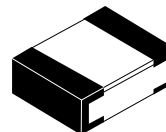
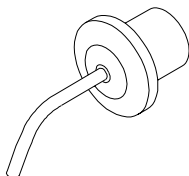


Chip Installation

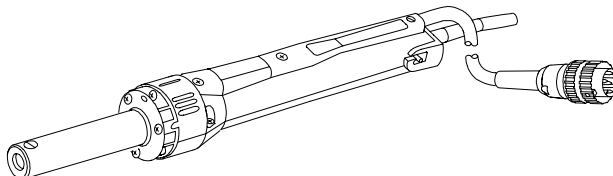
Solder Paste



**Mini
ThermoJet
Tip**



**Mini ThermoJet
Handpiece**



EQUIPMENT REQUIRED

PACE SensaTemp[®] Power Supply With Pressure Capability - - - - -

TJ-70 Mini ThermoJet[®]

TJ-70 Tip & Tool Stand

Mini Thermojet Tip

Pik & Paste Liquid Dispensing System

Tip Tool

Tweezers

PACE PART NUMBER

7023-0002-P1

6019-0044

See chart on back

8007-0157

1100-0296

Locally obtained

OPTIONAL EQUIPMENT

Manual Solder Paste Dispenser

Locally obtained

MATERIALS (approved by your organization)

Solder Paste

Cleaner

Solder Paste Dispense Needles

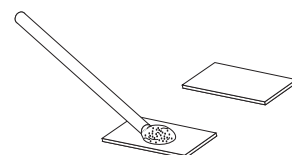
Tissue/wipe

Locally obtained

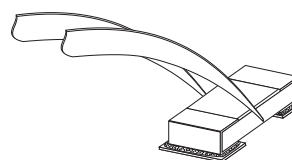
Locally obtained

Locally obtained

Locally obtained



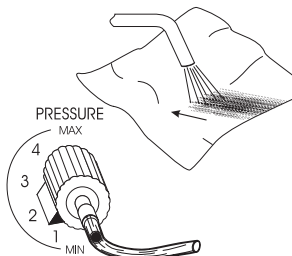
① **Apply Solder**



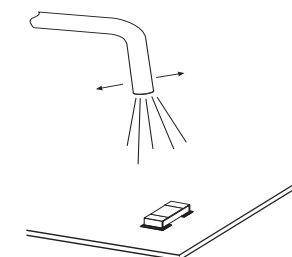
② **Position Component**

PROCEDURE

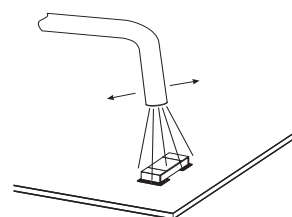
1. Start with a heater temperature of 427°C (800°F) and adjust as necessary.
2. Install Mini Thermojet Tip into ThermoJet Handpiece using Tip Tool.
3. Apply a small bead of solder paste to each land using a dispenser. ①
4. Position component onto lands using tweezers. ②
5. Starting at MINIMUM, adjust pressure output (on power supply) so hot air scorches a tissue from approximately 0.5cm (0.2") away. ③
6. Direct hot air over component with tip at a distance of 2.5cm (1.0") to pre-dry solder paste. ④
7. When pre-drying is observed (paste has dull, flat appearance), move tip closer (0.5cm [0.2"]) and heat until complete solder melt is observed. ⑤
8. Return ThermoJet to its Tip & Tool Stand.
9. Clean, if required, and inspect.



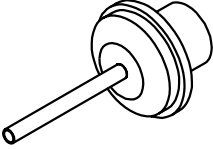
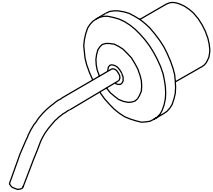
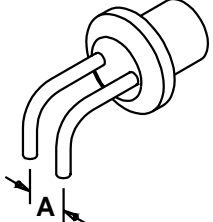
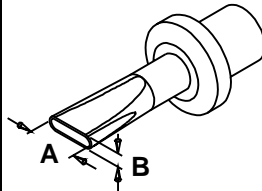
③ **Adjust Pressure**



④ **Pre-dry Paste**



⑤ **Melt Joints**

TIP	DESCRIPTION	TIP SIZE	PART NUMBER
	Small, Straight, Single Jet Tip	-----	1121-0366
	Small, Curved Single Jet Tip	-----	1121-0338
	SOT/Chip Component Tip (dual-jet)	A = 0.14" (3.56mm)	1121-0329
	SOIC Tip (dual-jet)	A = 0.17" (4.32mm)	1121-0330
	SOICL Tip (dual-jet)	A = 0.37" (9.40mm)	1121-0331
	Flat End Tip	A = 0.28" (7.11mm) B = 0.074" (1.88mm)	1121-0365
		A = 0.24" (6.10mm) B = 0.074" (1.88mm)	1121-0371