

Hand Soldering Guideline for TAB Product

TRULY OLED R&D Dept.

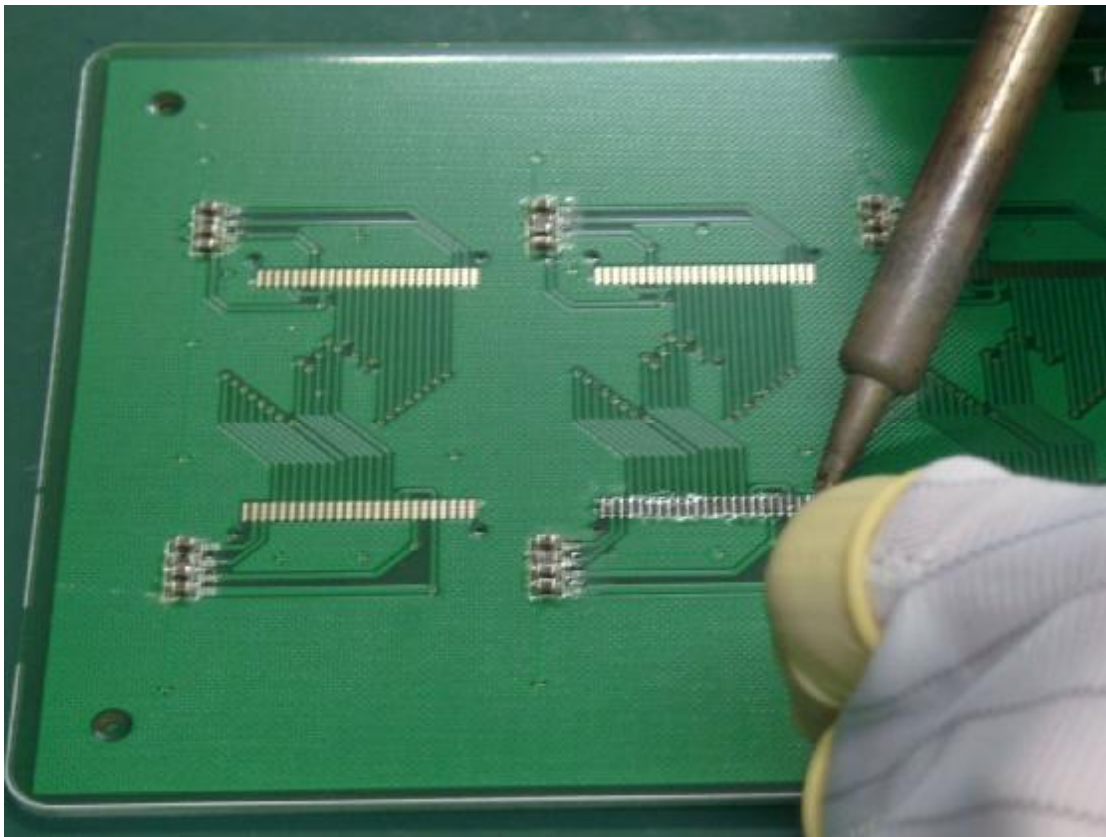
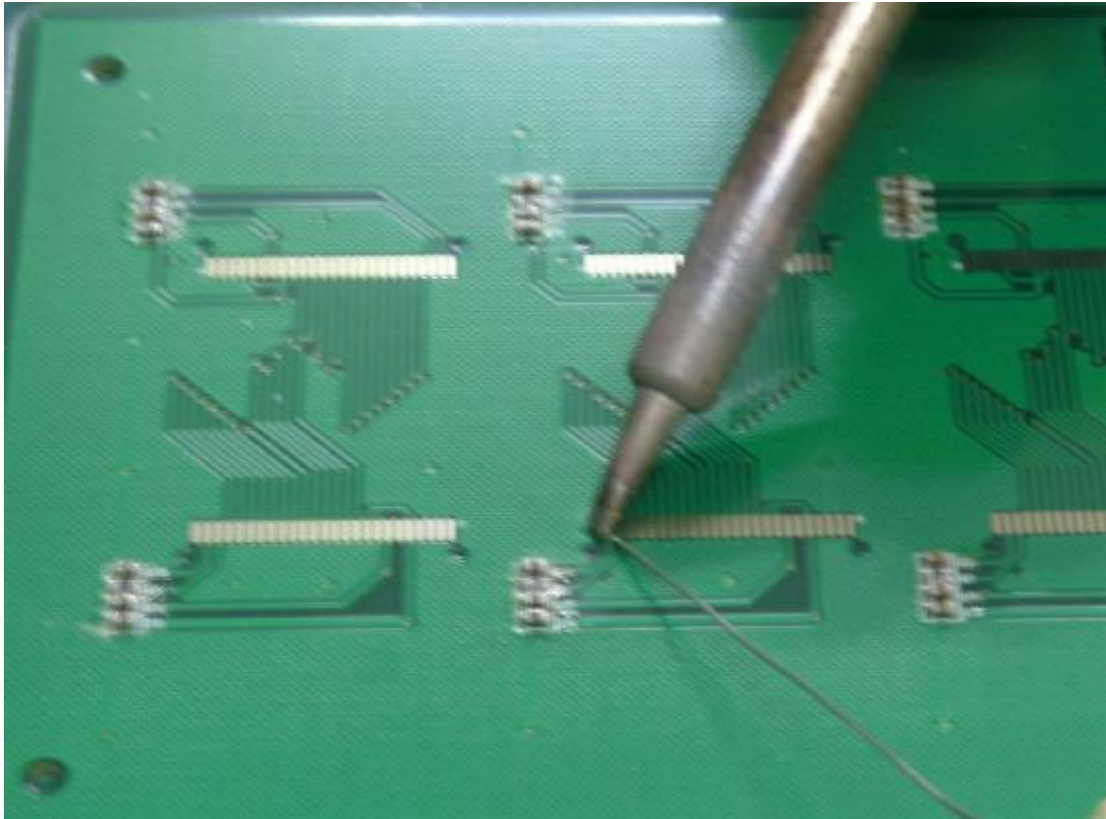
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This document is written in the hope that it will be useful for customers to solder **TRULY** OLED modules with TAB to PCB.

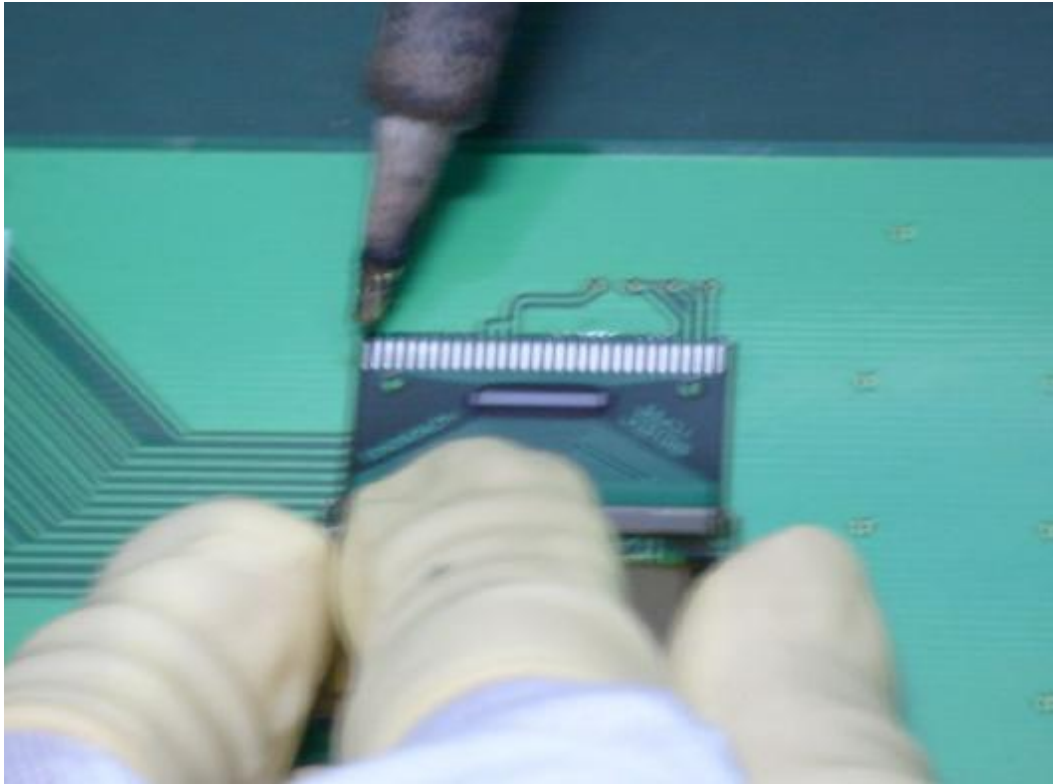
Step1. Before soldering, it is necessary to detect the actual temperature of iron end. The actual temperature should be set between 350°C and 380°C when using lead-free soldering tin.



Step2. Smear the pads on the PCB with soldering tin.



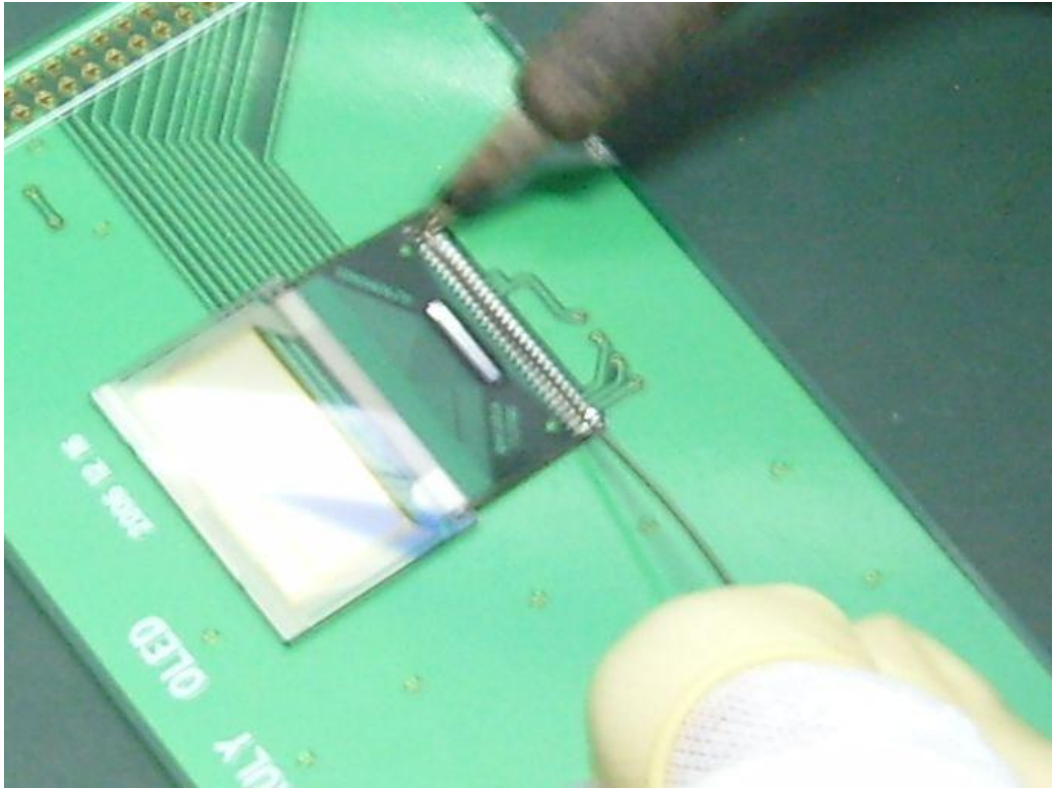
Step3. Position the TAB to pads on the PCB.



Step4. Use iron end to fix the first and the last pin of the TAB.



Step5. Drag the soldering iron on the surface of the TAB carefully **1 or 2** times. At this step, we should ensure the end of the soldering iron and TAB at 25-40 degree angle in order to keep a large contact area between iron end and TAB.



Step6. The last step would be QC. We should check whether there are virtual-circuits, short-circuits, misalignment etc. phenomenon exists. After QC, the hand soldering is completed.

