

# KESTER® EP256HA SOLDER PASTE

No-Clean

## DESCRIPTION

Kester EP256HA Solder Paste is a no-clean, air or nitrogen reflowable solder paste specifically designed to provide maximum print characteristics and solderability on lead-free parts using leaded solder paste. EP256HA has been designed for applications that require the ultimate activity with respect to difficult to solder to components and board surface metalizations. EP256HA is also capable of stencil printing after downtimes of up to 90 minutes with an effective first print down to 20 mils. EP256HA is a solder paste formula that maintains its activity and printing characteristics for up to 8 hours without any shear thinning.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

## FEATURES & BENEFITS

- Excellent solderability on difficult to solder to components, i.e., PdAg
- High activity on all substrates, including OSPs
- Capable of 90-minute break times in printing
- Excellent printing characteristics to 0.4 mm (16 mil) pitch with Type 3 powder
- High print speeds to 150 mm/sec (6 in/sec)
- Stable tack over 8+ hours
- Stencil life: 8+ hours (process dependent)
- Scrap is reduced due to less paste dry out
- Classified as ROL0 per J-STD-004

### Standard Applications:

For stencil printing: 90% Metal

## ROHS COMPLIANCE

Kester does not determine any applicable Restriction of Hazardous Substances (RoHS) exemptions for our lead containing products at the user level.

**TECHNICAL DATA**

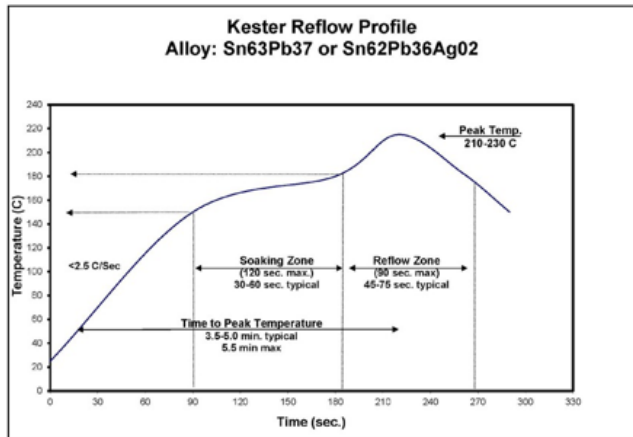
Category	Results	Procedure/Remarks
<b>Physical Properties (Data given for Sn63Pb37, 90% metal, -325+500 mesh)</b>		
Viscosity (Typical)	1600 poise	Malcom Viscometer @ 10 rpm and 25 °C
Initial Tackiness (Typical)	37 grams	Kester Method 1W-QC-3-04
Slump Test	Pass	J-STD-005, IPC-TM-650, Method 2.4.35
Solder Ball Test	Pass	J-STD-005, IPC-TM-650, Method 2.4.43
Wetting Test	Pass	J-STD-005, IPC-TM-650, Method 2.4.45
<b>Reliability Properties</b>		
Copper Mirror Corrosion	Low	J-STD-004, IPC-TM-650, Method 2.3.32
Corrosion Test	Low	J-STD-004, IPC-TM-650, Method 2.6.15
Silver Chromate	Pass	J-STD-004, IPC-TM-650, Method 2.3.35
Chloride and Bromides	None Detected	J-STD-004, IPC-TM-650, Method 2.3.35.1
Fluorides by Spot Test	Pass	J-STD-004, IPC-TM-650, Method 2.3.35.1
Surface Insulation Resistivity (SIR)	Pass	J-STD-004, IPC-TM-650, Method 2.6.3.3

## PROCESSING GUIDELINES

### Printing Parameters

<b>Squeegee Blade</b>	80 to 90 durometer polyurethane or stainless steel
<b>Squeegee Speed</b>	Capable to a maximum speed of 200 mm/sec (8 in/sec)
<b>Stencil Material</b>	Stainless Steel, Molybdenum, Nickel Plated, Brass
<b>Temperature/Humidity</b>	Optimal ranges are 21 to 25 °C (70 to 77 °F) and 35 to 65% RH

### Recommended Reflow Profile



The recommended reflow profile for EP256HA made with either the Sn63Pb37 or Sn62Pb36Ag02 is shown here. This profile is simply a guideline. Since EP256HA is a highly active solder paste, it can solder effectively over a wide range of profiles. EP256HA is capable of reflowing at the 235 °C peak temperatures required for fully collapsing lead-free SAC BGA's for maximum reliability and remains easy to clean after these high temperature profiles. Your optimal profile may be different from the one shown based on your oven, board and mix of defects. Contact Kester Technical Support if you need additional profiling advice.

### Cleaning

EP256HA is a no-clean formula. The residues don't need to be removed for typical applications. Although EP256HA is designed for no-clean applications, its residues can be easily removed using automated cleaning equipment (in-line or batch) with a variety of readily available cleaning agents. Call Kester Technical Support for details.

### Storage, Handling and Shelf Life

Refrigeration is the recommended optimum storage condition for solder paste to maintain consistent viscosity, reflow characteristics and overall performance. EP256HA should be stabilized at room temperature prior to printing. EP256HA should be kept at standard refrigeration conditions, 0 to 10 °C (32 to 50 °F). Contact Kester Technical Support if you require additional advice with regard storage and handling of this material. Shelf life is 6 months from the date of manufacture when handled properly when held at 0 to 10 °C (32 to 50 °F).

## AVAILABILITY

EP256HA is commonly available in the Sn63Pb37 and Sn62Pb36Ag02 alloys. Type 3 powder mesh is recommended, but different powder particle size distributions are available for standard and fine pitch applications. For specific packaging information, see Kester's Solder Paste Chart for available sizes. The appropriate combination depends on process variables and the specific application.

## RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area.



## SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available.**

## CONTACT INFORMATION

[www.macdermidalpha.com](http://www.macdermidalpha.com)

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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