

## Solder Paste No-Clean Sn63/Pb37

### Product Highlights

Clear residue

Long Stencil Life

**Ultra-Low Voiding for LGA, BGA & CSP Components****Halogen Free**

Excellent wetting compatibility on most board finishes

**REACH compliant flux**

### Specifications

Alloy: Sn63/Pb37

Flux Type: No-Clean

Flux Classification: ROL0

Melting Point: 183°C (361°F)

Shelf Life: Refrigerated &gt;12 months, Room Temperature &gt;1 month

Orderable Part Numbers	Mesh Size (Micron Range)	Metal Load	Application	Packaging
HMT19PB-T3-35S	T3 (25-45 µm)	87%	Dispense	35g syringe
HMT19PB-T3-100S				100g syringe
HMT19PB-T3-500J		90%	Print	500g jar
HMT19PB-T3-600C				600g cartridge
HMT19PB-T4-35S	T4 (20-38 µm)	87%	Dispense	35g syringe
HMT19PB-T4-100S				100g syringe
HMT19PB-T4-500J		90%	Print	500g jar
HMT19PB-T4-600C				600g cartridge
HMT19PB-T5-35S	T5 (15-25 µm)	87%	Dispense	35g syringe
HMT19PB-T5-100S				100g syringe
HMT19PB-T5-500J		90%	Print	500g jar
HMT19PB-T5-600J				600g cartridge

### Printer Operation

Print Speed: 25-100mm/sec

Squeegee Pressure: 70-250g/cm of blade

Under Stencil Wipe: Once every 10-25 prints, or as necessary

### Stencil Life

&gt;8 hours @ 20-50% RH 22-28°C (72-82°F)

&gt;6 hours @ 50-70% RH 22-28°C (72-82°F)

### Cleaning

HMT19PB is a no-clean solder paste that can be left on the board for most SMT assemblies. For applications requiring cleaning, HMT19PB can be removed with HMT175CS Co-Solvent series flux cleaner.

### Storage and Handling

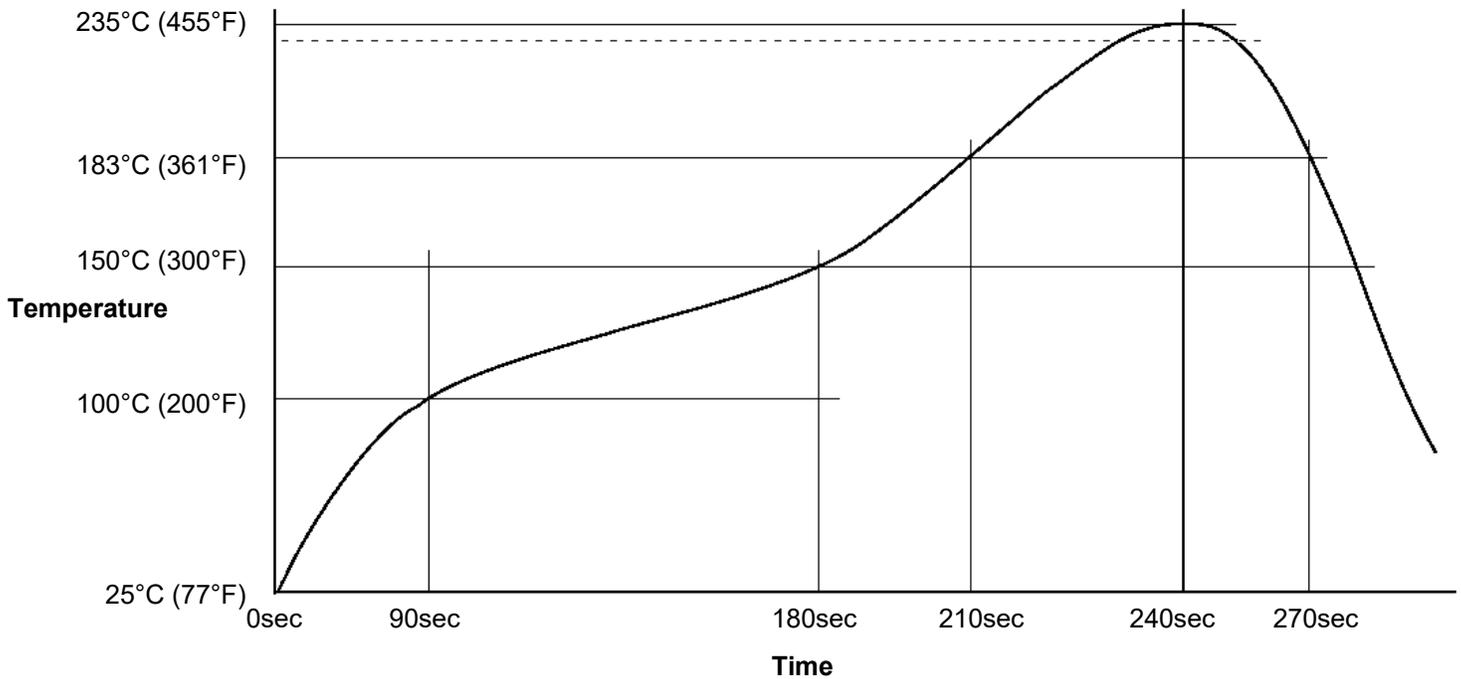
Refrigerate at 3-8°C (37-46°F). Do not freeze. Allow 4 hours for solder paste to reach an operating temperature of 20-25°C (68-77°F) before use.

### Transportation

This product has no shipping restrictions. Shipping below 0°C (32°F) or above 25°C (77°F) for normal transit times by ground or air will not impact this product's stated shelf life.

## Recommended Profile

Reflow profile for Sn63/Pb37 solder assembly, designed as a starting point for process optimization.



## Test Results

Test J-STD-004 or other requirements as stated	Test Requirement	Result
Copper Mirror	IPC-TM-650: 2.3.32	L: no breakthrough
Corrosion	IPC-TM-650: 2.6.15	L: no corrosion (uncleaned)
Quantitative Halides	IPC-TM-650: 2.3.28.1	L: <0.05
Electrochemical Migration	IPC-TM-650: 2.6.14.1	L: <1 decade drop (uncleaned)
Surface Insulation Resistance 40°C, 90% RH @ 168 Hours	IPC-TM-650: 2.6.3.7	L: ≥100MΩ (uncleaned)
Tack Value	IPC-TM-650: 2.4.44	35-45g
Viscosity – Malcom @ 10 RPM/25°C (x10 <sup>3</sup> mPa·s)	IPC-TM-650: 2.4.34.4	Print: 165-225, Dispense: 75-105
Visual	IPC-TM-650: 3.4.2.5	Clear and free from precipitation
Conflict Minerals Compliance	Electronic Industry Citizenship Coalition (EICC)	Compliant
REACH Compliance	Articles 33 and 67 of Regulation (EC) No 1907/2006	Contains no substance >0.1% w/w that is listed as a SVHC or restricted for use in solder materials

Conforms to the following Industry Standards:

J-STD-004B, Amendment 1 (Solder Fluxes):

J-STD-005A (Solder Pastes):

J-STD-006C, Amendments 1 & 2 (Solder Alloys and Fluxed/Non-Fluxed Solders):

RoHS 3 Directive (EU) 2015/863:

Yes

Yes

Yes

No (Contains Lead)