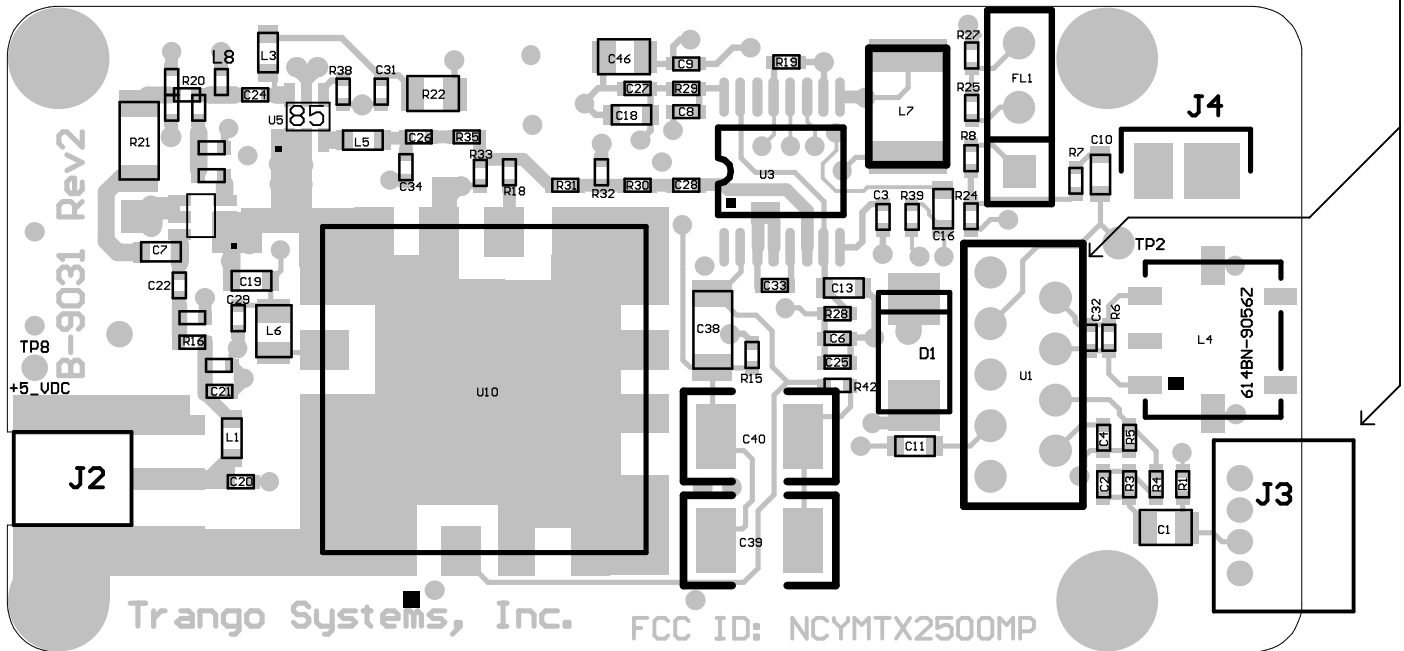


Use SN63 wire solder to attach these parts.
after all SMT has been placed.



ASSEMBLY INSTRUCTIONS:

- 1) Use SN62/Pb36/AG02 Microbond Solder Paste.
- 2) Use Stencil ST-9031r2-2 for solder printing.
- 3) Use TCM Program # 310-9069-2.
- 4) Visual inspect before oven reflow.
- 5) Use Trango2 oven reflow profile for reflow process.
- 6) For SMT rework (if needed) use Hakko 851 hot air system or soldering iron with solder tip #8.
- 7) Fiducials are on the array frame.

Engineering:	TRANGO SYSTEMS, INC.		
Manufacturing:	SUB ASSEMBLY 320-9069, SIDE #2		
	420-9043		1
ECO #: 01-9027	Scale: NTS	DATE: 4-18-01	Sheet 2 of 2