



# NO-CLEAN SOLDER PASTE DISPENSING GRADE



## "ORION™ 410RA Di"

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ORION™ 410RA Di no-clean dispensing grade solder paste is carefully formulated to confer high activity soldering and yet, leaves very low clear, benign residues.

- RA formulation (0.2% halide on total).
- High activity.
- Low and safe residue.
- Lead-free option available.
- Extended tack-life (>48 hours).
- Excellent slump resistance.

ORION™ 410RA Di no-clean dispensing grade solder paste is made to strict quality assurance standards.

Alloys	Metal content (%)	Viscosity (cP)
Sn96Ag4	85 to 86	300,000 – 500,000
Sn95Sb5	85 to 86	300,000 – 500,000
Sn95.5Ag3.8Cu0.7	85 to 86	300,000 – 500,000
Sn99Cu1	85 to 86	300,000 – 500,000

### Dispensing

ORION™ 410RADi has been designed for most types of solder paste dispensing machines equipped with needles down to 0.41mm (using 25-45µm powder). Finer dispensing needles require 15-30µm powder.

**Packaging:** Syringes and cartridges of 5cc, 10cc, 30cc and 50cc. Others on request.

### **Ambient Conditions**

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

### **Cleanup-Nozzles and Tools**

Use MBO Easy-Purge 400 conditioning fluid.

### 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**

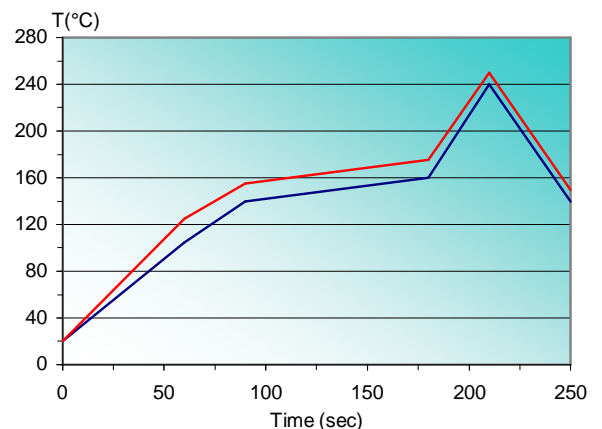
Most stencil cleaners and saponifiers.

#### **Temperature**

35-60°C.

#### **Spray Pressure**

20 to 40 psi.



**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 Europe).