SOLDER PASTE
NO-CLEAN
STORAGE AT ROOM TEMPERATURE
"LEAD FREE"

Created: 25/01/2013- Updated: 29/10/2014 - Index 02

SIRIUS 1 LFP no-clean and lead free solder paste is carefully formulated in MBO Laboratories to confer high activity soldering and yet, leaves very low, clear, benign residues.
This product, suitable for screen printing, meets the international requirements of the electronics industry.
Its composition has been specially developed for pin-test.
SIRIUS 1 LFP no-clean and lead free solder paste **can be stored up to 3 months at room temperature (up to 25°C) without deterioration.**

- Halide-free.
- High activity.
- Low, safe and pin-testable residue.
- Fast print capabilities (up to 150mm/s).
- Long abandon time (24 hours).
- Long stencil-life (16 hours).
- Fine-pitch (400µm) and ultra-fine pitch (<300µm) capabilities.
- Available powder sizes: type 3 (25-45µm), 4 (20-38µm) and 5 (15-25 µm). Other: consult us.

SIRIUS 1 LFP no-clean solder paste is made to strict quality assurance standards.

Alloys	Solidus-Liquidus	Metal content (%)
Sn95.5Ag3.8Cu0.7	E217°C	88.5-89
Sn96.5Ag3Cu0.5	217-219°C	88.5-89
Sn99Ag0.3Cu0.7	217-228°C	88.5-89
Sn99CuSP	E227°C	88.5-89
Other: consult us.		

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. Best results: 80 to 120 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.

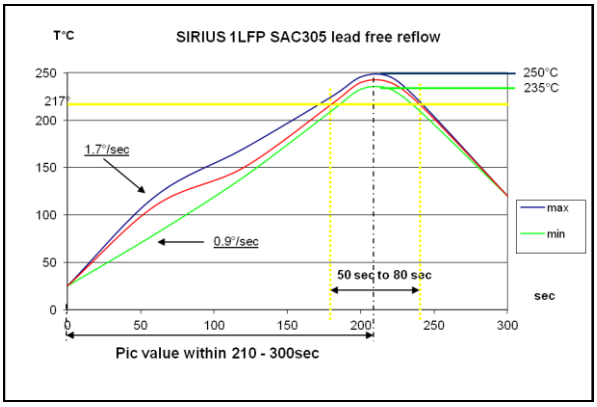
Ambient Conditions
18-22°C and 35% to 70% RH. Minimize exposure of paste direct to air flow.

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.



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

Storage: **Can be stored up to 3 months at room temperature (up to 25°C) without deterioration** in original container or between 5 and 10°C up to 12 months. In this case, wait until the pot has reached the ambient temperature before opening to avoid water condensation on the surface of the paste. Once opened, do not return to the fridge.

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

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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