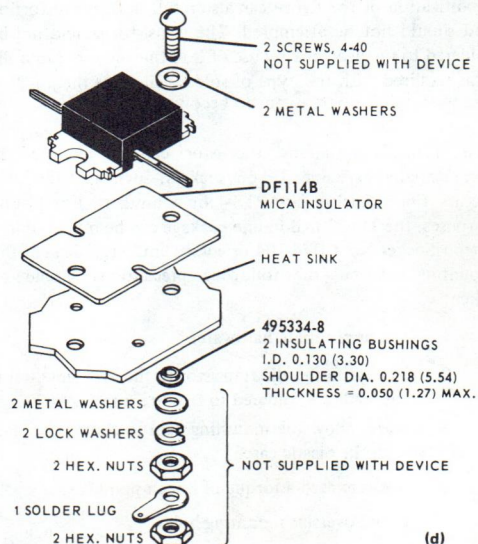
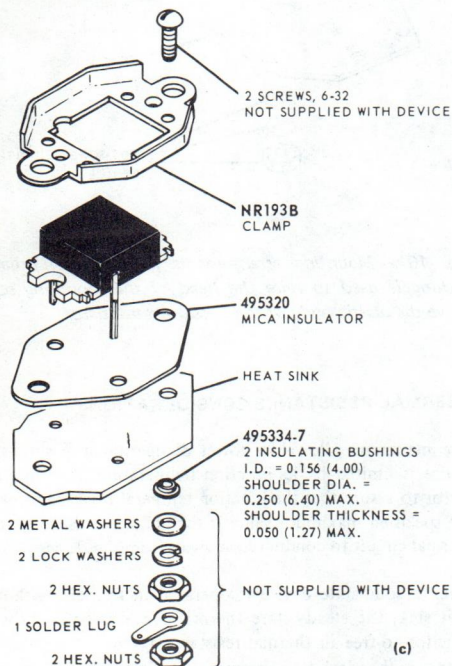
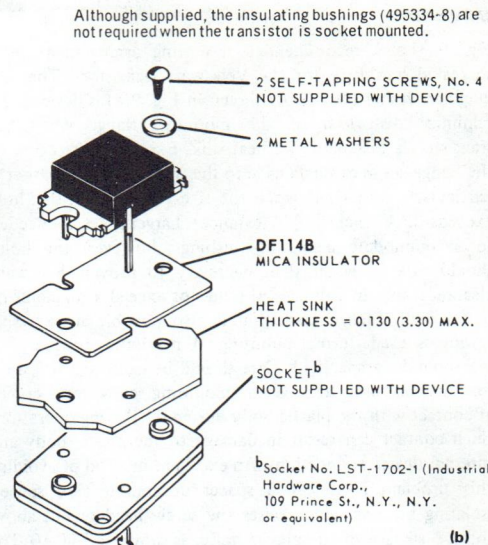
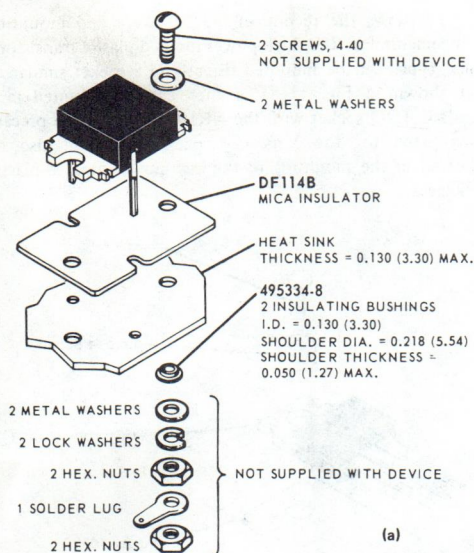


Fig. 10 - Mounting arrangements in which an isolating bushing is used to raise the head of the mounting screw above the plastic body of the Versawatt transistor.

## THERMAL-RESISTANCE CONSIDERATIONS

The maximum allowable power dissipation in a solid-state device is limited by its junction temperature. An important factor to assure that the junction temperature remains below the specified maximum value is the ability of the associated thermal circuit to conduct heat away from the device.

When a solid-state device is operated in free air, without a heat sink, the steady-state thermal circuit is defined by the junction-to-free-air thermal resistance given in the published data on the device. Thermal considerations require that there be a free flow of air around the device and that the power dissipation be maintained below that which would cause the junction temperature to rise above the maximum rating. When the device is mounted on a heat sink, however, care must be taken to assure that all portions of the thermal circuit are considered.



Dimensions in parentheses are in millimeters and are derived from the basic inch dimensions as indicated.

Fig. 11 - Mounting arrangements for high-power plastic-package transistors: (a) chassis mounting; (b) socket mounting; (c) chassis mounting with top clamp; (d) printed-circuit-board mounting.

Fig. 12 shows the thermal circuit for a heat-sink-mounted transistor. This figure shows that the junction-to-ambient thermal circuit includes three series thermal-resistance components, i.e., junction-to-case,  $\theta_{J-C}$ ; case-to-heat-sink,  $\theta_{C-S}$ ; and heat-sink-to-ambient,  $\theta_{S-A}$ . The junction-to-case thermal resistance of the various transistor types is given in the individual technical bulletins on specific types. The heat-sink-to-ambient thermal resistance can be determined from the technical data provided by the heat-sink manufacturer, or from published heat-sink nomographs. The case-to-heat-sink thermal resistance depends on several factors, which include the condition of the heat-sink surface, the type of material and thickness of the insulator, the type of thermal compound, the mounting torque, and the diameter of the mounting hole in the heat-sink.

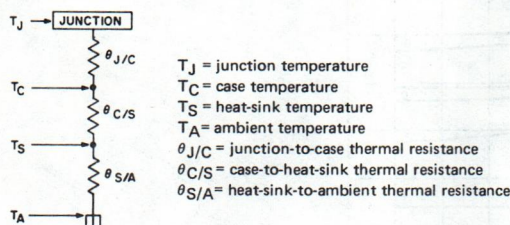


Fig. 12 - Thermal equivalent circuit for a transistor mounted on a heat sink.

Fig. 13 shows a set of curves of typical case-to-heat-sink thermal resistance of the Versawatt transistor as a function of mounting torque for several mounting arrangements. Curves A through D show typical case-to-heat-sink thermal resistance for the mounting arrangements shown in Figs. 9(a) through 9(d). Curves E and F are representative of a Versawatt transistor mounted over a heat-sink mounting hole that has a diameter of 0.140 inch (No. 6 screw clearance). Curve E shows the wide variation in thermal resistance with torque when the transistor is mounted dry. Curve F shows the effect on contact thermal resistance of a thin layer of Dow Corning No. 340 silicone grease applied between transistor and heat sink. For torques within the recommended range of 4 to 8 inch-pounds, contact thermal resistance is reduced to between 18 and 25 per cent of the dry values.

The curves shown in Fig. 14 represent typical case-to-heat-sink thermal resistance of the high-power molded-plastic transistor package as a function of mounting torque. The thermal resistances shown by curves A and C are representative of the mounting arrangements shown in Fig. 11(a) through 11(d). Curves B and D are typical for mounting without mica over heat-sink mounting holes that have a diameter of 0.113 inch (No. 4 screw clearance). The effect of a thin layer of silicone grease on contact thermal resistance is illustrated by a comparison of curves B and D.

Operation of the transistor with heat-sink temperatures of 100°C or greater results in some shrinkage of the insulating bushing normally used to mount power transistors. The degradation of contact thermal resistance (refer to Figs. 13 and 14) is usually less than 25 per cent if a good thermal compound is used. (A more detailed discussion of thermal resistance, including nomographs, can be found in the **RCA Power Circuits Manual**, Technical Series SP-5T.)

During the mounting of RCA molded-plastic solid-state power devices, the following special precautions should be taken to assure efficient heat transfer from case to heat sink:

1. Mounting torque should be between 4 and 8 inch-pounds.
2. The mounting holes should be kept as small as possible.
3. Holes should be drilled or punched clean with no burrs or ridges, and chamfered to a maximum radius of 0.010 inch.
4. The mounting surface should be flat within 0.002 inch/inch.
5. Thermal grease (Dow Corning 340 or equivalent) should always be used (on both sides of the insulating washer if one is employed).
6. Thin insulating washers should be used (thickness of factory-supplied mica washers ranges from 2 to 4 mils).
7. A lock washer or torque washer should be used, together with materials that have sufficient creep strength to prevent degradation of heat-sink efficiency during life.

A wide variety of solvents is available for degreasing and flux removal. The usual practice is to submerge components in a solvent bath for a specified time. From a reliability standpoint, however, it is extremely important that the solvent, together with other chemicals in the solder-cleaning system (such as flux and solder covers), not adversely affect the life of the component. This consideration applies to all non-hermetic and molded-plastic components.

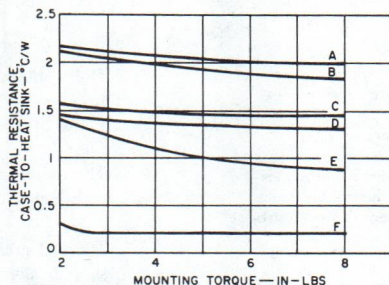
It is, of course, impractical to evaluate the effect on long-term transistor life of all cleaning solvents, which are marketed under a variety of brand names with numerous additives. These solvents can, however, be classified with respect to their component parts, as either acceptable or unacceptable. Chlorinated solvents tend to dissolve the outer package and, therefore, make operation in a humid atmosphere unreliable. Gasoline and other hydrocarbons cause the inner encapsulant to swell and damage the transistor. Alcohol and unchlorinated freons are acceptable solvents. Examples of such solvents are:

1. Freon TE
2. Freon TE-35
3. Freon TP-35 (Freon PC)
4. Alcohol (isopropanol, methanol, and special denatured alcohols, such as SDA1, SDA30, SDA34, and SDA44)

Care must also be used in the selection of fluxes in the soldering of leads. Rosin or activated rosin fluxes are recommended, while organic or acid fluxes are not. Examples of acceptable fluxes are:

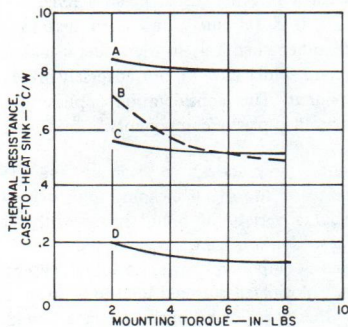
1. Alpha Reliaros No. 320-33
2. Alpha Reliaros No. 346
3. Alpha Reliaros No. 711
4. Alpha Reliafoam No. 807
5. Alpha Reliafoam No. 809
6. Alpha Reliafoam No. 811-13
7. Alpha Reliafoam No. 815-35
8. Kester No. 44

If the completed assembly is to be encapsulated, the effect on the molded-plastic transistor must be studied from both a chemical and a physical standpoint.



CURVE	MOUNTING ARRANGEMENT FIGURE	HEAT SINK HOLE DIA. (IN.)	MICA THICKNESS (MILS)	THERMAL COMPOUND
A	9(a)	.250	4	Dow Corning No.340
B	9(b)	.113	4	Dow Corning No.340
C	9(a)	.250	2	Dow Corning No.340
D	9(b)	.113	2	Dow Corning No.340
E	—	.140	None	None
F	—	.140	None	Dow Corning No.340

Fig. 13 - Typical case-to-heat-sink thermal resistance as a function of mounting torque for an RCA Versawatt transistor.



CURVE	MOUNTING ARRANGEMENT FIGURE	MICA THICKNESS (MILS)	THERMAL COMPOUND
A	10(a) thru 10(d)	4	Dow Corning No.340
B	—	None	None
C	10(a) thru 10(d)	2	Dow Corning No.340
D	—	None	Dow Corning No.340

Fig. 14 - Typical case-to-heat thermal resistance as a function of mounting torque for an RCA high-power plastic-package transistor.