

SPECIFICATION

NAME : HR-19M LFM-48 P3 Cored Solder Wire

Lot No.	Type
	HR-19M LFM-48 P3 Flux Content P3 (2.7-3.9%) Dia(mm): 0.2, 0.3, 0.38, 0.5, 0.65, 0.8, 1.0, 1.2, 1.6, 2.0, 2.7

NIHON ALMIT CO., LTD

Head Office: Almit Bldg., 2-14-2, Yayoicho, Nakano-ku, Tokyo 164 Japan
Tel: +81 3-3379-2277, Fax: +81 3-3374-2593

Productive Engineering Center: 8154-227, Uenohara, Kitatsuru-gun, Yamanashi 409-0112 Japan
Tel: +81 554-62-2281, Fax: +81 554-62-2282

Osaka Office: Ashiike Bldg., 3-6-5, Minamisenba, Chuo-ku, Osaka 542, Japan
Tel: +81 6-252-5039, Fax: +81 6-252-5026

Kyushu Office: Pacific Atlas Fukuoka Bldg., 2-12-26, Hakataekimae, Hakata-ku, Fukuoka-shi 812 Japan.
Tel: +81 92-483-0367, Fax: +81 92-483-032

Chubu Almit Kogyo: Daiwa Bldg., 4-2-58, Ohsu, Naka-ku, Nagoya-shi 460, Japan
Tel: +81 52-241-1171, Fax: +81 52-241-2426

Almit GmbH: Dekan-Groh-Str. 4, D 64720 Michelstadt/near Frankfurt, Germany
Tel.: +49 6066 969100, Fax: +49 6066 969102

1. Product Name : HR-19M LFM-48 P3

2. Scope : This spec. is specified for Almit KR-19SH RMA LFM-48 P3 delivered by Nihon Almit Co., Ltd. to Company _____ .

3. Diameter, Net Weight and Allowance:

Diameter (mm)											Net Weight of one Reel (kg)		
0.2	0.3	0.38	0.5	0.65	0.8	1.0	1.2	1.6	2.0	2.7	0.5	0.8	1.0
±0.05											+0.01 -0		

0.2 mm =0.1 Kg reel

0.3mm – 2.0 mm =0.5 Kg reel

2.7 mm = 1.0 kg reel

4. Physical Properties :

Solidus	Liquidus	Specific Gravity
217°C	220°C	7.4

5. Characteristics :

	Characteristics	Test Methods
Solids Content, Flux (%)	P3 (2.7-3.9 %)	IPC-TM-650:2.3.34
Copper Mirror Test	Pass	IPC-TM-650:2.3.32
Dryness	Pass	JIS-Z-3197:1999
Corrosion Test	Pass	IPC-TM-650:2.6.15
SIR (85°C,85%,168hr, measured out of Chamber) (Ω)	≥ 1×10 ⁸	IPC-TM-650:2.6.3.3
Quantitative Halide	M1	IPC-TM-650:2.3.35
Flux materials composition	RE	J-STD-004:1.2

6. Chemical Composition (%) :

Zusammen- setzung	Hauptbestandteile			Verunreinigungen				
	Sn	Ag	Cu	Pb	Sb	Bi	Zn	Fe
HR-19M LFM-48 P3	Rest	3.0±0.2	0.5±0.2	≤0.05	≤0.50	≤0.10	≤0.005	≤0.02
Zusammen- setzung	Verunreinigungen							
	Al	As	Cd	Au	In	Ni	P	S
HR-19M LFM-48 P3	≤0.005	≤0.03	≤0.005	≤0.08	≤0.10	≤0.01	≤0.01	≤0.005

7. Lot Size : 500 kg (amount of single melting)

8. Identification :

Spool		Cardboard	
Name	HR-19M LFM-48 P3	Name	HR-19M LFM-48 P3
Flux Content	P3 (2.7-3.9 %)	Flux Content	P3 (2.7-3.9 %)
Diameter	mm	Diameter	Ø
Net Weight	Ex. 500 g	Net Weight	Ex. 5 kg
Lot No.	Ex. 04.5.-1	Lot No.	Ex. 04.5.-1
Maker	Nihon Almit Co., Ltd.	Maker	Nihon Almit Co., Ltd.

9. Packing :

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8, 1.0 kg	Plastic Bag	5, 8, 10 kg	Cardboard

10. Maker Address :

Nihon Almit Co., Ltd. Productive Engineering Center
8154-227, Uenohara, Kitatsuru-gun, Yamanashi, 409-0112 Japan

11. In case of changing this spec., it must be accepted by _____ .

12. This product is manufactured, using all guaranteed materials according to the "LAW ON INSPECTION AND MANUFACTURING OF CHEMICAL SUBSTANCES".

13. Shelf Life :

Up to two (2) years from the manufactured date (lot number).