

## SPECIFICATION

NAME : SR-55 LFM-48-S 3,5% Cored Solder Wire

Lot No.	Type
	SR-55 LFM-48-S 3.5% Flux Content 3.5% Dia(mm): 0.2, 0.3, 0.38, 0.5, 0.65, 0.8, 1.0, 1.2, 1.6, 2.0, 2.7

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**1. Product Name :** SR-55 LFM-48-S 3.5%

**2. Scope :** This spec. is specified for Almit SR-37 LFM-48-S 3.5% delivered by Nihon Almit Co., Ltd. to Company \_\_\_\_\_ .

**3. Chemical Composition (%) :**

Composition	Principal Component			Impurities				
	Sn	Ag	Cu	Pb	Sb	Bi	Zn	Fe
Standard	Remainder	3.0 ±0.2	0.5 ±0.2	≤0.05	≤0.10	≤0.05	≤0.001	≤0.04
Composition	Impurities							
	Al	As	Cd	Co	Ni			
Standard	≤0.001	≤0.03	≤0.002	≤0.02	≤0.02			

**4. Physical Properties :**

Solidus	Liquidus	Specific Gravity
217°C	221°C	7.4

**5. Characteristics :**

	Characteristics	Test Methods
Solids Content, Flux (%)	3.5 (3.0 - 4.0)	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 <sup>8</sup>	IPC-TM-650:2.6.3.3
Quantitative Halide	M1<0.5%	IPC-TM-650:2.3.35
Flux materials composition	RE	J-STD-004:1.2

**6. 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

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

**8. Packing :**

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

**9. Identification :**

Spool		Cardboard	
Name	SR-55 LFM-48-S 3.5%	Name	SR-55 LFM-48-S 3.5%
Flux Content	3.5%	Flux Content	3.5%
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.

**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).