

Product	S6M-XM3S
Date	2018.05.18
Release	15.1
Language	English

Solder paste**SUMMARY**

SnPb -No-Clean solder paste - Anti tombstoning

PASTE	S6M-XM3S
PROCESS	
No-Clean process	5
Post-solder cleaning	2

INDUSTRY APPLICATION	
Consumer electronics	4
Standard industrial electronics	5
Hi-Rel electronics (automotive)	5

PROCESS CAPABILITY	
Squeegee	5
ProFlow	4
Pb-free Profile Air, short	2
Pb-free Profile Air, long	1
Pb-free process N2	3
Vapor phase process	5
Shiny joint appearance	3
Cosmetic cleanliness	5
ICCT compatible	5
Conformal coating	5

Legend	
<i>Especially made for this purpose</i>	5
<i>Generally qualified for this purpose</i>	4
<i>Generally usable, but not the best choice</i>	3
<i>Generally not usable for this purpose</i>	2
<i>Wrong choice</i>	1

Check material compatibility with every process change!

Industrial chemical product.

Read MSDS before use.

Product contains SVHC substance Lead with more than 0,1 Mass%.

CLASSIFICATION	
DIN-EN-29454-1: 1994	1.2.2.C
IPC-J-STD-004-A: 2004	REL1
IPC-J-STD-005: 1995 (Powder)	T3
Particle size	[µm] 25-45

PROPERTIES		
Flux code	M3S	
Alloy Code	S6M	
Alloy composition	Sn62.5/Pb36.5/Ag1	
Liquidus	[°C]	183
Solidus	[°C]	179
Recommended peak temp.	[°C]	205-225
Acid number	[mg KOH/g]	80.7
Flux	[% w/w]	9.7
Residues	Colorless	
Tackiness Malcom TK1	JIS-Z-3284	[gf] @ 0h 110

TEST REPORTS	
IPC/ANSI-J-STD-005	Compliant
Certificate of Compliance	Website
RoHS Compliant	No
Application Note	EN/DE

PACKAGING AND STORAGE		
Packaging jar	PP [g]	500
Packaging cartridge	HDPE [g]	650
Packaging cartridge	HDPE [g]	1300
Packaging Cassette Pro-Flow	[g]	850
Minimum shelf-life in months	4-10 °C	6

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