

KESTER® NP545 SOLDER PASTE

Zero-Halogen, No-Clean

DESCRIPTION

Kester NP545 Solder Paste is a no-clean, zero-halogen solder paste formula designed for consistency and repeatability. NP545 consistently delivers paste transfer efficiencies of 0.55 to 0.50 AR. This paste is also fully capable of printing and reflowing 01005 components, even in air reflow, with minimal graping behavior. NP545 is classified as ROL0 under IPC JSTD-004 and ROM0 under IPC JSTD-004B. NP545 is has been developed as a SnPb alloy solder paste can used in backward applications and is thus fully compatible for soldering complex lead-free component on SnPb assemblies.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

- Zero-Halogen (none intentionally added)
- Consistent print performance to 0.5AR
- Excellent cosmetics and a clear residue

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

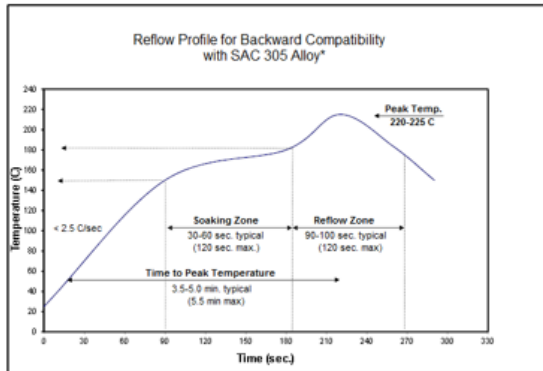
Category	Results	Procedure/Remarks
Physical Properties (Based on SnPb / SnPbAg Type 4)		
Viscosity (Typical)	1250 poise	Malcom Viscometer @ 10 rpm and 25 °C
Initial Tackiness (Typical)	35 grams	J-STD-005, IPC-TM-650, Method 2.4.44
Cold Slump Test	Pass	J-STD-005, IPC-TM-650, Method 2.4.35
Hot Slump Test	Pass	J-STD-005, IPC-TM-650, Method 2.4.35

Category	Results	Procedure/Remarks
Solder Ball Test	Pass	J-STD-005, IPC-TM-650, Method 2.4.43
Wetting	Pass	IPC-TM-650, Method 2.4.45
Reliability Properties		
Copper Mirror Corrosion	No Breakthrough "L"	J-STD-004B, IPC-TM-650, Method 2.3.32
Corrosion Test	No Corrosion "L"	J-STD-004, IPC-TM-650, Method 2.6.15B
	Minor Corrosion "M"	J-STD-004B, IPC-TM-650, Method 2.6.15C
Halogen Content	None Detected	J-STD-004B, IPC-TM-650, Method 2.3.41
Electrochemical Migration (ECM)	Pass	J-STD-004B, IPC-TM-650, Method 2.6.14.1 Test Conditions: 65 °C, 90% RH, 100V, 25 days
Surface Insulation Resistance (SIR)	Pass	J-STD-004B, IPC-TM-650, Method 2.6.3.7 Test Conditions: 40 °C, 90% RH, 7 days, 12.5V

PROCESSING GUIDELINES

Below information are process guidelines, and it is advisable to note that the optimum setting for a given assembly may vary and this is dependent on the circuit board design, board thickness, components used, and equipment used. A design of experiments is recommended to be done to optimize the soldering process. In addition, incoming solderability inspection of circuit boards and components is recommended as part of process control to maintain consistent soldering performance and electrical reliability.

Printing Process Parameters	Recommendations
Solder Paste Bead Size	Initial 2cm (0.75in); Add below 1.4cm (0.5in)
Squeegee Blade	Stainless steel preferred; 80 to 90 durometer or polyurethane could also be used
Squeegee Angle	60 deg. from horizontal; 45 deg. for pin in paste
Speed	25mm/sec-150mm/sec (1 to 6in/sec)
Pressure ¹	0.18 to 0.27 kg/cm (1 to 1.5 lb/in)
Separation Speed	2 to 10mm/sec
Stencil Life	8 hours at 20 to 25 °C (70 to 77 °F) and 35 to 65% RH

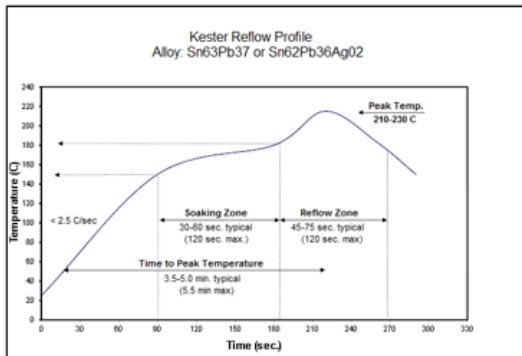


¹ Pressure should be increased with increasing print speed. First set the print speed. Then set the pressure to the minimum required to clean the solder paste off of the stencil.

² Some cleaning chemistry can interact with the solder paste and can impact print performance.

Recommended Reflow Profile

The recommended reflow profile for NP545 formula made with SnPb / SnPbAg alloys are shown here. This profile is simply a guideline. NP545 has excellent solderability and wetting across a wide range of profiles, with similar performance in air and nitrogen. Your optimal profile may be different from the one shown based on your oven, board and mix of components. Contact Kester Technical Support if you need additional profiling advice



* This profile is simply a guideline. For a reliable solder joint the reflow profile must produce a homogenous mixing of the tin lead alloy with the lead-free component sphere. The mixing level between the tin lead and lead-free alloy is a function of reflow peak temperature, time above liquidus, component sphere size and sphere alloy. Your optimal reflow profile may be different from the one shown based on your oven, component sphere size and sphere alloy.

Cleaning

NP545 residues are non-conductive and do not require removal. Although NP545 is designed for no-clean applications; its residues can be removed using automated cleaning equipment (in-line or batch) with a variety of readily available cleaning agents.

Storage, Handling and Shelf Life

NP545 (Sn63Pb37 and Sn62Pb36Ag2 alloys) have a shelf life of 12 months from the date of manufacture when handled properly at 0 to 10 °C (32 to 50 °F). NP545 should be stabilized at room temperature (27 °C/80 °F) prior to printing. Please contact Kester Technical Support if you require additional advice with regards to handling and storage of this material.

AVAILABILITY

NP545 is available in Sn63Pb37 / Sn62Pb36Ag2 alloys with type 4 powder mesh (20 to 38µm). Type 4 mesh size is recommended for standard and fine pitch applications. NP545 standard packaging in 500gm jars and 600gm cartridges. The appropriate combination depends on the process variables and the specific application. If other packaging configuration is needed, please contact your local representative for additional information. NP545 is also available with SAC alloys with T3 and T4 powder mesh.

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

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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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