

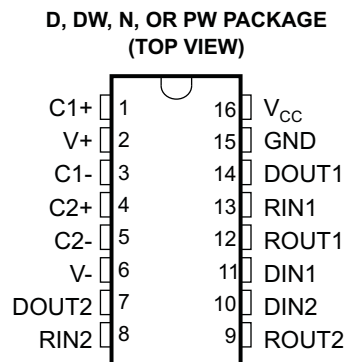


## FEATURES

- ESD Protection for RS-232 Bus Pins
  - $\pm 15$ -kV Human-Body Model (HBM)
- Meets or Exceeds the Requirements of TIA/EIA-232-F and ITU v.28 Standards
- Operates at 5-V  $V_{CC}$  Supply
- Operates up to 120 kbit/s
- External Capacitors . . .  $4 \times 0.1 \mu\text{F}$
- Latch-Up Performance Exceeds 100 mA Per JESD 78, Class II

## APPLICATIONS

- Battery-Powered Systems
- PDAs
- Notebooks
- Laptops
- Palmtop PCs
- Hand-Held Equipment



## DESCRIPTION/ORDERING INFORMATION

The TRS202 device consists of two line drivers, two line receivers, and a dual charge-pump circuit with  $\pm 15$ -kV ESD protection pin-to-pin (serial-port connection pins, including GND). The device meets the requirements of TIA/EIA-232-F and provides the electrical interface between an asynchronous communication controller and the serial-port connector. The charge pump and four small external capacitors allow operation from a single 5-V supply. The device operates at data signaling rates up to 120 kbit/s and a maximum of 30-V/ $\mu\text{s}$  driver output slew rate.

### ORDERING INFORMATION

$T_A$	PACKAGE <sup>(1)(2)</sup>		ORDERABLE PART NUMBER	TOP-SIDE MARKING
0°C to 70°C	PDIP – N	Tube of 25	TRS202CN	PREVIEW
	SOIC – D	Tube of 40	TRS202CD	TRS202C
		Reel of 2500	TRS202CDR	
	SOIC – DW	Tube of 40	TRS202CDW	TRS202C
		Reel of 2000	TRS202CDWR	
	TSSOP – PW	Tube of 90	TRS202CPW	RU02C
Reel of 2000		TRS202CPWR		
–40°C to 85°C	PDIP – N	Tube of 25	TRS202IN	PREVIEW
	SOIC – D	Tube of 40	TRS202ID	TRS202I
		Reel of 2500	TRS202IDR	
	SOIC – DW	Tube of 40	TRS202IDW	TRS202I
		Reel of 2000	TRS202IDWR	
	TSSOP – PW	Tube of 90	TRS202IPW	RU02I
Reel of 2000		TRS202IPWR		

(1) Package drawings, standard packing quantities, thermal data, symbolization, and PCB design guidelines are available at [www.ti.com/sc/package](http://www.ti.com/sc/package).

(2) For the most current package and ordering information, see the Package Option Addendum at the end of this document, or see the TI website at [www.ti.com](http://www.ti.com).



Please be aware that an important notice concerning availability, standard warranty, and use in critical applications of Texas Instruments semiconductor products and disclaimers thereto appears at the end of this data sheet.

**FUNCTION TABLES**

**Each Driver<sup>(1)</sup>**

INPUT DIN	OUTPUT DOUT
L	H
H	L

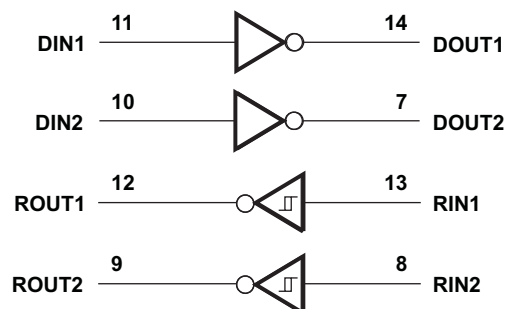
(1) H = high level, L = low level

**Each Receiver<sup>(1)</sup>**

INPUT RIN	OUTPUT ROUT
L	H
H	L
Open	H

(1) H = high level, L = low level,  
Open = input disconnected or  
connected driver off

**LOGIC DIAGRAM (POSITIVE LOGIC)**



### Absolute Maximum Ratings<sup>(1)</sup>

over operating free-air temperature range (unless otherwise noted)

		MIN	MAX	UNIT
V <sub>CC</sub>	Supply voltage range <sup>(2)</sup>	−0.3	6	V
V+	Positive charge pump voltage range <sup>(2)</sup>	V <sub>CC</sub> − 0.3	14	V
V−	Negative charge pump voltage range <sup>(2)</sup>	−14	0.3	V
V <sub>I</sub>	Input voltage range	Drivers	V+ + 0.3	V
		Receivers	±30	
V <sub>O</sub>	Output voltage range	Drivers	V− − 0.3	V
		Receivers	−0.3	
DO <sub>UT</sub>	Short-circuit duration	DO <sub>UT</sub>		Continuous
θ <sub>JA</sub>	Package thermal impedance <sup>(3)(4)</sup>	D package		73
		DW package		57
		N package		67
		PW package		108
T <sub>J</sub>	Operating virtual junction temperature			150
T <sub>stg</sub>	Storage temperature range	−65	150	°C

- (1) Stresses beyond those listed under "absolute maximum ratings" may cause permanent damage to the device. These are stress ratings only, and functional operation of the device at these or any other conditions beyond those indicated under "recommended operating conditions" is not implied. Exposure to absolute-maximum-rated conditions for extended periods may affect device reliability.
- (2) All voltages are with respect to network GND.
- (3) Maximum power dissipation is a function of T<sub>J(max)</sub>, θ<sub>JA</sub>, and T<sub>A</sub>. The maximum allowable power dissipation at any allowable ambient temperature is P<sub>D</sub> = (T<sub>J(max)</sub> − T<sub>A</sub>)/θ<sub>JA</sub>. Operating at the absolute maximum T<sub>J</sub> of 150°C can affect reliability.
- (4) The package thermal impedance is calculated in accordance with JESD 51-7.

### Recommended Operating Conditions<sup>(1)</sup>

 See [Figure 4](#)

		MIN	NOM	MAX	UNIT
Supply voltage		4.5	5	5.5	V
V <sub>IH</sub>	Driver high-level input voltage	DIN		2	V
V <sub>IL</sub>	Driver low-level input voltage	DIN		0.8	V
V <sub>I</sub>	Driver input voltage	DIN		0	V
	Receiver input voltage	−30	30		
T <sub>A</sub>	Operating free-air temperature	TRS202C		0	°C
		TRS202I		−40	

- (1) Test conditions are C1–C4 = 0.1 μF at V<sub>CC</sub> = 5 V ± 0.5 V.

### Electrical Characteristics<sup>(1)</sup>

 over recommended ranges of supply voltage and operating free-air temperature (unless otherwise noted) (see [Figure 4](#))

PARAMETER	TEST CONDITIONS	MIN	TYP <sup>(2)</sup>	MAX	UNIT
I <sub>CC</sub>	Supply current	No load, V <sub>CC</sub> = 5 V		8	15

- (1) Test conditions are C1–C4 = 0.1 μF at V<sub>CC</sub> = 5 V ± 0.5 V.
- (2) All typical values are at V<sub>CC</sub> = 5 V, and T<sub>A</sub> = 25°C.

# TRS202

## 5-V DUAL RS-232 LINE DRIVER/RECEIVER WITH $\pm 15$ -kV ESD PROTECTION

SLLS808–JULY 2007

### DRIVER SECTION

#### Electrical Characteristics<sup>(1)</sup>

over recommended ranges of supply voltage and operating free-air temperature (unless otherwise noted) (see [Figure 4](#))

PARAMETER	TEST CONDITIONS	MIN	TYP <sup>(2)</sup>	MAX	UNIT
V <sub>OH</sub> High-level output voltage	DOUT at R <sub>L</sub> = 3 k $\Omega$ to GND, DIN = GND	5	9		V
V <sub>OL</sub> Low-level output voltage	DOUT at R <sub>L</sub> = 3 k $\Omega$ to GND, DIN = V <sub>CC</sub>	–5	–9		V
I <sub>IH</sub> High-level input current	V <sub>I</sub> = V <sub>CC</sub>		15	200	$\mu$ A
I <sub>IL</sub> Low-level input current	V <sub>I</sub> at 0 V		–15	–200	$\mu$ A
I <sub>OS</sub> <sup>(3)</sup> Short-circuit output current	V <sub>CC</sub> = 5.5 V, V <sub>O</sub> = 0 V		$\pm 10$	$\pm 60$	mA
r <sub>o</sub> Output resistance	V <sub>CC</sub> , V <sub>+</sub> , and V <sub>–</sub> = 0 V, V <sub>O</sub> = $\pm 2$ V	300			$\Omega$

(1) Test conditions are C1–C4 = 0.1  $\mu$ F at V<sub>CC</sub> = 5 V  $\pm$  0.5 V.

(2) All typical values are at V<sub>CC</sub> = 5 V, and T<sub>A</sub> = 25°C.

(3) Short-circuit durations should be controlled to prevent exceeding the device absolute power dissipation ratings, and not more than one output should be shorted at a time.

#### Switching Characteristics<sup>(1)</sup>

over recommended ranges of supply voltage and operating free-air temperature (unless otherwise noted) (see [Figure 4](#))

PARAMETER	TEST CONDITIONS	MIN	TYP <sup>(2)</sup>	MAX	UNIT
Maximum data rate	C <sub>L</sub> = 50 to 1000 pF, R <sub>L</sub> = 3 k $\Omega$ to 7 k $\Omega$ , One DOUT switching, See <a href="#">Figure 1</a>	120			kbit/s
t <sub>PLH(D)</sub> Propagation delay time, low- to high-level output	C <sub>L</sub> = 2500 pF, R <sub>L</sub> = 3 k $\Omega$ , All drivers loaded, See <a href="#">Figure 1</a>		2		$\mu$ s
t <sub>PHL(D)</sub> Propagation delay time, high- to low-level output	C <sub>L</sub> = 2500 pF, R <sub>L</sub> = 3 k $\Omega$ , All drivers loaded, See <a href="#">Figure 1</a>		2		$\mu$ s
t <sub>sk(p)</sub> Pulse skew <sup>(3)</sup>	C <sub>L</sub> = 150 pF to 2500 pF, R <sub>L</sub> = 3 k $\Omega$ to 7 k $\Omega$ , See <a href="#">Figure 2</a>		300		ns
SR(tr) Slew rate, transition region (see <a href="#">Figure 1</a> )	C <sub>L</sub> = 50 pF to 1000 pF, R <sub>L</sub> = 3 k $\Omega$ to 7 k $\Omega$ , V <sub>CC</sub> = 5 V	3	6	30	V/ $\mu$ s

(1) Test conditions are C1–C4 = 0.1  $\mu$ F at V<sub>CC</sub> = 5 V  $\pm$  0.5 V.

(2) All typical values are at V<sub>CC</sub> = 5 V, and T<sub>A</sub> = 25°C.

(3) Pulse skew is defined as |t<sub>PLH</sub> – t<sub>PHL</sub>| of each channel of the same device.

#### ESD Protection

PIN	TEST CONDITIONS	TYP	UNIT
DOUT, RIN	Human-Body Model (HBM)	$\pm 15$	kV

## RECEIVER SECTION

### Electrical Characteristics<sup>(1)</sup>

over recommended ranges of supply voltage and operating free-air temperature (unless otherwise noted) (see [Figure 4](#))

PARAMETER		TEST CONDITIONS	MIN	TYP <sup>(2)</sup>	MAX	UNIT
V <sub>OH</sub>	High-level output voltage	I <sub>OH</sub> = -1 mA	3.5	V <sub>CC</sub> - 0.4		V
V <sub>OL</sub>	Low-level output voltage	I <sub>OL</sub> = 1.6 mA			0.4	V
V <sub>IT+</sub>	Positive-going input threshold voltage	V <sub>CC</sub> = 5 V, T <sub>A</sub> = 25°C		1.7	2.4	V
V <sub>IT-</sub>	Negative-going input threshold voltage	V <sub>CC</sub> = 5 V, T <sub>A</sub> = 25°C	0.8	1.2		V
V <sub>hys</sub>	Input hysteresis (V <sub>IT+</sub> - V <sub>IT-</sub> )		0.2	0.5	1	V
r <sub>I</sub>	Input resistance	V <sub>I</sub> = $\pm 3$ V to $\pm 25$ V	3	5	7	k $\Omega$

(1) Test conditions are C1–C4 = 0.1  $\mu$ F at V<sub>CC</sub> = 5 V  $\pm$  0.5 V.

(2) All typical values are at V<sub>CC</sub> = 5 V and T<sub>A</sub> = 25°C.

### Switching Characteristics<sup>(1)</sup>

over recommended ranges of supply voltage and operating free-air temperature (unless otherwise noted) (see [Figure 3](#))

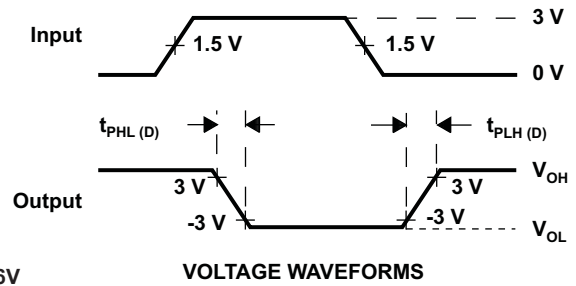
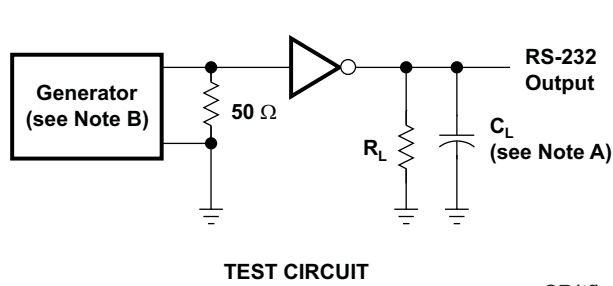
PARAMETER		TEST CONDITIONS	MIN	TYP <sup>(2)</sup>	MAX	UNIT
t <sub>PLH(R)</sub>	Propagation delay time, low- to high-level output	C <sub>L</sub> = 150 pF		0.5	10	$\mu$ s
t <sub>PHL(R)</sub>	Propagation delay time, high- to low-level output	C <sub>L</sub> = 150 pF		0.5	10	$\mu$ s
t <sub>sk(p)</sub>	Pulse skew <sup>(3)</sup>			300		ns

(1) Test conditions are C1–C4 = 0.1  $\mu$ F at V<sub>CC</sub> = 5 V  $\pm$  0.5 V.

(2) All typical values are at V<sub>CC</sub> = 5 V and T<sub>A</sub> = 25°C.

(3) Pulse skew is defined as |t<sub>PLH</sub> - t<sub>PHL</sub>| of each channel of the same device.

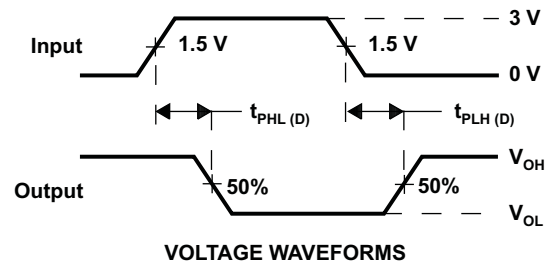
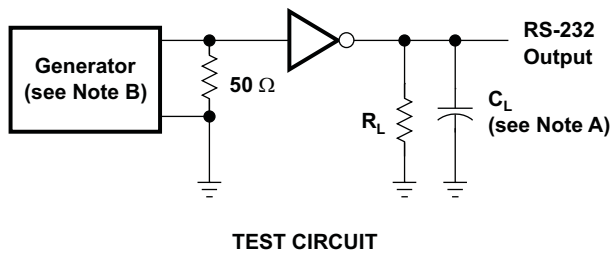
PARAMETER MEASUREMENT INFORMATION



$$SR(tf) = \frac{6V}{t_{PHL(D)} \text{ or } t_{PLH(D)}}$$

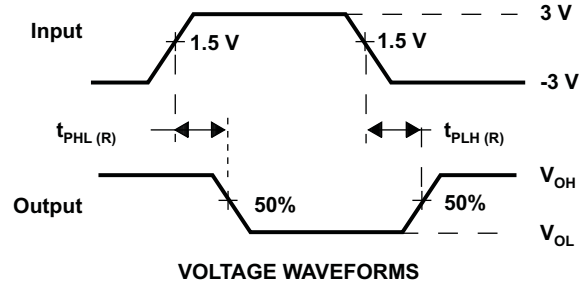
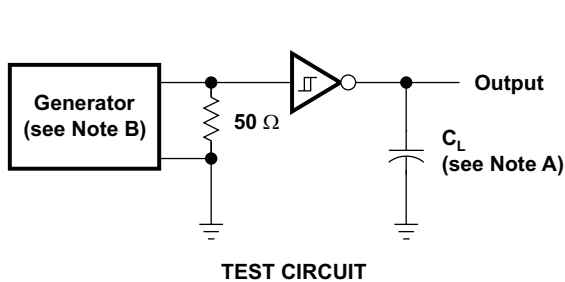
- NOTES: A.  $C_L$  includes probe and jig capacitance.  
B. The pulse generator has the following characteristics: PRR = 120 kbit/s,  $Z_0 = 50 \Omega$ , 50% duty cycle,  $t_r \leq 10 \text{ ns}$ ,  $t_f \leq 10 \text{ ns}$ .

Figure 1. Driver Slew Rate



- NOTES: A.  $C_L$  includes probe and jig capacitance.  
B. The pulse generator has the following characteristics: PRR = 120 kbit/s,  $Z_0 = 50 \Omega$ , 50% duty cycle,  $t_r \leq 10 \text{ ns}$ ,  $t_f \leq 10 \text{ ns}$ .

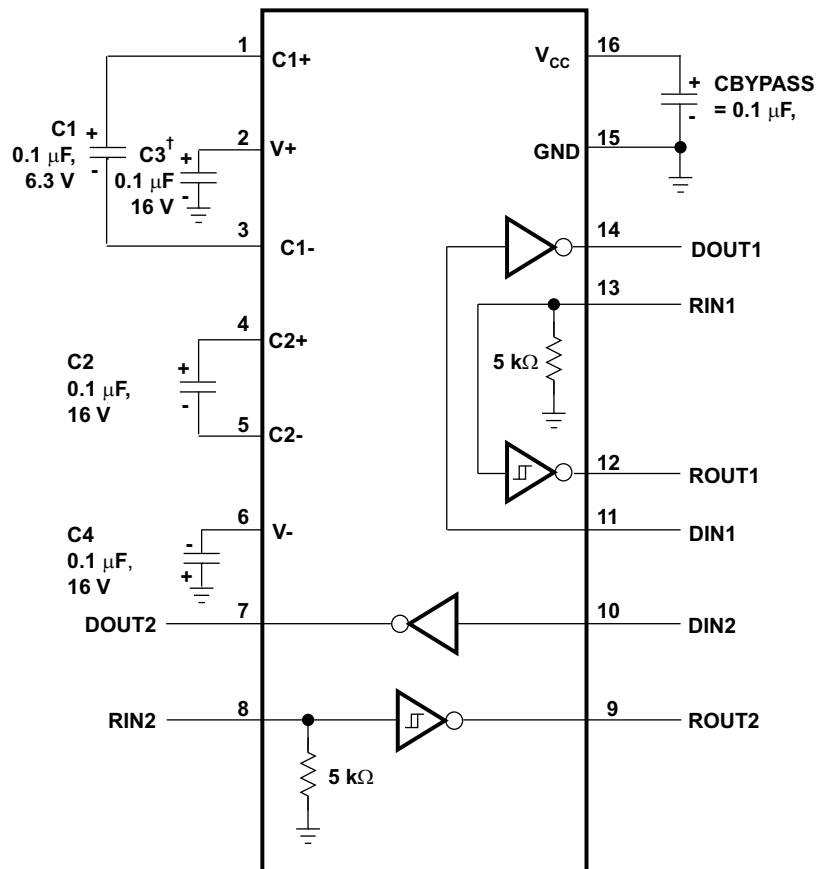
Figure 2. Driver Pulse Skew



- NOTES: A.  $C_L$  includes probe and jig capacitance.  
B. The pulse generator has the following characteristics:  $Z_0 = 50 \Omega$ , 50% duty cycle,  $t_r \leq 10 \text{ ns}$ ,  $t_f \leq 10 \text{ ns}$ .

Figure 3. Receiver Propagation Delay Times

## APPLICATION INFORMATION



† C3 can be connected to  $V_{CC}$  or GND.

NOTES: A. Resistor values shown are nominal.

B. Nonpolarized ceramic capacitors are acceptable. If polarized tantalum or electrolytic capacitors are used, they should be connected as shown.

**Figure 4. Typical Operating Circuit and Capacitor Values**

### Capacitor Selection

The capacitor type used for C1–C4 is not critical for proper operation. The TRS202 requires 0.1- $\mu$ F capacitors, although capacitors up to 10  $\mu$ F can be used without harm. Ceramic dielectrics are suggested for the 0.1- $\mu$ F capacitors. When using the minimum recommended capacitor values, make sure the capacitance value does not degrade excessively as the operating temperature varies. If in doubt, use capacitors with a larger (e.g., 2 $\times$ ) nominal value. The capacitors' effective series resistance (ESR), which usually rises at low temperatures, influences the amount of ripple on V+ and V–.

Use larger capacitors (up to 10  $\mu$ F) to reduce the output impedance at V+ and V–.

Bypass  $V_{CC}$  to ground with at least 0.1  $\mu$ F. In applications sensitive to power-supply noise generated by the charge pumps, decouple  $V_{CC}$  to ground with a capacitor the same size as (or larger than) the charge-pump capacitors (C1–C4).

### Electrostatic Discharge (ESD) Protection

TI TRS202 devices have standard ESD protection structures incorporated on the pins to protect against electrostatic discharges encountered during assembly and handling. In addition, the RS232 bus pins (driver outputs and receiver inputs) of these devices have an extra level of ESD protection. Advanced ESD structures were designed to successfully protect these bus pins against ESD discharge of  $\pm 15$  kV when powered down.

APPLICATION INFORMATION (continued)

ESD Test Conditions

Stringent ESD testing is performed by TI, based on various conditions and procedures. Please contact TI for a reliability report that documents test setup, methodology, and results.

Human-Body Model (HBM)

The HBM of ESD testing is shown in Figure 5. Figure 6 shows the current waveform that is generated during a discharge into a low impedance. The model consists of a 100-pF capacitor, charged to the ESD voltage of concern, and subsequently discharged into the device under test (DUT) through a 1.5-k $\Omega$  resistor.

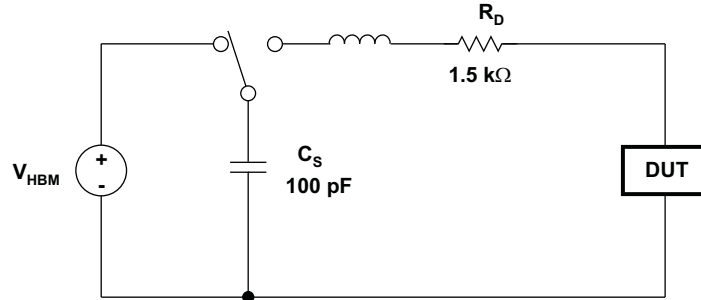


Figure 5. HBM ESD Test Circuit

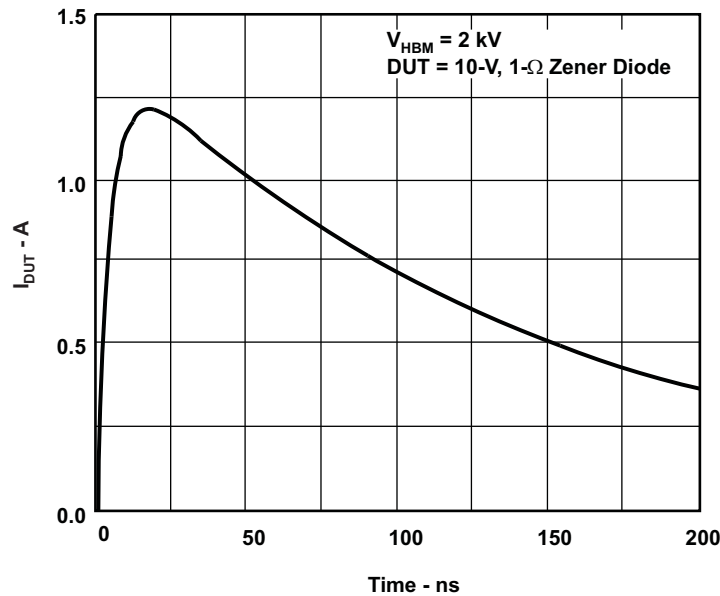


Figure 6. Typical HBM Current Waveform

Machine Model (MM)

The MM ESD test applies to all pins using a 200-pF capacitor with no discharge resistance. The purpose of the MM test is to simulate possible ESD conditions that can occur during the handling and assembly processes of manufacturing. In this case, ESD protection is required for all pins, not just RS-232 pins. However, after PC board assembly, the MM test no longer is as pertinent to the RS-232 pins.

**PACKAGING INFORMATION**

Orderable Device	Status <sup>(1)</sup>	Package Type	Package Drawing	Pins	Package Qty	Eco Plan <sup>(2)</sup>	Lead/Ball Finish	MSL Peak Temp <sup>(3)</sup>	Samples (Requires Login)
TRS202CD	ACTIVE	SOIC	D	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDG4	ACTIVE	SOIC	D	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDR	ACTIVE	SOIC	D	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDRG4	ACTIVE	SOIC	D	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDW	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDWG4	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDWR	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CDWRG4	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CPW	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CPWG4	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CPWR	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202CPWRG4	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202ID	ACTIVE	SOIC	D	16	40	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	Contact TI Distributor or Sales Office
TRS202IDG4	ACTIVE	SOIC	D	16	40	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	Contact TI Distributor or Sales Office
TRS202IDR	ACTIVE	SOIC	D	16	2500	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	<a href="#">Request Free Samples</a>
TRS202IDRG4	ACTIVE	SOIC	D	16	2500	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	<a href="#">Request Free Samples</a>
TRS202IDW	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IDWG4	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IDWR	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IDWRG4	ACTIVE	SOIC	DW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IPW	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IPWG4	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IPWR	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>
TRS202IPWRG4	ACTIVE	TSSOP	PW	16		TBD	Call TI	Call TI	<a href="#">Purchase Samples</a>

<sup>(1)</sup> The marketing status values are defined as follows:

**ACTIVE:** Product device recommended for new designs.

**LIFEBUY:** TI has announced that the device will be discontinued, and a lifetime-buy period is in effect.

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**NRND:** Not recommended for new designs. Device is in production to support existing customers, but TI does not recommend using this part in a new design.

**PREVIEW:** Device has been announced but is not in production. Samples may or may not be available.

**OBSOLETE:** TI has discontinued the production of the device.

<sup>(2)</sup> Eco Plan - The planned eco-friendly classification: Pb-Free (RoHS), Pb-Free (RoHS Exempt), or Green (RoHS & no Sb/Br) - please check <http://www.ti.com/productcontent> for the latest availability information and additional product content details.

**TBD:** The Pb-Free/Green conversion plan has not been defined.

**Pb-Free (RoHS):** TI's terms "Lead-Free" or "Pb-Free" mean semiconductor products that are compatible with the current RoHS requirements for all 6 substances, including the requirement that lead not exceed 0.1% by weight in homogeneous materials. Where designed to be soldered at high temperatures, TI Pb-Free products are suitable for use in specified lead-free processes.

**Pb-Free (RoHS Exempt):** This component has a RoHS exemption for either 1) lead-based flip-chip solder bumps used between the die and package, or 2) lead-based die adhesive used between the die and leadframe. The component is otherwise considered Pb-Free (RoHS compatible) as defined above.

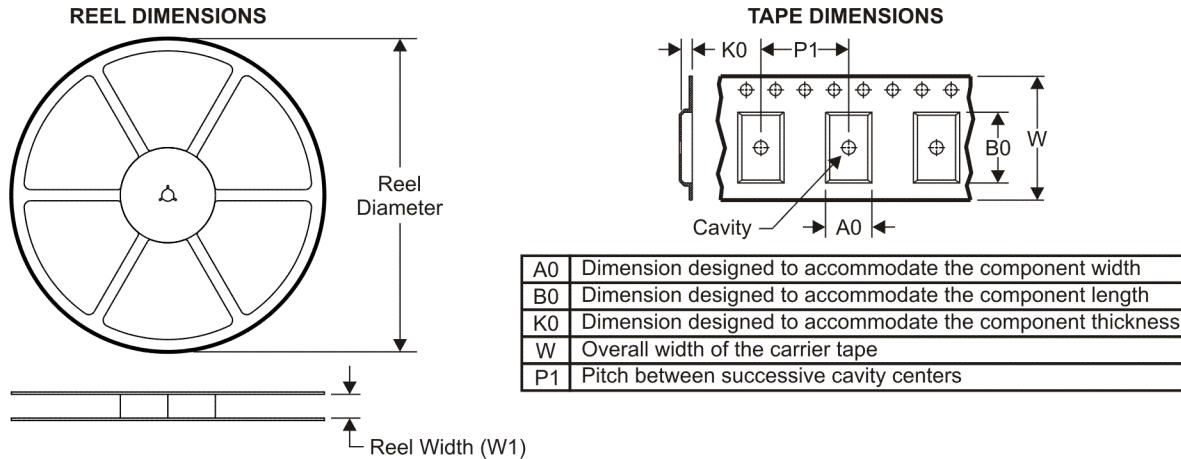
**Green (RoHS & no Sb/Br):** TI defines "Green" to mean Pb-Free (RoHS compatible), and free of Bromine (Br) and Antimony (Sb) based flame retardants (Br or Sb do not exceed 0.1% by weight in homogeneous material)

<sup>(3)</sup> MSL, Peak Temp. -- The Moisture Sensitivity Level rating according to the JEDEC industry standard classifications, and peak solder temperature.

**Important Information and Disclaimer:** The information provided on this page represents TI's knowledge and belief as of the date that it is provided. TI bases its knowledge and belief on information provided by third parties, and makes no representation or warranty as to the accuracy of such information. Efforts are underway to better integrate information from third parties. TI has taken and continues to take reasonable steps to provide representative and accurate information but may not have conducted destructive testing or chemical analysis on incoming materials and chemicals. TI and TI suppliers consider certain information to be proprietary, and thus CAS numbers and other limited information may not be available for release.

In no event shall TI's liability arising out of such information exceed the total purchase price of the TI part(s) at issue in this document sold by TI to Customer on an annual basis.

## TAPE AND REEL INFORMATION



### QUADRANT ASSIGNMENTS FOR PIN 1 ORIENTATION IN TAPE



\*All dimensions are nominal

Device	Package Type	Package Drawing	Pins	SPQ	Reel Diameter (mm)	Reel Width W1 (mm)	A0 (mm)	B0 (mm)	K0 (mm)	P1 (mm)	W (mm)	Pin1 Quadrant
TRS202IDR	SOIC	D	16	2500	330.0	16.4	6.5	10.3	2.1	8.0	16.0	Q1

TAPE AND REEL BOX DIMENSIONS

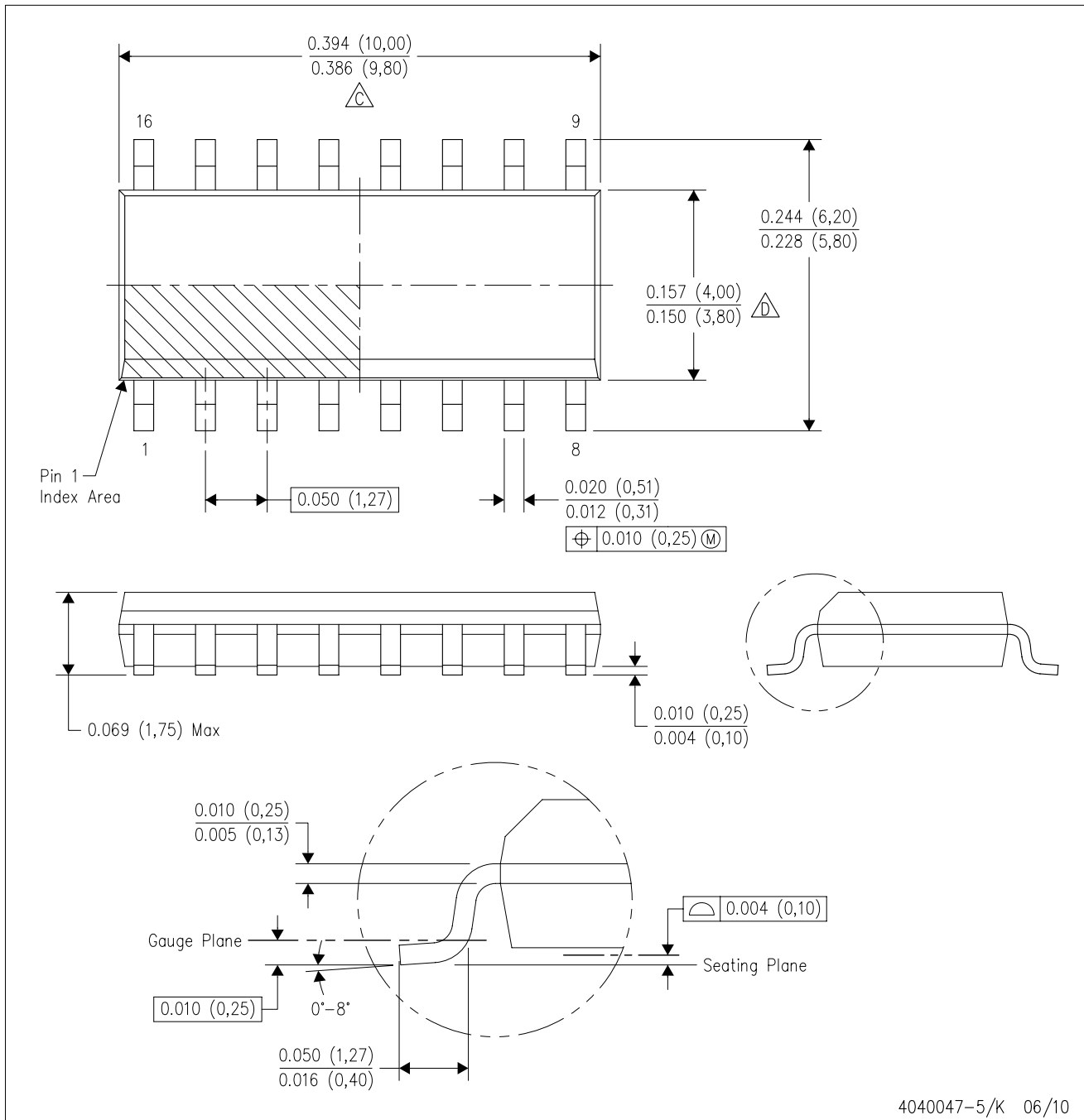


\*All dimensions are nominal

Device	Package Type	Package Drawing	Pins	SPQ	Length (mm)	Width (mm)	Height (mm)
TRS202IDR	SOIC	D	16	2500	333.2	345.9	28.6

D (R-PDSO-G16)

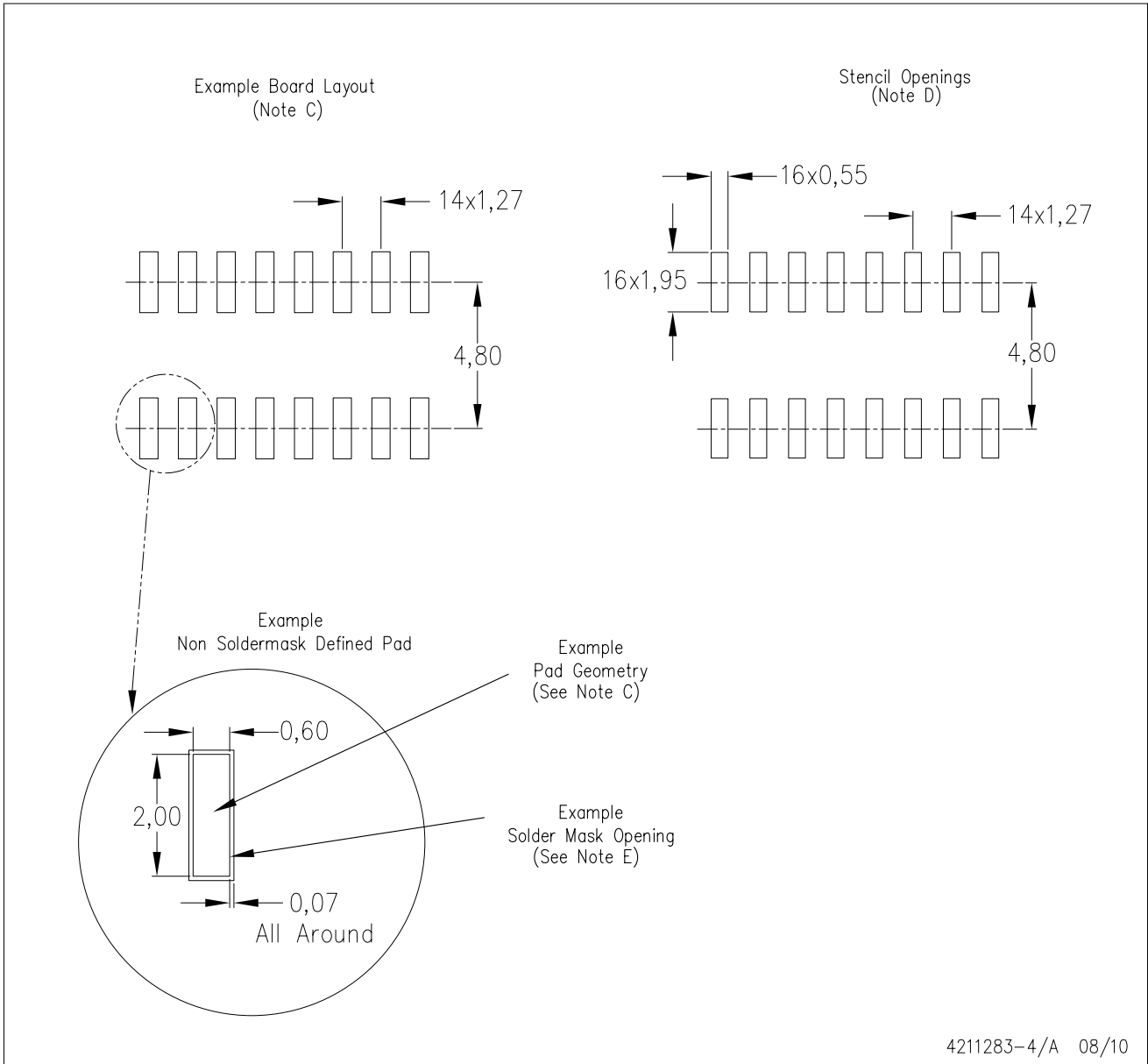
PLASTIC SMALL-OUTLINE PACKAGE



- NOTES:
- A. All linear dimensions are in inches (millimeters).
  - B. This drawing is subject to change without notice.
  - C. Body length does not include mold flash, protrusions, or gate burrs. Mold flash, protrusions, or gate burrs shall not exceed .006 (0,15) per end.
  - D. Body width does not include interlead flash. Interlead flash shall not exceed .017 (0,43) per side.
  - E. Reference JEDEC MS-012 variation AC.

D (R-PDSO-G16)

PLASTIC SMALL OUTLINE



- NOTES:
- A. All linear dimensions are in millimeters.
  - B. This drawing is subject to change without notice.
  - C. Publication IPC-7351 is recommended for alternate designs.
  - D. Laser cutting apertures with trapezoidal walls and also rounding corners will offer better paste release. Customers should contact their board assembly site for stencil design recommendations. Refer to IPC-7525 for other stencil recommendations.
  - E. Customers should contact their board fabrication site for solder mask tolerances between and around signal pads.

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