

PRODUCT DATA SHEET



ECOREL FREE X 13013

LEAD FREE no-clean solder paste



<u>SPECIFICATIONS</u>	According to C 90 550 IPC TM 650	
Alloy Powder size distribution Melting point (°C) Metal content (%) Residue after reflow soldering (%) Acid index on organic part (mg KOH/g) Halogen content (%) Viscosity* (Pa.s 20°C) <i>*Brookfield RVT - TF at 5 rpm.</i>	SnAg4Cu0,5 25 - 45 217 89 61 105 0 900	
<u>FUNCTIONAL TESTS</u>	<u>NORM</u>	
Flux classification Solderballing test Copper mirror Chromate paper Copper corrosion Surface Insulation Resistance OHMS After 7 days 85°C - 85 % RH - 50 Volts 25°C - 65 % RH	FC L0 F-SW 32 113 Class 1 pass pass pass > 10 ¹⁰ > 10 ¹²	C 90550 ANSI/J-STD-004 DIN 8511 ISO 9454 C 90550 ANSI/J-STD-004 ANSI/J-STD-004 ANSI/J-STD-004 ANSI/J-STD-004



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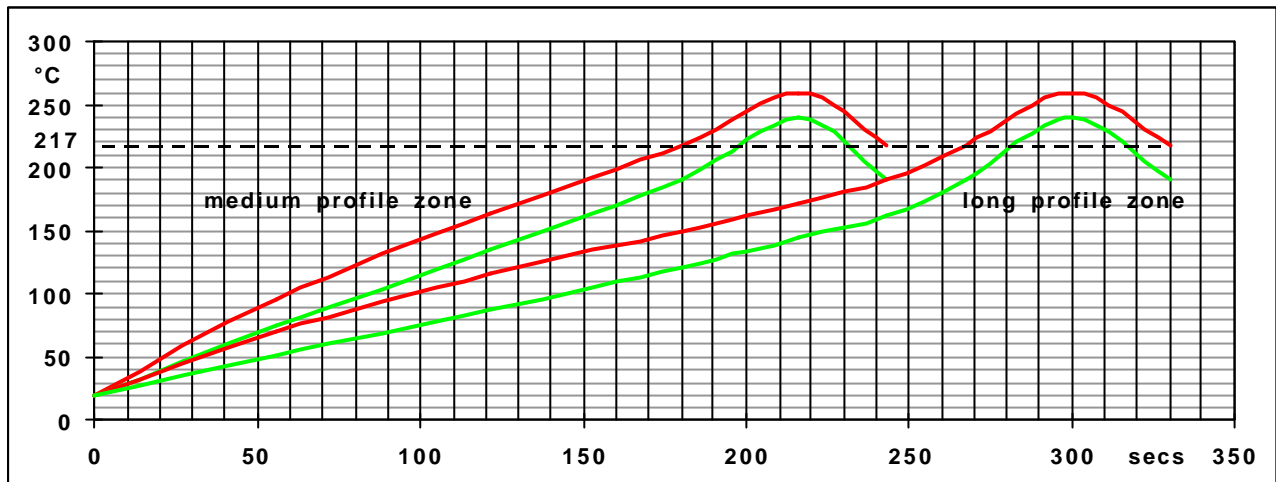
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REFLOW THERMAL PROFILE

The under graph indicates, according to thermal mass of PCB and mounted components, the optimal profile zone which have to be respected to obtain a good reflow under air without solderballs.



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 X 13013 solder paste is particularly easy to print down to 0.3 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 : 250g - 500 g and 1 kg.
- ✦ Cartridges : 700 g and 1,400 Kg.

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 in jars. In cartridges, the shelf life is 6 months.

Before use, allow several hours at room temperature for the paste to stabilize. Once a jar has been opened, a refrigerated storage is no longer required.

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.
03/00



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