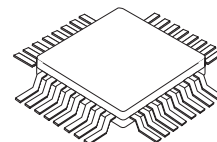
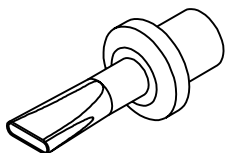


QFP Installation

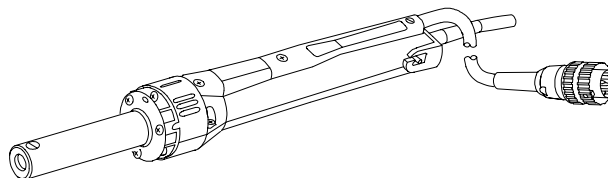
Solder Paste



Flat End Tip



Mini Thermojet Handpiece



EQUIPMENT REQUIRED

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

TJ-70 Mini ThermoJet[®] 7023-0002-P1

TJ-70 Tip & Tool Stand 6019-0044

Flat End Tip See chart on back

Pik & Paste Liquid Dispensing System 8007-0157

Tip Tool 1100-0296

OPTIONAL EQUIPMENT

Tweezers Locally obtained

Manual Solder Paste Dispenser Locally obtained

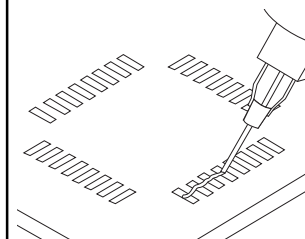
MATERIALS (approved by your organization)

Solder Paste Locally obtained

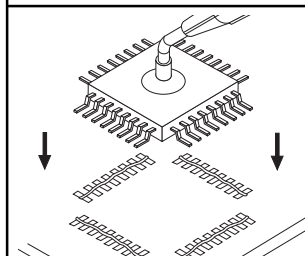
Cleaner Locally obtained

Solder Paste Dispense Needles Locally obtained

Tissue/wipe Locally obtained



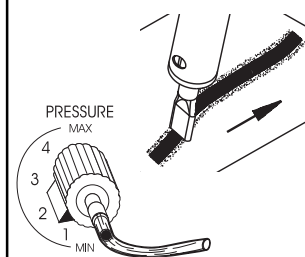
① **Apply Solder**



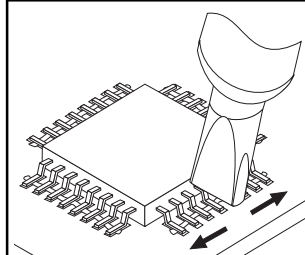
② **Position Component**

PROCEDURE

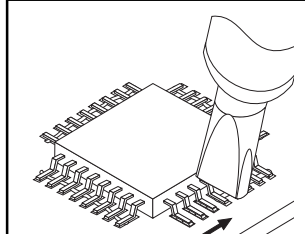
1. Start with a heater temperature of 427°C (800°F) and adjust as necessary.
2. Install tip into ThermoJet Handpiece using Tip Tool.
3. Apply a small bead of solder paste along the land pattern using a dispenser. ①
4. Position component onto lands using a Pik-Vac or tweezers. ②
5. Starting at MINIMUM, 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), bring tip closer (0.5cm [0.2"]) and slowly move tip along each row of leads to form proper solder fillets. ⑤
8. Return ThermoJet to its Tip & Tool Stand.
9. Clean, if required, and inspect.



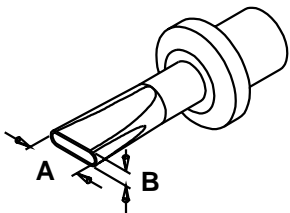
③ **Adjust Pressure**



④ **Pre-dry Paste**



⑤ **Melt Joints**

Flat End Tips	Tip Size	Part Number
	A = 7.11mm (0.28") B = 1.88mm (0.074")	1121-0365
	A = 6.10mm (0.24") B = 1.88mm (0.074")	1121-0371