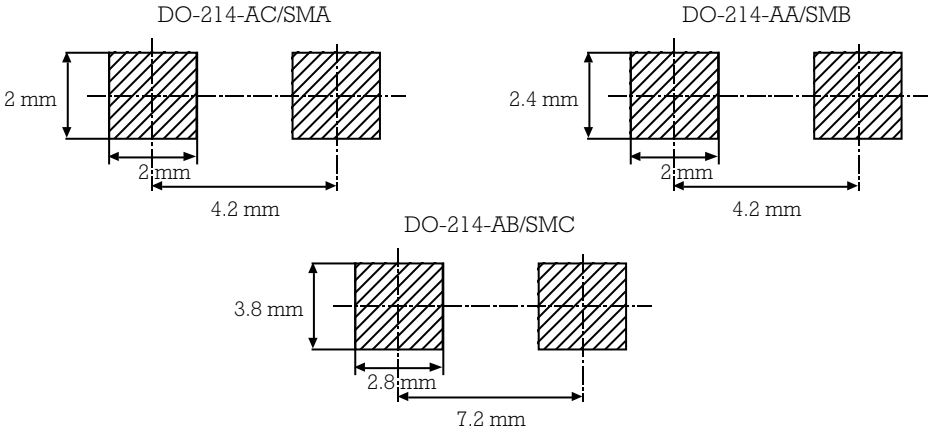


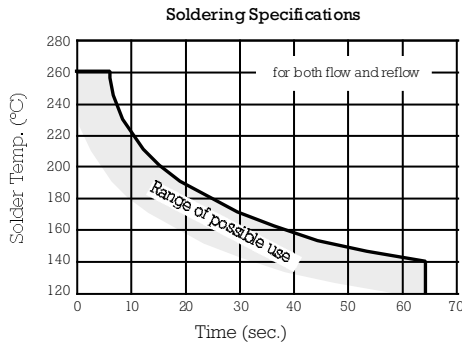
# Rules for Soldering of SMD Devices

## RECOMMENDED SOLDERING PAD.



## SOLDERING INSTRUCTIONS

1. Use rosin flux. Avoid using strong acid flux.
2. In order to avoid major heat stress, preheating cycle is required before soldering. It is recommended that the parts be preheated for one to two minutes at 150 °C and soldered within the temperature range shown in the following chart.



3. When using the soldering iron, be sure to use it within the following ranges.
  - iron tip temperature : 300 °C or lower  
(standard for soldering iron is 30W)
  - diameter of iron tip : 1 mm or less
  - diameter of solder : 1 mm or less
  - soldering time : 10 second or less