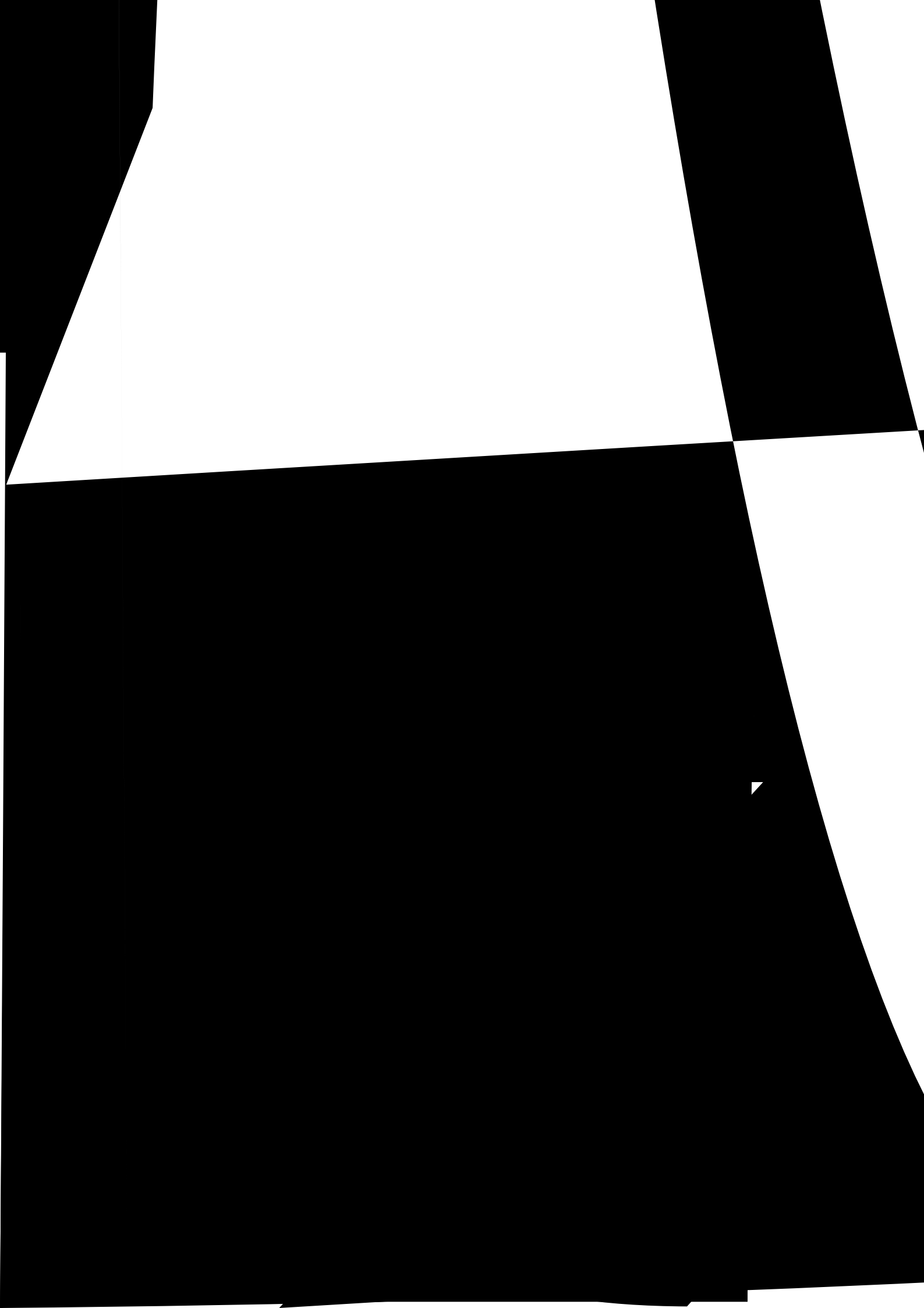
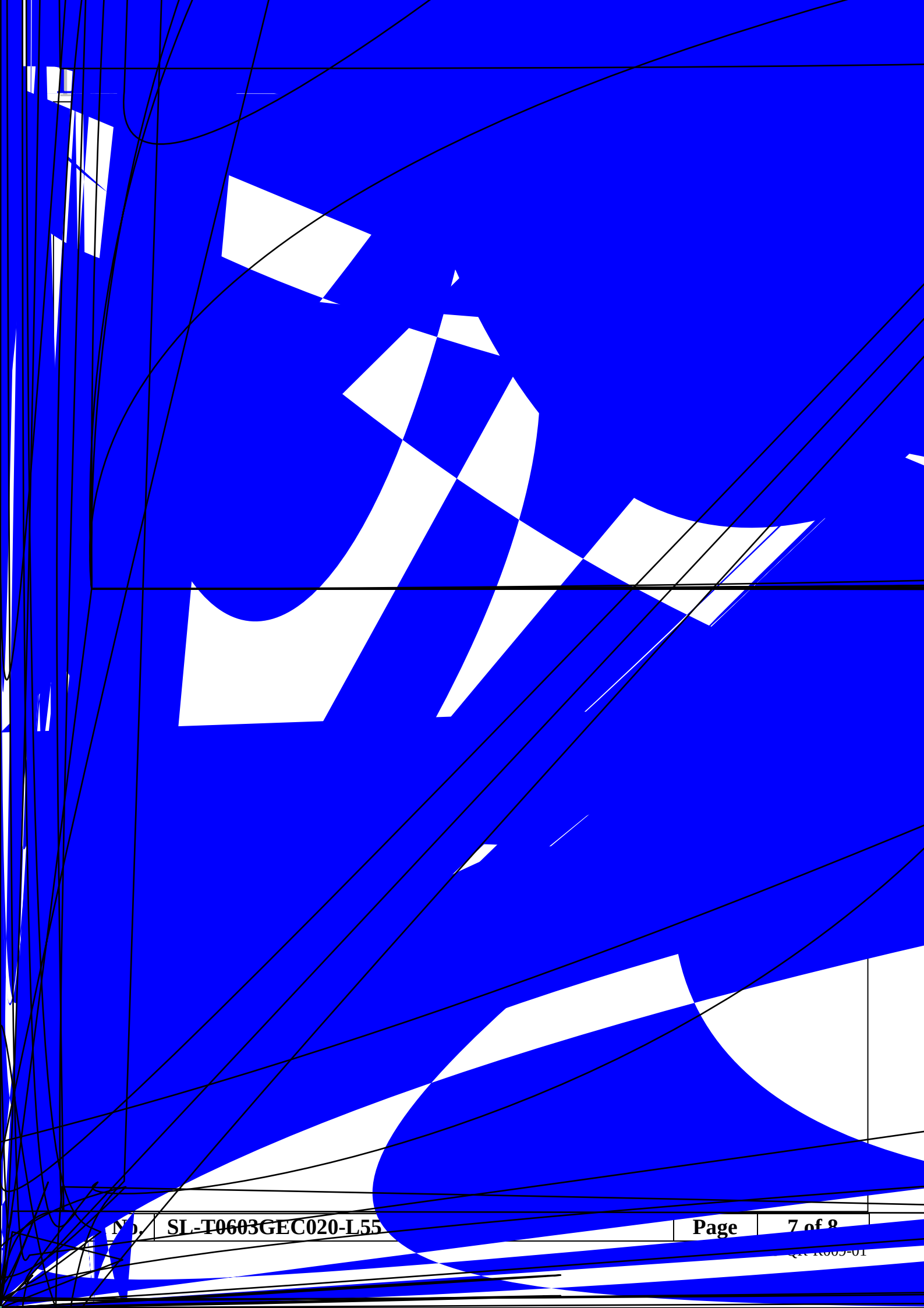
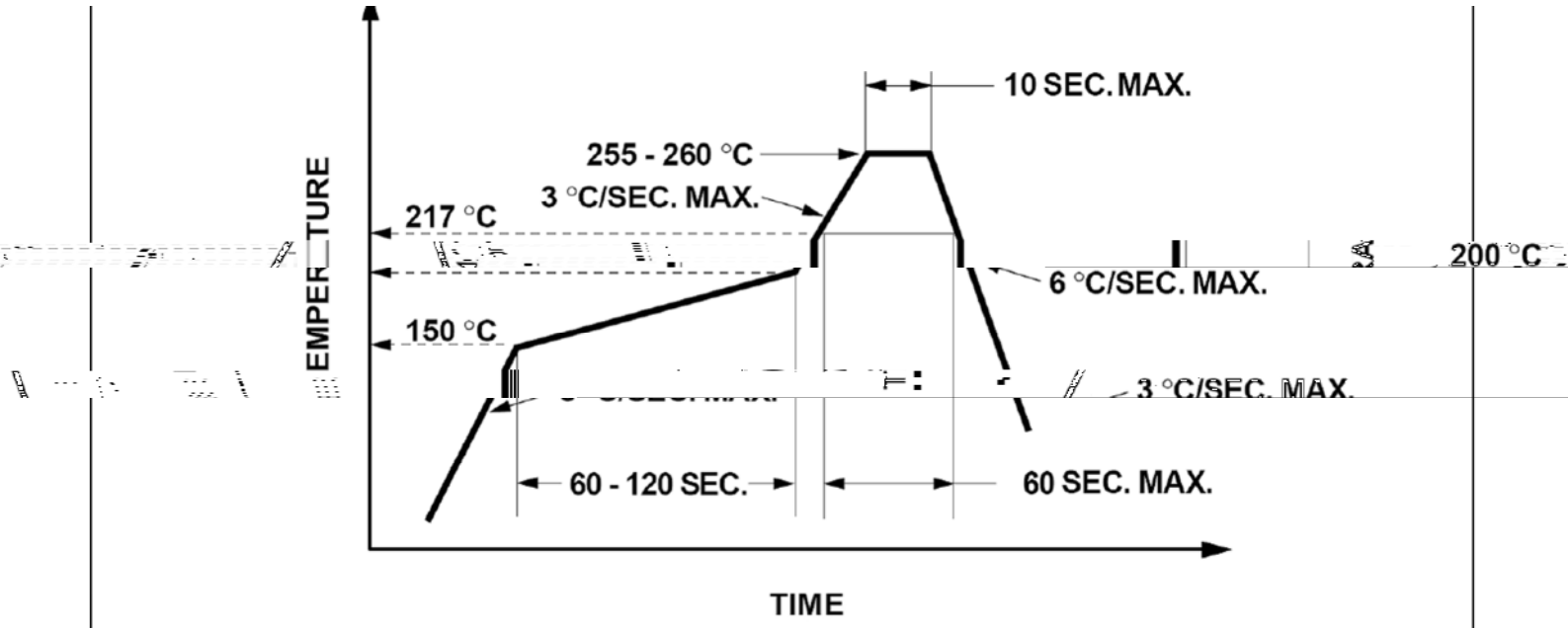


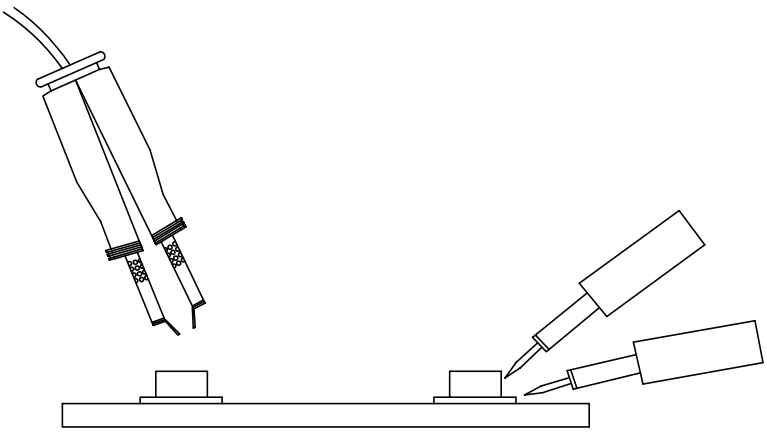




1. Reflow soldering should not be done more than two times.
2. When soldering, do not put stress on the LEDs during heating.

Soldering iron

1. When hand soldering, the temperature of the iron must less than 300℃ for 3 seconds.
2. The hand solder should be done only once.

Repairing

double-head soldering iron should be used (as below figure). It should be confirmed beforehand whether the characteristics of LEDs will or will not be damaged by repairing.