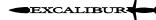
-48V PT4701_



35-W Quad-Output **DC/DC Converter for DSL**



Description

The PT4701 Excalibur[™] power module is a 35-watt quad-output DC/DC converter that is designed to meet the power requirements of Texas Instruments' TNETD7112. The TNETD7112 is a dual-channel line-interface driver/receiver that compliments the AC6 ADSL chipset for use in POTS (plain old telephone service) applications. To conserve power, the TNETD7112 line drivers require two pairs of complimentary power supply voltages. These are ±8 V and ±3.75 V respectively.

The PT4701 module operates from a standard (-48 V) telecom central office supply and provides all four supply voltages as two com-

Features

- Input Voltage: 36 V to 75 V
- Designed for AC6 ADSL Line-Interface Driver/Receivers
- Powers up to 32 Channels
- Quad Outputs (±8 V, ±3.75 V)
- Dual Logic On/Off Control
- Output Current Limit

plimentary balanced loads. (This

product is not suitable for unbalanced

load applications.) The load capacity

allows the PT4701 to operate up to

16 line-driver ICs, representing 32

features to simplify system integra-

tion. These include a flexible On/Off

enable control, input under-voltage

lock-out, and over-temperature pro-

tection. All outputs are short-circuit

protected, and internally sequenced

to meet the TNETD7112 power-up

The module is packaged in a

space-saving solderable copper case,

requires no heat sink, and can occupy as little as 1.2 in² of PCB area.

and power-down requirements.

The PT4701 incorporates many

ADSL channels.

- Unbalanced Load Protection
- Fixed Frequency Operation
- Over-Temperature Shutdown

- Under-Voltage Lockout
- 1500 VDC Isolation
- Space-Saving Solderable Case 1.2 sq. in. PCB Area (suffix N)
- Surface Mountable
- IPC Lead Free 2
- Safety Approvals: (Pending) UL60950 CSA 22.2 950

Ordering Information

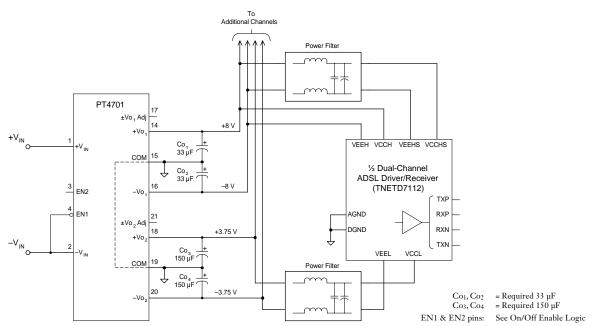
PT4701 = ±8.0/±3.75 V

PT Series Suffix (PT1234x)

Case/Pin Configuration	Order Suffix	Package Code
Vertical	N	(ENM)
Horizontal	Α	(ENN)
SMD	С	(ENP)
(D. C	1 1 1.	1

(Reference the applicable package code drawing for the dimensions and PC layout)







35-W Quad-Output DC/DC Converter for DSL

Environmental Specifications

Characteristics	Symbols	Conditions	Min	Тур	Max	Units
Operating Temperature Range	Ta	Over Vin Range	-40	_	85 (i)	°C
Solder Reflow Temperature	Treflow	Surface temperature of module pins or case	_	_	215 (ii)	°C
Storage Temperature	Ts	—	-40	_	125	°C
Mechanical Shock		Per Mil-STD-883D, Method 2002.3 1 msec, ½ Sine, mounted	_	500	—	G's
Mechanical Vibration		Mil-STD-883D, Method 2007.2 Suffix A 20-2000 Hz Suffix N, C	_	15 (iii) 20 (iii)	_	G's
Weight	_	Vertical/Horizontal	_	50	_	grams
ShutdownTemperature	OTP			115	125	°C
Flammability	_	Meets UL 94V-O				

Notes: (i) See SOA curves or consult factory for appropriate derating.

(ii) During solder reflow of SMD package version, do not elevate the module case, pins, or internal component temperatures above a peak of 215 °C. For further guidance refer to the application note, "Reflow Soldering Requirements for Plug-in Power Surface Mount Products," (SLTA051).
(iii) Only the case pins on through-hole pin configurations (N & A) must be soldered. For more information see the applicable package outline drawing.

Pin Configuration

Pin Function	Pin Function	Pin Function
1 +Vin	8 Pin Not Present	15 COM
2 –Vin	9 Pin Not Present	16 –Vo ₁
3 EN 2	10 Pin Not Present	17 ±Vo ₁ Adjust
4 EN 1	11 Pin Not Present	18 +Vo ₂
5 Do Not Connect	12 Pin Not Present	19 COM
6 Do Not Connect	13 Pin Not Present	20 –Vo ₂
7 Do Not Connect	14 +Vo ₁	21 ±Vo ₂ Adjust

Note: Shaded functions indicates those pins that are at primary-side potential. All other pins are referenced to the secondary.

On/Off Enable Logic

Pin 3	Pin 4	Output Status
×	1	Off
1	0	On
0	×	Off

Notes:

Logic 1 =Open collector Logic 0 = -Vin (pin 2) potential For positive Enable function, connect pin 4 to pin 2 and use pin 3.

For negative Enable function, leave pin 3 open and use pin 4.

Pin Descriptions

+Vin: The positive input supply for the module with respect to $-V_{in}$. When powering the module from a -48V telecom central office supply, this input is connected to the primary system ground.

-Vin: The negative input supply for the module, and the 0VDC reference for the EN 1, and EN 2 inputs. When powering the module from a +48-V supply, this input is connected to the 48-V(Return).

EN 1: The negative logic input that activates the module output. This pin must be connected to $-V_{in}$ to enable the module's outputs. A high impedance disables the module's outputs.

EN 2: The positive logic input that activates the module output. If not used, this pin should be left open circuit. Connecting this input to $-V_{in}$ disables the module's outputs.

+Vo 1: This is the positive high-output voltage. It is the balanced compliment of (–Vo₁) and referenced to the secondary COM node.

-Vo 1: The negative high-output voltage, which is the balanced compliment of (+Vo₁) with respect to COM.

+Vo 2: This is the positive low-output voltage. It is the balanced complement of (-Vo₂) and referenced to the secondary COM node.

-Vo 2: The negative low-output voltage, which is the balanced compliment of (+Vo₂) with respect to COM.

COM: This is the common node and the secondary reference for all four regulated output voltages. It provides a return for any unbalanced load current, and is DC isolated from the input supply pins.

\pmVo₁ Adjust: Using a single resistor, this pin allows the simultaneous adjustment of both +Vo₁ and -Vo₁ magnitude with respect to the COM node. Adjustment can be higher or lower than the preset value. If not used this pin should be left open circuit.

\pmVo₂ Adjust: Using a single resistor, this pin allows the simultaneous adjustment of both +Vo₂ and -Vo₂ magnitudes with respect to the COM node. Adjustment can be higher or lower than the preset value. If not used this pin should be left open circuit.

35-W Quad-Output **DC/DC Converter for DSL**

					PT4701		
Characteristics	Symbols	Conditions		Min	Тур	Max	Units
Output Current	Io ₁ , Io ₂	Balanced load	$\pm Vo_1 (8.0 V) \\ \pm Vo_2 (3.75 V)$	0 0	_	1.25 (1) 1.75 (1)	А
		Load imbalance	±Vo ₁ ±Vo ₂	_	_	±100 (2) ±100 (2)	mA
		Transient imbalance (<1 ms)	±Vo ₁ ±Vo ₂	_	_	±150 ±150	mA
Input Voltage Range	Vin	Continuous Surge (1 minute)		36	_	75 80	V
Set-Point Voltage	Vo_1, Vo_2	Either output to COM	±Vo ₁ ±Vo ₂	7.76 3.82	8.0 3.94	8.24 4.06 ⁽³⁾	V
Temperature Variation	Reg _{temp}	-40 °C ≤T _a ≤+85 °C, I _o =I _o min	±Vo ₁ ±Vo ₂	_	±0.5 ±0.5	_	$%V_{o}$
Line Regulation	Regline	All outputs, Over Vin range			±0.05	±0.25	%Vo
Load Regulation	Regload	All outputs, 0≤I₀≤I₀max			±0.2	±0.5	$%V_{o}$
Total Output Voltage Variation	ΔV_0 tot	Includes set-point, line, load, $\pm Vo_1 (8.0 \text{ V})$ -40 °C ≤T _a ≤+85 °C $\pm Vo_2 (3.75 \text{ V})$		7.6 3.75	_	8.4 4.13 ⁽³⁾	V
Efficiency	η			_	85	_	%
V _o Ripple (pk-pk)	V_n	Measured from each output to COM, ±Vo ₁ 0 to 20 MHz bandwidth ±Vo ₂		_	10 5	_	$\mathrm{mV}_{\mathrm{pp}}$
Transient Response	${f v}_{os}^{t_{tr}}$	0.1 A/µs load step, 50 % to 75 % I₀max V₀ over/undershoot		_	100 2	_	μSec %Vo
Output Adjust Range	Vo _x adj	Each $\pm V_0$ adjusted as pair		_	±10	_	%Vo
Balanced Load Current Limit Threshold	Io _{LIM}	Shutdown, auto restart ±Vo ₁ ±Vo ₂		_	$\begin{array}{ccc} 1.5 & (1) \\ 2.5 & (1) \end{array}$	_	А
Unbalanced Load Shutdown Threshold	I _o com _{sc}	Shutdown & latch off (within 1 ms)		—	200 (2)	—	mA
Switching Frequency	f_{s}	Over V _{in} and I _o ranges		550	600	650	kHz
Under Voltage Lockout	V _{on} V _{off}	V _{in} increasing V _{in} decreasing		_	34 32	_	V
Enable Control (pins 3 & 4) High-Level Input Voltage Low-Level Input Voltage	V_{IH} V_{IL}	Referenced to -V _{in} (pin 2)		4 0.2		Open (4) 0.8 (4)	V
Low-Level Input Current	I _{IL}	Pin connected to -Vin (pin 2)		_	-0.16	-0.27	mA
Standby Input Current	I _{in} standby	pins 3 & 4 open circuit		_	5	20	mA
Internal Input Capacitance	Cint			_	1	_	μF
External Output Capacitance	C _o	Each output to COM	±Vo ₁ ±Vo ₂	33 150	_	1,000 ⁽⁵⁾ 1,000 ⁽⁵⁾	μF
Primary/Secondary Isolation	V iso C iso R iso			$\frac{150}{10}$	2,200		V pF MΩ

PT4701 Electrical Specifications (Unless otherwise stated, the operating conditions are:- $T_a = 25$ °C, $V_{in} = 48$ V, and $I_o = I_o max$)

Notes: (1) A balanced load is defined as the current flowing out of (+Vox) being to equal that flowing into (-Vox). The current flowing in the COM termnal is zero.

(1) A balanced load is defined as the current flowing out of (+Vo_x) being to equal that flowing into (-Vo_x). The current flowing in the COM terminal is zero.
(2) The load imbalance is the difference between the current flowing out of (+Vo_x) and flowing into (-Vo_x). The difference flows in the COM terminal.
(3) The nominal output voltage of ±Vo₂ is 3.94 V. The output voltage and tolerance is defined as 3.75 V, -0%, +10%.
(4) The Enable inputs (pins 3 & 4) have internal pull-ups. Leaving pin 3 open-circuit and connecting pin 4 to -V_{in} allows the the converter to operate when input power is applied. The maximum open-circuit voltage (±Vo_x) must be divided equally between (+Vo_x) and (-Vo_x) with respect to the COM terminal. E.g. Co₁ must equal Co₃ must equal Co₄.

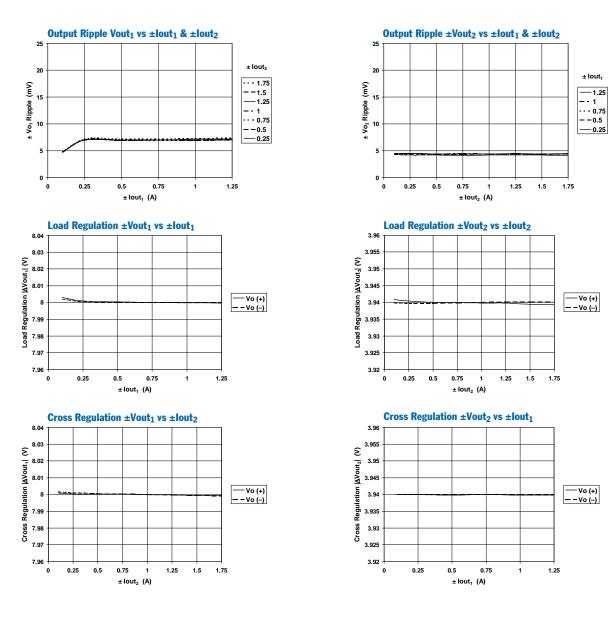


PT4701-48V

Typical Characteristics

35-W Quad-Output DC/DC Converter for DSL

SLTS182A - FEBRUARY 2003 - REVISED APRIL 2003



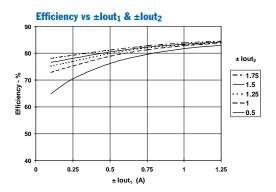
Performance Characteristics; V_{in} =48 V (See Note A)

Note A: All Characteristic data in the above graphs has been developed from actual products tested at 25°C. This data is considered typical data for the ISR.

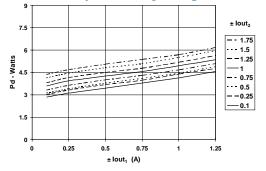


PT4701-48V

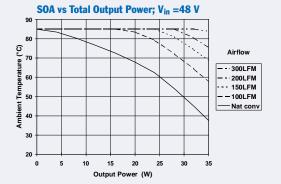
Performance Characteristics; V_{in} =48 V (See Note A)



Power Dissipation vs ±lout₁ & ±lout₂



PT4701 Safe Operating Area (SOA)(See Note B)(All outputs proportionally loaded from 0 to 100 % of full load)



Note A: All Characteristic data in the above graphs has been developed from actual products tested at 25°C. This data is considered typical data for the ISR. **Note B:** SOA curves represent operating conditions at which the internal components are at or below the manufacturer's maximum rated operating temperatures.



PT4701

Operating Features of the PT4701 Quad-Output DC/DC Converter for DSL Line Drivers

Balanced Load Fault Protection

A balanced load fault is the result of excess current flowing from one $+V_0$ output directly to the corresponding $-V_0$ output. The current flowing in or out of the COM node (pins 15 & 19) under this condition is within normal operating limits. Both (±)dual outputs from the PT4701 DC/DC converter incorporate protection against this type of load fault. This includes an absolute current limit in combination with a fault timeout period. When the balanced fault current from either ±dual output exceeds the "Balanced Load Current Limit Threshold" (see data sheet specifications), the converter initially limits the fault current to approximately 150 % of the maximum output current rating. If the fault persists for more than 20 ms the converter shuts down, forcing the voltage at all four regulated outputs to simultaneously fall to zero. Following shutdown the converter will periodically attempt to recover by executing a soft-start power-up. The converter will continually cycle through successive over-current shutdowns and restarts until the fault is removed.

Imbalanced Load Fault Protection

An imbalanced load fault is the result of excess current flowing between any one of the $+V_o$ (or the $-V_o$) outputs, and the COM node (pins 15 & 19). When the current sensed in the COM node exceeds the "Unbalanced Load Shutdown Threshold" (see data sheet specifications), the PT4701 shuts down and latches off within 1ms. Once latched off, the module must be reset by momentarily interrupting the input power source.

Over-Temperature Protection

The PT4701 DC/DC converter has an internal temperature sensor, which monitors the temperature of the module's internal components. If the sensed temperature exceeds a nominal 115 °C, the converter will shut down. The converter will automatically restart when the sensed temperature returns to about 100 °C.

Under-Voltage Lock-Out

The Under-Voltage Lock-Out (UVLO) circuit prevents operation of the converter whenever the input voltage to the module is insufficient to maintain output regulation. The UVLO has approximately 2 V of hysterisis. This is to prevent oscillation with a slowly changing input voltage. Below the UVLO threshold the module is off and the enable control inputs, EN1 and EN2 are inoperative.

Primary-Secondary Isolation

The PT4701 DC/DC converter incorporates electrical isolation between the input terminals (primary) and the output terminals (secondary). All converters are production tested to a withstand voltage of 1500 VDC. The isolation complies with UL60950 and EN60950, and the requirements for operational isolation. This allows the converter to be configured for either a positive or negative input voltage source.

The regulation control circuitry for these modules is located on the secondary (output) side of the isolation barrier. Control signals are passed between the primary and secondary sides of the converter. The data sheet 'Pin Descriptions' and 'Pin-Out Information' provides guidance as to which reference (primary or secondary) that must be used for each of the external control signals.

Input Current Limiting

The converter is not internally fused. For safety and overall system protection, the maximum input current to the converter must be limited. Active or passive current limiting can be used. Passive current limiting can be a fast acting fuse. A 125-V fuse, rated no more than 5 A, is recommended. Active current limiting can be implemented with a current limited "Hot-Swap" controller.

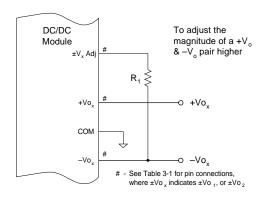
PT4701

Adjusting the Output Voltages of the PT4701 Quad-Output DC/DC Converters

The PT4701 quad-output DC/DC converter produces two pairs of balanced $\pm V_0$ complimentary output voltages. The magnitude of each balanced pair of outputs may be adjusted higher or lower by up to ± 10 %. The adjustment method uses a single external resistor ¹, which adjusts the magnitude of the respective $\pm V_0$ and $-V_0$ simultaneously. The value of the resistor determines the magnitude of adjustment, and the placement of the resistor determines the direction of adjustment (increase or decrease). The resistor values can be calculated using the appropriate formula (see below). The formula constants are provided in Table 3-2. Alternatively the resistor value may be selected directly from Table 3-3 and Table 3-4, for $\pm V_{01}$ and $\pm V_{02}$ respectively. The placement of each resistor is as follows.

Adjust Up: To increase the magnitude of the complimentary output voltages, add a resistor R₁ between the appropriate $\pm Vo_x Adj$ (' $\pm Vo_1 Adj$ ' or ' $\pm Vo_2 Adj$ ') and the $-Vo_x$ voltage rail. See Figure 3-1(a) and Table 3-1 for the resistor placement and pin connections.

Figure 3-1a



Notes:

- 1. Use only a single 1 % (or better) tolerance resistor in either the R_1 or (R_2) location to adjust a specific output. Place the resistor as close to the ISR as possible.
- 2. Never connect capacitors to any of the 'Vo_x Adj' pins. Any capacitance added to these control pins will affect the stability of the respective regulated output.

Adjust Down: To decrease the magnitude of the complimentary output voltages, add a resistor (\mathbb{R}_2), between the appropriate $V_{0x} Adj$ (Vo₁ Adj or Vo₂ Adj,) and the + V_{0x} voltage rail. See Figure 3-1(b) and Table 3-1 for the resistor placement and pin connections.



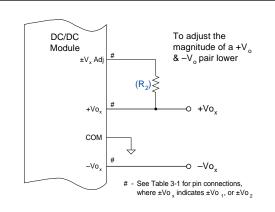


Table 3-1; Adjust Resistor Pin Connections

	To Adjust Up Connect R ₁		To Adjus Connec	
	from	to	from	to
	±Vo _x Adj	–Vo _x	±Vo _x Adj	+Vo _x
±Vo1	17	16	17	14
±Vo ₂	21	20	21	18

Calculation of Resistor Adjust Values

The adjust resistor value may also be calculated using an equation. Note that the equation for R_1 [Adjust Up] is different to that for (R_2) [Adjust Down].

$$R_1 [Adjust Up] = \frac{V_r R_o}{2 (V_a - V_o)} - R_s k\Omega$$

(R₂) [Adjust Down] =
$$\frac{R_o (2 V_a - V_r)}{2 (V_o - V_a)} - R_s k\Omega$$

Where: V_0 = Original output voltage ($\pm Vo_x$)

- V_a = Adjusted output voltage (±Va_x)
- V_r = The reference voltage from Table 3-2
- R_o = The resistance value in Table 3-2
- R_s = The series resistance from Table 3-2



PT4701

Table 3-2

Table J-2				
ADJUSTMENT RANGE AND FORMULA PARAMETERS				
	±Vo1 Bus	±Vo ₂ Bus		
V _o (nom)	$8.0\mathrm{V}$	3.94 V		
V _a (min)	7.2 V	3.55 V		
V _a (max)	$8.8\mathrm{V}$	4.33 V		
Vr	2.5 V	$1.24\mathrm{V}$		
R_o (k Ω)	14.3	13.0		
R _s (kΩ)	20.0	16.2		

	RESISTOR VALU	
dj. Resistor		R ₁ /(R ₂)
6 Adjust	$\pm V_a$ (req'd)	
-10 %	$7.20\mathrm{V}$	(86.4) kΩ
- 9%	$7.28\mathrm{V}$	(99.8) kΩ
- 8 %	7.36 V	(117.0) kΩ
- 7 %	$7.44\mathrm{V}$	(138.0) kΩ
- 6 %	7.52 V	(167.0) kΩ
- 5 %	$7.60\mathrm{V}$	(207.0) kΩ
- 4 %	$7.68\mathrm{V}$	(267.0) kΩ
- 3 %	$7.76\mathrm{V}$	(368.0) kΩ
- 2 %	$7.84\mathrm{V}$	(569.0) kΩ
- 1 %	7.92 V	(1.17) MΩ
0 %	$8.00\mathrm{V}$	
+ 1 %	$8.08\mathrm{V}$	203.0 kΩ
+ 2 %	$8.16\mathrm{V}$	91.7 kΩ
+ 3 %	8.24 V	54.5 kΩ
+ 4%	8.32 V	35.9 kΩ
+ 5 %	$8.40\mathrm{V}$	24.7 kΩ
+ 6%	$8.48\mathrm{V}$	17.2 kΩ
+ 7%	$8.56\mathrm{V}$	11.9 kΩ
+ 8%	8.64 V	7.9 kΩ
+9%	$8.72\mathrm{V}$	4.8 kΩ
+10 %	$8.80\mathrm{V}$	2.3 kΩ

ADJUSTINIENT	RESISTOR VALUES FOR \
Adj. Resistor	R ₁ /(R ₂)
±V _a (req'd)	
$3.546\mathrm{V}$	(80.3) kΩ
3.585 V	(92.5) kΩ
3.625 V	(108.0) k Ω
$3.664\mathrm{V}$	(127.0) kΩ
$3.704\mathrm{V}$	(153.0) kΩ
3.743 V	(190.0) k Ω
$3.782\mathrm{V}$	(245.0) kΩ
3.822 V	(336.0) kΩ
$3.861\mathrm{V}$	(519.0) kΩ
$3.900\mathrm{V}$	(1.07)MΩ
3.940 V	
$3.979\mathrm{V}$	$188.0 \text{ k}\Omega$
$4.019\mathrm{V}$	86.1 kΩ
$4.058\mathrm{V}$	52.0 kΩ
$4.098\mathrm{V}$	34.9 kΩ
$4.137\mathrm{V}$	24.7 kΩ
$4.176\mathrm{V}$	17.9 kΩ
4.216 V	13.0 kΩ
4.255 V	9.4 kΩ
4.295 V	6.5 kΩ
4.334 V	4.3 kΩ
$R_1 = Black,$	$R_2 = (Blue)$

V Texas Instruments

Using the On/Off Enable Controls on the PT4701 Quad-Output DC/DC Converter

The PT4701 is a quad-output DC/DC converter that is specifically designed for powering DSL line driver ICs. The converter incorporates two output enable controls. EN1 (pin 4) is the *Negative Enable* input, and EN2 (pin 3) is the *Positive Enable* input. Both inputs are electrically referenced to $-V_{in}$ (pin 2) on the primary or input side of the converter. A pull-up resistor is not required, but may be added if desired. Voltages of up to 70 V can be safely applied to the either of the *Enable* pins.

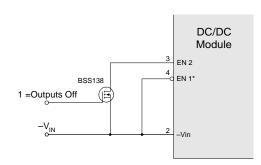
Automatic (UVLO) Power-Up

Connecting EN1 (pin 4) to $-V_{in}$ (pin 2) and leaving EN2 (pin 3) open-circuit configures the converter for automatic power up. (See data sheet "Typical Application"). The converter control circuitry incorporates an "Under Voltage Lockout" (UVLO) function, which disables the converter until the minimum specified input voltage is present at $\pm V_{in}$. (See data sheet Specifications). The UVLO circuitry ensures a clean transition during power-up and power-down, allowing the converter to tolerate a slow-rising input voltage. For most applications EN1 and EN2, can be configured for automatic power-up.

Positive Output Enable (Negative Inhibit)

To configure the converter for a positive enable function, connect EN1 (pin 4) to $-V_{in}$ (pin 2), and apply the system On/Off control signal to EN2 (pin 3). In this configuration, a low-level input voltage ($-V_{in}$ potential) applied to pin 3 disables the converter outputs. Figure 1 is an example of this configuration.



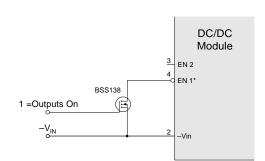


Negative Output Enable (Positive Inhibit)

To configure the converter for a negative enable function, EN2 (pin 3) is left open circuit, and the system On/Off control signal is applied to EN1 (pin 4). A low-level input voltage (- V_{in} potential) must then be applied to

pin 4 in order to enable the outputs of the converter. An example of this configuration is detailed in Figure 2. <u>Note</u>: The converter will only produce and output voltage if a valid input voltage is applied to $\pm V_{in}$.

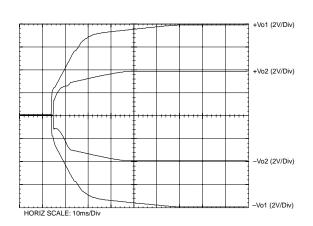
Figure 2; Negative Enable Configuration



On/Off Output Voltage Sequencing

The PT4701 converter power-up characteristics meet the requirements of Texas Instruments' TNETD7112 dual-channel line-interface driver/receiver ICs. All four outputs from the converter are internally sequenced to power up in unison. Figure 3 shows the waveforms from a PT4701 following the application of power. There is a delay of appoximately 25 ms from the application power to the point that the output voltages begin to rise. The converter typically produces a fully regulated output within 75 ms. The waveforms of Figure 3 were measured with loads of approximately 50% on each output, with an input source of 48 VDC.

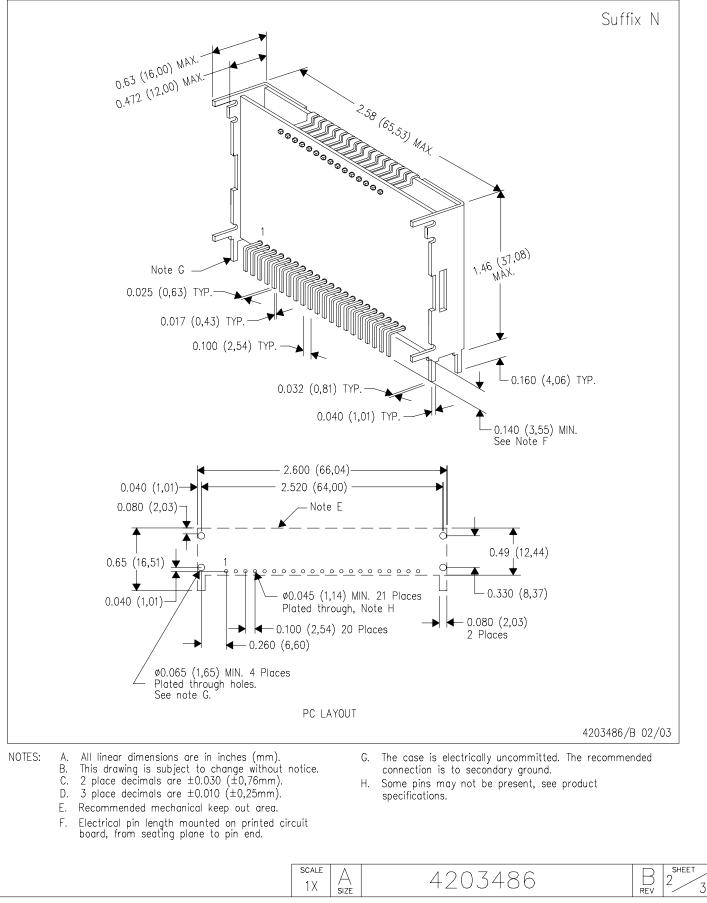
Figure 3; PT4701 Power-up Sequence





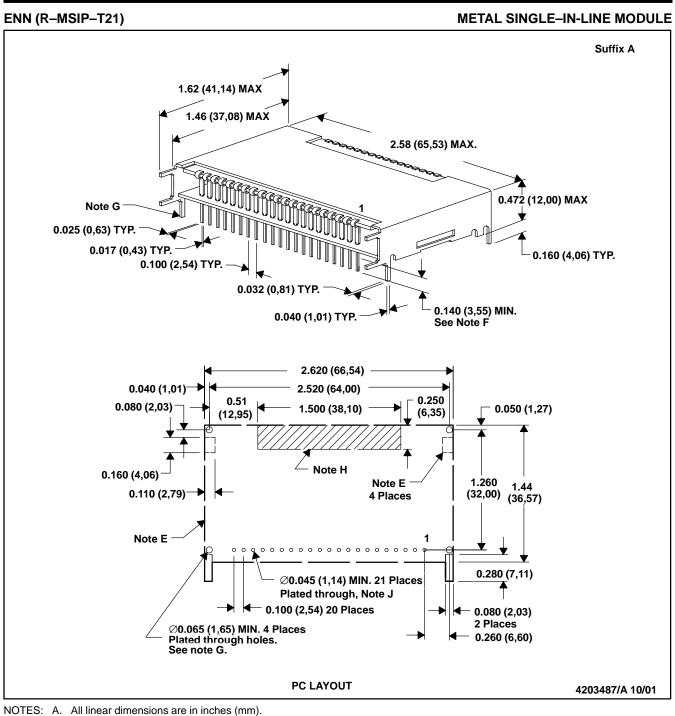
ENM (R-MSIP-T21)

METAL SINGLE-IN-LINE MODULE MMSI070A - OCTOBER 2001 - REVISED - FEBRUARY 2003



MECHANICAL DATA

MMSI071 - OCTOBER 2001

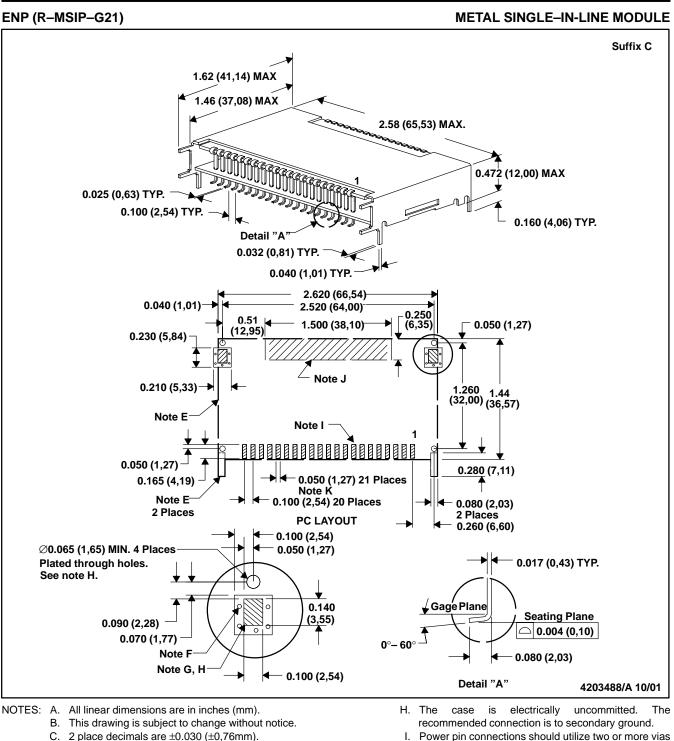


- B. This drawing is subject to change without notice.
- C. 2 place decimals are $\pm 0.030 (\pm 0.76 \text{ mm})$.
- D. 3 place decimals are $\pm 0.010 (\pm 0.25 \text{ mm})$.
- E. Recommended mechanical keep out area.
- F. Electrical pin length mounted on printed circuit board, from seating plane to pin end.
- G. The case is electrically uncommitted. The recommended connection is to secondary ground.
- H. No copper, power or signal traces in this area.
- J. Some pins may not be present, see product specifications.



MECHANICAL DATA

MMSI072 - OCTOBER 2001



- I. Power pin connections should utilize two or more vias per input, ground and output pin.
- J. No copper, power or signal traces in this area.
- K. Some pins may not be present, see product specifications.

D. 3 place decimals are $\pm 0.010 (\pm 0.25 \text{ mm})$.

to mechanical pins.

E. Recommended mechanical keep out area.

F. Vias are recommended to improve copper adhesion.

G. Solder mask openings to copper island for solder joints

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