

# PRODUCT DATA SHEET



## ECOREL EASY 802 MP– 803 MP

Low residue no-clean solderpaste  
For Closed Printer Head Systems



### BENEFITS

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

### FEATURES

- High and stable viscosity to fit in closed printer head (Proflow, Rheopump...)
- Also printable with conventional squeegees
- Long stencil life : more than 8 hrs.
- Abandon time on the stencil more than 2 hrs with excellent print restart.
- Printing speed : 20-100 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 MP	803 MP	
Alloy			
Sn62 Pb Ag2	x		
Sn63 Pb			x
Powder size distribution			
25-45 microns	x		x
Melting point	178		183
Metal content (%)		90	
Residue after reflow soldering (%)		60	
Acid index on organic part (mg/g KOH)		103	
Halogen content (%)		0	
Viscosity* (Pa.s at 20°C)		1100	
* Brookfield RVT, TF at 5 RPM			
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 <sup>9</sup>		
End of cycle			
20°C – 65 % RH	> 10 <sup>10</sup>		



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

In Proflow systems, set up example  
head length : 40 cm – speed : 80mm/sec  
pressure on head 4kg .on paste: 2.5kg

## 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 850g

## STORAGE

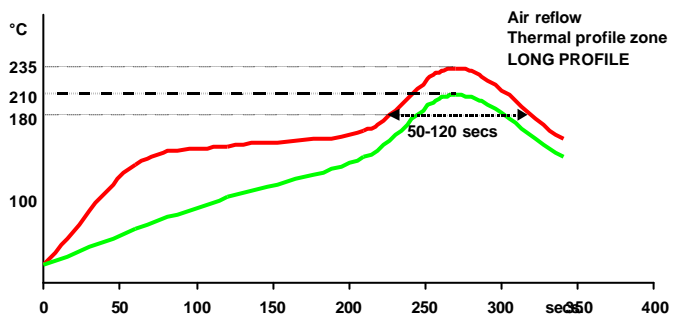
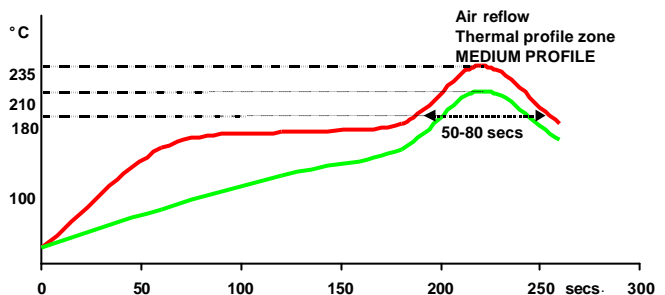
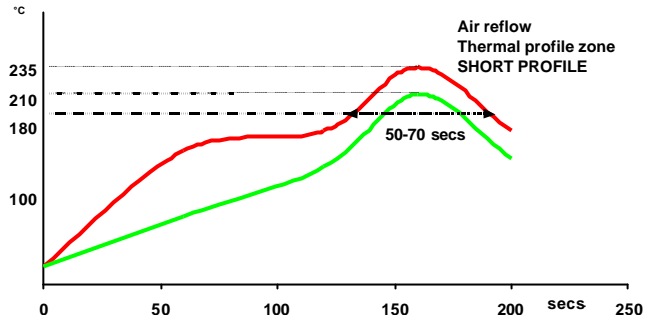
To ensure the best product performance, the recommended storage temperature range is 5°C to 10°C. A shelf life of 9 months is achieved under these conditions. For cartridges, shelf life is 6 months.

## 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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