Contact No.1

A ± 0.15
B ± 0.08
0.5 ± 0.08
(0.12)
(5)

③
①
HRS
②
HRS MARK
POLARIZATION MARK
A **
NUMBER OF CONTACTS
CAVITY No.

④

(C)
D ± 0.1
E ± 0.2

7 C

a

b

c

a(15:1)

(90°)
(110°)
(3.9)
(3.95)
2 ± 0.2
(0.43)
FPC : t 0.3
1.75 ± 0.2
1.2 ± 0.2
1.55 ± 0.2
(1.3)
(4.3)
0.45 ± 0.1
0.7 ± 0.2
5.7 ± 0.2
0
0
1 2 0.15MAX
0.15MAX 1 2

RECOMMENDED PCB MOUNTING PATTERN

Contact No.1
B
0.5
X
0.3 ± 0.03
nX
0.05 X
0.85 ± 0.05
5.85 ± 0.05
(0.2)
(Connector image)
1.8 ± 0.05
F ± 0.05
2 ± 0.03

RECOMMENDED STENCIL PATTERN
(RECOMMENDED STENCIL THICKNESS : t=0.12)

B
0.5
Y
0.25 ± 0.03
nX
0.05 Y
0.85 ± 0.05
5.85 ± 0.05
(PCB mounting pattern image)
1.8 ± 0.05
F ± 0.05
2 ± 0.03

NOTES

1 Lead CO-PLANARITY including reinforced metal fittings shall be 0.1 MAX.
2 Dimension : from reference b.
3. To be delivered with tape and reel packages.
4. Note that preventive hole for sink mark could be added for improvement.
5. The quality remains good. Even with the dark spots, which could occasionally occur molded plastics.
6. This product satisfies halogen free requirements defined as 900ppm maximum chlorine, 900ppm maximum bromine, and 1500ppm maximum total of chlorine and bromine.
7 Shows actuator configuration of 60 pos.
8. 'n' represents the number of contacts.
9. The dimension in parentheses are for reference.

NO.	MATERIAL	FINISH . REMARKS	NO.	MATERIAL	FINISH . REMARKS
4	BRASS	TIN PLATING 3μm MIN OVER NICKEL 1μm MIN	8	(CONNECTOR)	
3	COPPER ALLOY	(CONTACT AREA, LEAD) GOLD 0.03μmMIN OVER NICKEL 1μmMIN (OTHER) NICKEL PLATING 1μmMIN	7	POLYSTYRENE	
2	LCP	BLACK UL94V-0	6	POLYESTER	
1	LCP	GRAY UL94V-0	5	POLYSTYRENE	

UNITS mm	⊕ ◁	SCALE 5 : 1	COUNT 12	DESCRIPTION OF REVISIONS DIS-F-00011082	DESIGNED TA.SUZUKI	CHECKED HS.HIRAHARA	DATE 20211104

HRS
HIROSE ELECTRIC CO.,LTD.

APPROVED :HS.SAKAMOTO	20191205	DRAWING NO.	EDC-365730-99-00
CHECKED :HS.SAKAMOTO	20191205	PART NO.	FH52K-**S-0.5SH(99)
DESIGNED :NM.YONEYAMA	20191205		
DRAWN :DS.HIROWATARI	20191205	CODE NO.	CL580

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FORM HC0011-5-7

HRS DRAWING FOR REFERENCE

RECOMMENDED FPC/FFC (15:1)

10 > G ± 0.1

H ± 0.05

B

0.5 ± 0.07

0.5

0.3 ± 0.05

Contact No.1

Z

0.5 ± 0.07

n X

$\oplus$ 0.05 Z

0.35 ± 0.03 (FPC)
0.3 ± 0.03 (FFC)

2-R 0.2 ± 0.1

2-R 0.2 ± 0.1 < 10

2-R 0.2 ± 0.1 < 10

2-R 0.2 ± 0.1 < 10

2-R 0.2 ± 0.05 < 10

3.5 MIN

10 > 3.1 ± 0.1

10 > 1.35 ± 0.1

(1 MIN)
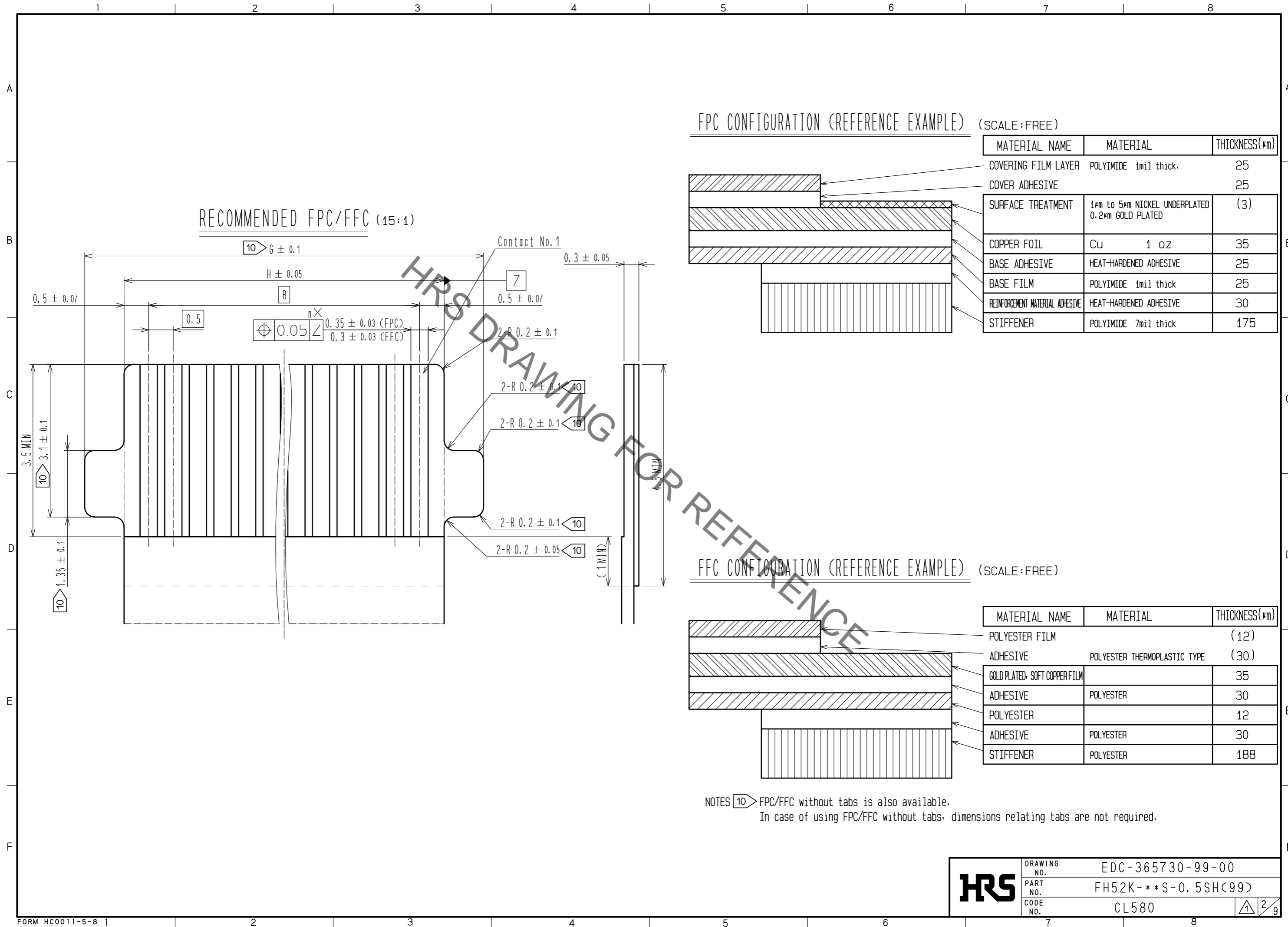
FPC CONFIGURATION (REFERENCE EXAMPLE) (SCALE:FREE)

MATERIAL NAME	MATERIAL	THICKNESS(μm)
COVERING FILM LAYER	POLYIMIDE 1mil thick.	25
COVER ADHESIVE		25
SURFACE TREATMENT	1μm to 5μm NICKEL UNDERPLATED 0.2μm GOLD PLATED	(3)
COPPER FOIL	Cu 1 oz	35
BASE ADHESIVE	HEAT-HARDENED ADHESIVE	25
BASE FILM	POLYIMIDE 1mil thick	25
REINFORCEMENT MATERIAL ADHESIVE	HEAT-HARDENED ADHESIVE	30
STIFFENER	POLYIMIDE 7mil thick	175

FFC CONFIGURATION (REFERENCE EXAMPLE) (SCALE:FREE)

MATERIAL NAME	MATERIAL	THICKNESS(μm)
POLYESTER FILM		(12)
ADHESIVE	POLYESTER THERMOPLASTIC TYPE	(30)
GOLD PLATED, SOFT COPPER FILM		35
ADHESIVE	POLYESTER	30
POLYESTER		12
ADHESIVE	POLYESTER	30
STIFFENER	POLYESTER	188

NOTES 10 > FPC/FFC without tabs is also available.
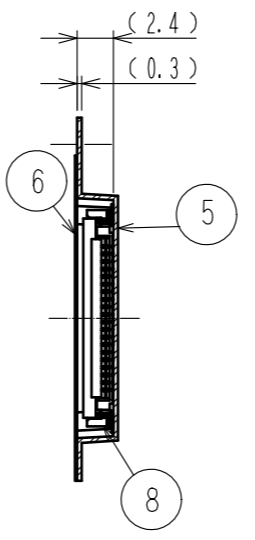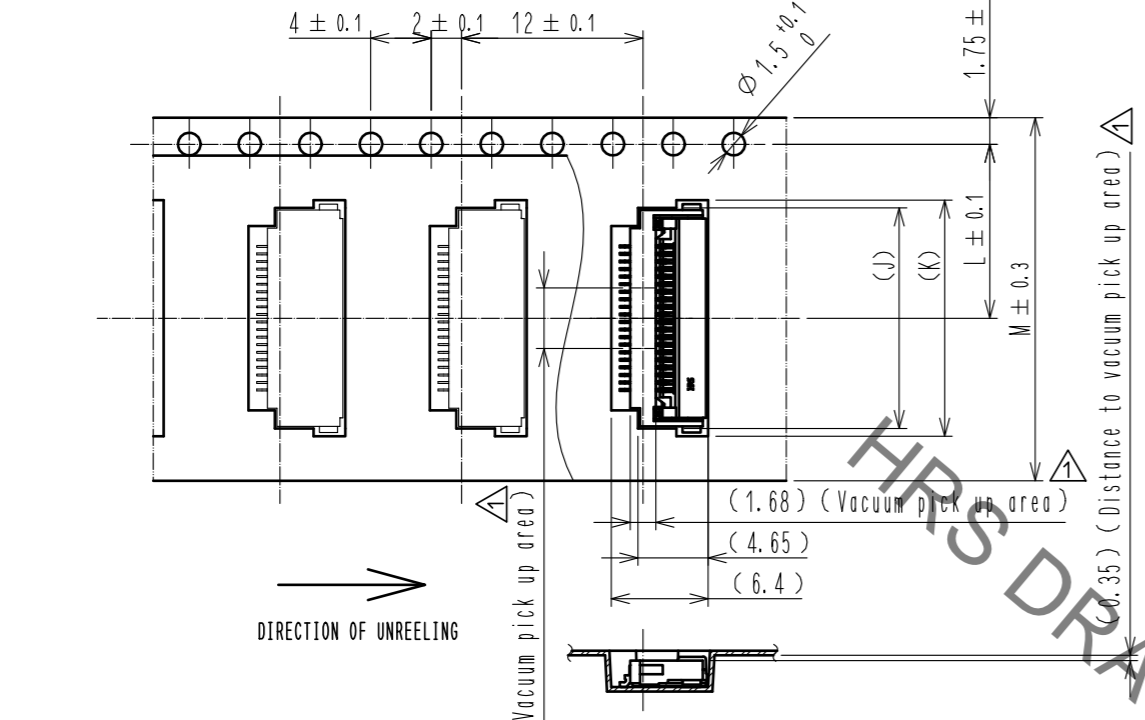In case of using FPC/FFC without tabs, dimensions relating tabs are not required.

HRS	DRAWING NO.	EDC-365730-99-00	
	PART NO.	FH52K-**S-0.5SH(99)	
	CODE NO.	CL580	2/9

FORM HC0011-5-8

EMBOSSED CARRIER TAPE DIMENSION (2:1)

TAPE WIDTH : 24mm MAX

4 ± 0.1 2 ± 0.1 12 ± 0.1

$\varnothing 1.5 ^{+0.1}_{0}$

1.75 ± 0.1

$L \pm 0.1$

(J) (K)

$M \pm 0.3$

(1.68) (Vacuum pick up area)
(4.65)
(6.4)

(2.4)
(0.3)

(6)
(5)
(8)

DIRECTION OF UNREELING

(4) (Vacuum pick up area)
(0.35) (Distance to vacuum pick up area)

TAPE WIDTH : 32mm MIN

4 ± 0.1 2 ± 0.1 12 ± 0.1

$\varnothing 1.5 ^{+0.1}_{0}$

1.75 ± 0.1

$L \pm 0.1$

(J) (K)

$N \pm 0.1$

$M \pm 0.3$

$1.5 ^{+0.1}_{0}$
$1.7 ^{+0.15}_{0}$

(1.68) (Vacuum pick up area)
(4.65)
(6.4)

(2.4)
(0.3)

(6)
(5)
(8)

DIRECTION OF UNREELING

(4) (Vacuum pick up area)
(0.35) (Distance to vacuum pick up area)

REEL DIMENSIONS(No Scale)

(7)

$\varnothing 180 \pm 2$
$\varnothing 80 \pm 1$

$P \pm 1$: OUTSIDE
$Q \pm 1$: INSIDE

d

$d(1:1)$

2 ± 0.5
$\varnothing 21 \pm 0.8$
$\varnothing 13 \pm 0.2$
$R1$

TRAILER   PORTION EQUIPPED WITH CONNECTORS   LEADER (400mm MIN)

EMBOSSED CARRIER TAPE

TOP COVER TAPE
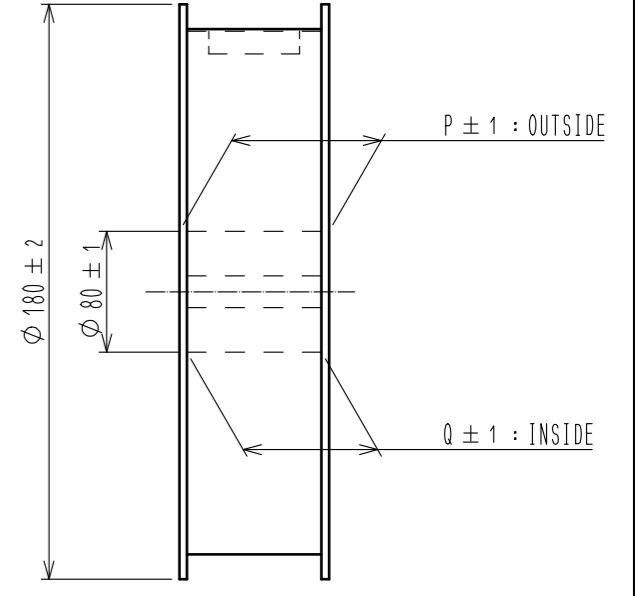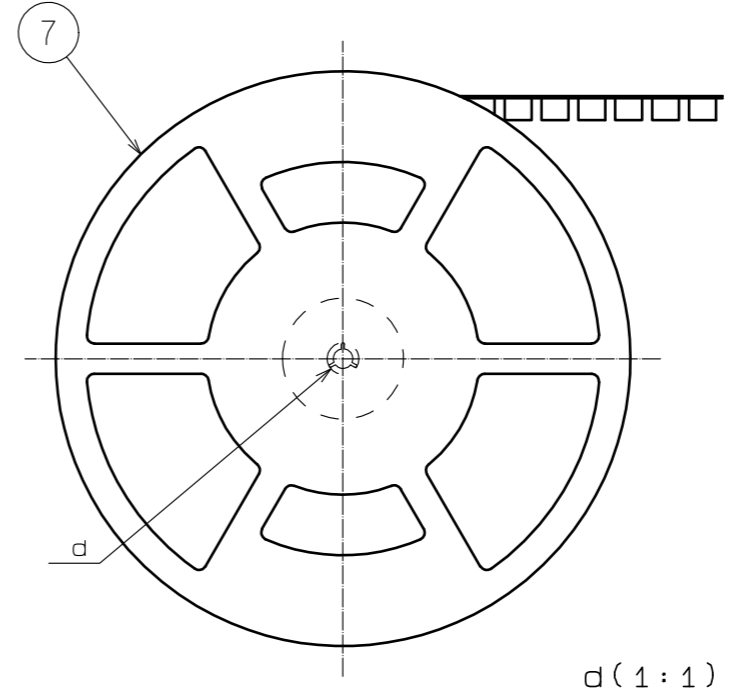
15 EMPTY COMPONENT COMPARTMENTS MIN   10 EMPTY COMPONENT COMPARTMENTS MIN
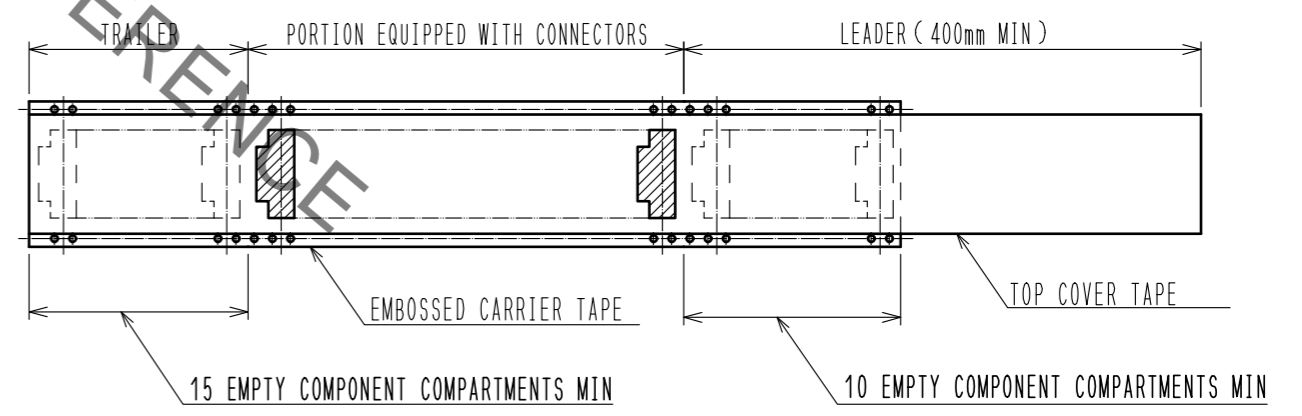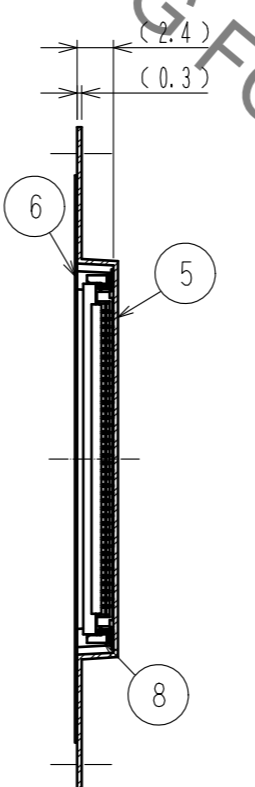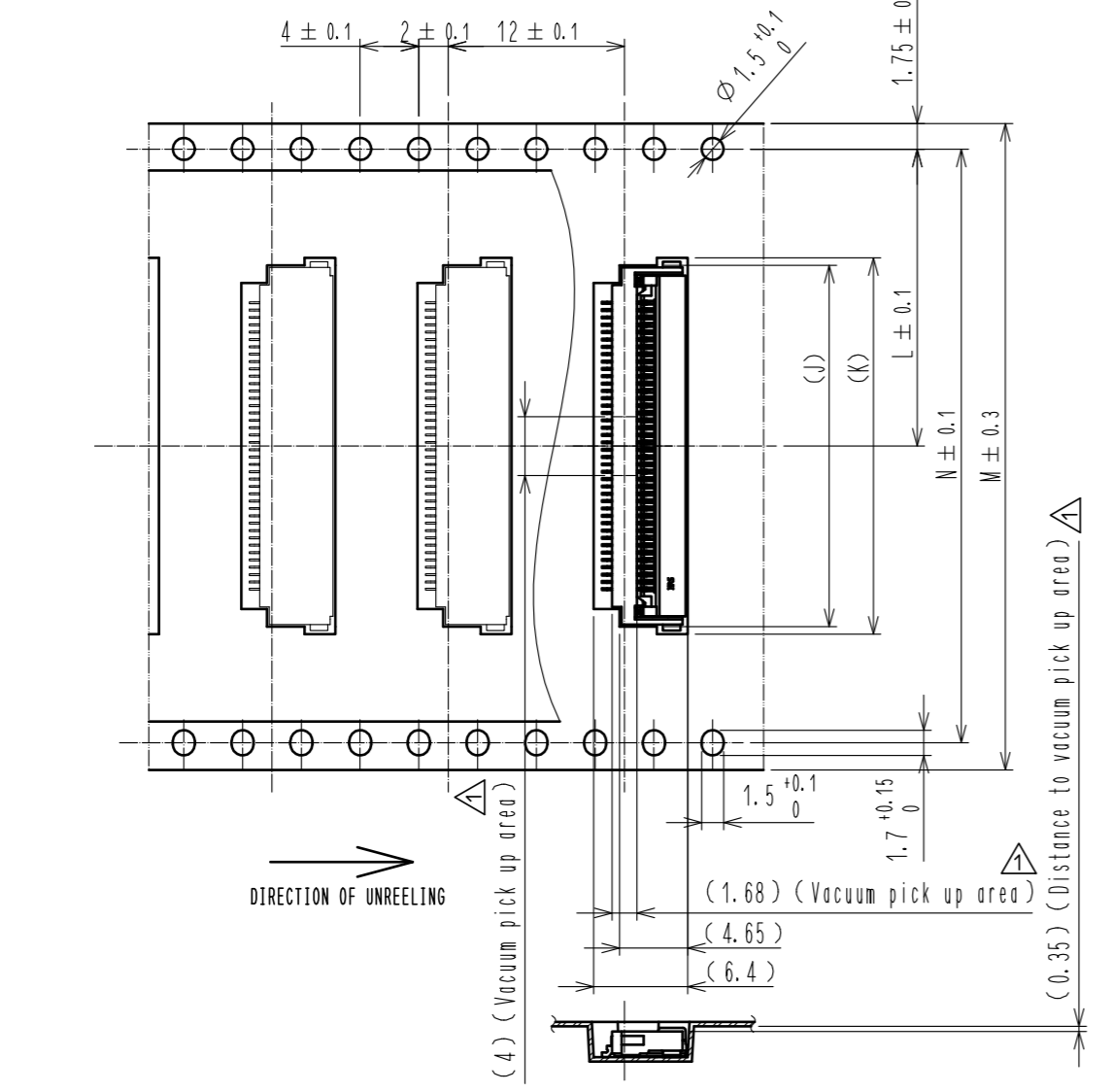
NOTES 11.   1 reel : 500 connectors.
       12.   Refer to JIS C 0806 and IEC 60286-3 (Packaging of components for automatic handling.)

HRS	DRAWING NO.	EDC-365730-99-00
	PART NO.	FH52K-**S-0.5SH(99)
	CODE NO.	CL580

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HRS DRAWING FOR REFERENCE

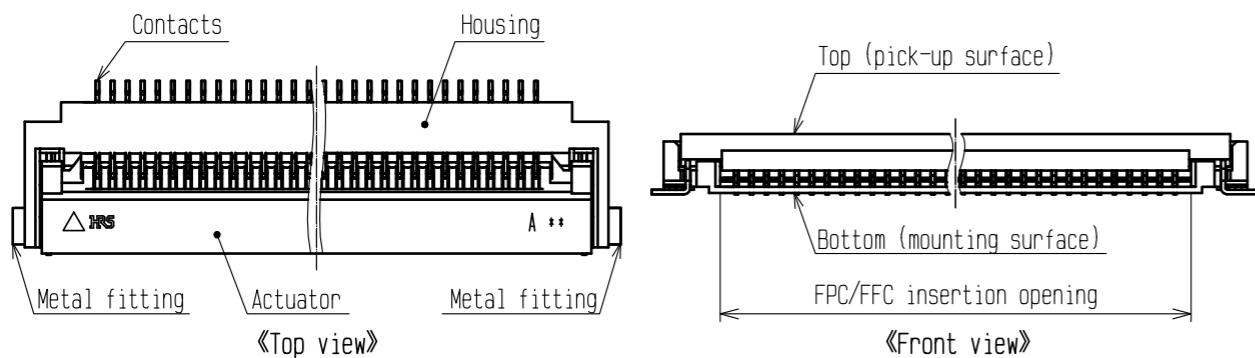| PART NO.	CODE NO.	NUMBER OF CONTACT	DIMENSION OF CONNECTOR, PCB MOUNTING PATTERN, STENCIL PATTERN AND FFC/FPC								DIMENSION OF DRAWING FOR PACKING						
			A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q
FH52K-6S-0.5SH(99)	CL580-4613-0-99	6	7.3	2.5	3.57	5.55	8.1	5.1	5.1	3.5	7.6	8.6	11.5	24.0	—	29.4	25.4
FH52K-8S-0.5SH(99)	CL580-4611-0-99	8	8.3	3.5	4.57	6.55	9.1	6.1	6.1	4.5	8.6	9.6	11.5	24.0	—	29.4	25.4
FH52K-10S-0.5SH(99)	CL580-4606-0-99	10	9.3	4.5	5.57	7.55	10.1	7.1	7.1	5.5	9.6	10.6	11.5	24.0	—	29.4	25.4
FH52K-12S-0.5SH(99)	CL580-4629-0-99	12	10.3	5.5	6.57	8.55	11.1	8.1	8.1	6.5	10.6	11.6	11.5	24.0	—	29.4	25.4
FH52K-15S-0.5SH(99)	CL580-4617-0-99	15	11.8	7.0	8.07	10.05	12.6	9.6	9.6	8.0	12.1	13.1	11.5	24.0	—	29.4	25.4
FH52K-18S-0.5SH(99)	CL580-4636-0-99	18	13.3	8.5	9.57	11.55	14.1	11.1	11.1	9.5	13.6	14.6	11.5	24.0	—	29.4	25.4
FH52K-20S-0.5SH(99)	CL580-4604-0-99	20	14.3	9.5	10.57	12.55	15.1	12.1	12.1	10.5	14.6	15.6	11.5	24.0	—	29.4	25.4
FH52K-22S-0.5SH(99)	CL580-4632-0-99	22	15.3	10.5	11.57	13.55	16.1	13.1	13.1	11.5	15.6	16.6	14.2	32.0	28.4	37.4	33.4
FH52K-24S-0.5SH(99)	CL580-4633-0-99	24	16.3	11.5	12.57	14.55	17.1	14.1	14.1	12.5	16.6	17.6	14.2	32.0	28.4	37.4	33.4
FH52K-25S-0.5SH(99)	CL580-4634-0-99	25	16.8	12.0	13.07	15.05	17.6	14.6	14.6	13.0	17.1	18.1	14.2	32.0	28.4	37.4	33.4
FH52K-26S-0.5SH(99)	CL580-4635-0-99	26	17.3	12.5	13.57	15.55	18.1	15.1	15.1	13.5	17.6	18.6	14.2	32.0	28.4	37.4	33.4
FH52K-30S-0.5SH(99)	CL580-4631-0-99	30	19.3	14.5	15.57	17.55	20.1	17.1	17.1	15.5	19.6	20.6	20.2	44.0	40.4	49.4	45.4
FH52K-32S-0.5SH(99)	CL580-4600-9-99	32	20.3	15.5	16.57	18.55	21.1	18.1	18.1	16.5	20.6	21.6	20.2	44.0	40.4	49.4	45.4
FH52K-34S-0.5SH(99)	CL580-4601-0-99	34	21.3	16.5	17.57	19.55	22.1	19.1	19.1	17.5	21.6	22.6	20.2	44.0	40.4	49.4	45.4
FH52K-40S-0.5SH(99)	CL580-4620-0-99	40	24.3	19.5	20.57	22.55	25.1	22.1	22.1	20.5	24.6	25.6	20.2	44.0	40.4	49.4	45.4
FH52K-45S-0.5SH(99)	CL580-4637-0-99	45	26.8	22.0	23.07	25.05	27.6	24.6	24.6	23.0	27.1	28.1	20.2	44.0	40.4	49.4	45.4
FH52K-50S-0.5SH(99)	CL580-4609-0-99	50	29.3	24.5	25.57	27.55	30.1	27.1	27.1	25.5	29.6	30.6	20.2	44.0	40.4	49.4	45.4
FH52K-60S-0.5SH(99)	CL580-4607-0-99	60	34.3	29.5	30.57	32.55	35.1	32.1	32.1	30.5	34.6	35.6	26.2	56.0	52.4	61.4	57.4
FH52K-64S-0.5SH(99)	————	64	36.3	31.5	32.57	34.55	37.1	34.1	34.1	32.5	36.6	37.6	26.2	56.0	52.4	61.4	57.4
FH52K-68S-0.5SH(99)	CL580-4614-0-99	68	38.3	33.5	34.57	36.55	39.1	36.1	36.1	34.5	38.6	39.6	26.2	56.0	52.4	61.4	57.4

※CONTACT POSITIONS WITHOUT CODE NUMBERS ARE CURRENTLY UNDER PLANNING.
PLEASE CONTACT HIROSE FOR DETAILED INFORMATION ABOUT PRODUCT VARIATION.

HRS	DRAWING NO.	EDC-365730-99-00
	PART NO.	FH52K-**S-0.5SH(99)
	CODE NO.	CL580

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This connector requires delicate and careful handling.
Read through the instructions shown below and handle the connector properly.
Each values indicating here are for reference and may differ from standard value.

[Connector Part Nomenclature]

Contacts   Housing

Metal fitting   Actuator   Metal fitting
《Top view》

Top (pick-up surface)

Bottom (mounting surface)

FPC/FFC insertion opening
《Front view》

Contact point   Contact lead
《Contact view》

[Operation and Precautions]

1. Initial condition
   The connector is delivered with the actuator closed.

   [Caution]
   -Do not insert FPC/FFC or operate actuator before mounting.

2. How to unlock (Before inserting FPC/FFC)

   The actuator rotates on its axis as shown below.
   Slowly flip up the actuator to release the lock.(example 1)

   [Caution]
   -Do not apply extra force to the connector while rotating the actuator as the illustration shows.(example 2)
   -Open the actuator by carefully lifting it at the center.(example 3)
   -Do not lift the actuator at one end only.(example 4)
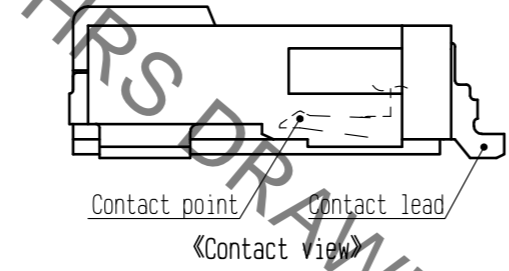   -The actuator must be operated by hand only.
    Do not insert any tools or fingernails into the connector.(example 5, 6)
   -The actuator rotates 116 degrees max.
    Do not try to rotate the actuator further towards the opening direction or apply any extra force to the actuator
    while it is fully open.(example 7)
   -Do not attempt to dislodge the actuator.(example 8,9)
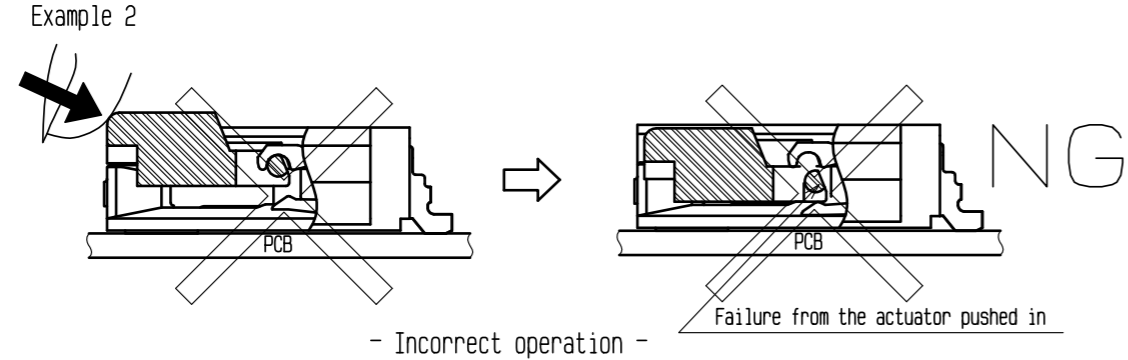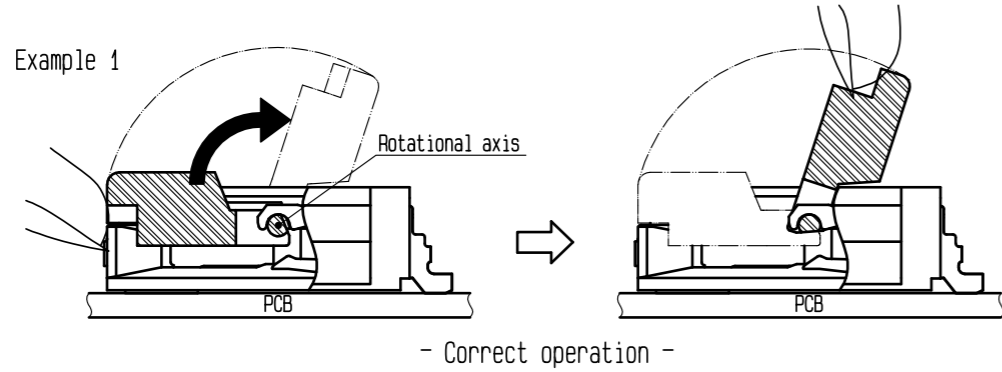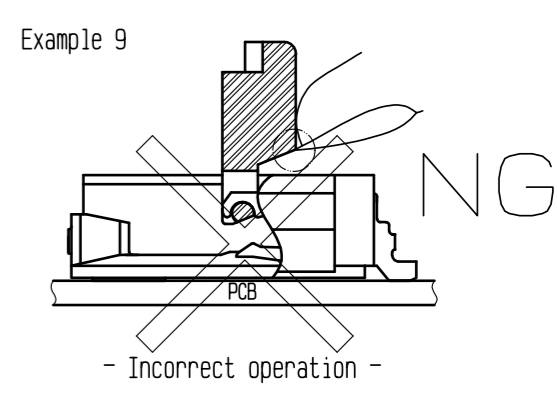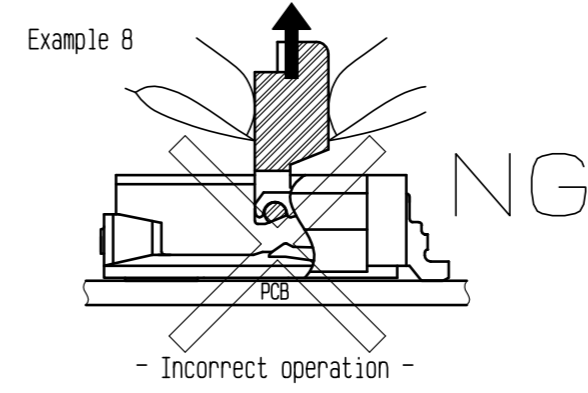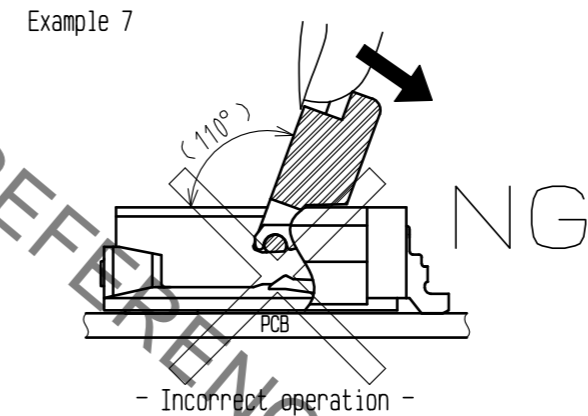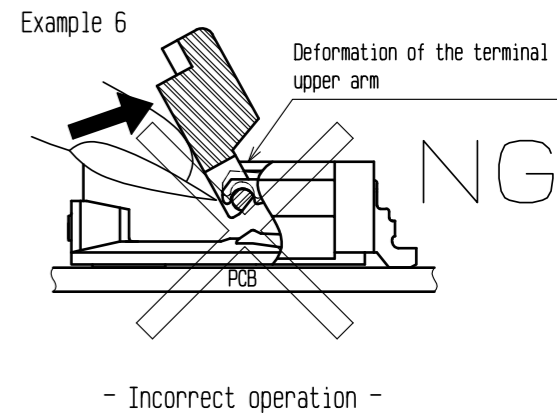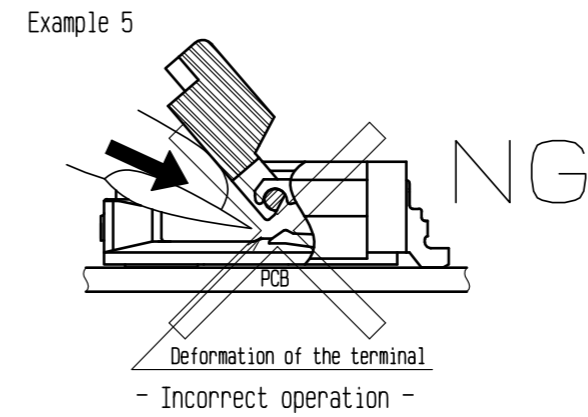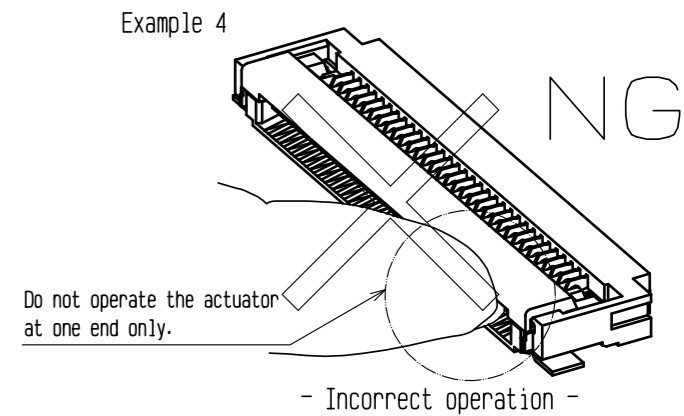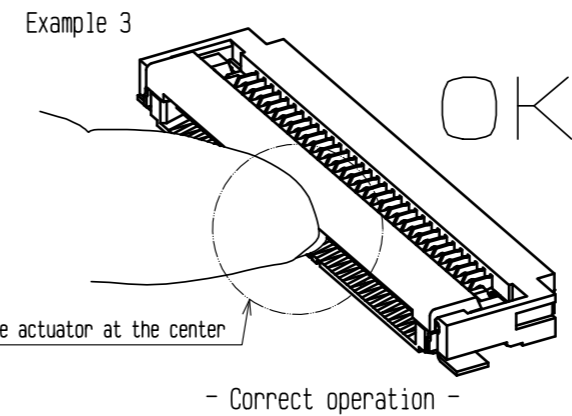
Example 1

Rotational axis

PCB

- Correct operation -

Example 2

PCB   PCB
Failure from the actuator pushed in
- Incorrect operation -

Example 3

OK
Open the actuator at the center
- Correct operation -

Example 4

NG
Do not operate the actuator at one end only.
- Incorrect operation -

Example 5

NG
PCB
Deformation of the terminal
- Incorrect operation -

Example 6

Deformation of the terminal upper arm
NG
PCB
- Incorrect operation -

Example 7

(110°)
NG
PCB
- Incorrect operation -

Example 8

NG
PCB
- Incorrect operation -

Example 9

NG
PCB
- Incorrect operation -

⚠ 〈INSTRUCTION MANUAL (1)〉

HRS	DRAWING NO.	EDC-365730-99-00
	PART NO.	FH52K-**S-0.5SH(99)
	CODE NO.	CL580 ⚠ 5/9

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3. How to insert FPC/FFC

This connector has contact point on the bottom, insert the FPC/FFC with the exposed conductors face down.
This connector has Guide for positioning FPC/FFC, insert the FPC/FFC at about 10 degree angle
to the PCB mounting surface.(example 10)
In case of using FPC/FFC without tabs, insert the FPC/FFC horizontally along the surface.

[Caution]
 -Do not insert the FPC/FFC with the conductor surface face up.
 -Insert the FPC/FFC properly to the very end.
 -Do not insert the FPC/FFC at an angle.(example 11)
 -Insert the FPC/FFC with the actuator opened.(example 12)
 -Do not twist the FPC/FFC to up and down, right and left or an angle.(example 13)

Example 10

Guide for positioning FPC/FFC

(10°)

PCB

Insert the FPC/FFC
with the exposed conductors face down.

PCB

- Correct operation -

Example 11

PCB

PCB

Pattern breakage

NG

- Incorrect operation -

Example 12

FPC/FFC

OK

- Correct operation -

Example 13

FPC/FFC

NG

- Incorrect operation -
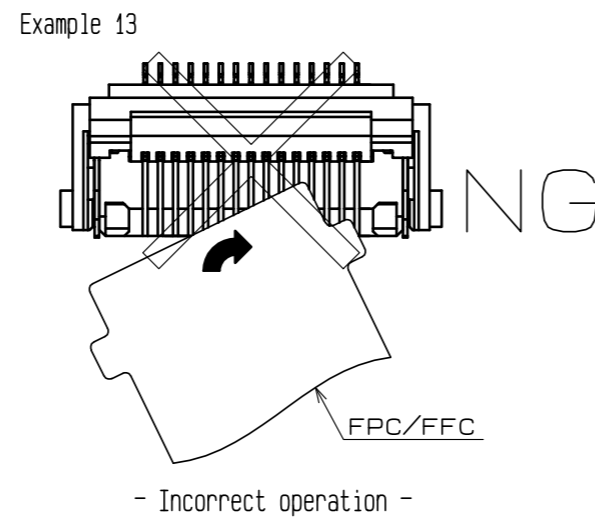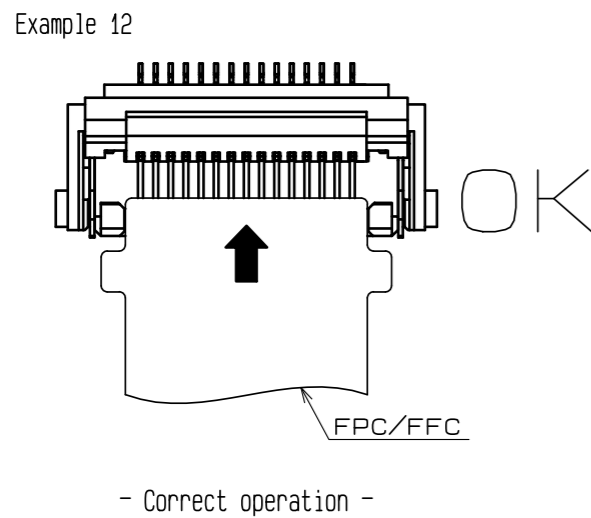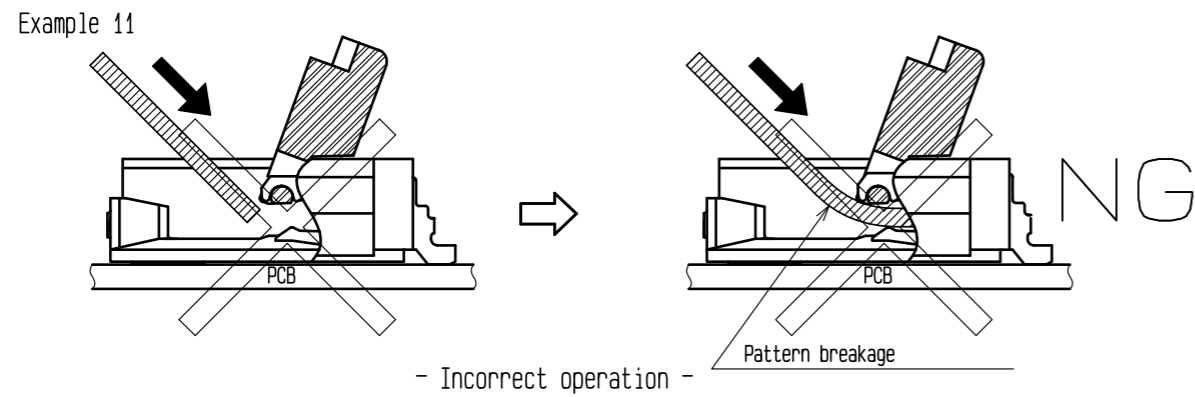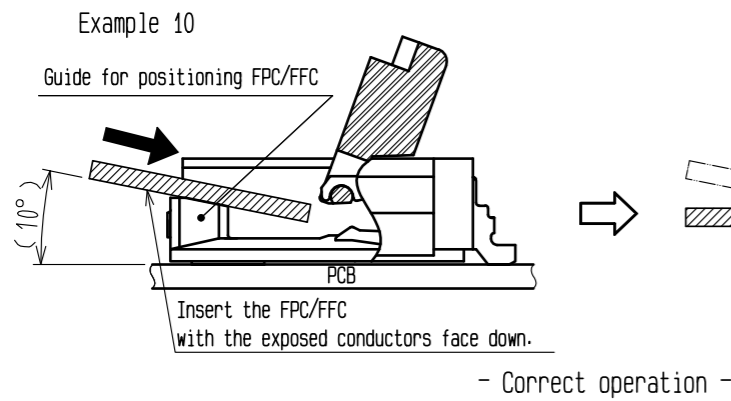
4. FPC/FFC insertion check

Guide for positioning FPC/FFC guide the FPC/FFC tabs to the correct position.
Make sure that the FPC/FFC tabs are located in correct position
as shown in the figure below after FPC/FFC insertion.(example 14)

[Caution]
 -Do not insert the FPC/FFC at an angle and/or stop it before insertion is completed.(example 15, 16)
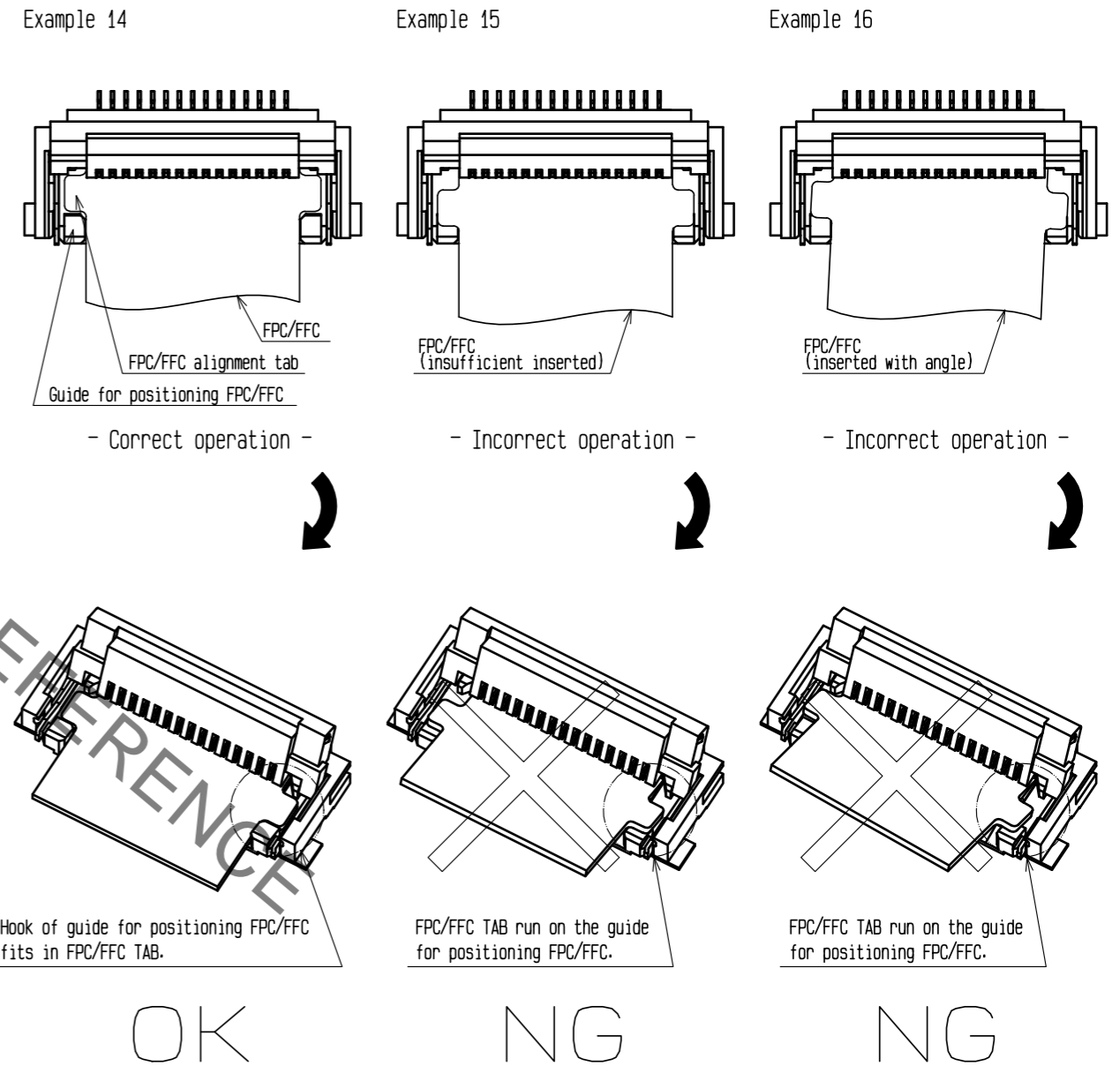
Example 14

FPC/FFC
FPC/FFC alignment tab
Guide for positioning FPC/FFC

- Correct operation -

Hook of guide for positioning FPC/FFC
fits in FPC/FFC TAB.

OK

Example 15

FPC/FFC
(insufficient inserted)

- Incorrect operation -

FPC/FFC TAB run on the guide
for positioning FPC/FFC.

NG

Example 16

FPC/FFC
(inserted with angle)

- Incorrect operation -

FPC/FFC TAB run on the guide
for positioning FPC/FFC.

NG

<INSTRUCTION MANUAL(2)>

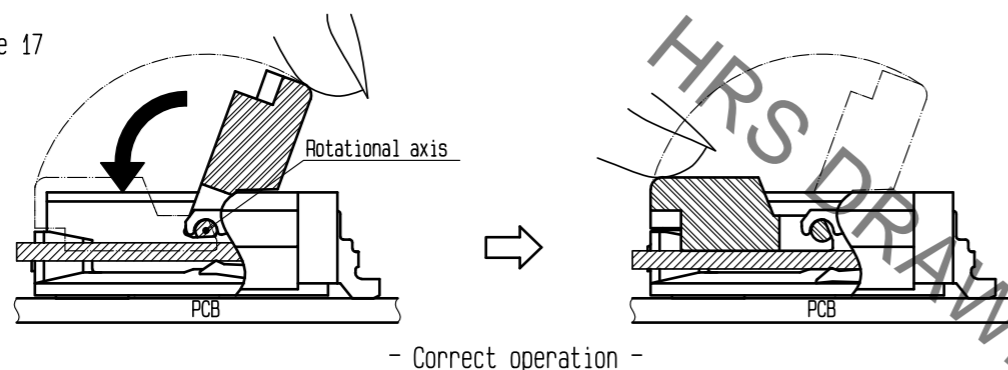|	DRAWING NO.	EDC-365730-99-00
HRS	PART NO.	FH52K-**S-0.5SH(99)
	CODE NO.	CL580

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5. How to lock

The actuator rotates on its axis as shown below.
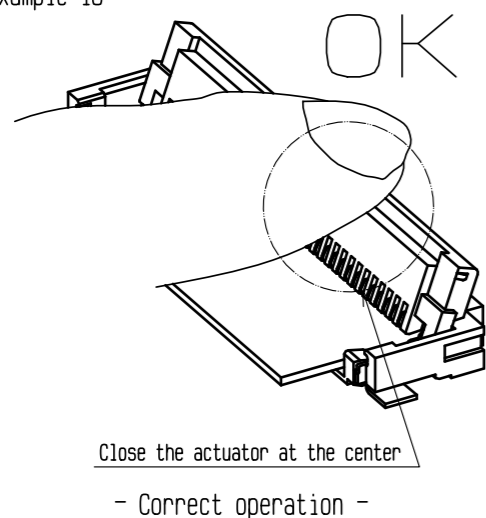Apply load to rotate the actuator after inserting the FPC/FFC.(example 17)

[Caution]
-Close the actuator by carefully operating it at the center.(example 18)
-Do not operate the actuator at one end only.(example 19)
-The actuator must be operated by hand only.
 Do not insert any tools or fingernails into the connector.
-Do not try to rotate the actuator further towards the opening direction while it is fully open.
-Do not apply excessive force to the actuator other than force necessary for rotating the actuator.
-Do not attempt to dislodge the actuator.
-After the actuator is closed, the actuator should be parallel to the PCB mounting surface.

Example 17

Rotational axis

PCB

PCB

- Correct operation -

Example 18

OK

Example 19

NG

Close the actuator at the center

- Correct operation -

Do not operate the actuator
at one end only

- Incorrect operation -
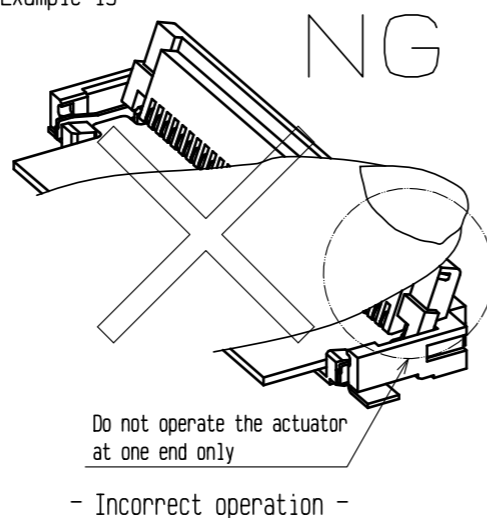
6. Mating confirmation of the FPC/FFC

After the actuator is closed, please check if the actuator is parallel to the PCB mounting surface.
Please keep the actuator stress free while it is near its 0° position.
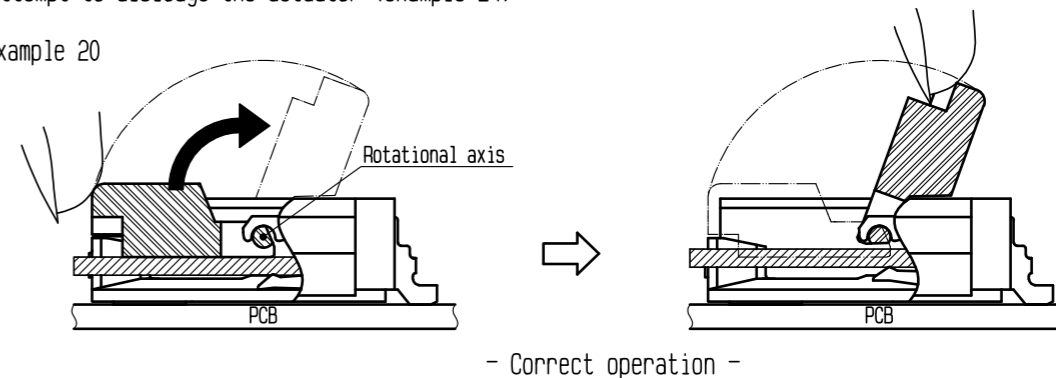Any extra stress on actuator may lead to contact deformation.

7. How to unlock
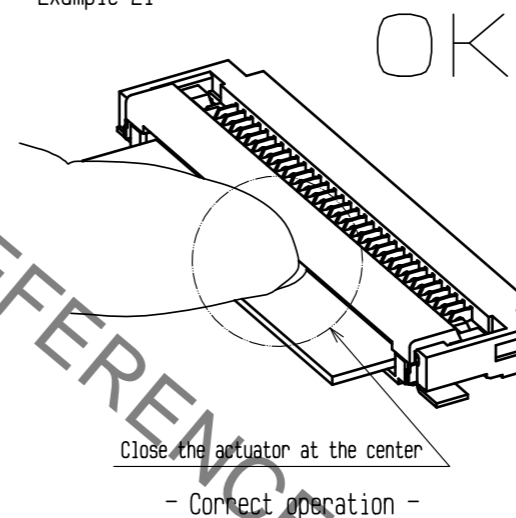
Slowly flip up the actuator to release the lock.(example 20)

[Caution]
-Open the actuator by carefully lifting it at the center.(example 21)
-Do not lift the actuator at one end only.(example 22)
-Do not apply excessive force to the actuator in the direction parallel to the actuator while unlocking the actuator.
-The actuator must be operated by hand only.
 Do not insert any tools or fingernails into the connector.
-The actuator rotates 116 degrees max.
 Do not try to rotate the actuator further towards the opening direction or apply any extra force to the actuator
 while it is fully open.(example 23)
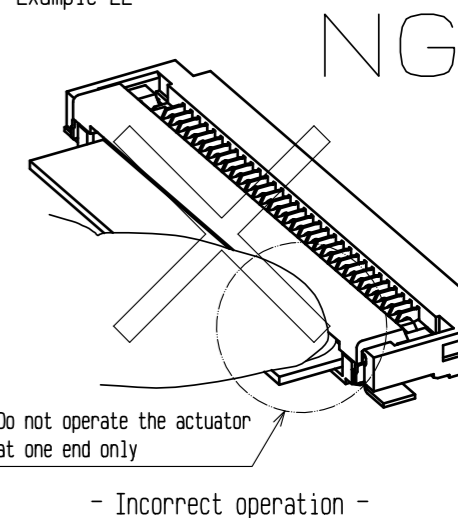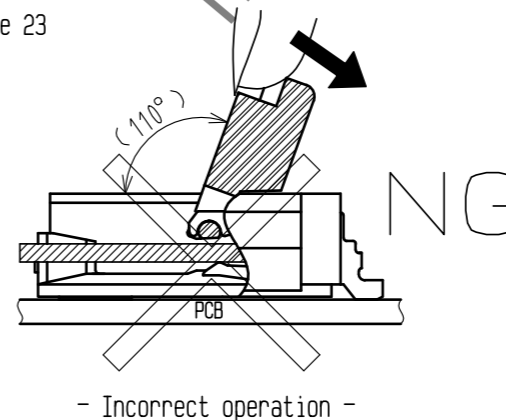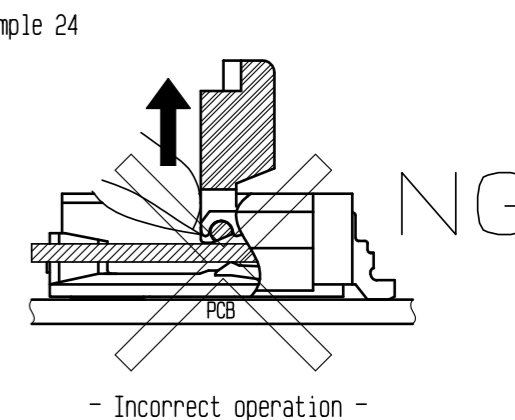-Do not attempt to dislodge the actuator.(example 24)

Example 20

Rotational axis

PCB

PCB

- Correct operation -

OK

Example 21

Example 22

NG

Close the actuator at the center

- Correct operation -

Do not operate the actuator
at one end only

- Incorrect operation -

Example 23

(116°)

PCB

NG

- Incorrect operation -

Example 24

PCB

NG

- Incorrect operation -

⚠<INSTRUCTION MANUAL (3)>

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8. How to remove FPC/FFC

This connector has a FPC/FFC positioning structure for guiding the FPC/FFC into the right position while insertion.
After rotating the actuator to the fully open position, carefully withdraw the FPC/FFC
at about 10 degree angle to the PCB mounting surface.(example 25)
In case of using FPC/FFC without tabs, pull out the FPC/FFC horizontally along the PCB mounting surface.

[Caution]
 -For FPC/FFC removal, do not pull out the FPC/FFC horizontally.
 -Do not withdraw the FPC/FFC at extreme(inclined towards vertical) angle.(example 26)
 -Do not attempt to pull the FPC/FFC without unlocking the actuator.(example 27)

Example 28

Example 29
Stiffener film (parallel to the PCB)
FPC/FFC
OK

Example 25

(10°)
PCB
- Correct operation -
OK

Example 30
Stiffener film (angled)
FPC/FFC
PCB
NG

Example 31
Stiffener film (angled)
FPC/FFC
PCB
Component part
NG

Example 26
Deformation of the terminal upper arm
PCB
- Incorrect operation -
NG

Example 27
Actuator(close)
PCB
- Incorrect operation -
NG
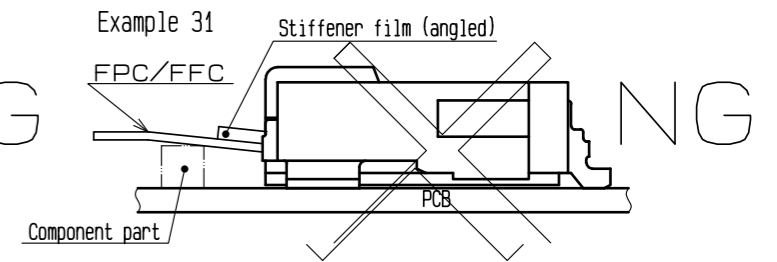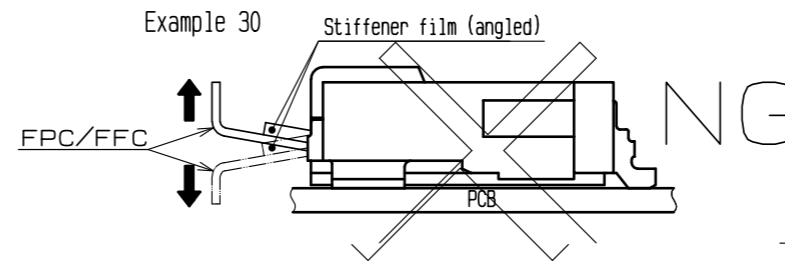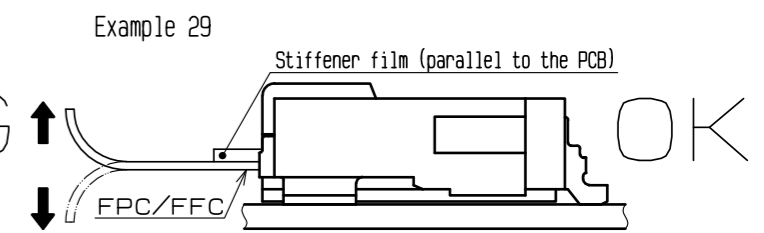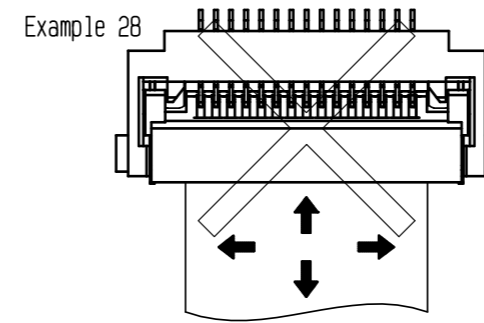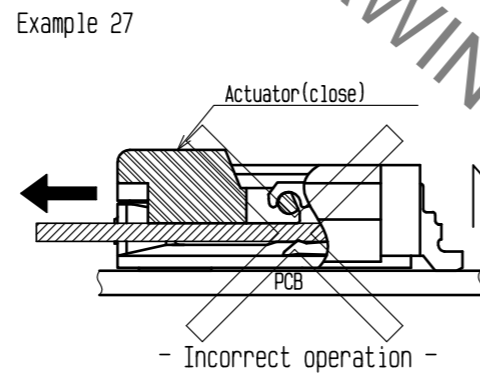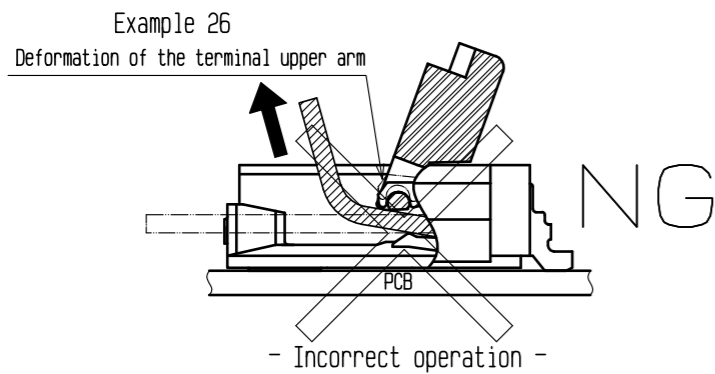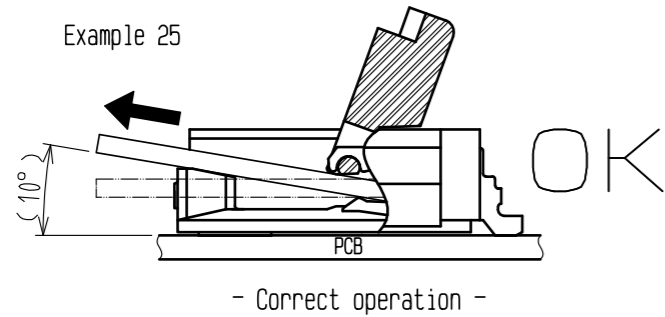
[Instructions for mounting on the PCB]

Follow the instructions shown below when mounting on the PCB.

[Caution]
 -Refer to recommended layouts on page 1 for PCB and stencil pattern.
 -Using either narrower land pattern or wider stencil pattern than recommendation
  may end up with excessive amount of solder/flux climbing on contact.
  Please inspect the size of solder fillet and flux climbing height of the mounted connector
  while using different land/stencil pattern from our recommendation.
 -Clearance between the mounting surface of the connector contact lead and the bottom of the housing is
  very small. Solder resist/silk screening applied underneath the connector may interfere with the connector.
  This may lead to soldering defect/insufficient fillet formation.
  Please verify your solder resist/silk screening design carefully before implementing the design.
 -Apply reflow temperature profile within the specified conditions.
  For specific applications, the recommended temperature may vary depending on
  type/ volume/thickness of solder paste and size/thickness of PCB.
  Please consult with your solder paste and equipment manufacturer for specific recommendations.
 -Please try to minimize the warpage of the PCB. Soldering failure could still occur
  due to the PCB warpage even if the coplanarity of the connecter is under 0.1mm.
 -If the connector is mounting on FPC/FFC, please make sure to put a stiffener
  on the backside of the FPC/FFC.
  Recommended stiffner: Glass epoxy material with thickness of 0.3 mm MIN.
 -Do not apply 1 N or greater external force on the connector when unreeling
  or handling the connector before mounting.
  Excessive mechanical stress may damage the connector before mounting.

[Precautions for component layout]
 While the FPC/FFC is under tension due to the connecting configuration, extra stress may be applied to the connector.
 As a result, conduction failure may occur due to the extra stress.
 In order to prevent such kind of conduction failure, please read through the following parts before making circuits/mechanism design.

[Caution]
 -Avoid applying forces to/pulling the FPC/FFC along/perpendicular to the direction of FPC/FFC insertion.(example 28)
  Avoid pushing/pulling the FPC/FFC upwards/downwards.
 -If the FPC/FFC has to be curled/bended in your cabling design,
  please keep enough degree of freedom in your design to keep the FPC/FFC tension free.
  In this regard, the stiffener should be parallel to the PCB.(example 29)
 -If the FPC/FFC has to be curled/bended in your cabling design, do not curl/bend the FPC/FFC area near the connector.
  This may lead to conduction failure or FPC/FFC breakage.(example 30)
  It is recommended to keep the FPC/FFC fixed to avoid applying stress through the FPC/FFC to the connector.
 -Do not mount other components underneath the FPC/FFC stiffener which may interfere with the connection.(example 31)
 -Follow the recommended FPC/FFC design.
  Please consult with the FPC/FFC manufacturer about FPC/FFC bending performance and wire breakage strength while making design.
 -Keep sufficient operating space for FPC/FFC insertion during layout design in order to avoid incorrect FPC/FFC insertion.
  Please keep enough FPC/FFC length and component layout space for assembly during design process.
  FPC/FFC with too short length may make the assembly difficult.
 -Keep enough space for the rotation of the actuator during PCB and component layout design.
 -Please consult with our sales representative if you are using FPC/FFC with different configuration from our recommendation.

<INSTRUCTION MANUAL(4)>

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|Instructions for PCB handling after mounting the connector|

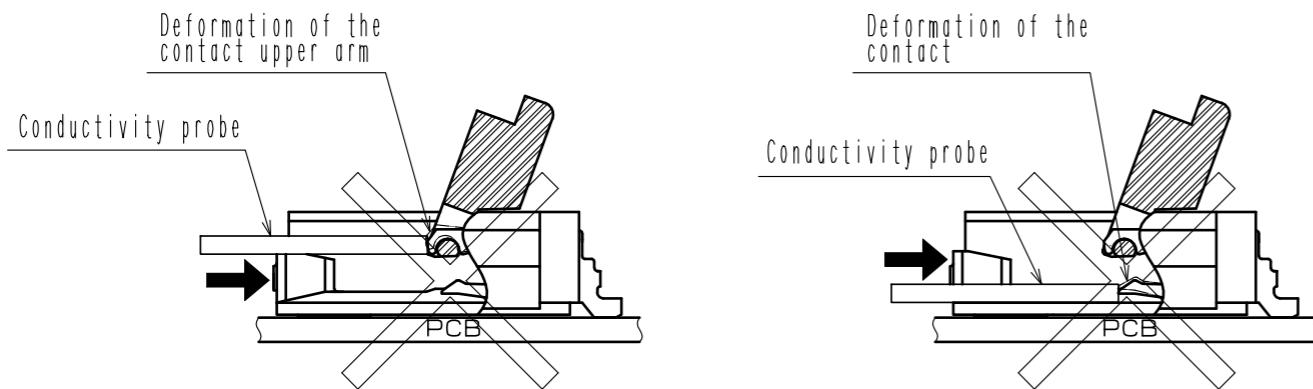Follow the instructions shown below when mounting on the PCB.

[Caution]
 - ·Splitting a large PCB into several pieces
   ·Installing mounting screw on PCB
 During the assembly processes described above, care shall be taken
 so as not to give any stresses of deflection or twisting to the PCB.
 Stresses applied on PCB may damage the connector as well
 -The warpage of a 100 mm wide PCB should remain within 0.5 mm .(example 32)
 The warpage of PCB may apply excessive stress on the connnector and damage the connector.
 -Please perform conduction check with caution.Conductivity probe may damage the connector contacts.
 -Attachment of foreign particles with the connector contact may lead to conduction failure.
 In this particular case, the conduction failure may be fixed by re-inserting the FPC/FFC.
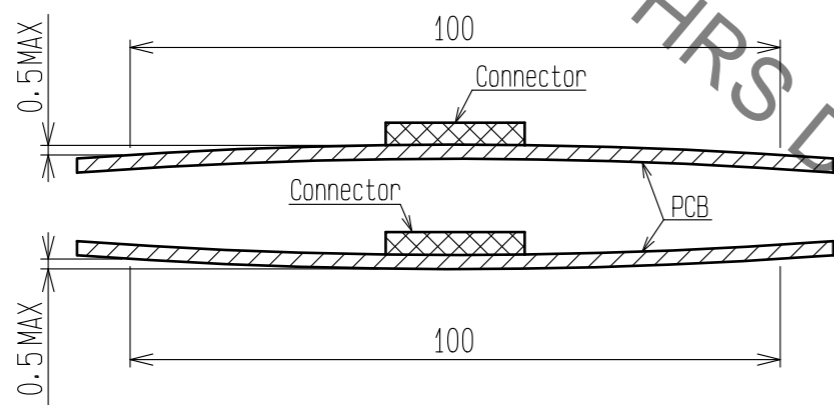
|Instructions on manual soldering|

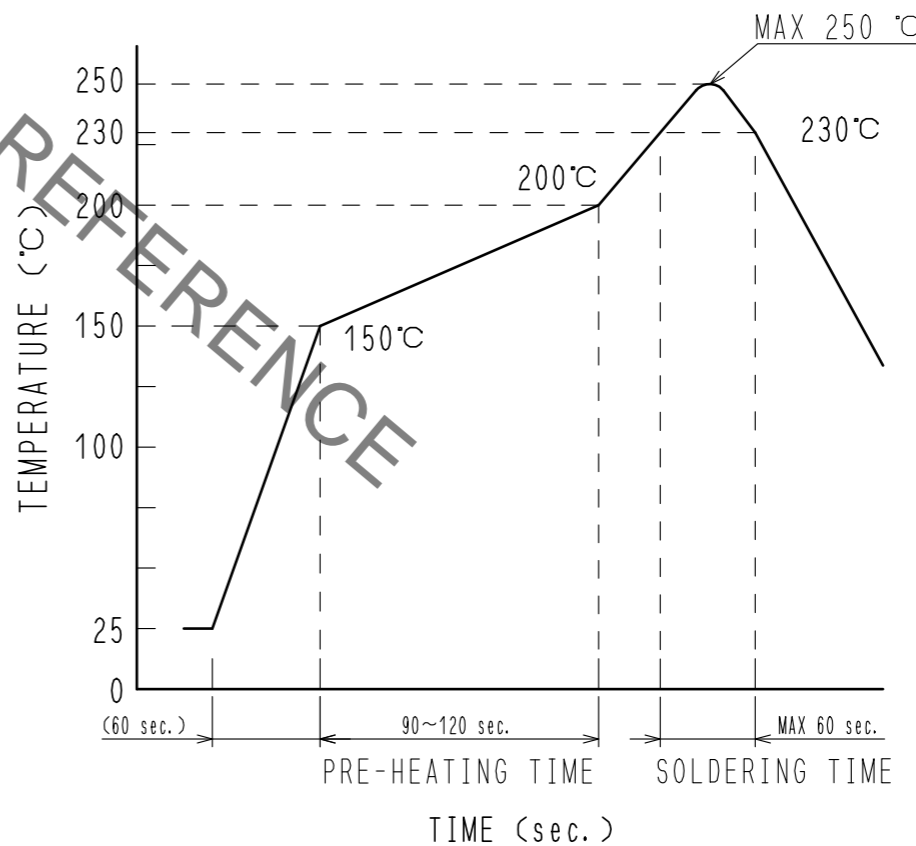Follow the instructions shown below when soldering the connector manually during repair work, etc.

[Caution]
 -Do not perform manual soldering with the FPC/FFC inserted into the connector.
 -Do not heat the connector excessively. Be very careful not to let the soldering iron touch
 any parts other than connector leads. Otherwise, the connector may be deformed or melted.
 -Do not supply excessive solder (or flux).
 If excessive solder (or flux) is supplied on the contact lead, solder or flux may adhere to the contact point
 or rotating parts of the actuator, resulting in conduction failure or a rotation failure of the actuator.
 Supplying excessive solder to the metal fittings may hinder actuator rotation,
 resulting in breakage of the connector.

|Recommended reflow temperature profile|

The temperatures mentioned below refer to the PCB surface
temperature near the connector contact leads.
For specific applications the recommended temperature may vary depending on
solder paste type,volume/thickness and board size/thickness.
Please consult with your solder paste and equipment manufacturer for specific recommendations.
-Reflow method:IR reflow
-Number of reflow cycles:2 cycles MAX.

Example 32

Example 33

⚠<Recommended reflow temperature profile>

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