

Product Data Sheet

Product	SAC4-325GM5
Productgroup	Solder Paste Dispense
Date	06-12-2006
Release	06.1

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

ISO 9454-1	1.2.2.C
JIS Z3284	1.2.3.N.II
IPC-ANSI-J-STD-004	REL1
IPC-ANSI-J-STD-005 (Powder)	4.
No-Clean process	5
Post-solder cleaning	3
Pb-Free process - Air, Standard	5
Pb-Free process - Air, Extended	4
Pb-Free process - N2	4
Vapor Phase	3
Consumer electronics	4
Med-Rel electronics	4
Hi-Rel electronics	5
OSP compatible	5
Ni/Au compatibel	5
Ni/Pd compatible	4
Ag compatible	4
Sn compatible	4
Automatic Hi-Speed Dispensing	5
Manual Dispensing	5
Fine-pitch (= < 0.625 mm)	5
Reduces solder balling	5
Reduces solder beading	4
Reduces bridging	4
Reduces tombstoning	4
Reduces de-wetting	5
Brilliant joint appearance	3
Cosmetic cleanliness	4
Reduces flux build-up in reflow oven	4
ICCT compatible	4
Conformal coating	5

Flux code	325.GM5
Particle size code	H
Alloy code	SAC4
Alloy type	Sn95.5/Ag4/Cu0.5
Liquidus [°C]	217.
Solidus [°C]	217.
Recommended peak temp. [°C]	232-250
Particle size [m]	25-38
Oxide content powder [ppm]	100.
Acid number [mgKOH] (+/-2.5%)	49.30
Halides [Silver-Chromate Test]	Pass
Halides [Potentiometric]	Detected
Flux [% w/w]	15.43
Metal [% w/w]	84.57
Filmformer(s)	Resin
Color of the residue	Colorless
Viscosity @25 °C [Pa's] Plate/Plate (+/-18%)	67.
Viscosity @ 25°C [Pa's] Malcom PCU205 (+/-18%)	57.
Min. Needle Diameter [swg]	26.
Minimum Dot	
Size [mm]	< 65
Dwell [m/sec]	50.
Maximum Dot	
Tackiness time 20°C/ 70%RH [H]	12.
Tackiness force Malcom TK1 [gr]	75.
Telcordia/Bellcore TR-NWT-000078/3	Compliant
IPC/ANSI-J-STD-005	Compliant
Test report(s)	-
Certificate of Compliance	Available
SPC-data*	Auditable
Environmental Load Unit	4.32
RoHS-Compliance Certificate	Available
User's Guidelines	English
Packaging	
Jar (PP) [gram]	500
Small cartridge (HDPE) [gram]	650
Large cartridge (HDPE) [gram]	1300
Syringe (HDPE) [gram]	25, 75
Shelf-life (Weeks)	
Storage 4-10 [°C]	20.
Storage 20 [°C]	6.