

# DATA SHEET

## **TEA6310T** Sound fader control circuit

Product specification  
File under Integrated Circuits, IC01

May 1992

# Sound fader control circuit

# TEA6310T

## FEATURES

- Volume and balance control; control range of 86 dB in steps of 2 dB
- Bass and treble control from +15 dB (treble 12 dB) to -12 dB in steps of 3 dB
- Fader control from 0 dB to -30 dB in steps of 2 dB
- Fast muting
- Low noise suitable for Dolby\* B and C N R (noise reduction)
- Signal handling suitable for compact disc
- I<sup>2</sup>C-bus control for all functions
- ESD protected.



## GENERAL DESCRIPTION

The Sound Fader Control circuit (SOFAC) is an I<sup>2</sup>C-bus controlled tone and volume control circuit for car radios.

## QUICK REFERENCE DATA

PARAMETER	SYMBOL	MIN.	TYP.	MAX.	UNIT
Supply voltage	V <sub>CC</sub>	7,0	8,5	13,2	V
Input sensitivity for full power at the output state	V <sub>i(rms)</sub>	–	50	–	mV
Input signal handling	V <sub>i(rms)</sub>	–	1,65	–	V
Frequency response	f <sub>r</sub>	35	–	20000	Hz
Channel separation f = 250 Hz to 10 kHz	α <sub>CS</sub>	70	96	–	dB
Total harmonic distortion	THD	–	0,05	–	%
Signal plus noise-to-noise ratio	(S+N)/N	–	80	–	dB
Operating ambient temperature range	T <sub>amb</sub>	-40	–	+ 85	°C

\* Dolby is a registered trademark of Dolby Laboratories Licensing Corporation, San Francisco, California (U.S.A.).

## PACKAGE OUTLINE

28-lead mini-pack; plastic (SO28; SOT136A); SOT136-1; 1996 August 08.

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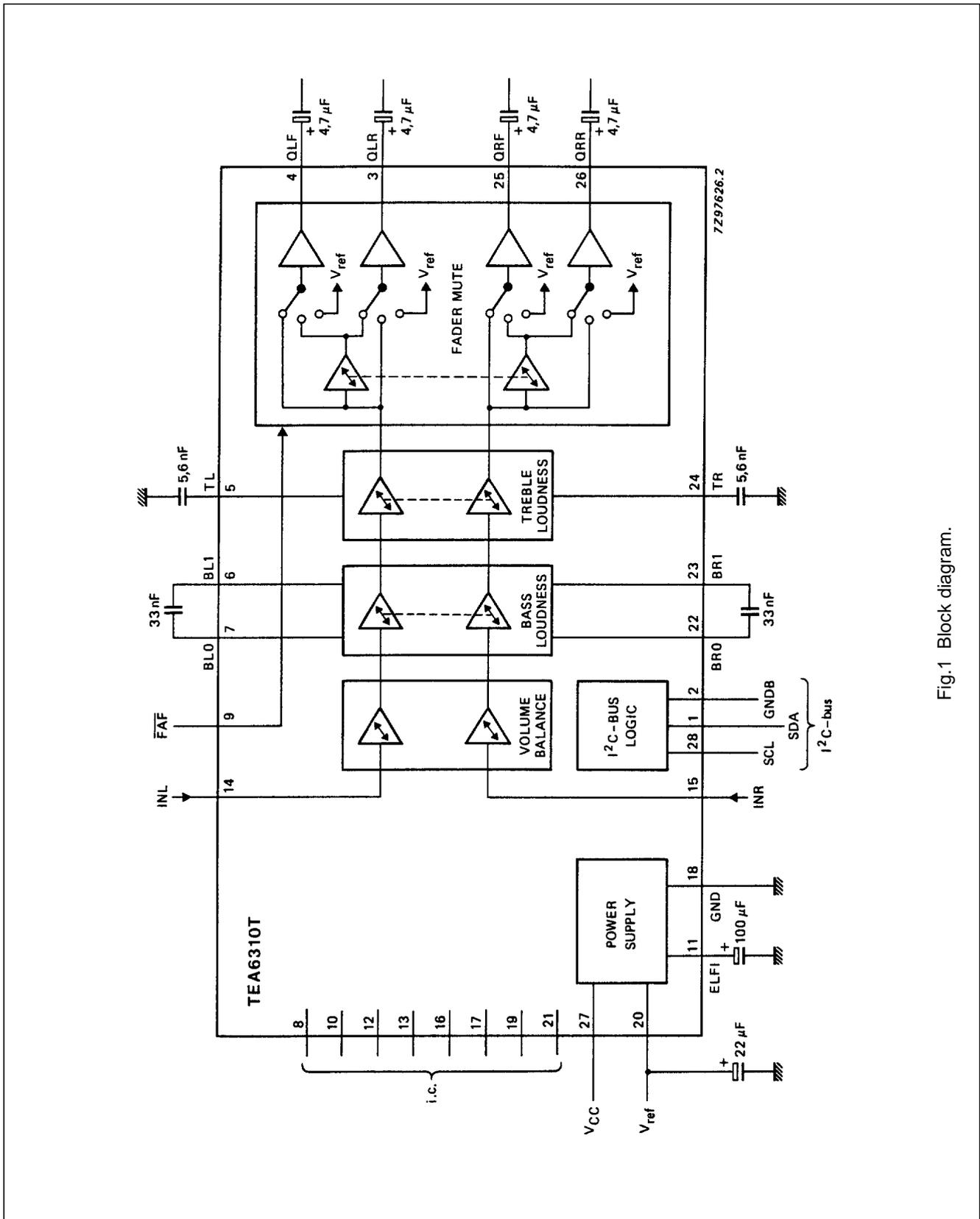


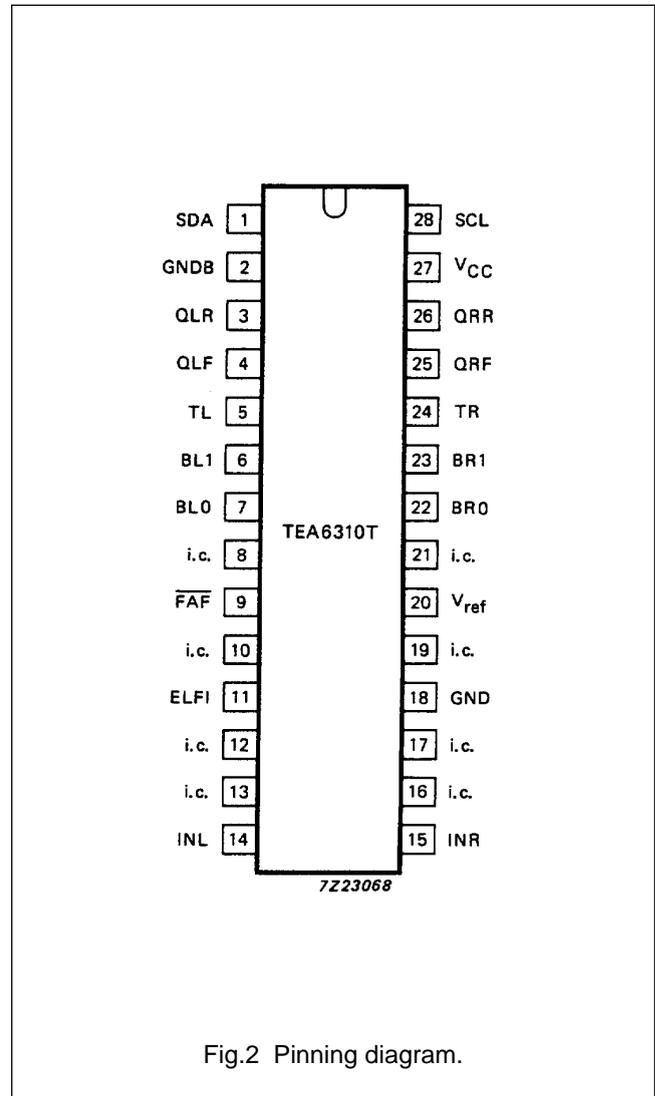
Fig.1 Block diagram.

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**PINNING**

1	SDA	serial data input/output (I <sup>2</sup> C-bus)
2	GNDB	ground for I <sup>2</sup> C-bus terminals
3	QLR	output left rear
4	QLF	output left front
5	TL	treble control capacitor; left channel
6	BL1	bass control capacitor; left channel
7	BL0	bass control capacitor; left channel
8	i.c.	internally connected
9	$\overline{FAF}$	fader off control input
10	i.c.	internally connected
11	ELFI	electronic filtering for supply
12	i.c.	internally connected
13	i.c.	internally connected
14	INL	input left control part
15	INR	input right control part
16	i.c.	internally connected
17	i.c.	internally connected
18	GND	ground
19	i.c.	internally connected
20	V <sub>ref</sub>	reference voltage (1/2 V <sub>CC</sub> )
21	i.c.	internally connected
22	BR0	bass control capacitor; right channel
23	BR1	bass control capacitor; right channel
24	TR	treble control capacitor; right channel
25	QRF	output right front
26	QRR	output right rear
27	V <sub>CC</sub>	supply voltage
28	SCL	serial clock input (I <sup>2</sup> C-bus)



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### FUNCTIONAL DESCRIPTION

The AC signal setting is performed by resistor chains in combination with multi-input operational amplifiers. The advantage of this principle is the combination of low noise, low distortion and a high dynamic range for the circuit.

The separate volume controls of the left and the right channel facilitate correct balance control. The range and balance control is software programmable.

Because the TEA6310T has four outputs a low level fader is included. The fader control is independent of the volume control and an extra mute position is built in for the front, the rear or for all channels. The last function may be used for muting during preset selection. The Fader function can be disabled by an input signal at  $\overline{FAF}$  (pin 9).

An extra pop suppression circuit is built in for pop-free switching on and off. As all switching and control functions are controllable via the two-wire I<sup>2</sup>C-bus, no external interface between the micro-computer and the TEA6310T is required.

The on-chip power-on-reset sets the TEA6310T to the general mute mode.

### RATINGS

Limiting values in accordance with the Absolute Maximum System (IEC 134)

PARAMETER	SYMBOL	MIN.	MAX.	UNIT
Supply voltage (pin 27-18)	$V_{CC}$	–	16	V
Maximum power dissipation	$P_{tot}$	–	1	W
Storage temperature range	$T_{stg}$	–55	+150	°C
Operating ambient temperature range	$T_{amb}$	–40	+ 85	°C

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**CHARACTERISTICS**

$V_{CC} = 8,5 \text{ V}$ ;  $R_S = 600 \Omega$ ;  $R_L = 10 \text{ k}\Omega$ ;  $f = 1 \text{ kHz}$ ;  $T_{amb} = 25 \text{ }^\circ\text{C}$ ; test circuit Fig.10; unless otherwise specified

PARAMETER	SYMBOL	MIN.	TYP.	MAX.	UNIT
Supply voltage	$V_{CC}$	7,0	8,5	13,2	V
Supply current	$I_{CC}$	–	26	–	mA
Supply current at 8,5 V	$I_{CC}$	–	–	30	mA
Supply current at 13,2 V	$I_{CC}$	–	–	44	mA
DC voltage inputs, outputs and reference	$V_{DC}$	0,45	0,5	0,55	$V_{CC}$
Internal reference voltage (pin 20); $V_{ref} = 0,5 V_{CC}$	$V_{REF}$	–	4,25	–	V
Maximum voltage gain, bass and treble linear, fader off	$G_V$	19	20	21	dB
Output voltage level					
for $P_{max}$ at the output stage	$V_{o(rms)}$	–	500	–	mV
for start of clipping	$V_{o(rms)}$	–	1000	–	mV
Input sensitivity at $V_o = 500 \text{ mV}$	$V_{i(rms)}$	–	50	–	mV
Frequency response bass and treble linear; roll-off frequency $-1 \text{ dB}$	$f_r$	35	–	20000	Hz
Channel separation					
$G_V = 0 \text{ dB}$ ; bass and treble linear; frequency range 250 Hz to 10 kHz	$\alpha_{CS}$	70	96	–	dB
Total harmonic distortion					
frequency range 20 Hz to 12,5 kHz					
$V_i = 50 \text{ mV}$ ; $G_V = 20 \text{ dB}$	THD	–	0,1	0,3	%
$V_i = 500 \text{ mV}$ ; $G_V = 0 \text{ dB}$	THD	–	0,05	0,2	%
$V_i = 1,6 \text{ V}$ ; $G_V = -10 \text{ dB}$	THD	–	0,2	0,5	%
Ripple rejection					
$V_{r(rms)} < 200 \text{ mV}$ ; $G_V = 0 \text{ dB}$ ;					
bass and treble linear;					
at $f = 100 \text{ Hz}$	$RR_{100}$	–	70	–	dB
at $f = 40 \text{ Hz}$ to 12,5 kHz	$RR_{range}$	–	60	–	dB
Signal-to-noise ratio;					
bass and treble linear; notes 1 and 2;					
CCIR 468-2 weighted; quasi peak;					
$V_i = 50 \text{ mV}$ ; $V_o = 46 \text{ mV}$ ; $P_o = 50 \text{ mW}$	$S/(S+N)$	–	65	–	dB
$V_i = 500 \text{ mV}$ ; $V_o = 45 \text{ mV}$ ; $P_o = 50 \text{ mW}$	$S/(S+N)$	–	67	–	dB
$V_i = 50 \text{ mV}$ ; $V_o = 200 \text{ mV}$ ; $P_o = 1 \text{ W}$	$S/(S+N)$	65	72	–	dB
$V_i = 500 \text{ mV}$ ; $V_o = 200 \text{ mV}$ ; $P_o = 1 \text{ W}$	$S/(S+N)$	65	78	–	dB
$V_i = 50 \text{ mV}$ ; $V_o = 500 \text{ mV}$ ; $P_o = 6 \text{ W}$	$S/(S+N)$	–	72	–	dB
$V_i = 500 \text{ mV}$ ; $V_o = 500 \text{ mV}$ ; $P_o = 6 \text{ W}$	$S/(S+N)$	–	86	–	dB
Noise output power					
mute position, only contribution of TEA310T, power amplifier for 25 W	$P_{no}$	–	–	10	nW

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PARAMETER	SYMBOL	MIN.	TYP.	MAX.	UNIT
Crosstalk ( $20 \log V_{\text{bus(p-p)}}/V_{\text{o(rms)}}$ ) between bus inputs and signal outputs $G_V = 0$ dB; bass and treble linear;	$\alpha_B$	–	110	–	dB
<b>Control part</b>					
Input impedance	$Z_i$	35	50	65	k $\Omega$
Output impedance	$Z_o$	–	100	150	$\Omega$
Output load resistance	$R_L$	5	–	–	k $\Omega$
Output load capacity	$C_L$	0	–	2500	pF
Maximum input voltage; THD < 0,5%; $G_V = -10$ dB; bass and treble linear	$V_{i(\text{rms})}$	–	2,0	–	V
Noise output voltage; weighted acc CCIR 468-2, quasi peak, bass and treble linear, fader off;					
$G_V = 20$ dB	$V_{\text{no}}$	–	110	220	$\mu\text{V}$
$G_V = 0$ dB	$V_{\text{no}}$	–	25	50	$\mu\text{V}$
$G_V = -66$ dB	$V_{\text{no}}$	–	19	38	$\mu\text{V}$
mute position	$V_{\text{no}}$	–	11	22	$\mu\text{V}$
<b>Volume control</b>					
Continuous control range	$G_c$	–	86	–	dB
Step resolution		–	2	–	dB
Attenuator set error; ( $G_V = +20$ to $-50$ dB)	$\Delta G_a$	–	–	2	dB
Attenuator set error; ( $G_V = +20$ to $-66$ dB)	$\Delta G_a$	–	–	3	dB
Gain tracking error; balance in mid position, bass and treble linear	$\Delta G_t$	–	–	2	dB
Mute attenuation	$\alpha_m$	76	90	–	dB
DC step offset Between any adjoining step and any step to mute					
$G_V = 0$ to $-66$ dB		–	0,2	10	mV
$G_V = 20$ to $0$ dB		–	2	15	mV
In any treble and fader position $G_V = 0$ to $-66$ dB		–	–	10	mV
In any bass position $G_V = 0$ to $-66$ dB		–	–	20	mV

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PARAMETER	SYMBOL	MIN.	TYP.	MAX.	UNIT
<b>Bass control</b>					
Bass control range;					
f = 40 Hz; maximum boost	$G_b$	14	15	16	dB
f = 40 Hz; maximum attenuation	$G_b$	11	12	13	dB
Step resolution		–	3	–	dB
Step error		–	–	0,5	dB
<b>Treble control</b>					
Treble control range					
f = 15 kHz; maximum boost	$G_t$	11	12	13	dB
f = 15 kHz; maximum attenuation	$G_t$	11	12	13	dB
f > 15 kHz; maximum boost	$G_t$	–	–	15	dB
Step resolution		–	3	–	dB
Step error		–	–	0,5	dB
<b>Fader control</b>					
Continuous attenuation fader control range	$G_f$	–	30	–	dB
Step resolution		–	2	–	dB
Attenuator set error		–	–	1,5	dB
Mute attenuation	$\alpha_m$	74	84	–	dB
<b>Fader enable/disable control (pin 9)</b>					
Fader enabled					
Input voltage HIGH	$V_{9-18}$	3	–	12	V
Fader disabled					
Input voltage LOW	$V_{9-18}$	–0,3	–	1,5	V
Input current					
HIGH	$I_9$	–10	–	+10	$\mu$ A
LOW	$I_9$	–10	–	+10	$\mu$ A
<b>Digital part</b>					
<i>Bus terminals</i>					
Input voltage					
HIGH	$V_{IH}$	3	–	12	V
LOW	$V_{IL}$	–0,3	–	1,5	V
Input current					
HIGH	$I_{IH}$	–10	–	+10	$\mu$ A
LOW	$I_{IL}$	–10	–	+10	$\mu$ A
Output voltage LOW					
$I_L = 3$ mA	$V_{OL}$	–	–	0,4	V

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PARAMETER	SYMBOL	MIN.	TYP.	MAX.	UNIT
<i>AC characteristics</i>					
in accordance with the I <sup>2</sup> C-bus specification					
<i>Power-on-Reset</i>					
When RESET is active the GMU (general mute) bit is set and the I <sup>2</sup> C-bus receiver is in RESET position					
Increasing supply voltage					
start of reset	V <sub>CC</sub>	–	–	2,5	V
end of reset	V <sub>CC</sub>	5,2	6,0	6,8	V
Decreasing supply voltage					
start of reset	V <sub>CC</sub>	4,2	5,0	5,8	V

**Notes to the characteristics**

1. The indicated values for output power assume a 6 W power amplifier with 20 dB gain, connected to the output of the circuit. Signal-to-noise ratios exclude noise contribution of the power amplifier.
2. Signal-to-noise ratios on a CCIR 468-2 average meter reading are 4,5 dB better than on CCIR 468-2 quasi peak.

**I<sup>2</sup>C-BUS FORMAT**

<b>S</b>	<b>SLAVE ADDRESS</b>	<b>A</b>	<b>SUBADDRESS</b>	<b>A</b>	<b>DATA</b>	<b>A</b>	<b>P</b>
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- S = start condition
- SLAVE ADDRESS = 10000 0000
- A = acknowledge, generated by the slave
- SUBADDRESS = see Table 1
- DATA = see Table 1
- P = STOP condition

If more than 1 byte DATA are transmitted, then auto-increment of the subaddress is performed.

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Table 1 I<sup>2</sup>C-bus; subaddress/data

FUNCTION	SUBADDRESS	DATA							
		D7	D6	D5	D4	D3	D2	D1	D0
volume left	0 0 0 0 0 0 0 0	X	X	VL5	VL4	VL3	VL2	VL1	VL0
volume right	0 0 0 0 0 0 0 1	X	X	VR5	VR4	VR3	VR2	VR1	VR0
bass	0 0 0 0 0 0 1 0	X	X	X	X	BA3	BA2	BA1	BA0
treble	0 0 0 0 0 0 1 1	X	X	X	X	TR3	TR2	TR1	TR0
fader	0 0 0 0 0 1 0 0	X	X	MFN	FCH	FA3	FA2	FA1	FA0
switch	0 0 0 0 0 1 0 1	GMU	X	X	X	X	X	X	X

## Function of the bits:

VL0 to VL5	volume control left
VR0 to VR5	volume control right
BA0 to BA3	bass control
TR0 to TR3	treble control
FA0 to FA3	fader control
FCH	select fader channel (front or rear)
MFN	mute control of the selected fader channel (front or rear)
GMU	mute control (general mute) for the outputs QLF, QLR, QRF and QRR
X	don't care bits (logic 1 during testing)

Table 2 Bass setting

G <sub>V</sub> DB	DATA			
	BA3	BA2	BA1	BA0
+15	1	1	1	1
+15	1	1	1	0
+15	1	1	0	1
+15	1	1	0	0
+12	1	0	1	1
+9	1	0	1	0
+6	1	0	0	1
+3	1	0	0	0
0	0	1	1	1
-3	0	1	1	0
-6	0	1	0	1
-9	0	1	0	0
-12	0	0	1	1
-12	0	0	1	0
-12	0	0	0	1
-12	0	0	0	0

Table 3 Treble setting

G <sub>V</sub> DB	DATA			
	TR3	TR2	TR1	TR0
+12	1	1	1	1
+12	1	1	1	0
+12	1	1	0	1
+12	1	1	0	0
+12	1	0	1	1
+9	1	0	1	0
+6	1	0	0	1
+3	1	0	0	0
0	0	1	1	1
-3	0	1	1	0
-6	0	1	0	1
-9	0	1	0	0
-12	0	0	1	1
-12	0	0	1	0
-12	0	0	0	1
-12	0	0	0	0

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Table 4 Volume setting LEFT

G <sub>V</sub> DB	DATA					
	VL5	VL4	VL3	VL2	VL1	VL0
20	1	1	1	1	1	1
18	1	1	1	1	1	0
16	1	1	1	1	0	1
14	1	1	1	1	0	0
12	1	1	1	0	1	1
10	1	1	1	0	1	0
8	1	1	1	0	0	1
6	1	1	1	0	0	0
4	1	1	0	1	1	1
2	1	1	0	1	1	0
0	1	1	0	1	0	1
-2	1	1	0	1	0	0
-4	1	1	0	0	1	1
-6	1	1	0	0	1	0
-8	1	1	0	0	0	1
-10	1	1	0	0	0	0
-12	1	0	1	1	1	1
-14	1	0	1	1	1	0
-16	1	0	1	1	0	1
-18	1	0	1	1	0	0
-20	1	0	1	0	1	1
-22	1	0	1	0	1	0
-24	1	0	1	0	0	1
-26	1	0	1	0	0	0
-28	1	0	0	1	1	1
-30	1	0	0	1	1	0
-32	1	0	0	1	0	1
-34	1	0	0	1	0	0
-36	1	0	0	0	1	1
-38	1	0	0	0	1	0
-40	1	0	0	0	0	1
-42	1	0	0	0	0	0
-44	0	1	1	1	1	1
-46	0	1	1	1	1	0
-48	0	1	1	1	0	1
-50	0	1	1	1	0	0
-52	0	1	1	0	1	1
-54	0	1	1	0	1	0
-56	0	1	1	0	0	1
-58	0	1	1	0	0	0
-60	0	1	0	1	1	1
-62	0	1	0	1	1	0
-64	0	1	0	1	0	1
-66	0	1	0	1	0	0
mute left	0	1	0	0	1	1
mute left	0	1	0	0	1	0
.			.			
.			.			
.			.			
mute left	0	0	0	0	0	0
mute left	0	0	0	0	0	0

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Table 5 Volume setting RIGHT

G <sub>V</sub> DB	DATA					
	VR5	VR4	VR3	VR2	VR1	VR0
20	1	1	1	1	1	1
18	1	1	1	1	1	0
16	1	1	1	1	0	1
14	1	1	1	1	0	0
12	1	1	1	0	1	1
10	1	1	1	0	1	0
8	1	1	1	0	0	1
6	1	1	1	0	0	0
4	1	1	0	1	1	1
2	1	1	0	1	1	0
0	1	1	0	1	0	1
-2	1	1	0	1	0	0
-4	1	1	0	0	1	1
-6	1	1	0	0	1	0
-8	1	1	0	0	0	1
-10	1	1	0	0	0	0
-12	1	0	1	1	1	1
-14	1	0	1	1	1	0
-16	1	0	1	1	0	1
-18	1	0	1	1	0	0
-20	1	0	1	0	1	1
-22	1	0	1	0	1	0
-24	1	0	1	0	0	1
-26	1	0	1	0	0	0
-28	1	0	0	1	1	1
-30	1	0	0	1	1	0
-32	1	0	0	1	0	1

G <sub>V</sub> DB	DATA					
	VR5	VR4	VR3	VR2	VR1	VR0
-34	1	0	0	1	0	0
-36	1	0	0	0	1	1
-38	1	0	0	0	1	0
-40	1	0	0	0	0	1
-42	1	0	0	0	0	0
-44	0	1	1	1	1	1
-46	0	1	1	1	1	0
-48	0	1	1	1	0	1
-50	0	1	1	1	0	0
-52	0	1	1	0	1	1
-54	0	1	1	0	1	0
-56	0	1	1	0	0	1
-58	0	1	1	0	0	0
-60	0	1	0	1	1	1
-62	0	1	0	1	1	0
-64	0	1	0	1	0	1
-66	0	1	0	1	0	0
mute right	0	1	0	0	1	1
mute right	0	1	0	0	1	0
.						
.						
.						
mute right	0	0	0	0	0	0
mute right						

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Table 6 Fader function

SETTING		DATA					
FRONT	REAR	MFN	FCH	FA3	FA2	FA1	FA0
DB	DB						
		fader off					
0	0	1	1	1	1	1	1
0	0	0	1	1	1	1	1
		fader front					
-2	0	1	1	1	1	1	0
-4	0	1	1	1	1	0	1
-6	0	1	1	1	1	0	0
-8	0	1	1	1	0	1	1
-10	0	1	1	1	0	1	0
-12	0	1	1	1	0	0	1
-14	0	1	1	1	0	0	0
-16	0	1	1	0	1	1	1
-18	0	1	1	0	1	1	0
-20	0	1	1	0	1	0	1
-22	0	1	1	0	1	0	0
-24	0	1	1	0	0	1	1
-26	0	1	1	0	0	1	0
-28	0	1	1	0	0	0	1
-30	0	1	1	0	0	0	0
		mute front					
-80	0	0	1	1	1	1	0
.	.			.			
.	.			.			
.	.			.			
-80	0	0	1	0	0	0	0

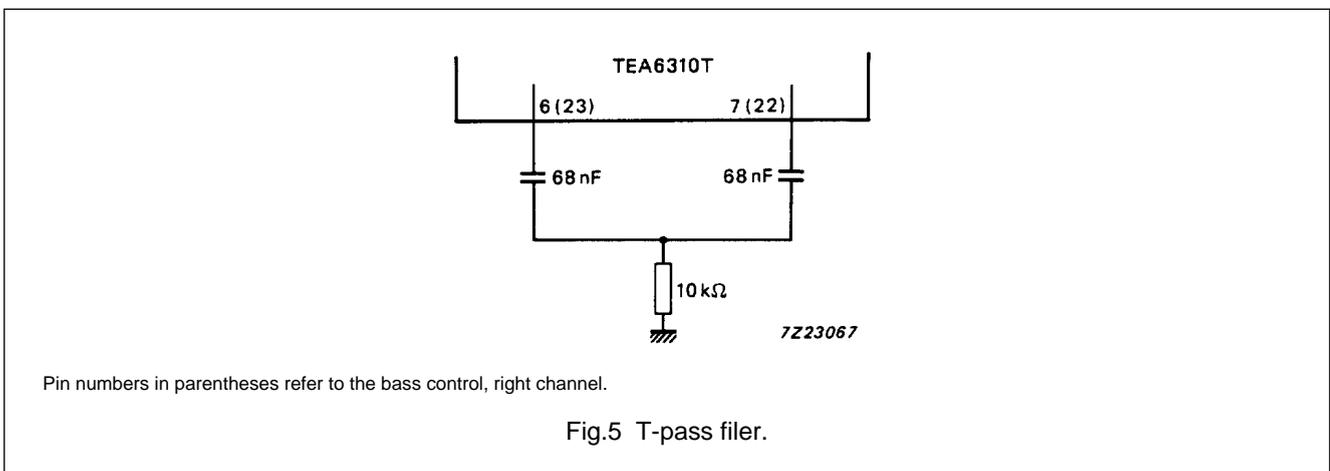
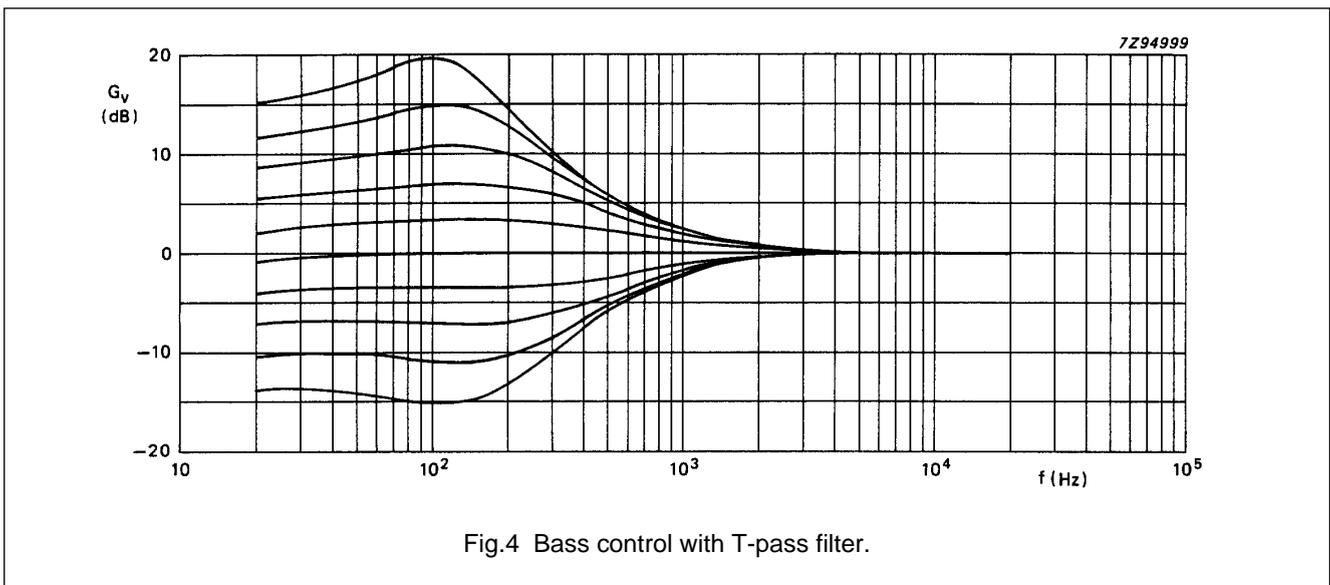
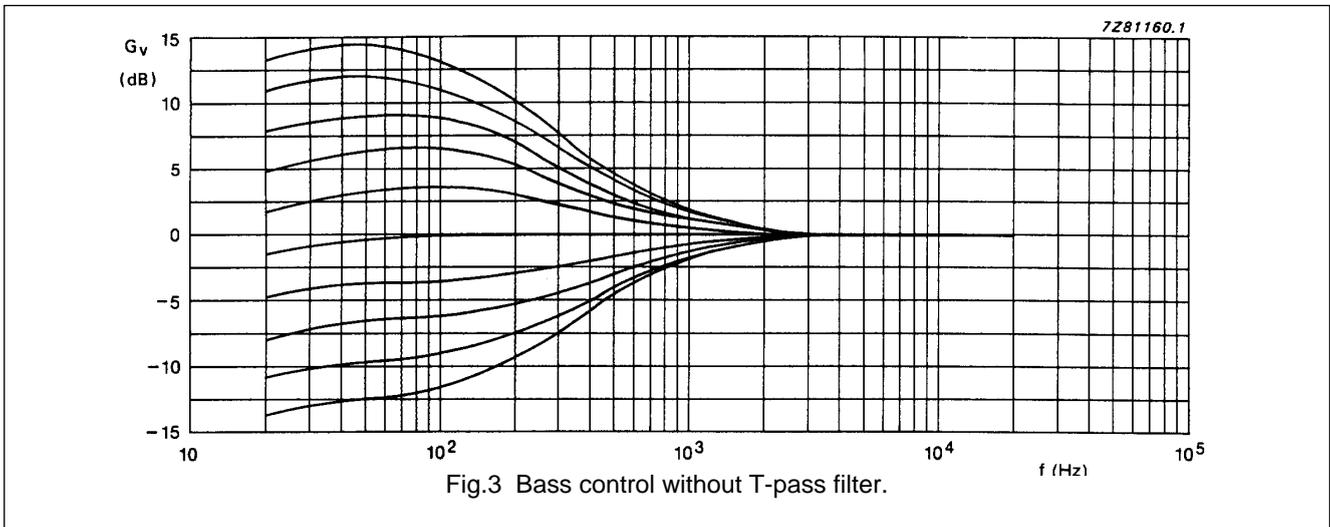
SETTING		DATA					
FRONT	REAR	MFN	FCH	FA3	FA2	FA1	FA0
DB	DB						
		fader off					
0	0	1	0	1	1	1	1
0	0	0	0	1	1	1	1
		fader rear					
0	-2	1	0	1	1	1	0
0	-4	1	0	1	1	0	1
0	-6	1	0	1	1	0	0
0	-8	1	0	1	0	1	1
0	-10	1	0	1	0	1	0
0	-12	1	0	1	0	0	1
0	-14	1	0	1	0	0	0
0	-16	1	0	0	1	1	1
0	-18	1	0	0	1	1	0
0	-20	1	0	0	1	0	1
0	-22	1	0	0	1	0	0
0	-24	1	0	0	0	1	1
0	-26	1	0	0	0	1	0
0	-28	1	0	0	0	0	1
0	-30	1	0	0	0	0	0
		mute rear					
0	-80	0	0	1	1	1	0
.	.			.			
.	.			.			
.	.			.			
0	-80	0	0	0	0	0	0

Table 7 Mute control

MUTE CONTROL	DATA GMU	REMARKS
active	1	outputs QLF, QLR QRF and QRR are muted
passive	0	no general mute

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Sound fader control circuit

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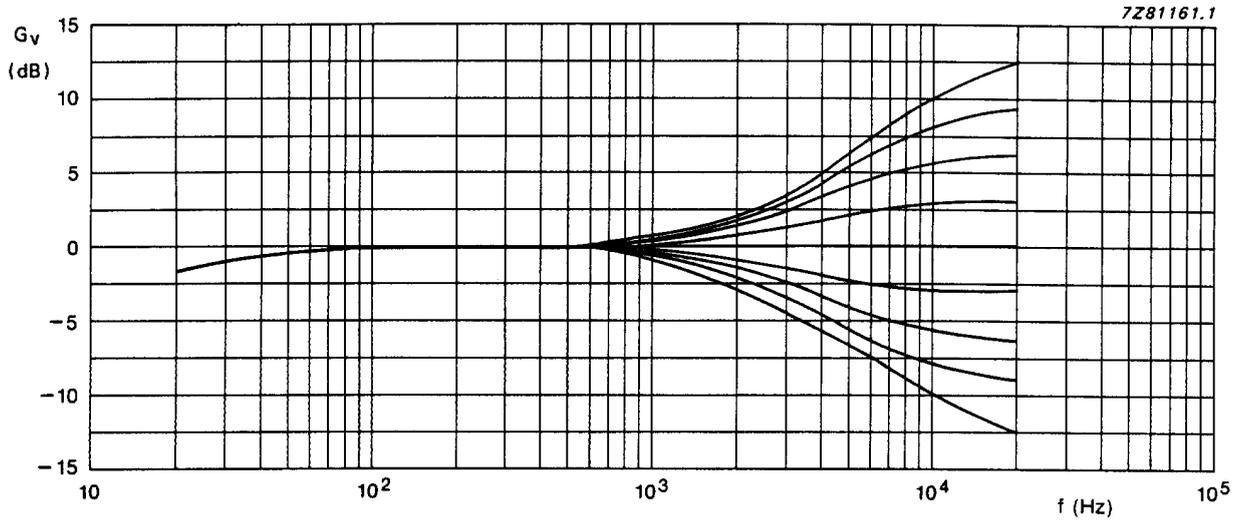


Fig.6 Treble control.

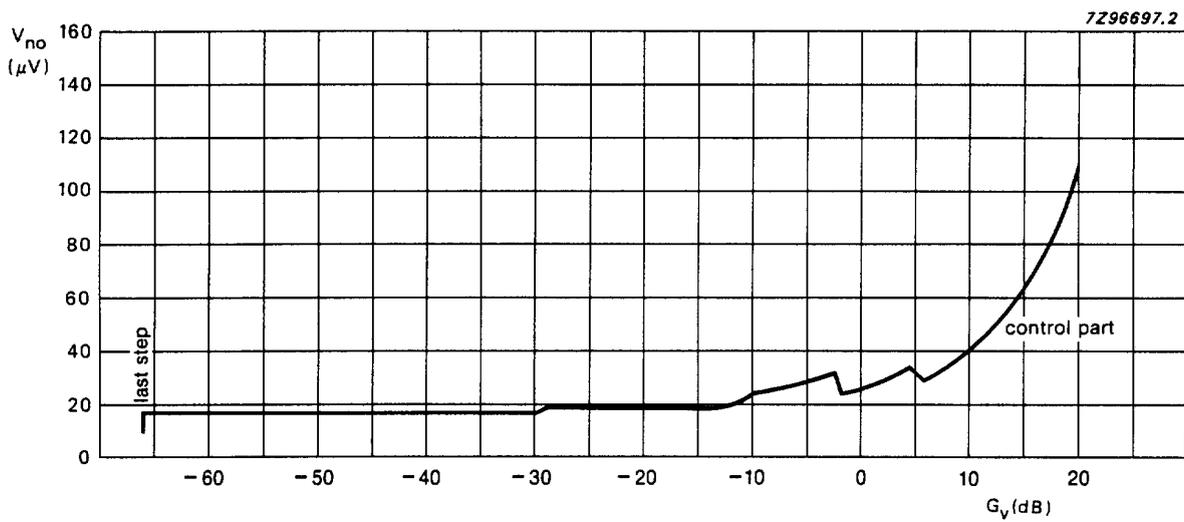


Fig.7 Output noise voltage (CCIR 468-2 weighted: quasi peak).

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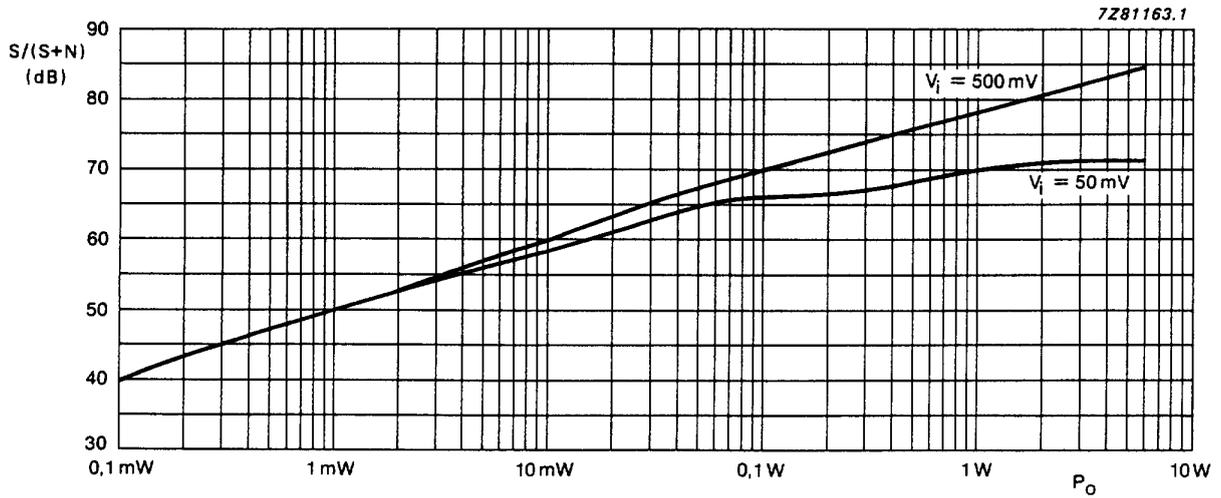


Fig.8 Signal-to-noise ratio (CCIT 468-2 weighted; quasi peak) with a 6 W power amplifier (gain 20 dB) without noise contribution of the power amplifier (see Fig.9).

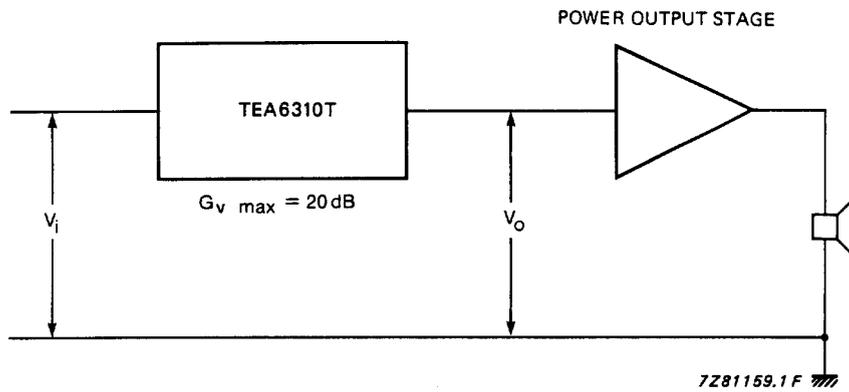


Fig.9 Recommended level diagram;  $V_{i \text{ min}} = 50$  mV,  $V_o = 500$  mV for  $P_{\text{max}}$ .

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APPLICATION INFORMATION

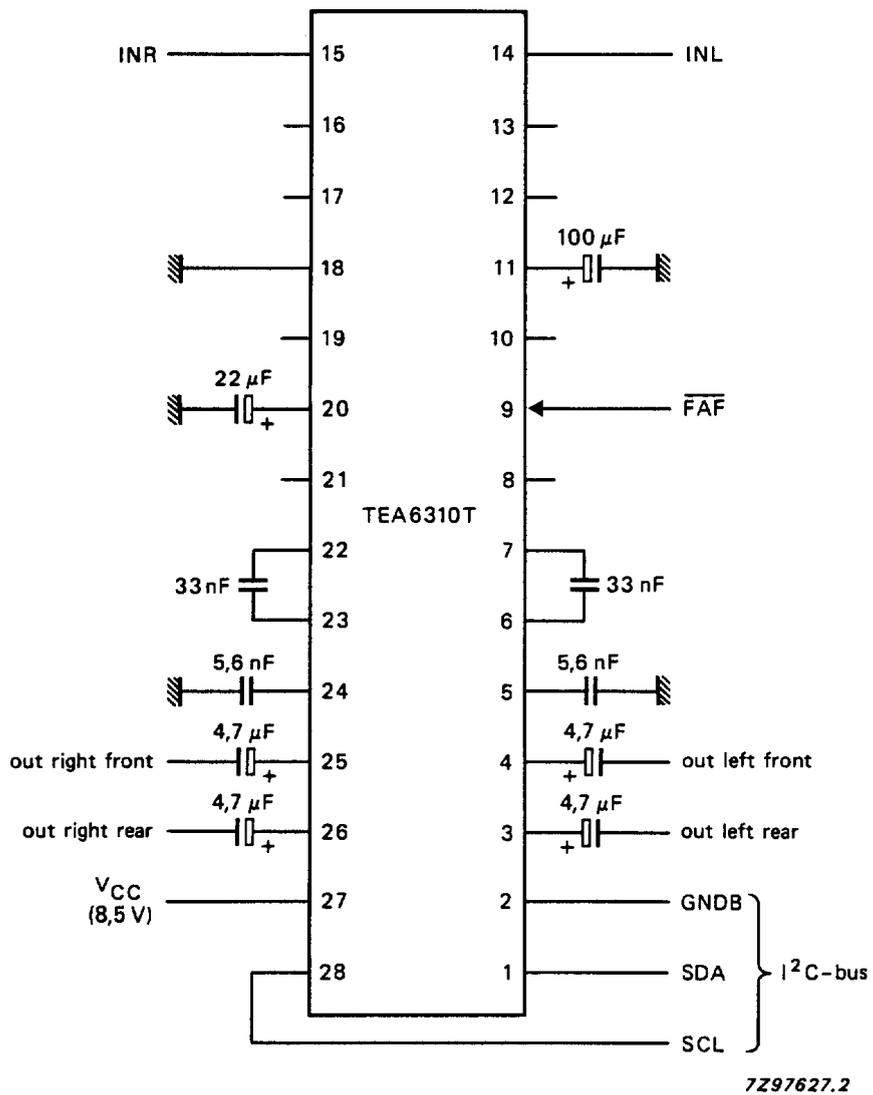
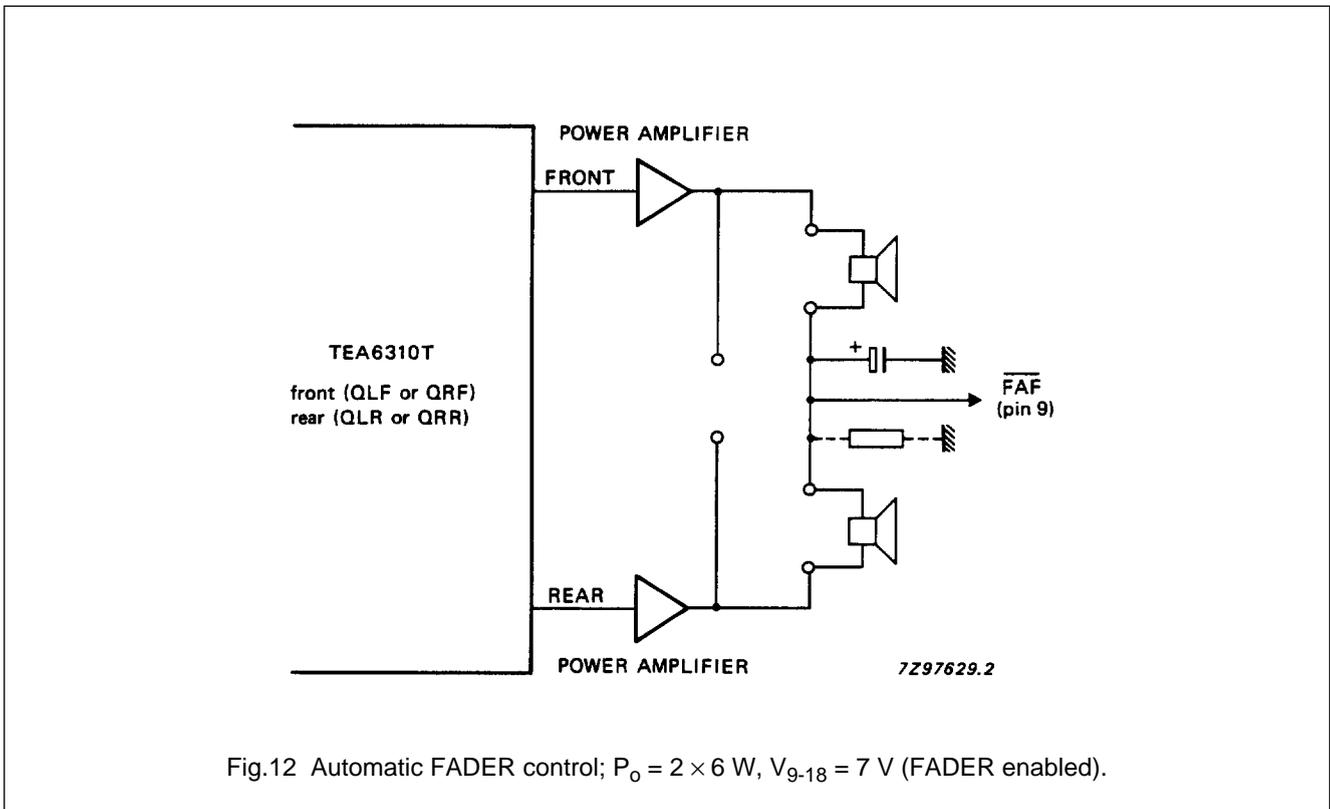
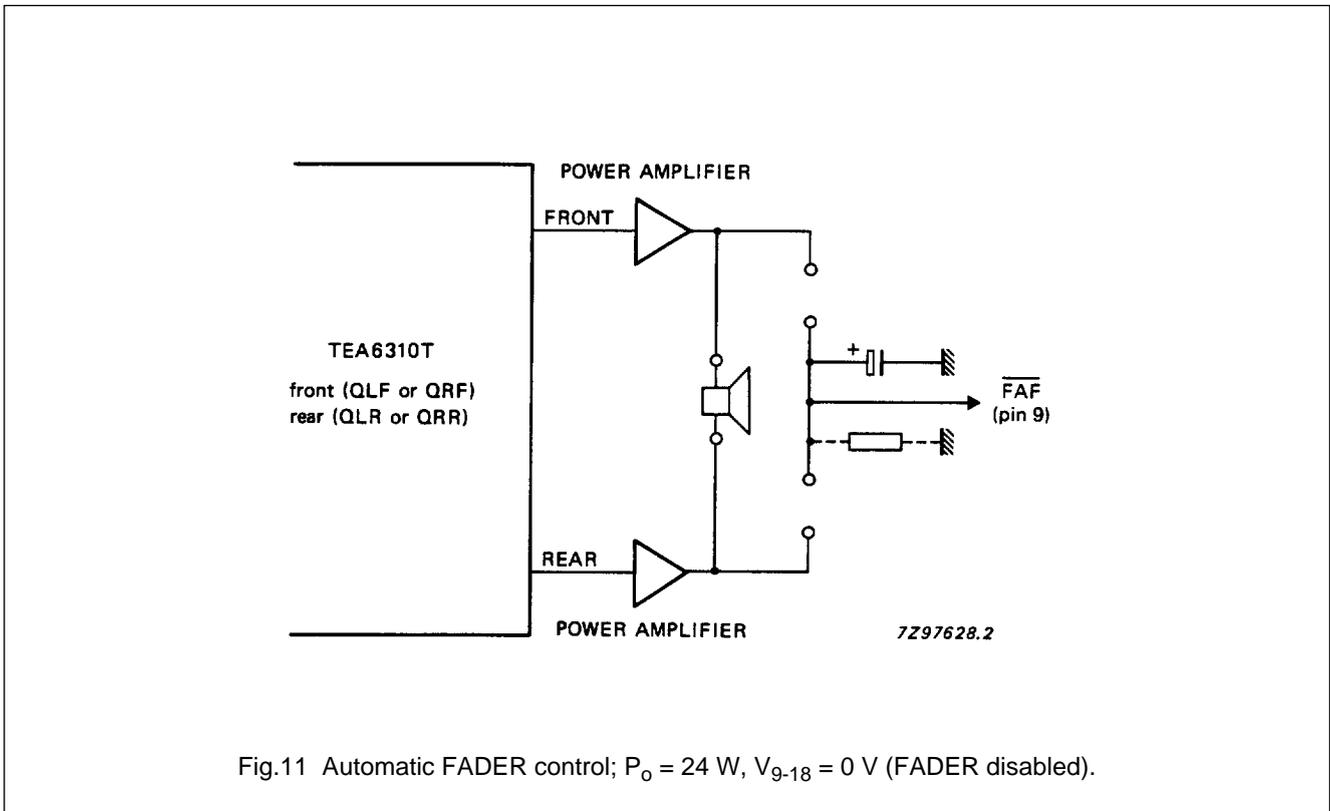


Fig.10 Test and application circuit.

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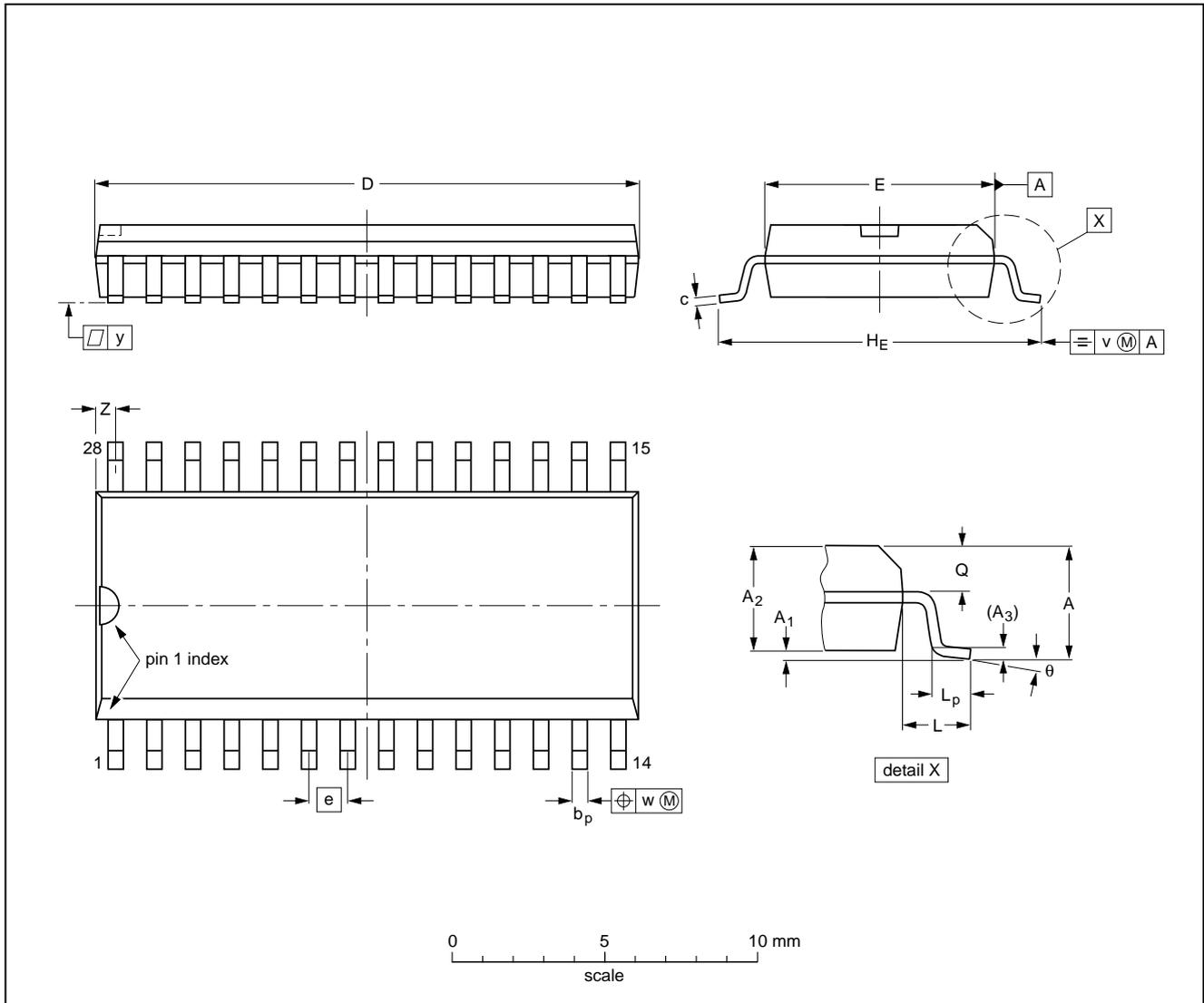
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PACKAGE OUTLINE

SO28: plastic small outline package; 28 leads; body width 7.5 mm

SOT136-1



DIMENSIONS (inch dimensions are derived from the original mm dimensions)

UNIT	A max.	A <sub>1</sub>	A <sub>2</sub>	A <sub>3</sub>	b <sub>p</sub>	c	D <sup>(1)</sup>	E <sup>(1)</sup>	e	H <sub>E</sub>	L	L <sub>p</sub>	Q	v	w	y	Z <sup>(1)</sup>	θ
mm	2.65	0.30 0.10	2.45 2.25	0.25	0.49 0.36	0.32 0.23	18.1 17.7	7.6 7.4	1.27	10.65 10.00	1.4	1.1 0.4	1.1 1.0	0.25	0.25	0.1	0.9 0.4	8° 0°
inches	0.10	0.012 0.004	0.096 0.089	0.01	0.019 0.014	0.013 0.009	0.71 0.69	0.30 0.29	0.050	0.42 0.39	0.055	0.043 0.016	0.043 0.039	0.01	0.01	0.004	0.035 0.016	

Note

1. Plastic or metal protrusions of 0.15 mm maximum per side are not included.

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	EIAJ			
SOT136-1	075E06	MS-013AE				91-08-13 95-01-24

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### SOLDERING

#### Introduction

There is no soldering method that is ideal for all IC packages. Wave soldering is often preferred when through-hole and surface mounted components are mixed on one printed-circuit board. However, wave soldering is not always suitable for surface mounted ICs, or for printed-circuits with high population densities. In these situations reflow soldering is often used.

This text gives a very brief insight to a complex technology. A more in-depth account of soldering ICs can be found in our "*IC Package Databook*" (order code 9398 652 90011).

#### Reflow soldering

Reflow soldering techniques are suitable for all SO packages.

Reflow soldering requires solder paste (a suspension of fine solder particles, flux and binding agent) to be applied to the printed-circuit board by screen printing, stencilling or pressure-syringe dispensing before package placement.

Several techniques exist for reflowing; for example, thermal conduction by heated belt. Dwell times vary between 50 and 300 seconds depending on heating method. Typical reflow temperatures range from 215 to 250 °C.

Preheating is necessary to dry the paste and evaporate the binding agent. Preheating duration: 45 minutes at 45 °C.

#### Wave soldering

Wave soldering techniques can be used for all SO packages if the following conditions are observed:

- A double-wave (a turbulent wave with high upward pressure followed by a smooth laminar wave) soldering technique should be used.
- The longitudinal axis of the package footprint must be parallel to the solder flow.
- The package footprint must incorporate solder thieves at the downstream end.

During placement and before soldering, the package must be fixed with a droplet of adhesive. The adhesive can be applied by screen printing, pin transfer or syringe dispensing. The package can be soldered after the adhesive is cured.

Maximum permissible solder temperature is 260 °C, and maximum duration of package immersion in solder is 10 seconds, if cooled to less than 150 °C within 6 seconds. Typical dwell time is 4 seconds at 250 °C.

A mildly-activated flux will eliminate the need for removal of corrosive residues in most applications.

#### Repairing soldered joints

Fix the component by first soldering two diagonally-opposite end leads. Use only a low voltage soldering iron (less than 24 V) applied to the flat part of the lead. Contact time must be limited to 10 seconds at up to 300 °C. When using a dedicated tool, all other leads can be soldered in one operation within 2 to 5 seconds between 270 and 320 °C.

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**DEFINITIONS**

<b>Data sheet status</b>	
Objective specification	This data sheet contains target or goal specifications for product development.
Preliminary specification	This data sheet contains preliminary data; supplementary data may be published later.
Product specification	This data sheet contains final product specifications.
<b>Limiting values</b>	
Limiting values given are in accordance with the Absolute Maximum Rating System (IEC 134). Stress above one or more of the limiting values may cause permanent damage to the device. These are stress ratings only and operation of the device at these or at any other conditions above those given in the Characteristics sections of the specification is not implied. Exposure to limiting values for extended periods may affect device reliability.	
<b>Application information</b>	
Where application information is given, it is advisory and does not form part of the specification.	

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