

# Solder paste NP303-MF155-GQ

## Product description

GENMA SMD solder paste – our NP303-MF155-GQ solder paste features a good printability, sufficient tackiness on the stencil, and a good adhesiveness during the pick-and-place process. Its good wetting properties guarantee consistent soldering joints. Cleaning after soldering is not necessary. The solder paste can be soldered under air or nitrogen reflow. Due to the high thixotropic index, the solder paste is well suited for dispensing.

## Technical properties

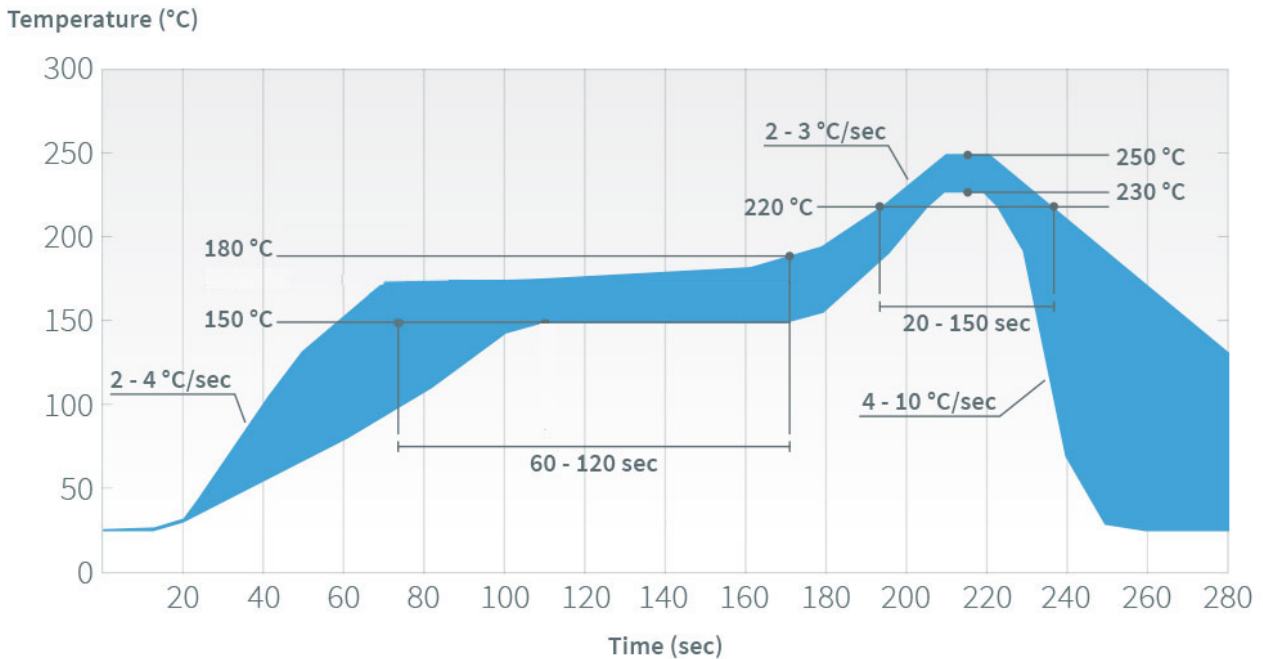
	Specific value	Testing method
<b>Alloy</b>	Sn 96,5 / Ag 3,0 / Cu 0,5 / SAC305	
<b>Melting temperature range</b>	217 - 221	IEC61189-11
<b>Powder size (µm)</b>	22 - 38, type 4	IPC-TM-650-2.2.14.2
<b>Viscosity (Pa · s)</b>	190 ± 20	IPC-TM-650-2.4.34.3
<b>Flux content (wt %)</b>	11,0 ± 0,3	IPC-TM-650-2.3.34.1
<b>Flux type</b>	ROL1, no clean	IPC-J-STD-004B
<b>Printing pitch (mm)</b>	0,4	
<b>Halide content (wt %)</b>	0,04 ± 0,02	IPC-TM-650-2.3.35
<b>Slump in print (mm)</b>	≤ 0,2	IPC-TM-650-2.4.35
<b>Slump in heat (mm)</b>	≤ 0,3	IPC-TM-650-2.4.35 (180°C / 60sec)
<b>Insulation resistance (Ω)</b>	40°C 90 % r. L ≥ 1 x 10 <sup>12</sup> Ω	IPC-TM-650-2.6.3.3
<b>Insulation resistance (Ω)</b>	85°C 85 % r. L ≥ 5 x 10 <sup>8</sup> Ω	IPC-TM-650-2.6.3.3
<b>Migration test</b>	No migration	IPC-TM-650-2.6.14.1
<b>Copper mirror test</b>	No corrosion	IPC-TM-650-2.3.32
<b>Packaging</b>	Jar (0,5 kg) Semco cartridge (0,65 kg, 1,2 kg) EFD Kartusche (10ccm mit 30g)	
<b>Shelf life</b>	6 month at 0-10°C	
<b>Transport</b>	keep cool	
<b>Tempering the solder paste</b>	Set to room temperature before opening to avoid condensation.	
<b>Recommended printing speed (mm/s)</b>	20 - 80	
<b>Recommended temperature during print ( °C )</b>	25 ± 3	
<b>Recommended relative humidity in % during print</b>	50 ± 20	

## Compliance

Conform with RoHS-Regulation 2011/65/EU and 2015/863/EU

Contains no substances more than threshold (0,1%) according to REACH legislation EG Nr. 1907/2006 (SVHC-list - dated 10.03.2022)

## Recommended Reflow Profile



### Preheating

The temperature increase should be 2°C to 4°C/sec until the preheating zone is reached. If the temperature rises too quickly this may cause a running of the solder paste.

To achieve a temperature spread ( $\Delta t$ ) on the circuit board that is as limited as possible, the temperature in the preheating zone should be between 150 and 180°C and the preheating time should be 60 to 120 seconds. If the temperature is too low or the preheating time too short, the temperature spread ( $\Delta t$ ) on the circuit board will be too high. If the temperature is too high and the preheating time too long the activators will get lost which may lead to poor melting of the solder paste.

### Reflow peak

We recommend keeping the temperature at 220°C for 20 to 150 seconds, if possible. If this is impossible, a temperature of up to 250°C can be maintained for a shorter period of time. It must be ensured, however, that the components are suited for the higher temperature.

### Cooling down

The cooling rate should be between 4 and 10°C/sec. If the cooling rate is too low components may be displaced or come up and reduce the strength of the solder connections. If the cooling rate is too high, however, components can be damaged through thermal shock.