

ECOREL™ EASY 862 / 863



Low Residue No-Clean Solder Paste

PERFORMANCES

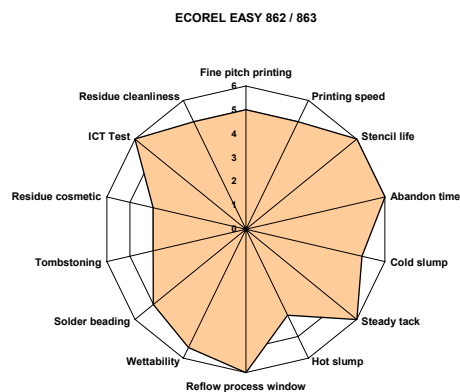
ECOREL™ EASY 862 and 863 solder pastes are very easy to use. They exhibit very high printing capability long abandon time, steady tackiness during several days and permits a very high yield after reflow. The outstanding nature of its organic part allows residue fully compatible with pin point test.

SPECIFICATIONS

ECOREL™ EASY	862	863
Alloy	Sn62Pb Ag2	Sn63Pb
Melting point °C	178	183
Powder size distribution	25-45 microns	25-45 microns
Metal content (%)	89.5 +/- 0.5	89.5 +/- 0.5
Halogen content	No halogen	No halogen
Viscosity* (Pa.s at 20°C) <i>*Brookfield RVT, TF at 5 RPM</i>	700 – 900	700 - 900

CHARACTERISTICS

Stencil life over 12 hours
Abandon time over 8 hours
Pitch 0.5mm stencil 150 µm
More than 24 hours of steady tackiness
Excellent wettability
Very high first pass yield at ICT



FUNCTIONAL TESTS	Results	Procedures
Flux classification	L0	ANSI/J-STD-004
	F-SW 32	DIN 8511
	113	ISO9454
Solderballing test	pass	ANSI/J-STD-005
Copper mirror	pass	ANSI/J-STD-004
Chromate paper	pass	ANSI/J-STD-004
Copper corrosion	pass	ANSI/J-STD-004
S.I.R. Ohms	pass	ANSI/J-STD-004
After 21 days 85°C - 85 % RH - 50 Volts	> 10 ⁹	
End of cycle 20°C – 65 % RH	> 10 ¹⁰	

PACKAGING

Jar	250 g or 500 g
Cartridge	700 g or 1400 g
PROFLOW Cassette	800 g

For an optimal preservation, store cartridges in vertical position, tip downwards.

STOCKAGE & VALIDITE

To ensure the best product performance, the recommended storage temperature range is from 5°C to 10°C. A shelf life of 9 months is achieved under these conditions. For cartridges, shelf life is 6 months.

PROCESS PARAMETERS

Solder paste preparation

Before printing, it is essential to properly mix the solder paste, either manually with a spatula, or by doing several preliminary prints on the stencil.

Printing operation

Apply about 2 cm bead diameter solder paste to allow for a smooth even roll during the printing process. Generally 100-g per 10 cm squeegee length

Squeegee speed : 50 to 150 mm/sec.

Squeegee pressure : depends on squeegee length

Ex: 5 kg for 25 mm squeegee at 50 mm/sec.

Minimum Pitch 0,3mm

Reflow thermal profile

Even though linear profile is recommended Ecorel™ Easy 862/863 withstand harder profile including long soak time as described here beside.

Cleaning

This no-clean solder paste can be cleaned with recommended INVENTEC cleaning solution.

HSE

Contains lead. Do not handle without gloves. Read MSDS before use.
No issues when used as recommended.

This data is based on information that the manufacturer believe to be reliable and offered in good faith. In no event will INVENTEC be responsible for special, incidental and consequential damages. The user is responsible to the Administrative Authorities (regulations for the protection of the Environment) for the conformity of his installation.

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