

PRODUCT DATA SHEET

Web site : www.promosol.com



ECOREL EASY 802 SP - 803 SP

**Low residue no-clean solderpaste
For Closed Printer Head Systems and
standard printing (double squeegee)**



BENEFITS

➤ **EASY PROCESS** ➤ **EASY PRINTING** ➤ **EASY REFLOW**

FEATURES

- Long stencil life : more than 8 hrs.
- Abandon time on the stencil more than 4 hrs with excellent print restart.
- Printing speed : 60-150 mm/sec.
- Printing Closed printer head systems (Proflow, Rheopump, Crossflow...).
- Solderballing resistance at high % RH.
- Good wettability on all finishes.
- Stable tack : more than 12 hrs at 22°C between printing and component placement.
- No slump out by preheat.
- Slight yellow residue after reflow, ate probe compatible.
- No halogen.
- High SIR – No residue deterioration during accelerated ageing.

SPECIFICATIONS		according to C 90550	
ECOREL EASY	802 SP	803 SP	
Alloy	Sn62 Pb Ag2	Sn63 Pb	
Melting point	178	183	
Powder size distribution	25-45 microns		
Metal content (%)	90		
Residue after reflow soldering (%)	60		
Halogen content (%)	0		
Viscosity* (Pa.s at 20°C) <small>* Brookfield RVT, TF at 5 RPM</small>	1100		
FUNCTIONAL TESTS		NORM	
Flux classification	FC L 0 F-SW 32 113	C 90550 ANSI/J-STD-004 DIN 8511 ISO 9454	
Solderballing test	Class 1	C 90550	
Copper mirror	Pass	ANSI/J-STD-004	
Chromate paper	Pass	ANSI/J-STD-004	
Copper corrosion	Pass	ANSI/J-STD-004	
S.I.R. OHMS		ANSI/J-STD-004	
After 21 days 85°C - 85 % RH - 50 Volts	> 10 ⁹		
End of cycle 20°C - 65 % RH	> 10 ¹⁰		



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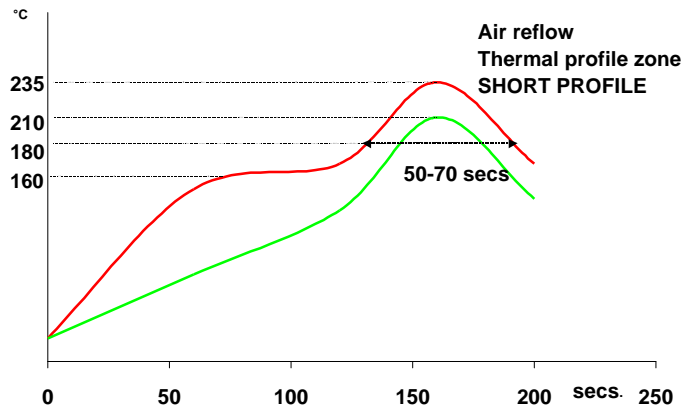
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REFLOW THERMAL PROFILE

The opposite figures indicate, according to thermal mass of PCB and mounted components, the minimum and maximum areas, which have to be respected to obtain a good reflow under air without solderball.

By using a nitrogen atmosphere, you can enlarge your process window towards reflow thermal profile. This permits better wetting and coalescence.

A regular preheat temperature rise is preferable to a too long plateau, in order to avoid solderbeading to get a shining joint and a uniform residue distribution.

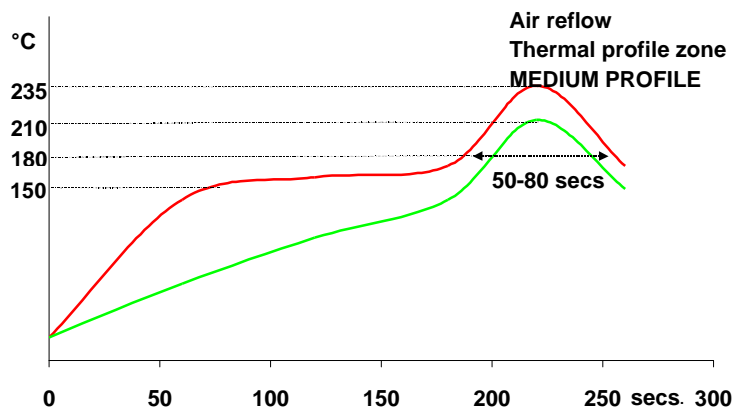


PRINTING

ECOREL EASY 802SP & 803SP solderpastes are particularly easy to stencil print down to 0.3 mm pitch and up to 150 mm/sec. squeegee speed.

SOLDERPASTE PREPARATION

Before printing, it is essential to properly mix the solderpaste, either manually with a spatula, or by doing several preliminary prints on the stencil.

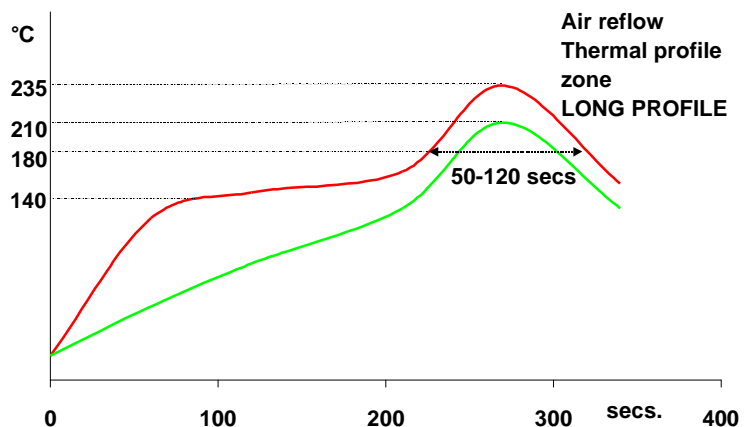


PACKAGING

- ✦ Jars : 250 g – 500 g and 1000 g
- ✦ Cartridges : 700 g and 1400 g
- ✦ Proflow cassette 800g

STORAGE

To ensure the best product performance, the recommended storage temperature range is 5°C to 10°C. A shelf life of 9 months is achieved under these conditions. For cartridges, shelf life is 6 months.



HEALTH and SAFETY

Please refer to MSDS.

*The information given herewith is designed only as a guidance and is not to be considered warranty of PROMOSOL.
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