


Updated : 23/10/2018	SPECIFICATIONS			
Reference : Solder paste				
Previous : 02/05/2013	Type 393 E2	No Clean	Pb92.5Sn5Ag2.5	

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. It can also be used in printing applications.

ADDITIONAL INFORMATION:

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

2 – Physical characteristics:

Chloride content	= No chloride
Acid value IA	= 110 mg KOH/g
RNV	= 60 %
Composition	= 85 % metal + 15% flux (Dispensing) and 88.5 % metal + 11.5% flux (Printing)
Viscosity	= 500 Pa.s (viscosimeter RVT 5 t/min 20°C)

Alloy = Pb92.5Sn5Ag2.5

Other alloys Sn63Pb37, Sn43Pb43Bi14, Sn96.5Ag3.5 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.

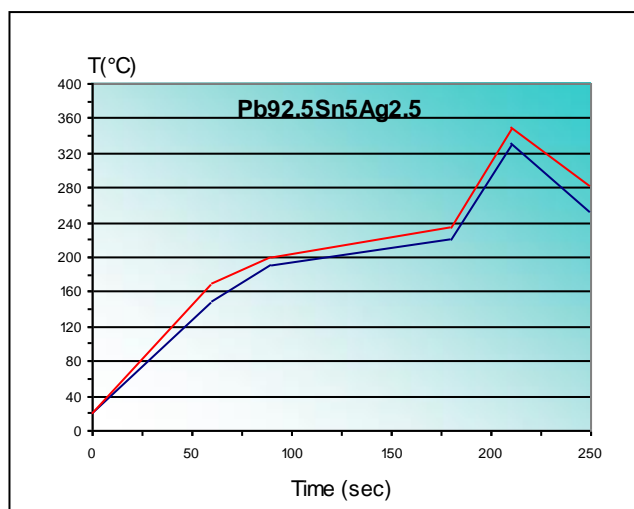
Updated : 23/10/2018	SPECIFICATIONS			
Reference : Solder paste				
Previous : 02/05/2013	Type 393 E2	No Clean	Pb92.5Sn5Ag2.5	

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 (Dispensing)

Pb92.5Sn5Ag2.5
Alloy

393 E2
Ref.

85
metal %

3
Class

500
Viscosity Pa.s

Pb92.5Sn5Ag2.5 393 E2 – 88.5 – 3 – 500 (Jar)

Packaging: Syringes of 20g, 40g, 100g, 200g and jar of 500 g.

Storage: 6 months (for dispensing) and 12 months (for printing) in closed packaging in the fridge at 5 to 10°C.

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.