


Updated : 02/05/2013	<b>SPECIFICATIONS</b>			
Reference : Solder paste				
Previous : 10/2005	<b>Type 393 E2</b>	<b>No Clean</b>	<b>Pb92.5Sn5Ag2.5</b>	

### 1-**General Characteristics:**

The solder paste type 393 E2 has been developed by MBO laboratories especially for pneumatic deposition and let safe and clear residues.

#### **ADDITIONAL INFORMATION:**

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

### 2 – **Physical characteristics:**

Chloride content	=	< 0,05 % (no chloride)
Acid value IA	=	110 mg KOH/g
RNV	=	60 %
Composition	=	85 % metal + 15% flux
Viscosity	=	500 Pa.s (viscosimeter RVT 5 t/min 20°C)

Maximum impurities:

Cu	Cd	Sb	Bi	Fe	Zn	Al	As	S	Cl	P	Autre
<0.05	<0.002	<0.05	<0.01	<0.02	<0.001	<0.001	<0.01	<0.001	<0.001	<0.001	<0.05

Alloy = Pb92.5Sn5Ag2.5

Other alloys Sn63Pb37, Sn43Pb43Bi14, Sn96Ag4 are available upon request.

Powder size:

Class 2 – particles size = 45 à 75 µm


Class 3 – particlesize = 25 à 45 µm

Smallest classes are upon request (Class 4 and Class 5).

### 3 - **Application**

Optimal rheological properties are optimum around 20°C.

Storage must be in cool place (around 5°C) before using let the paste minimum 1 hour at room temperature in closed container.

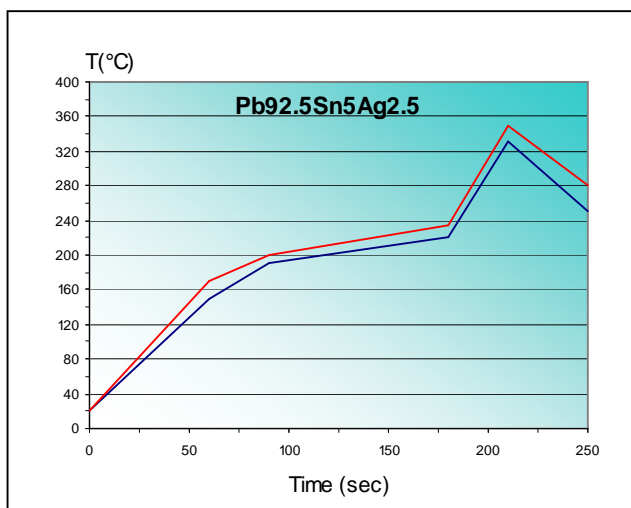
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#### 4 – Using instructions:

**Reflow:** infra-red, convection, vapour phase

**Preheating:** Preheating is necessary to evaporate solvents and to activate the flux. End of preheating before melting must be around 220°C to 240°C. Melting must be between 320°C and 360 °C for HMP Alloy.

**Washing:** after melting residues can be let on PCB without corrosion problems



#### 5 - Miscellaneous

**Labelling :** Pb92.5Sn5Ag2.5 393 E2 – 85 – 3 – 500

**Pb92.5Sn5Ag2.5**  
Alloy

393 E2  
Ref.

85  
metal %

3  
Class

500  
Viscosity Pa.s

**Packaging:** Syringes of 20g, 40g, 100g, 200g.

**Storage:** 12 months in closed syringe (5 à 10°C).