



**ORION™ 410 RA** no-clean 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.
- Fast print capabilities (up to 150mm/s). Best results: 80 to 120 mm/s
- Lead-Free option available.
- Long abandon time (>8 hours).
- Extended tack-life (>48 hours).
- Long stencil-life (>8 hours).
- Fine-pitch (400µm) and ultra-fine pitch (<300µm) capabilities.

**ORION™ 410 RA** solder paste is made to strict quality assurance standards.

Alloys	Metal content (%)	Viscosity (cP)
Sn63Pb37	89.5	650,000 – 850,000
Sn62PbAg2	89.5	650,000 – 850,000
Sn95.5Ag3.8Cu0.7	88.5	650,000 – 850,000
+ Others	On request	

### 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. Minimise exposure of solder paste to direct air flow.

#### Cleaning of Stencils and Tools

Most stencil wipes and stencil cleaners. Contact MBO for details.

### Reflow

#### Heating Methods

Hot air 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, if required.

#### Cleaning solvents

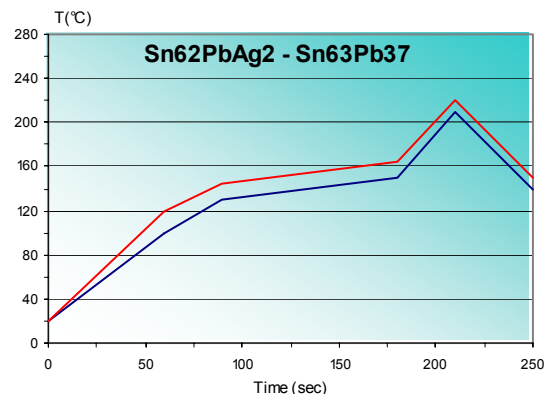
Most stencil cleaners and saponifiers.

#### Temperature

35-60°C.

#### Spray Pressure

20 to 40 psi.



### Packaging

250g and 500g jars. 25g, 75g, 500g and 1000gm Cartridges. 800gm Proflow®. Others on request. Contact MBO.

### Storage

In original container between 5 and 10°C for up to 12 months. Wait until the pot has reached ambient temperature before opening to avoid water condensation on the surface of the paste. Once opened, do not return to the fridge. Product should be stored at ambient conditions and used within one week. Dispensing grades available.