

ALTERNATION HISTORY RECORDS

Date	Version	Mark	Page	Description	Drafter	Approver
2026-03-03	C	/	/	Release with a new version	Doris Chang	/

Part Numbering System:

<u>CR</u>	<u>03</u>	<u>J</u>	<u>B</u>	<u>10K</u>
<u>Series Name</u> Chip Resistor: CR: Thick Film chip resistors	<u>Type Inch (mm)</u> 01-0201(0603) 02-0402(1005) 03-0603(1608) 05-0805(2012) 06-1206(3216) 10-1210(3225) A8-1218(3248) 0A-2010(5025) 12-2512(6432)	<u>Tolerance</u> B= $\pm 0.1\%$ D= $\pm 0.5\%$ F= $\pm 1\%$ J= $\pm 5\%$ P : Jumper	<u>Package</u> Z=3Kpcs/10"Reel A=4Kpcs/7"Reel B=5Kpcs/7"Reel C=10Kpcs/7"Reel M=15Kpcs/7"Reel D=10Kpcs/10"Reel X=16Kpcs/13"Reel E=20Kpcs/13"Reel G =70Kpcs/13"Reel	<u>Resistance</u> 1R2=1.2 Ω 10K=10K Ω 10K5=10.5K Ω 100K=100K Ω 1M2=1.2M Ω

FEATURES

- 1). High reliability and stability
- 2.) Reduced size of final equipment
- 3). Lower assembly costs
- 4). Higher component and equipment reliability
- 5). RoHS 2 compliant with exemption 7C-I and Halogen free products
- 6). Flammability against UL94-V0

APPLICATIONS

- 1) Consumer electrical equipment
- 2) EDP, Computer application
- 3) Telecom application

DESCRIPTION

The resistors are constructed in a high grade ceramic body (aluminum oxide). Internal metal electrodes are added at each end and connected by a resistive paste that is applied to the top surface of the substrate. The composition of the paste is adjusted to give the approximate resistance required and the value is trimmed to within tolerance by laser cutting of this resistive layer.

The resistive layer is covered with a protective coat. Finally, the two external end terminations are added. For ease of soldering the outer layer of these end terminations is a Tin (lead free) alloy.

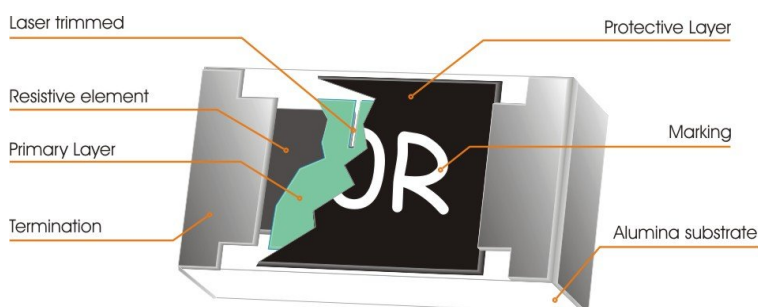


Fig 1.1. Construction of Chip-R

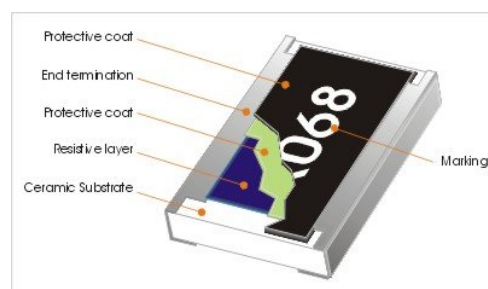


Fig 1.2. Construction of a 1218 Chip-R

QUICK REFERENCE DATA

Item	General Specification								
Series No.	CR12	CR0A	CRA8	CR10	CR06	CR05	CR03	CR02	CR01
Size code	2512 (6432)	2010 (5025)	1218 (3248)	1210 (3225)	1206 (3216)	0805 (2012)	0603 (1608)	0402 (1005)	0201 (0603)
Resistance Range	1Ω~10MΩ								
Resistance Tolerance	±1%, E96/E24, ±5%, E24								
TCR (ppm/°C)	10Ω< R≤ 10MΩ: ±100 R≤10Ω: ±200			10Ω< R≤ 10MΩ: ≤ ±100 R≤10Ω: -200~+400				10- 10MΩ: ±200 1- 9.76Ω: +600~-200	
Max. dissipation @ T _{amb} =70°C	1W	3/4W	1W	1/2W	1/4W	1/8W	1/10W	1/16W	1/20W
Max. Operation Voltage	250V	200V	200V	200V	200V	150V	75V	50V	25V
Max. Overload Voltage	500V	400V	400V	400V	400V	300V	150V	100V	50V
Operation temperature	-55 ~ +155°C								

Remark:

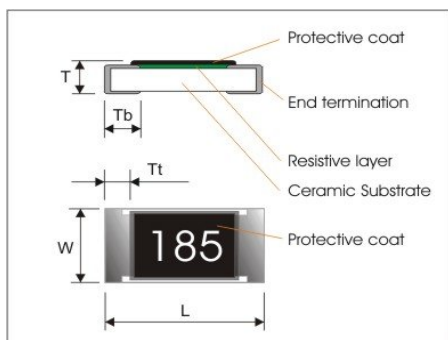
1. This is the maximum voltage that may be continuously supplied to the resistor element, see "IEC publication 60115-8"
2. Max. Operation Voltage : So called RCWV (Rated Continuous Working Voltage) is determined by

$$RCWV = \sqrt{\text{Rated Power} \times \text{Resistance Value}} \text{ or Max. RCWV listed above, whichever is lower.}$$

For Jumper (0Ω) :

Item	General Specification								
Series No.	CR12	CR0A	CRA8	CR10	CR06	CR05	CR03	CR02	CR01
Size code	2512 (6432)	2010 (5025)	1218 (3248)	1210 (3225)	1206 (3216)	0805 (2012)	0603 (1608)	0402 (1005)	0201 (0603)
Resistance Range	≤50mΩ for P tolerance ≤30mΩ for F tolerance								
TCR (ppm/°C)	TCR is not applicable for Jumper product								
Max. dissipation @ T _{amb} =70°C	1W	3/4W	1W	1/2W	1/4W	1/8W	1/10W	1/16W	1/20W
P tol.	Rated Current	4.5A	3.8A	4.5A	3A	2A	1.6A	1A	1A
	Peak Current	11A	9A	11A	7.5A	5A	3.2A	3A	2.5A
F tol.	Rated Current	5.8A	5A	-	4A	2.9A	2A	1.8A	1.25A
	Peak Current	14.5A	12.5A	-	10A	5.8A	4A	3.6A	2.5A
Operation temperature	-55 ~ +155°C								

DIMENSIONS (unit : mm)



Series	CR12	CR0A	CRA8	CR10	CR06	CR05	CR03	CR02	CR01
L	6.40±0.20	5.00±0.20	3.05±0.15	3.10±0.10	3.10±0.10	2.00±0.10	1.60±0.10	1.00±0.05	0.60±0.03
W	3.20±0.20	2.50±0.20	4.60±0.20	2.60±0.10	1.60±0.10	1.25±0.10	0.80±0.10	0.50±0.05	0.30±0.03
T	0.60±0.10	0.55±0.10	0.55±0.10	0.55±0.10	0.55±0.10	0.50±0.15	0.45±0.15	0.35±0.05	0.23±0.03
Tt	0.65±0.25	0.65±0.25	0.45±0.25	0.5 ±0.20	0.50±0.20	0.40±0.20	0.30±0.10	0.20±0.10	0.10±0.05
Tb	0.90±0.25	0.60±0.25	0.50±0.25	0.50±0.20	0.45±0.20	0.40±0.20	0.30±0.15	0.25±0.10	0.15±0.05

FUNCTIONAL DESCRIPTION

Product characterization

Standard values of nominal resistance are taken from the E24 series for resistors with a tolerance of $\pm 5\%$, and E96 series for resistors with a tolerance of $\pm 1\%$. The values of the E24/E96 series are in accordance with "IEC publication 60063"

Derating Curve

The power that the resistor can dissipate depends on the operating temperature; see Fig.2

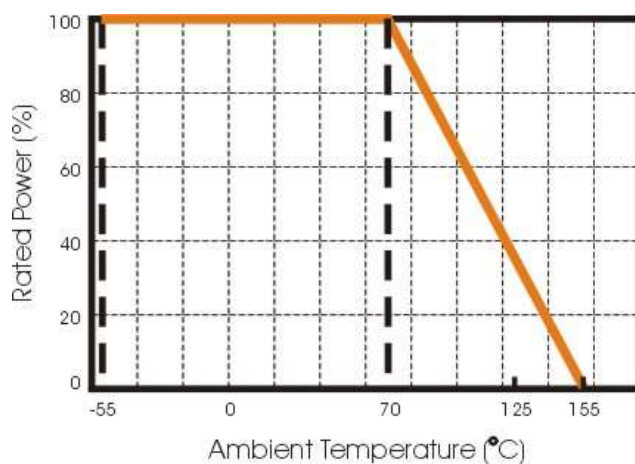


Figure 2 Maximum dissipation in percentage of rated power as a function of the ambient temperature

MOUNTING

Due to their rectangular shapes and small tolerances, Surface Mountable Resistors are suitable for handling by automatic placement systems.

Chip placement can be on ceramic substrates and printed-circuit boards (PCBs).

Electrical connection to the circuit is by individual soldering condition.

STORAGE AND HANDLING CONDITIONS:

1. Products are recommended to be used up within two years since operation date as ensured shelf life. Check solderability in case shelf life extension is needed.
2. To store products with following condition:
 - Temperature :5 to 40°C
 - Humidity :20 to 70% relative humidity
3. Caution:
 - a. Don't store products in a corrosive environment such as sulfide, chloride gas, or acid.
It may cause oxidation of electrode, which easily be resulted in poor soldering.
 - b. To store products on the shelf and avoid exposure to moisture.
 - c. Don't expose products to excessive shock, vibration, direct sunlight and so on

SOLDERING CONDITION follows J-STD-020D

The robust construction of chip resistors allows them to be completely immersed in a solder bath of 260°C for 10 seconds. Therefore, it is possible to mount Surface Mount Resistors on one side of a PCB and other discrete components on the reverse (mixed PCBs).

Surface Mount Resistors are tested for solderability at 235°C during 2 seconds. The test condition for no leaching is 260°C for 30 seconds.

Typical examples of soldering processes that provide reliable joints without any damage are given in Fig 3.

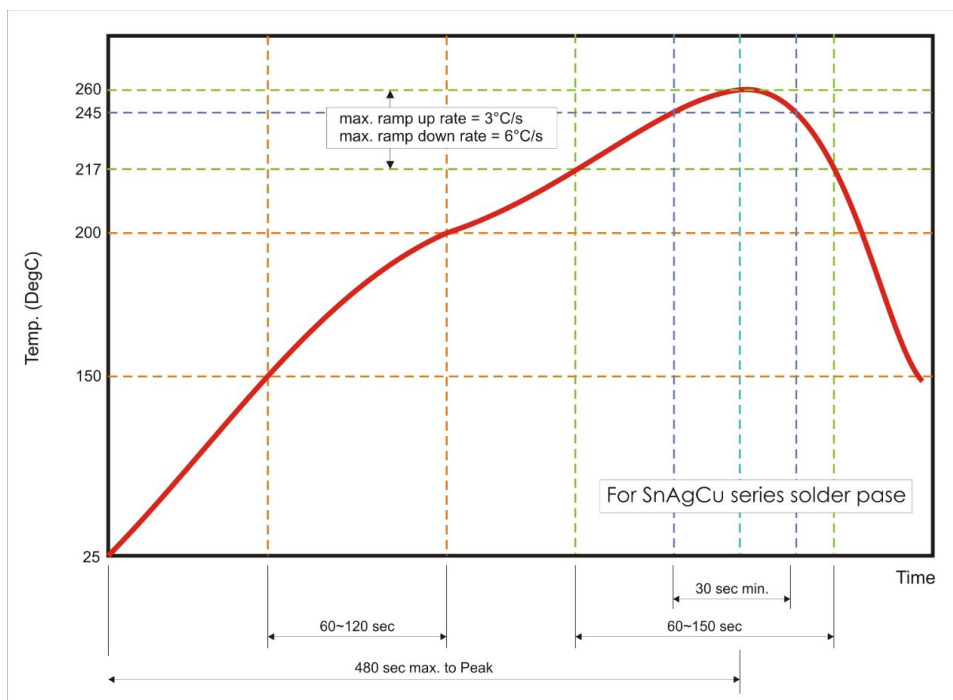
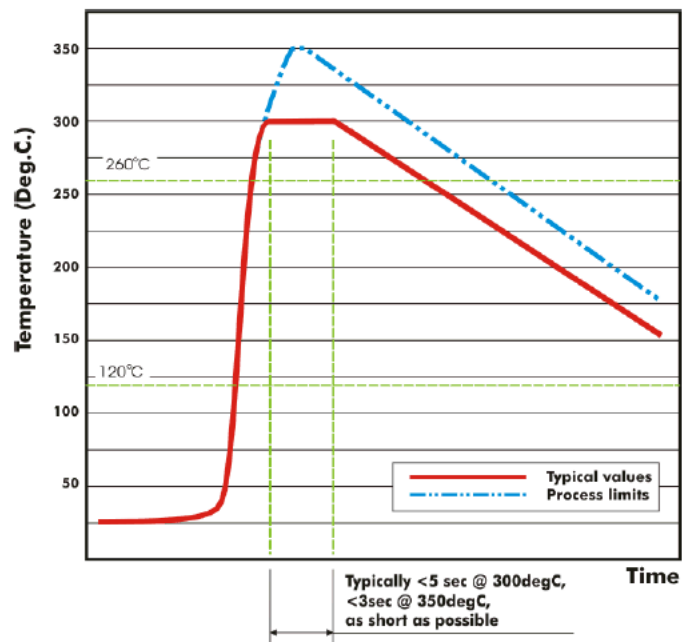
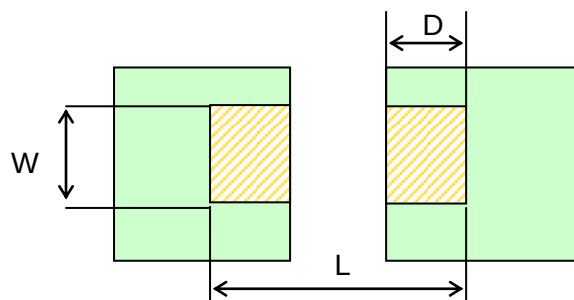


Fig 3. Recommended IR reflow soldering profile for
SMT process with SnAgCu series solder paste

Manual soldering (solder iron)



Recommended Solder Pad Dimensions



Type	W (mm)	L (mm)	D (mm)
01(0201)	0.25~0.3	0.7~0.9	0.3~0.4
02(0402)	0.5~0.6	1.4~1.6	0.4~0.6
03(0603)	0.7~0.9	2.0~2.2	0.8~1.0
05(0805)	1.0~1.4	3.2~3.8	0.9~1.4
06(1206)	2.0~2.4	4.4~5.0	1.2~1.8
10(1210)	2.0~2.4	4.4~5.0	2.3~3.5
0A(2010)	3.3~3.7	5.7~6.5	2.3~3.5
12(2512)	3.6~4.0	7.8~8.6	2.3~3.5

Remark :

Due to their rectangular shapes and small tolerances, Surface Mountable Resistors are suitable for handling by automatic placement systems.

Chip placement can be on ceramic substrates and printed-circuit boards (PCBs).

Electrical connection to the circuit is by individual soldering condition.

The end terminations guarantee a reliable contact.

MARKING

Size \ Nr. Of digit of code\tolerance	±5% & Jumper (0Ω)	±1%
2512, 2010, 1218	4 digits marking	4 digits marking
1210, 1206, 0805	3 digits marking	4 digits marking
0603	3 digits marking	3 digits marking
0402,0201	No marking	

1) No marking for 0402 and 0201 size.

2) Jumper (0 Ω):

2512, 2010, 1218: 0000

1210, 1206, 0805, 0603 : 000

3) 3 digits marking for ±5% 1210, 1206, 0805, 0603:

Each resistor is marked with a three digits code on the protective coating to designate the nominal resistance value.

2 significant digits followed by No. of zeros.

4) 3 digits marking for ±1% 0603 size:

Nominal resistance	Description										
1.E24 series	2 significant digits followed by No. of zeros.										
	Example										
	RESISTANCE	4.7Ω	47Ω	470Ω	4K70	47K0	470K	4M70			
	3 digits marking	4R7	470	471	472	473	474	475			
2.E96 series	The 1st two digit codes are referring to the CODE on the table, the 3rd code is the index of resistance value. Repeat values between E24 and E96 series, whose marking are based on the E96 CODE table.										
	Code Multiplier	Z 10 ⁻³	Y 10 ⁻²	X 10 ⁻¹	A 10 ⁰	B 10 ¹	C 10 ²	D 10 ³	E 10 ⁴	F 10 ⁵	G 10 ⁶
	Example										
	RESISTANCE	1.78Ω	17.8Ω	178Ω	1K78	17K8	178K	1M78			
	3 digits marking	25Y	25X	25A	25B	25C	25D	25E			
3. Remark	There is no marking for the items not under E24 and E96 series.										

E96 CODE table:

CODE	R value	CODE	R-value	CODE	R-Value	CODE	R-value	CODE	R-value	CODE	R-value	CODE	R-value	CODE	R-value
01	100	13	133	25	178	37	237	49	316	61	422	73	562	85	750
02	102	14	137	26	182	38	243	50	324	62	432	74	576	86	768
03	105	15	140	27	187	39	249	51	332	63	442	75	590	87	787
04	107	16	143	28	191	40	255	52	340	64	453	76	604	88	806
05	110	17	147	29	196	41	261	53	348	65	464	77	619	89	825
06	113	18	150	30	200	42	267	54	357	66	475	78	634	90	845
07	115	19	154	31	205	43	274	55	365	67	487	79	649	91	866
08	118	20	158	32	210	44	280	56	374	68	499	80	665	92	887
09	121	21	162	33	215	45	287	57	383	69	511	81	681	93	909
10	124	22	165	34	221	46	294	58	392	70	523	82	698	94	931
11	127	23	169	35	226	47	301	59	402	71	536	83	715	95	953
12	130	24	174	36	232	48	309	60	412	72	549	84	732	96	976

5) 4 digits marking for ±5% & ±1% 2512, 2010, 1218 size, for ±1% 1210, 1206, 0805 size:

For E24/E96 series, each resistor is marked with a four digits code on the protective coating to designate the nominal resistance value. For values below 97Ω the R is used as a digit. For values of 100Ω or greater, the first 3 digits are significant, the fourth digit indicates the number of multiple to follow.

Example

RESISTANCE	Jumper (0Ω)	1Ω	10Ω	33Ω	470Ω	6800Ω	47000Ω	680000Ω	1000000Ω
3 digits marking	000	1R0	100	330	471	682	473	684	105
4 digits marking		1R00	10R0	33R0	4700	6801	4702	6803	1004

Special customer (foreign customers)

No Marking

The Rated resistance of 0402 should not be marked.

0805 1206 1210 2010 2512

The nominal resistance shall be marked in 3 digits or 4 digits and marked on over coat side.

- E24 series: 3 digits, E96 series: 4 digits

In case of the resistance value that E96 overlaps with E24, It is marked by either.

Marking example	Contents	Application
123	$12 \times 10^{-3} [\Omega] \rightarrow 12 [\text{k}\Omega]$	0805 1206 1210 2010 2512
2R2	2.2 $[\Omega]$	Less than 10W of 1206 1210 2010 2512
2.2	2.2 $[\Omega]$	Less than 10 Ω of 0805
5623	$562 \times 10^{-3} [\Omega] \rightarrow 562 [\text{k}\Omega]$	0805 1206 1210 2010 2512
12R7	12.7 $[\Omega]$	0805 1206 1210 2010 2512

0603

The nominal resistance shall be marked in 3 digits (E24) and marked on over coat side.

No marking in the E96 series

In case of the resistance value that E96 overlaps with E24, there is a case to mark in E96.

Marking example		Contents	Application
Malaysia	China		
123	123	$12 \times 10^{-3} [\Omega] \rightarrow 12 [\text{k}\Omega]$	E24
2R2	2R2	2.2 $[\Omega]$	E24
No marking	02C	$102 \times 10^{-2} [\Omega] \rightarrow 10.2 [\text{k}\Omega]$	E96
No marking	51X	$332 \times 10^{-1} [\Omega] \rightarrow 33.2 [\Omega]$	E96

Symbol for E96 series of resistance value

E96	Symbol	E96	Symbol	E96	Symbol	E96	Symbol	E96	Symbol
100	01	162	21	261	41	422	61	681	81
102	02	165	22	267	42	432	62	698	82
105	03	169	23	274	43	442	63	715	83
107	04	174	24	280	44	453	64	732	84
110	05	178	25	287	45	464	65	750	85
113	06	182	26	294	46	475	66	768	86
115	07	187	27	301	47	487	67	787	87
118	08	191	28	309	48	499	68	806	88
121	09	196	29	316	49	511	69	825	89
124	10	200	30	324	50	523	70	845	90
127	11	205	31	332	51	536	71	866	91
130	12	210	32	340	52	549	72	887	92
133	13	215	33	348	53	562	73	909	93
137	14	221	34	357	54	576	74	931	94
140	15	226	35	365	55	590	75	953	95
143	16	232	36	374	56	604	76	976	96
147	17	237	37	388	57	619	77		
150	18	243	38	392	58	634	78		
154	19	249	39	402	59	649	79		
158	20	255	40	412	60	665	80		

Symbol of multipliers

Symbol	Y	X	A	B	C	D	E	F
Multipliers	10^{-2}	10^{-1}	10^0	10^1	10^2	10^3	10^4	10^5

Marking example of Jumper Chip

Marking example	Contents	Application
0 or 000	Jumper	0603
0 or 000		0805 1206
0 or 000		1210 2010 2512

TESTS AND REQUIREMENTS

Essentially all tests are carried out according to the schedule of IEC publication 115-8, category **LCT/UCT/56**(rated temperature range : Lower Category Temperature, Upper Category Temperature; damp heat, long term, 56 days). The testing also meets the requirements specified by EIA, EIAJ and JIS.

The tests are carried out in accordance with IEC publication 68, "Recommended basic climatic and mechanical robustness testing procedure for electronic components" and under standard atmospheric conditions according to IEC 60068-1, subclause 5.3. Unless otherwise specified, the following value supplied :

Temperature: 15°C to 35°C.

Relative humidity: 45% to 75%.

Air pressure: 86kPa to 106 kPa (860 mbar to 1060 mbar).

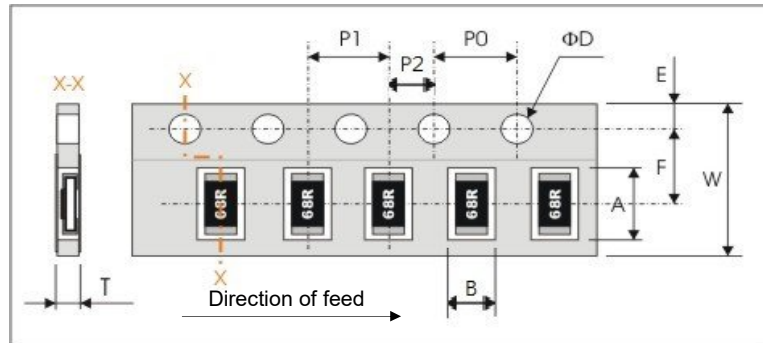
All soldering tests are performed with mildly activated flux.

TEST	PROCEDURE / TEST METHOD	REQUIREMENT	
		Resistance	Jumper
Electrical Characteristics JISC5201-1: 1998 Clause 4.8	- DC resistance values measurement - Temperature Coefficient of Resistance (T.C.R) Natural resistance change per change in degree centigrade. $\frac{R_2 - R_1}{R_1(t_2 - t_1)} \times 10^6 \text{ (ppm/°C)}$ $t_1 : 20^\circ\text{C} \pm 5^\circ\text{C} - 1^\circ\text{C};$ $t_2 : -55^\circ\text{C} \text{ or } +155^\circ\text{C}$ $R_1 : \text{Resistance at reference temperature (20}^\circ\text{C} \pm 5^\circ\text{C} / -1^\circ\text{C)}$ $R_2 : \text{Resistance at test temperature (-55}^\circ\text{C} \text{ or } +155^\circ\text{C)}$	Within the specified tolerance Refer to "QUICK REFERENCE DATA"	
Resistance to soldering heat(R.S.H) JISC5201-1:1998 Clause 4.18	Un-mounted chips completely immersed for 10±1second in a SAC solder bath at 260°C ±5°C	Others: ±5%:ΔR/Rmax.±(1%+0.05Ω) ±1%:ΔR/Rmax.±(0.5%+0.05Ω) 2512,2010,1218: Δ R/R max. ±(1%+0.05Ω) 0201: ΔR/R max. ±(1%+0.05Ω) No visible damage	<50mΩ
Solderability JISC5201-1:1998 Clause 4.17	Un-mounted chips completely immersed for 2±0.5 second in a SAC solder bath at 235°C±5°C	95% coverage min., good tinning and no visible damage	
Temperature cycling JISC5201-1:1998 Clause 4.19	30 minutes at -55°C±3°C, 2~3 minutes at 20°C+5°C-1°C, 30 minutes at +155°C±3°C, 2~3 minutes at 20°C+5°C-1°C, total 5 continuous cycles	±5%: ΔR/R max. ±(1%+0.05Ω) ±1%:ΔR/Rmax.±(0.5%+0.05Ω) 2512,2010,1218: ΔR/R max. ±(1%+0.05Ω) 0201: ΔR/R max. ±(0.5%+0.05Ω) No visible damage	<50mΩ
High Temperature Exposure MIL-STD-202 method 108	1000+48/-0 hours; without load in a temperature chamber controlled 155±3°C	±5%:ΔR/Rmax.±(2%+0.1Ω) ±1%:ΔR/Rmax.±(1%+0.1Ω) 0201: ΔR/R max. ±(2%+0.1Ω) No visible damage	<50mΩ

TEST	PROCEDURE / TEST METHOD	REQUIREMENT	
		Resistance	Jumper
Bending strength JISC5201-1:1998 Clause 4.33	Resistors mounted on a 90mm glass epoxy resin PCB(FR4), bending once for 10sec, 2mm for 2512,2010,1218 3mm for 1210,1206,0805,0603 5mm for 0402,0201	$\pm 5\%: \Delta R/R_{\max.} \pm (1\% + 0.05\Omega)$ $\pm 1\%: \Delta R/R_{\max.} \pm (1\% + 0.05\Omega)$ No visual damaged	<50m Ω
Adhesion JISC5201-1:1998 Clause 4.32	Pressurizing force: 3N for 0201, 5N for others Test time: 10 $\pm$ 1sec.	No remarkable damage or removal of the terminations	
Short Time Overload (STOL) JISC5201-1:1998 Clause 4.13	2.5 times RCWV or max. overload voltage, for 5seconds	Others: $\pm 5\%: \Delta R/R_{\max.} \pm (2\% + 0.05\Omega)$ $\pm 1\%: \Delta R/R_{\max.} \pm (1\% + 0.05\Omega)$ No visible damage 0201: $\Delta R/R_{\max.} \pm (2\% + 0.10\Omega)$ No visible damage	<50m Ω
Load life in Humidity JISC5201-1:1998 Clause 4.24	1000 +48/-0 hours, loaded with RCWV or Vmax in humidity chamber controller at 40°C $\pm$ 2°C and 90~95% relative humidity, 1.5hours on and 0.5 hours off	Others: $\pm 5\%: \Delta R/R_{\max.} \pm (2\% + 0.1\Omega)$ $\pm 1\%: \Delta R/R_{\max.} \pm (1\% + 0.1\Omega)$ 2512,2010,1218: $\Delta R/R_{\max.} \pm (3\% + 0.05\Omega)$ 0201: 10 Ω $\leq$ R < 1M Ω : $\Delta R/R_{\max.} \pm (3\% + 0.10\Omega)$ R < 10 Ω , R $\geq$ 1M Ω : $\Delta R/R_{\max.} \pm (5\% + 0.10\Omega)$	<50m Ω
Load life (endurance) JISC5201-1:1998 Clause 4.25	1000 +48/-0 hours, loaded with RCWV or Vmax in chamber controller 70 $\pm$ 2°C, 1.5 hours on and 0.5 hours off	$\pm 5\%: \Delta R/R_{\max.} \pm (3\% + 0.1\Omega)$ $\pm 1\%: \Delta R/R_{\max.} \pm (1\% + 0.1\Omega)$ 2512,2010,1218: $\Delta R/R_{\max.} \pm (3\% + 0.05\Omega)$ 0201: 10 Ω $\leq$ R < 1M Ω : $\Delta R/R_{\max.} \pm (3\% + 0.10\Omega)$ R < 10 Ω , R $\geq$ 1M Ω : $\Delta R/R_{\max.} \pm (5\% + 0.10\Omega)$	<50m Ω
Insulation Resistance JISC5201-1:1998 Clause 4.6	Apply the maximum overload voltage (DC) for 1minute	R $\geq$ 10G Ω	
Dielectric Withstand Voltage JISC5201-1:1998 Clause 4.7	Apply the maximum overload voltage (AC) for 1 minute	No breakdown or flashover	

PACKAGING

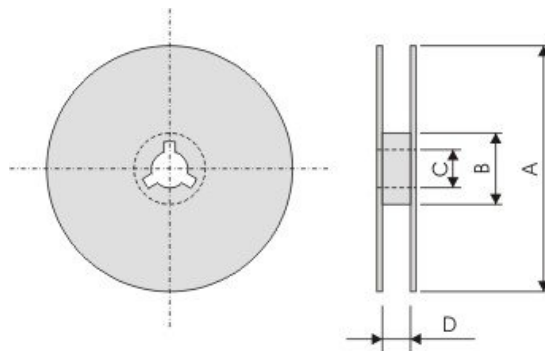
Tape specifications (unit :mm)



Series No.	A	B	W	F	E
CR12	6.90 ±0.20	3.60±0.20	12.00±0.30	5.50±0.10	1.75±0.10
CR0A	5.50 ±0.20	2.80±0.20			
CRA8	4.90 ±0.20	3.55±0.30			
CR10	3.60±0.20	3.00±0.20	8.00±0.30	3.50±0.20	1.75±0.10
CR06	3.60±0.20	2.00±0.20			
CR05	2.40±0.20	1.65±0.20			
CR03	1.90±0.20	1.10±0.20			
CR02	1.90±0.10	0.70±0.10			
CR01	0.67±0.05	0.37±0.05			

Series No.	P1	P0	P2	ΦD	T
CR12	4.00±0.10	4.00±0.10	2.00±0.10	Φ1.50 ^{+0.1} _{-0.0}	Max.1.2
CR0A					Max.1.2
CRA8	8.00 ±0.10	4.00±0.10	2.00±0.10	Φ1.50 ^{+0.1} _{-0.0}	1.30±0.20
CR10/CR06/CR05	4.00±0.10	4.00±0.10	2.00±0.10	Φ1.50 ^{+0.1} _{-0.0}	0.80±0.10
CR03					0.70±0.05
CR02	2.00±0.05	4.00±0.10	2.00±0.10	Φ1.50 ^{+0.1} _{-0.0}	0.50±0.05
CR01					0.45±0.05

Reel dimensions



Reel	A	B	C	D
7" reel	Φ178.0±2.0	Φ60.0±1.0	13.0±0.2	14.0±0.20 (12mm tape) 9.0±0.5 (8mm tape)
10" reel	Φ254.0±2.0	Φ100.0±1.0	13.0±0.2	
13" reel	Φ330.0±2.0	Φ100.0±1.0	13.0±0.2	

Tape packaging :

Size	Packaging tape	Packaging code						
		7"reel	10"reel	13"reel				B: poly-bag
2512,2010	12mm width plastic tape	4,000pcs	8,000pcs	16,000pcs	-	-	-	5000pcs
1210,1206,0805,0603	8mm width paper tape	5,000pcs	10,000pcs	20,000pcs	-	-	-	5000pcs
0402		10,000pcs	-	70,000pcs	-	-	-	5000pcs
0201		15,000pcs	-	70,000pcs	-	-	-	5000pcs
1218	12mm width plastic tape	-	3,000pcs	-	-	-	-	5000pcs

Performance of Taping :

Strength of Carrier Tape and Top Cover Tape

-Carrier Tape

When a tensile force 1.02kgf is applied in the direction of unreeling the tape, the tape shall withstand this force.

-Top cover Tape

When a tensile force 1.02kgf is applied to the tape, the tape shall withstand this force.

Peel Force of Top Cover Tape

Unless otherwise specified, the peel force of top cover tape shall be 10.2 to 71.4 g f when the top cover tape is pulled at a speed of 300mm/min with the angle between the taped during peel and the direction of unreeling maintained at 165 to 180° as illustrated in Fig.

