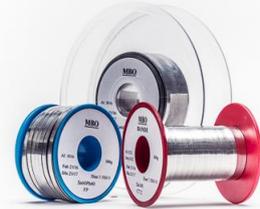


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Ref: Solder Preforms		
Created on: 03/05/2001	SOLDER PREFORMS Tape & reel packaging	



Solder Preforms are used in a variety of applications that require precise amount of solder.

Major features:

- **With incorporated flux and solid preforms**
- **Low voiding**
- **Preforms with tight tolerances**
- **Wide range of alloys**

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WIDE RANGE of ALLOYS:

A wide assortment of alloys is available in liquidus temperatures that range from 145°C to 301°C.

Alloy selection should be based on strength and other required physical properties, as well as the preferred soldering temperature and the operating temperature of the device being soldered. A general rule is to select an alloy that melts at least 60°C higher than the operational temperature of the part being soldered.

Metals and alloys have different characteristics that can affect the ease with which they can be made into different shapes and thicknesses. It is important to consider the shape of the final preform in the alloy selection process.

Alloy	Melting point °C	
	Solidus	Liquidus
Sn96.5Ag3Cu0.5 (SAC 305)	217	220
Sn99Ag0.3Cu0.7 (SAC 0307)	217	227
Sn96.5Ag3.5	221	221
Sn100	232	232
Sn99.3Cu0.7 (SP/SP PLUS)	227	227
Sn99CuNiGe	227	227
Sn60Pb40	183	190
Sn62Pb36Ag2	179	179
Pb93.5Sn5Ag1.5	296	301
Sn50Pb32Cd18	145	145
OTHERS ON REQUEST		

AVAILABLE DIMENSIONS:

Solder Preforms come in standard shapes such as squares, rectangles, washers and discs. Typical sizes range from 1 mm up to 30mm. Others sizes, as well as custom shapes, are also available. Dimensions can be held to tight tolerances to assure volume accuracy.

The location of the solder joint and the volume of solder needed will determine the size and shape of the preform. Once the flat dimensions (diameter, length, width) have been determined, the thickness can be adjusted to achieve the desired volume of solder. Generally, for through-hole connections, add 15-20% to the calculated volume for a good fillet. For pad to pad joints, figure about 5% less surface area than the pad.

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DISCS

Diameter (mm)
1
1,7
2
2,3
2,5
3
4,9
5
5,8
6
7
7,4
7,6
8
9
10
12
13,5
15
16
19

SQUARES

Dimensions (mm)
1.50 X 1.50
2.00 X 2.00
3.00 X 3.00
4.10 X 4.10
5.00 X 5.00
7.00 X 7.00
8.40 X 8.40
9.00 X 9.00
12.4 X 12.4
25 X 25

RECTANGLES

Dimension (mm)
2.00 X 1.25
2.78 X 1.76
4.30 X 2.80
4.50 X 1.40
4.60 X 3.00
5.50 X 1.40
6.00 X 1.50
6.00 X 5.00
7.62 X 5.08
11.43 X 7.62
12.00 X 3.00
16.80 X 11.09
17.00 X 8.00
20.50 X 16.80
30 X 10

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WASHERS

Outer diameter (mm)	Inner diameter (mm)
1,6	0,6
1,6	0,9
1,72	1,3
1,9	0,9
2	1,1
2,1	0,8
2,8	1,65
3	1,25
3,04	2,05
3,3	1,5
3,5	1,95
3,6	2,6
3,87	2,46
3,9	2,4
4	1,5
4,3	2,97
4,5	2,1
4,5	3,1
4,5	3,25
5	1,5
5	2
5	3,3
5,2	3,7
5,6	4,23
5,8	2,5

Outer diameter (mm)	Inner diameter (mm)
6	2,5
6,5	4,8
7	4,6
7,4	3,5
7,5	6
7,7	4,85
8	3,4
8,2	6,2
10	8
11,43	7,62
12	10
12	10,2
13	11
13,5	8
14	12
14,7	12,7
16	14
19	16
23,5	18
24	21
25,4	6,35
27,78	19,5
28,58	17,46
29	23
30,95	18,25

RECOMMENDED FLUXES (J-STD 004 classification):

J-STD 004 Classification	MBO brand name
ROL0	A0, RT15, EL
ROL1	CT2, ROB
ROM1	A11, CR, RD, RL

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PACKAGING / STORAGE:

Solder Preforms come in a variety of packaging options, including tape and reel. To minimize excessive handling, and exposure to air and subsequent oxidation, Solder Preforms should be packaged according to the quantity used during a typical work shift.

The shelf life of Solder Preforms is 2-years from the date of manufacture (DOM).

<p><u>SAFETY:</u> Material Safety Data Sheet available on request. Please consult it before use.</p>	<p><u>ADDITIONAL INFORMATION:</u> Quality Certificate available on request.</p> <p>Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in France).</p> <div style="text-align: right;">   </div>
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We cannot anticipate any and all conditions and situations under which the information and our products or the combination of both with others will be used. We do not assume any liability in the safety and suitability of our products alone or in combination with others. Users must make their own tests to determine the safety and suitability of each product used alone or with other products for their own use. Except any previous written agreement, our products are sold without guarantee and customers must assume all liability for any loss or damage suffered by themselves or by third parties, either from handling or use of our products alone or with others. In case of any difference or variation seen during the use of the products we request that you contact our technical department.

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