- Bidirectional Bus Transceivers in High-Density 20-Pin Packages
- True Logic
- 3-State Outputs
- Package Options Include Plastic Small-Outline (DW) Packages, Ceramic Chip Carriers (FK), and Standard Plastic (N) and Ceramic (J) 300-mil DIPs

#### description

These octal bus transceivers are designed for asynchronous two-way communication between data buses. These devices transmit data from the A bus to the B bus or from the B bus to the A bus, depending on the level at the direction-control (DIR) input. The output-enable ( $\overline{OE}$ ) input can be used to disable the device so that the buses are effectively isolated.

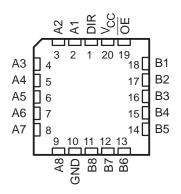
The -1 version of the SN74ALS645A is identical to the standard version, except that the recommended maximum  $I_{OL}$  is increased to 48 mA. There is no -1 version of the SN54ALS645A.

The SN54ALS645A and SN54AS645 are characterized for operation over the full military temperature range of  $-55^{\circ}$ C to  $125^{\circ}$ C. The SN74ALS645A and SN74AS645 are characterized for operation from 0°C to 70°C.

SN54ALS645A, SN54AS645 J PACKAGE
SN74ALS645A, SN74AS645 DW OR N PACKAGE
(TOP VIEW)

DIR	1	υ	20	Vcc
A1	2		19	] OE
A2			18	] B1
A3			17	] B2
A4			16	] B3
A5			15	] B4
A6	7		14	] B5
A7			13	] B6
A8	9		12	] B7
GND	10		11	] B8
				,

#### SN54ALS645A, SN54AS645...FK PACKAGE (TOP VIEW)



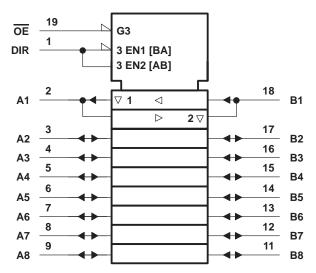
FUNCTION TABLE

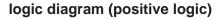
INP	UTS	
OE	DIR	OPERATION
L	L	B data to A bus
L	Н	A data to B bus
н	Х	Isolation

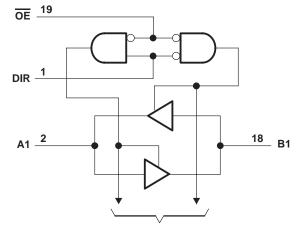
PRODUCTION DATA information is current as of publication date. Products conform to specifications per the terms of Texas Instruments standard warranty. Production processing does not necessarily include testing of all parameters.

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### logic symbol<sup>†</sup>







**To Seven Other Transceivers** 

<sup>†</sup> This symbol is in accordance with ANSI/IEEE Std 91-1984 and IEC Publication 617-12.

#### absolute maximum ratings over operating free-air temperature range (unless otherwise noted)<sup>‡</sup>

Supply voltage, V <sub>CC</sub>	
Input voltage, V <sub>I</sub> : All inputs	
I/O ports	5.5 V
Operating free-air temperature range, T <sub>A</sub> : SN54ALS645A	-55°C to 125°C
SN74ALS645A	0°C to 70°C
Storage temperature range	-65°C to 150°C

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.

#### recommended operating conditions

		SN54ALS645A			SN74ALS645A			UNIT	
		MIN	NOM	MAX	MIN	NOM	MAX	UNIT	
V <sub>CC</sub>	Supply voltage	4.5	5	5.5	4.5	5	5.5	V	
VIH	High-level input voltage	2			2			V	
VIL	Low-level input voltage			0.7			0.8	V	
ЮН	High-level output current			-12			-15	mA	
				12			24	mA	
IOL	Low-level output current						48§		
ТА	Operating free-air temperature	-55		125	0		70	°C	

Applies only to the -1 version and only if V<sub>CC</sub> is between 4.75 V and 5.25 V



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		TECT CO	NDITIONS	SN	54ALS64	5A	SN7	4ALS64	5A	UNIT
	PARAMETER	TEST CO	TEST CONDITIONS			MAX	MIN	TYP <sup>†</sup>	MAX	UNIT
VIK		V <sub>CC</sub> = 4.5 V,	lj = – 18 mA			-1.5			-1.5	V
		$V_{CC} = 4.5 V \text{ to } 5.5 V,$	I <sub>OH</sub> = -0.4 mA	V <sub>CC</sub> -2	2		V <sub>CC</sub> -2	2		
Val			I <sub>OH</sub> = -3 mA	2.4	3.2		2.4	3.2		V
VOH		$V_{CC} = 4.5 V$	$I_{OH} = -12 \text{ mA}$	2						v
			I <sub>OH</sub> = -15 mA				2			
V <sub>OL</sub>			I <sub>OL</sub> = 12 mA		0.25	0.4		0.25	0.4	
		$V_{CC} = 4.5 V$	I <sub>OL</sub> = 24 mA					0.35	0.5	V
			$I_{OL} = 48 \text{ mA}^{\ddagger}$					0.35	0.5	
1.	Control inputs		VI = 7 V			0.1			0.1	mA
łı	A or B ports	$V_{CC} = 5.5 V$	V <sub>I</sub> = 5.5 V			0.1			0.1	mA
	Control inputs		VI = 2.7 V			20			20	۸
lΗ	A or B ports§	V <sub>CC</sub> = 5.5 V,	V] = 2.7 V			20			20	μA
lu.	Control inputs					-0.1			-0.1	mA
ΙL	A or B ports§	$V_{CC} = 5.5 V,$	V <sub>I</sub> = 0.4 V		-0.1				-0.1	mA
IO		V <sub>CC</sub> = 5.5 V,	V <sub>O</sub> = 2.25 V	-20		-112	-30		-112	mA
			Outputs high		30	48		30	45	
ICC		$V_{CC} = 5.5 V$	Outputs low		36	60		36	55	mA
			Outputs disabled		38	63		38	58	

#### electrical characteristics over recommended operating free-air temperature range (unless otherwise noted)

<sup>†</sup> All typical values are at  $V_{CC} = 5 \text{ V}$ ,  $T_A = 25^{\circ}\text{C}$ .

<sup>‡</sup> Applies only to the -1 version and only if V<sub>CC</sub> is between 4.75 V and 5.25 V § For I/O ports, the parameters I<sub>IH</sub> and I<sub>IL</sub> include the off-state output current.

The output conditions have been chosen to produce a current that closely approximates one half of the true short-circuit output current, IOS.

### switching characteristics (see Figure 1)

PARAMETER	FROM (INPUT)	TO (OUTPUT)	ν <sub>(</sub> C <sub>L</sub> R1 R2 Τ <sub>Α</sub>	UNIT			
			SN54AL	S645A	SN74AL		
			MIN	MAX	MIN	MAX	
tPLH	A or B	Dert	1	19	3	10	
<sup>t</sup> PHL	AUB	B or A	1	14	3	10	ns
<sup>t</sup> PZH	OE	A ca D	2	30	5	20	ns
<sup>t</sup> PZL	ÛE	A or B	2	29	5	20	115
<sup>t</sup> PHZ	OE	A or B	2	14	2	10	ns
tPLZ	UE	AUIB	2	30	4	15	115

<sup>#</sup> For conditions shown as MIN or MAX, use the appropriate value specified under recommended operating conditions.



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### absolute maximum ratings over operating free-air temperature range (unless otherwise noted)<sup>†</sup>

Supply voltage, V <sub>CC</sub>	
Input voltage, VI: All inputs	7 V
I/O ports	5.5 V
Operating free-air temperature range, T <sub>A</sub> : SN54AS645	-55°C to 125°C
SN74AS645	0°C to 70°C
Storage temperature range	-65°C to 150°C

<sup>†</sup> 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.

#### recommended operating conditions

		SI	154AS64	15	SI	5	UNIT	
		MIN	NOM	MAX	MIN	NOM	MAX	UNIT
VCC	Supply voltage	4.5	5	5.5	4.5	5	5.5	V
VIH	High-level input voltage	2			2			V
VIL	Low-level input voltage			0.8			0.8	V
IOH	High-level output current			-12			-15	mA
IOL	Low-level output current			48			64	mA
TA	Operating free-air temperature	-55		125	0		70	°C

# electrical characteristics over recommended operating free-air temperature range (unless otherwise noted)

		TEST CO	NDITIONS	SI	154AS64	15	SN	LINUT		
	PARAMETER	TEST CO	NDITIONS	MIN	TYP <sup>‡</sup>	MAX	MIN	TYP <sup>‡</sup>	MAX	UNIT
VIK		V <sub>CC</sub> = 4.5 V,	lj = - 18 mA			-1.2			-1.2	V
V <sub>OH</sub>		V <sub>CC</sub> = 4.5 V to 5.5 V,	$I_{OH} = -2 \text{ mA}$	V <sub>CC</sub> -2	2		V <sub>CC</sub> -2	2		
			I <sub>OH</sub> = -3 mA	2.4	3.2		2.4	3.2		V
		$V_{CC} = 4.5 V$	$I_{OH} = -12 \text{ mA}$	2.4						v
			I <sub>OH</sub> = -15 mA				2.4			
V <sub>OL</sub>			I <sub>OL</sub> = 48 mA		0.3	0.55				V
		$V_{CC} = 4.5 V$	I <sub>OL</sub> = 64 mA					0.35	0.55	v
<b>I</b> .	Control inputs		V <sub>I</sub> = 7 V			0.1			0.1	mA
1 <sub>1</sub>	A or B ports	V <sub>CC</sub> = 5.5 V	V <sub>I</sub> = 5.5 V			0.1			0.1	ША
I	Control inputs	V <sub>CC</sub> = 5.5 V,	V <sub>1</sub> = 2.7 V			20			20	μA
ΊН	A or B ports§	VCC = 5.5 V,	v = 2.7 v			70			70	μΑ
1	Control inputs		VI = 0.4 V			-0.5			-0.5	mA
۱Ľ	A or B ports§	$V_{CC} = 5.5 V,$	v] = 0.4 v		-0.75			-0.7		
lo¶		V <sub>CC</sub> = 5.5 V,	V <sub>O</sub> = 2.25 V	-50		-150	-50		-150	mA
			Outputs high		62	97		62	97	
ICC		$V_{CC} = 5.5 V$	Outputs low		95	149		95	149	mA
			Outputs disabled		79	123		79	123	

<sup>‡</sup> All typical values are at V<sub>CC</sub> = 5 V, T<sub>A</sub> =  $25^{\circ}$ C.

§ For I/O ports, the parameters IIH and IIL include the off-state output current.

The output conditions have been chosen to produce a current that closely approximates one half of the true short-circuit output current, IOS.



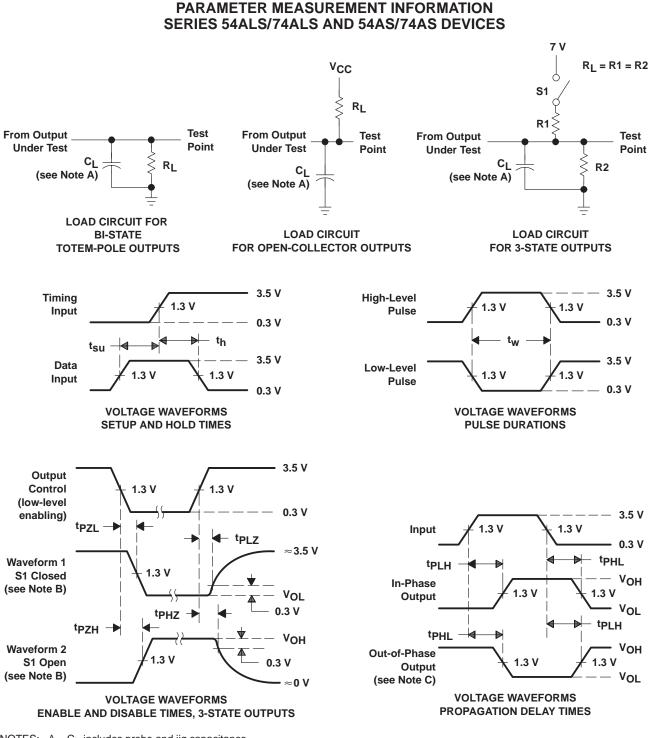
### switching characteristics (see Figure 1)

PARAMETER	FROM (INPUT)	TO (OUTPUT)	V <sub>C</sub> CL R1 R2 T <sub>A</sub>	UNIT			
			SN54A	S645	SN74A		
			MIN	MAX	MIN	MAX	
<sup>t</sup> PLH	A or B	David	2	11	2	9.5	ns
<sup>t</sup> PHL	AUD	B or A	2	10.5	2	9	115
<sup>t</sup> PZH	OE	A D	2	12	2	11	ns
tPZL	ÛE	A or B	2	12	2	10	115
<sup>t</sup> PHZ	OE	A or B	2	8	2	7	-
<sup>t</sup> PLZ	UE	AUID	2	13	2	12	ns

<sup>†</sup> For conditions shown as MIN or MAX, use the appropriate value specified under recommended operating conditions.



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NOTES: A. C<sub>L</sub> includes probe and jig capacitance.

- B. Waveform 1 is for an output with internal conditions such that the output is low except when disabled by the output control. Waveform 2 is for an output with internal conditions such that the output is high except when disabled by the output control.
- C. When measuring propagation delay items of 3-state outputs, switch S1 is open.
- D. All input pulses have the following characteristics: PRR  $\leq$  1 MHz,  $t_{f}$  =  $t_{f}$  = 2 ns, duty cycle = 50%.
- E. The outputs are measured one at a time with one transition per measurement.

#### Figure 1. Load Circuits and Voltage Waveforms





17-Dec-2015

### **PACKAGING INFORMATION**

Orderable Device	Status	Package Type		Pins		Eco Plan	Lead/Ball Finish	MSL Peak Temp	Op Temp (°C)	Device Marking	Samples
	(1)		Drawing		Qty	(2)	(6)	(3)		(4/5)	
8403301RA	ACTIVE	CDIP	J	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	8403301RA SNJ54ALS645AJ	Samples
8403301SA	ACTIVE	CFP	W	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	8403301SA SNJ54ALS645AW	Samples
SN54ALS645AJ	ACTIVE	CDIP	J	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	SN54ALS645AJ	Samples
SN54AS645J	ACTIVE	CDIP	J	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	SN54AS645J	Samples
SN74ALS645A-1DW	ACTIVE	SOIC	DW	20	25	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A-1	Samples
SN74ALS645A-1DWG4	ACTIVE	SOIC	DW	20	25	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A-1	Samples
SN74ALS645A-1DWR	ACTIVE	SOIC	DW	20	2000	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A-1	Samples
SN74ALS645A-1N	ACTIVE	PDIP	Ν	20	20	Pb-Free (RoHS)	CU NIPDAU	N / A for Pkg Type	0 to 70	SN74ALS645A-1N	Samples
SN74ALS645A-1N3	OBSOLET	PDIP	Ν	20		TBD	Call TI	Call TI	0 to 70		
SN74ALS645A-1NE4	ACTIVE	PDIP	N	20	20	Pb-Free (RoHS)	CU NIPDAU	N / A for Pkg Type	0 to 70	SN74ALS645A-1N	Samples
SN74ALS645A-1NSR	ACTIVE	SO	NS	20	2000	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A-1	Samples
SN74ALS645ADW	ACTIVE	SOIC	DW	20	25	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A	Samples
SN74ALS645ADWR	ACTIVE	SOIC	DW	20	2000	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A	Samples
SN74ALS645AN	ACTIVE	PDIP	N	20	20	Pb-Free (RoHS)	CU NIPDAU	N / A for Pkg Type	0 to 70	SN74ALS645AN	Samples
SN74ALS645AN3	OBSOLET	PDIP	Ν	20		TBD	Call TI	Call TI	0 to 70		
SN74ALS645ANSR	ACTIVE	SO	NS	20	2000	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	ALS645A	Samples
SN74AS645DW	ACTIVE	SOIC	DW	20	25	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	AS645	Samples
SN74AS645DWE4	ACTIVE	SOIC	DW	20	25	Green (RoHS & no Sb/Br)	CU NIPDAU	Level-1-260C-UNLIM	0 to 70	AS645	Samples



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Orderable Device	Status (1)	Package Type	Package Drawing		Package Qty	Eco Plan (2)	Lead/Ball Finish (6)	MSL Peak Temp	Op Temp (°C)	Device Marking (4/5)	Samples
SN74AS645N	ACTIVE	PDIP	Ν	20	20	Pb-Free (RoHS)	CU NIPDAU	N / A for Pkg Type	0 to 70	SN74AS645N	Samples
SN74AS645NE4	ACTIVE	PDIP	N	20	20	Pb-Free (RoHS)	CU NIPDAU	N / A for Pkg Type	0 to 70	SN74AS645N	Samples
SNJ54ALS645AJ	ACTIVE	CDIP	J	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	8403301RA SNJ54ALS645AJ	Samples
SNJ54ALS645AW	ACTIVE	CFP	W	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	8403301SA SNJ54ALS645AW	Samples
SNJ54AS645FK	OBSOLET	E LCCC	FK	20		TBD	Call TI	Call TI	-55 to 125		
SNJ54AS645J	ACTIVE	CDIP	J	20	1	TBD	A42	N / A for Pkg Type	-55 to 125	SNJ54AS645J	Samples

<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.

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.

(2) 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.

<sup>(4)</sup> There may be additional marking, which relates to the logo, the lot trace code information, or the environmental category on the device.

<sup>(5)</sup> Multiple Device Markings will be inside parentheses. Only one Device Marking contained in parentheses and separated by a "~" will appear on a device. If a line is indented then it is a continuation of the previous line and the two combined represent the entire Device Marking for that device.

<sup>(6)</sup> Lead/Ball Finish - Orderable Devices may have multiple material finish options. Finish options are separated by a vertical ruled line. Lead/Ball Finish values may wrap to two lines if the finish value exceeds the maximum column width.



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17-Dec-2015

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#### OTHER QUALIFIED VERSIONS OF SN54ALS645A, SN54AS645, SN74ALS645A, SN74AS645 :

- Catalog: SN74ALS645A, SN74AS645
- Military: SN54ALS645A, SN54AS645

NOTE: Qualified Version Definitions:

- Catalog TI's standard catalog product
- Military QML certified for Military and Defense Applications

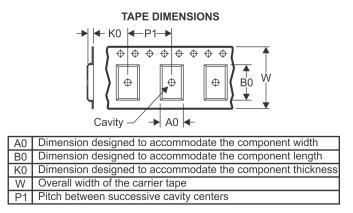
## **PACKAGE MATERIALS INFORMATION**

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### **TAPE AND REEL INFORMATION**





### QUADRANT ASSIGNMENTS FOR PIN 1 ORIENTATION IN TAPE



Device	Package Type	Package Drawing		SPQ	Reel Diameter (mm)	Reel Width W1 (mm)	A0 (mm)	B0 (mm)	K0 (mm)	P1 (mm)	W (mm)	Pin1 Quadrant
SN74ALS645A-1DWR	SOIC	DW	20	2000	330.0	24.4	10.8	13.3	2.7	12.0	24.0	Q1
SN74ALS645A-1NSR	SO	NS	20	2000	330.0	24.4	9.0	13.0	2.4	12.0	24.0	Q1
SN74ALS645ADWR	SOIC	DW	20	2000	330.0	24.4	10.8	13.3	2.7	12.0	24.0	Q1
SN74ALS645ANSR	SO	NS	20	2000	330.0	24.4	9.0	13.0	2.4	12.0	24.0	Q1

TEXAS INSTRUMENTS

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## PACKAGE MATERIALS INFORMATION

17-Aug-2016



\*All dimensions are nominal

Device	Package Type	Package Drawing	Pins	SPQ	Length (mm)	Width (mm)	Height (mm)
SN74ALS645A-1DWR	SOIC	DW	20	2000	367.0	367.0	45.0
SN74ALS645A-1NSR	SO	NS	20	2000	367.0	367.0	45.0
SN74ALS645ADWR	SOIC	DW	20	2000	367.0	367.0	45.0
SN74ALS645ANSR	SO	NS	20	2000	367.0	367.0	45.0

J (R-GDIP-T\*\*) 14 LEADS SHOWN

CERAMIC DUAL IN-LINE PACKAGE



NOTES: A. All linear dimensions are in inches (millimeters).

- B. This drawing is subject to change without notice.
- C. This package is hermetically sealed with a ceramic lid using glass frit.
- D. Index point is provided on cap for terminal identification only on press ceramic glass frit seal only.
- E. Falls within MIL STD 1835 GDIP1-T14, GDIP1-T16, GDIP1-T18 and GDIP1-T20.

W (R-GDFP-F20)

CERAMIC DUAL FLATPACK



- NOTES: A. All linear dimensions are in inches (millimeters).
  - This drawing is subject to change without notice. В.
  - C. This package can be hermetically sealed with a ceramic lid using glass frit.
    D. Index point is provided on cap for terminal identification only.
    E. Falls within Mil-Std 1835 GDFP2-F20



LEADLESS CERAMIC CHIP CARRIER

FK (S-CQCC-N\*\*) 28 TERMINAL SHOWN



NOTES: A. All linear dimensions are in inches (millimeters).

B. This drawing is subject to change without notice.

- C. This package can be hermetically sealed with a metal lid.
- D. Falls within JEDEC MS-004



## N (R-PDIP-T\*\*)

PLASTIC DUAL-IN-LINE PACKAGE

16 PINS SHOWN



NOTES:

- A. All linear dimensions are in inches (millimeters).B. This drawing is subject to change without notice.
- Falls within JEDEC MS-001, except 18 and 20 pin minimum body length (Dim A).
- $\triangle$  The 20 pin end lead shoulder width is a vendor option, either half or full width.



## **DW0020A**



## **PACKAGE OUTLINE**

### SOIC - 2.65 mm max height

SOIC



NOTES:

- 1. All linear dimensions are in millimeters. Dimensions in parenthesis are for reference only. Dimensioning and tolerancing per ASME Y14.5M. 2. This drawing is subject to change without notice. 3. This dimension does not include mold flash, protrusions, or gate burrs. Mold flash, protrusions, or gate burrs shall not
- exceed 0.15 mm per side.
- 4. This dimension does not include interlead flash. Interlead flash shall not exceed 0.43 mm per side.
- 5. Reference JEDEC registration MS-013.



## DW0020A

## **EXAMPLE BOARD LAYOUT**

### SOIC - 2.65 mm max height

SOIC



NOTES: (continued)

6. Publication IPC-7351 may have alternate designs.

7. Solder mask tolerances between and around signal pads can vary based on board fabrication site.



## DW0020A

## **EXAMPLE STENCIL DESIGN**

### SOIC - 2.65 mm max height

SOIC



NOTES: (continued)

- 8. Laser cutting apertures with trapezoidal walls and rounded corners may offer better paste release. IPC-7525 may have alternate design recommendations.
- 9. Board assembly site may have different recommendations for stencil design.



### MECHANICAL DATA

### PLASTIC SMALL-OUTLINE PACKAGE

#### 0,51 0,35 ⊕0,25⊛ 1,27 8 14 0,15 NOM 5,60 8,20 5,00 7,40 $\bigcirc$ Gage Plane ₽ 0,25 7 1 1,05 0,55 0-10 Δ 0,15 0,05 Seating Plane — 2,00 MAX 0,10PINS \*\* 14 16 20 24 DIM 10,50 10,50 12,90 15,30 A MAX A MIN 9,90 9,90 12,30 14,70 4040062/C 03/03

NOTES: A. All linear dimensions are in millimeters.

NS (R-PDSO-G\*\*)

**14-PINS SHOWN** 

- B. This drawing is subject to change without notice.
- C. Body dimensions do not include mold flash or protrusion, not to exceed 0,15.



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