

PRODUCT DATA SHEET



ECOREL EASY 802 M – 803 M

Low residue no-clean solderpaste



BENEFITS

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

FEATURES

- Long stencil life : more than 8 hrs.
- Abandon time on the stencil more than 2 hrs with excellent print restart.
- Printing speed : 20-150 mm/sec.
- Solderballing resistance at high % RH.
- Good wettability on all finishes.
- Stable tack : 8 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 M	803 M	
Alloy			
Sn62 Pb Ag2	x		
Sn63 Pb			x
Powder size distribution			
25-45 microns	x		x
Melting point	178		183
Metal content (%)		89,5	
Residue after reflow soldering (%)		50	
Acid index on organic part (mg/g KOH)		103	
Halogen content (%)		0	
Viscosity* (Pa.s at 20°C)		900	
* Brookfield RVT, TF at 5 RPM			
FUNCTIONAL TESTS		NORM	
Flux classification	FC	C 90550	
	L 0	ANSI/J-STD-004	
	F-SW 32	DIN 8511	
	113	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		



FRANCE

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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 802 M and 803 M solderpastes are particularly easy to screen print down to 0.4 mm pitch.

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

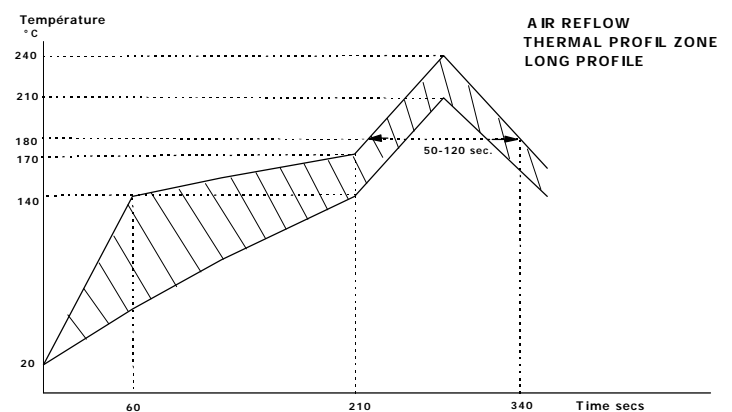
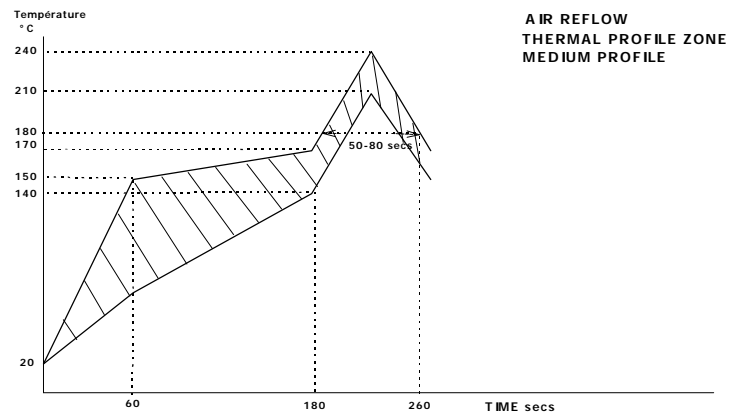
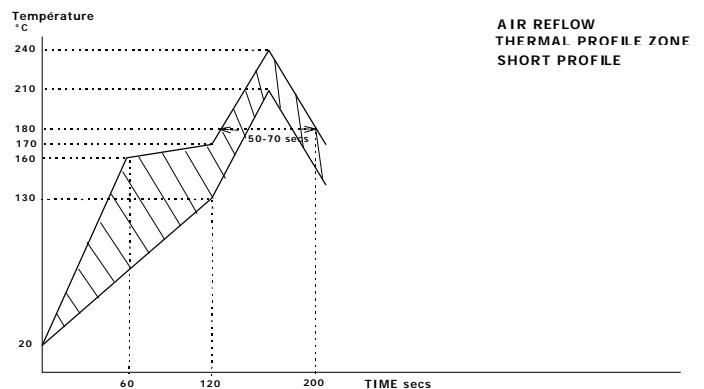
- ✦ Jars : 250 g – 500 g and 1000 g
- ✦ Cartridges : 700 g and 1400 g

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.

FPCGB 08023 TSI PRO 02 – 10.12/99



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