Lead-Free Solder Paste

PF629-P30

Rev. 2017/07/11 Ver.03-01

BASIC OVERVIEW

SnAg0.3Cu0.7 Solder Paste
Halide Free
No Clean
Low Silver Solder Paste

APPLICATIONS

Universal Lead-Free SMD Solder Paste
Wide Range of Applications and PCB designs

FEATURES

Appearance	Gray paste w/o visible foreign and clusters					
Alloy Composition	Sn/Ag0.3/Cu0.7					JIS-Z-3282
Melting Point	217~226 °C					
Particle Size	(Type 3)	+45µm	< 1%	, - 20µm	< 10%	J-STD-005
	(Type 4)	+38µm	< 1%	, - 20µm	< 10%	
Powder Shape	Spherical					
Flux Content	11.5 ± 1.0 wt%					JIS-Z-3197, 8.1.2
Viscosity	200 ± 30 Pa.s (25±1°C, 10rpm, Malcom)					JIS-Z-3284 Annex 6
Flux Type	ROL0					J-STD-004

Alloy Detail Composition

(Sn)	(Ag)	(Cu)	(Ni)	(Ge)	(Zn)	(Al)	(Sb)	(Fe)	(As)	(Bi)	(Cd)	(Pb)
REM.	0.2~ 0.4	0.5~ 0.9	0~ 0.01	0~ 0.01	0.001 MAX	0.001 MAX	0.05 MAX	0.02 MAX	0.03 MAX	0.06 MAX	0.002 MAX	0.05 MAX

Patent No.: U.S Patent No. 6179935B1, Germany Patent No.19816671C2

(wt%)

Scan Code for Solder Paste Documents

www.nevo-solder.com

SHENMAO TECHNOLOGY

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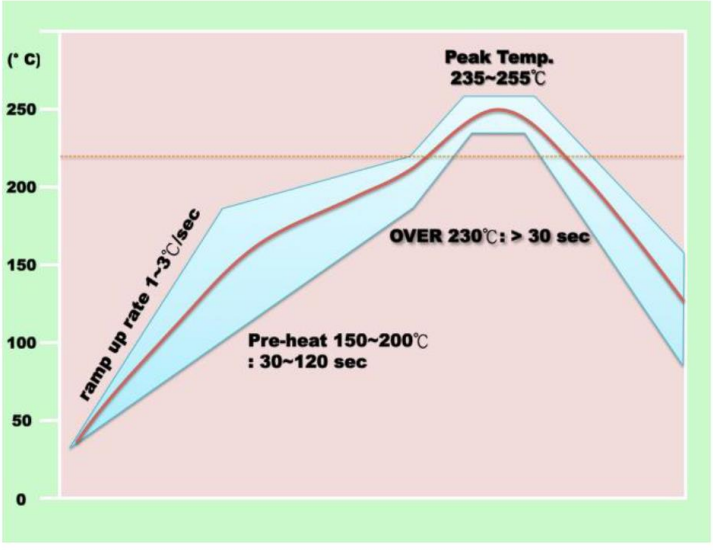
PERFORMANCE & RELIABILITY

Copper Plate Corrosion Test	Pass	IPC-TM-650, 2.6.15
Spreading Test	> 70%	JIS-Z-3197, 8.3.1.1
Halogen Content Test	ROL0	BS EN14582
Copper Mirror Test	Pass	IPC-TM-650, 2.3.32
Viscosity Test (25°C,10 rpm)	200 ± 30 Pa.s	JIS-Z-3284. Annex 6
Tackiness Test (gf)	> 130 (8hr)	JIS-Z-3284. Annex 9
Slump Test	Pass	JIS-Z-3284. Annex 7,8
Solder Ball Test	Pass	JIS-Z-3284. Annex 11

S.I.R. Test ▲	Pass	IPC-TM-650, 2.6.3.3
Electro Migration Test ◆	Pass	IPC-TM-650, 2.6.14.1

▲ *Test Conditions : 85 °C, 85% RH for 168hrs* ◆ *Test Conditions: 65°C, 88.5% RH for 596 hrs*

RECOMMENDED REFLOW PROFILE



Ramp Up Rate (30-150°C): **1.0-3.0 °C/sec**

Pre-heating Time (150-200°C): **30-120 sec**

Time Period Above 230°C: **>30 sec**

Peak Temperature: **235-255 °C**

Ramp Down Cooling Rate: **1.0-6.0 °C/sec**

Note: The recommended reflow profile is provided as a guideline. Optimal profile may differ due to oven type, assembly layout or other process variables.

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STORAGE & HANDLING:

- Refrigerate the solder paste at 0-10°C helps prolong shelf life. Normal shelf life is 6 months from production date (sealed jars).
- Keep away from direct sunlight.
- Allow the paste to reach ambient temperature 22-28°C for 3-4 hrs. Do not heat to raise temperature abruptly.
- Well mix paste with plastic spatula for 1-3 mins before use. Mixing time depends on tool type.
- At first, add 2/3 jar of solder paste onto stencil. Do not add more than 1 jar.
- Add a little amount of paste at a time on the stencil according to printing speed
- It is recommended to finish fresh paste within 24 hrs. To maintain paste quality, make sure not to store used paste and fresh paste in the same jar.
- After printing, it is suggested to place components to be mounted on the PCB and reflow within 4~6 hrs.
- If printing proces was interrupted for more than 1hr, be sure to remove paste from stencil and seal it in the jar.
- It is recommended to keep the environment at 22-28°C and RH 30-60% .
- To clean up printed circuit boards, it is suggested to use ethanol or isopropanol.

HOW TO ORDER

PF629 – P30 – T3 – 500

Solder Alloy	Flux	Particle Size	Weight / Packaging
PF629 = SnAg0.3Cu0.7	P30 = ROL0	T3 = 20-45µm	30 = syringe 30g
		T4 = 20-38µm	100 = syringe 100g
			150 = syringe 150g
			250 = plastic jar 250g
			500 = plastic jar 500g
			600 = small cartridge 600g
			1200 = large cartridge 1200g

CARTRIDGE

JAR

SYRINGE

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