

SMD291SNL,SMD291SNL10,SMD291SNL10T5, SMD291SNL250T3, SMD291SNL250T5

SynTECH-LF Lead Free Solder Paste

500 Main Street, Suite 18 PO Box 989 Deep River, CT 06417 USA

Toll Free: 800.435.0317 Phone: 860.526.8300 Fax: 860.526.8243 www.amtechsolder.com

Product Data Sheet

Product Highlights

- n ROLO flux classification
- n Higher viscosity solder paste for better print definition
- n Clear residue
- n Low voiding
- n RoHS II and REACH compliant
- n Compatible with enclosed printing heads
- n Print & Dispense grade solder paste available
- n Passes BONO Test @ 1.56%

Available Alloys

Alloy	Temp °C	Temp °F
42Sn/58Bi	138	280
42Sn/57Bi/1Ag	138	280
96.5Sn/3.0Ag/0.5Cu	217-220	423-428
99.0Sn/0.3Ag/0.7Cu	217-221	423-430
96.5Sn/3.5Ag	221	430
99.3Sn/0.7Cu	227	441
95Sn/5Sb	235-240	455-464
95Sn/5Ag	221-245	430-473

Packaging

500 gram jars, 500gram cartridges 35 or 100 gram syringes ProFlow cassettes

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
Quantitative Halides	IPC-TM-650: 2.3.28.1	L: <0.5%
Electrochemical Migration	IPC-TM-650: 2.6.14.1	L: <1 decade drop (No-clean)
Surface Insulation Resistance 85 °C, 85% RH @ 168 Hours	IPC-TM-650: 2.6.3.7	L: ≥100 MΩ (No Clean)
Tack Value	IPC-TM-650: 2.4.44	64g
Viscosity - Malcom @ 10 RPM/25 °C (x10³mPa/s)-SAC305 T3/T4	IIPC-TM-650: 2.4.34.4	Print: 155-215 Dispensing: 125-170
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

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Printer Operation

TThe following are general guidelines for stencil printer optimization with SynTECH-LF. Some adjustments may be necessary based on your process requirements.

Print Speed: 25-100 mm/sec

Squeegee Pressure: 70-250g/cm of blade

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

necessary

Stencil Life

>12 hours @ 30-45% RH and 20-25 °C

~ 4 hours @ 45-75% RH and 20-25 °C

Cleaning

SynTECH-LF is a no-clean solder paste that does not require cleaning for most SMT assemblies. For applications requiring cleaning, SynTECH-LF can be cleaned using commercially available flux residue removers such as Kyzen Aquanox A4241, A4520, A4625 and A4625B (Batch Cleaners). Kyzen brand cleaners are available from Amtech.

Amtech Low Oxide Powder Distribution

Micon Size	Туре	Pitch Requirements
45 - 75μ	Type-2	24 mil and above
25 - 45μ	Type-3	16 - 24 mil
20 - 38μ	Type-4	12 - 16 mil
15 - 25μ	Type-5	8 - 12 mil
5 - 15μ	Type-6	5 - 8 mil
2 - 11µ	Type-7	< 5 mil

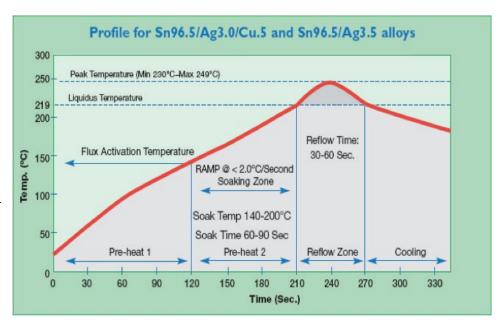
Note: Type-6 and Type-7 may not be available in certain alloys. Other powder distributions are available on request.

Storage

Solder paste should be stored between 3-8 °C (37-46 °F) to obtain the maximum refrigerated shelf life of six months. Unopened solder paste stored at room temperature, 25 °C (77 °F) will have a one month shelf life. Syringes and cartridges should be stored vertically in the refrigerator with the dispensing tip down. Allow 4-8 hours for solder paste to reach an operating temperature of 20-25 °C (68-77 °F). Keep the solder paste container sealed while warming the solder paste to operating temperature. **NEVER FREEZE SOLDER PASTE**.

Recommended Profile

This profile is designed to serve as a starting point for process optimization using SynTECH-LF. To achieve better results with voiding or to reduce tombstoning, consider using a longer soaking zone, (170-220 °C) for 60-90 seconds, with a rapid pre-heat stage. If there is evidence of solder de-wetting, consider lowering the peak reflow temperature, or reduce the time above liquidus to <60 seconds.



AMTECH Part Numbers

SynTECH-LF 96.5Sn/3.0Ag/0.5Cu, Type 3, 500 gram jar: Part Number: 13680 SynTECH-LF 96.5Sn/3.0Ag/0.5Cu, Type 4, 500 gram jar: Part Number: 13689 SynTECH-LF 96.5Sn/3.0Ag/0.5Cu, Type 3, 35 gram syringe: Part Number: 13650 Other alloy and packaging combinations available upon request.