

**Trade Name:** SRC Sn62U SS4M

**1. Company Address:** Almit GmbH Ph.: +49 6061 96925-0  
 Unterer Hammer 3 Fax: +49 6061 96925-18  
 (D) 64720 Michelstadt - near Frankfurt

**2. Validity:** This specification is specified for:  
 Almit-Solder-Paste SRC Sn62U SS4M  
 Delivered by Almit GmbH to: \_\_\_\_\_

**3. Diameter & Allowance:**

|           |         |     |     |      |      |
|-----------|---------|-----|-----|------|------|
| Weight    | 20g     | 40g | 80g | 100g | 250g |
| Allowance | -0, +5g |     |     |      |      |

**4. Deliverable Reel Size:**

|            |            |             |                  |
|------------|------------|-------------|------------------|
| Metal Name | Solidus °C | Liquidus °C | Specific Gravity |
| Sn62       | 179        | 190         | 8.4              |

**5. Physical Properties:**

| Test                       | Characteristics     | Test Methods        |
|----------------------------|---------------------|---------------------|
| Metal Content              | 85.0 ± 1.0          | IPC-TM-650 2.2.20   |
| Silver Chromate            | pass                | IPC-TM-650 2.3.33   |
| Copper Mirror Test         | pass                | IPC-TM-650 2.3.32   |
| SIR (85°C, 85%, 168hr) (Ω) | ≥ 1x10 <sup>8</sup> | IPC-TM-650 2.6.3.3  |
| Corrosion Test             | pass                | IPC-TM-650 2.6.15   |
| Flux materials composition | RO                  | J-STD-004B          |
| Quantitative Halide        | L1                  | IPC-TM-650 2.3.28.1 |
| Fluorides By Spot Test     | pass                | IPC-TM-650 2.3.35.1 |

**6. Characterisitcs:**

| Composition | Components |       |        |       |       |        |       |      |
|-------------|------------|-------|--------|-------|-------|--------|-------|------|
|             | Sn         | Pb    | Cu     | Ag    | Sb    | Bi     | Au    | In   |
| Standard    | 62.0       | Rest  | ≤0.05  | 2.0   | ≤0.12 | ≤0.05  | ≤0.08 | ≤0.1 |
| Composition | Components |       |        |       |       |        |       |      |
|             | Al         | As    | Cd     | Fe    | Ni    | Zn     |       |      |
| Standard    | ≤0.001     | ≤0.03 | ≤0.002 | ≤0.02 | ≤0.01 | ≤0.001 |       |      |

**7. Solder Powder Size & Distribuon:**

% of Sample by Weight – Nominal Size

| Type       | not larger than | less than 1% larger than | at least 80% between | at most 10% less than |
|------------|-----------------|--------------------------|----------------------|-----------------------|
| Type 5 (U) | -               | 28 Microns               | 10 - 28 Microns      | 10 Microns            |

**8. Lot-Size:** A single lot contains 500kg which is the amount of one melting.

**9. Quality and Inspecon:**

Inspecon items are applied to each lot as follows:

| Test No. | Inspection Item    | Contents  | Standard   |       |        |
|----------|--------------------|---|--|-------|--------|
| 1        | Appearance         | Color   | Comparison with Limit Specimen                                 |       |        |
| 2        | Weight             | Net Weight  | -0 ; +5  | (g)   |        |
| 3        | Solder Powder Size | 10 - 28 $\mu\text{m}$ (U)                                     | 90 $\leq$  | (wt%) |        |
| 4        | Metal Composition  | Pb  | Rest   | (wt%) |        |
|          |                    | Sn  | 62.0 $\pm$ 0.5   | (wt%) |        |
|          |                    | Ag  | 2.0 $\pm$ 0.2  | (wt%) |        |
|          |                    |   |  | (wt%) |        |
| 5        | Characteristics    | Flux Content  | 15.0 $\pm$ 0.5   | (wt%) |        |
| 6        |                    | Solder Balling Test   | Comparison with Limit Specimen                                 |       |        |
| 7        |                    | Viscosity<br>(Spiral type, 10rpm, 25°C)<br>(IPC-650-2.4.34.3) | 100000 $\pm$ 30000<br>100 $\pm$ 30                             | (cps) | (Pa•s) |
| 8        |                    | Solderability on Cu-Plate                                     | Comparison with Limit Specimen                                 |       |        |
| 9        |                    | Dryness   | Chalk powder should be easily removed from each test specimen. |       |        |

\*Straight lines of solder paste are printed on a JIS-2 type substrate then reflowed. The reflowed solder is examined with a stereo microscope at 30X magnification. No more than 2 solder balls larger than one fifth the size of the pattern gap is allowed per gap.

**10. Packing:**

| Individual Package |                 | Outer Package |               |
|--------------------|-----------------|---------------|---------------|
| Unit               | Packing         | Unit          | Packing       |
| 20g                | 5cc Cartridge   | -             | Cardboard Box |
| 40g                | 10cc Cartridge  | -             |               |
| 80g                | 30cc Cartridge  | -             |               |
| 100g               | 30cc Cartridge  | -             |               |
| 250g               | 100cc Cartridge | -             |               |

**11. Identification:**

|                    | Cartridge                            | Cardboard        |
|--------------------|--------------------------------------|------------------|
| Name               | Almit-Solder-Paste<br>SRC Sn62U SS4M | same as the left |
| Lot Nr.            | (Ex.) 120119-9 (JJMMTT)              | dto.             |
| Solder Powder Size | 10 - 28 $\mu\text{m}$                | dto.             |
| Date of Mfg.       | (Ex.) 19.01.2012                     | dto.             |
| Net Weight         | (Ex.) 20g                            | dto.             |
| Maker              | Nihon Almit Co. Ltd.                 | dto.             |

**10. Maker Address:**

Nihon Almit Co. Ltd.  
Almit Bldg., 2-14-2 Yayoicho, Nakano-ku, Tokyo, Japan

**11. In case of changing this specification it should be accepted by:**

Signature\_\_\_\_\_ Date\_\_\_\_\_

**12.** This product is manufactured, using all guaranteed materials according to the legal law regulations.

**13. Shelf Life:**

Up to 6 months from the manufactured date (lot number).