



# NO-CLEAN SOLDER PASTE

## HALIDE FREE

### "TITAN HT12"



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**TITAN HT12** no-clean solder paste is carefully formulated to confer high activity soldering at elevated temperatures and yet, leaves very low benign residues.

- Halide-free.
- High activity even at elevated temperatures.
- Low and safe residue.
- Fast print capabilities (up to 150mm/s).
- Lead-free option available.
- Long abandon time (>4 hours).
- Extended tack-life (>48 hours).
- Long stencil-life (>8 hours).
- Fine-pitch (400µm) and ultra-fine pitch (<300µm) capabilities.
- **ROL0** (J-STD 004)
- **SIR : Pass** > 3.3 \*10<sup>8</sup> ohms

**TITAN HT12** no-clean solder paste is made to strict quality assurance standards.

Alloys	Metal content (%)	Viscosity (cP)
Sn63Pb37	90	900,000
Sn62PbAg2	90	900,000
Pb92.5Sn5Ag2.5	90	900,000
Sn95.5Ag3.8Cu0.7	89	900,000
Sn95Sb5	89	900,000

## Printing

### **Stencil**

Stainless steel, brass or nickel. Chemical etched, laser cut or electroformed.

### **Squeegee**

Stainless steel or 80-100 durometer polyurethane.

### **Print speed**

50-150 mm/s. Generally slower for fine pitch.

### **Squeegee pressure**

5-10 Kg. Generally higher for fine pitch.

### **Snap-off**

0 to 0.25mm. On contact printing is preferred.

### **Ambient Conditions**

18-22°C and 35% to 70% RH. Minimize exposure of paste direct to air flow.

### **Cleanup-Stencils and Tools**

Most stencil wipes and stencil cleaners.

## Reflow

### **Heating Methods**

Convection, infrared, vapour phase, hot plate, hot bar, laser and others. Aerobic or inerted.

### **Heating Profile**

See suggested reflow profile for specific alloy.

### **Cleaning Equipment**

Spray, immersion, vapour degreaser or scrubber.

### **Cleaning solvents**

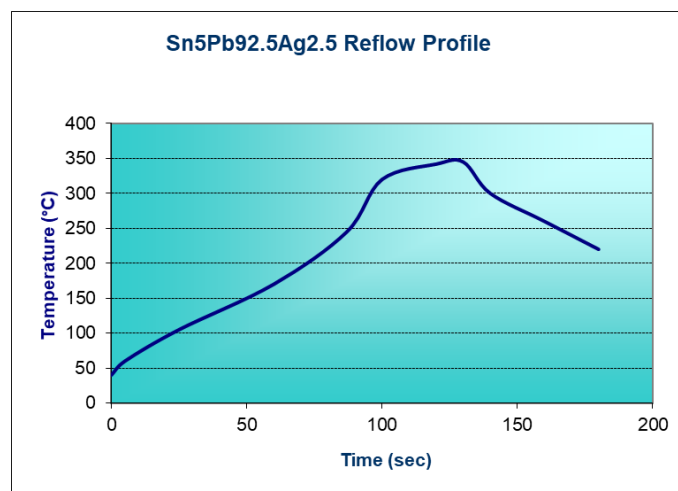
Most stencil cleaners and saponifiers.

### **Temperature**

35-60°C.

### **Spray Pressure**

20 to 40 psi.



**Packaging:** jars of 250g, 500g - cartridges of 500 and 1000 g - Proflow® of 800g - others on request.

**Storage:** in original container between 5 and 10°C for up to 12 months. Wait until the pot has reach the ambient temperature before opening to avoid water condensation on the surface of the paste. Once opened, do not return to the fridge. Should be stored at ambient conditions within two weeks.

### **Additional information:**

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in France).

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