



ESL EUROPE

SOLDER PASTES &
THICK-FILM MATERIALS

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NO CLEAN SOLDER PASTE

NC-3716-G

NC-3716 G is a high reflow temperature, rosin mildly activated, no clean solder paste. Reflow temperatures depend on the board and component size and should be optimised to give minimal charring of the small amount of flux residues.

PASTE DATA

Solder Alloy:

(Meets QQ-S-571 -E Specifications)

93% Pb / 5% Sn / 1.5% Ag

Particle Size:

-325 / +500 mesh

Viscosity:

(TF Spindle, 5 rpm, 25.5°C ± 0.5 °C)

600 ± 50 Pa.s

Solids:

90 ± 1.0 %

Reflow Temperature:

> 340 °C

Solidus / Liquidus Temperatures:

296 / 301 °C

Flux:

Rosin Mildly Activated

Flux Removal:

Not required. Note: If cleaning is desired, residue can be removed using standard flux solvent or saponifier cleaning methods.

Thinner:

ESL 401

Packaging:

500 to 1000 grams in jars and 1 kg cartridges

ESL Europe NC-3716-G 0507-D

ESL Worldwide

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See Caution and Disclaimer on next page.

TECHNICAL SPECIFICATIONS

Water Extraction Conductivity Test:

(Per QQ-S-571 -E)

> 100,000 Ω / cm

Halide Test:

(Per QQ-S-571 -E)

Passes

Surface Insulation Resistance:

(MIL-F-14256, IPC Test Boards,
168 hours, 85 °C / 85 % R.H.)

> $10^{14}\Omega$ (cleaned and uncleaned)

Screen Time:

> 10 hours

Tack Time:

~ 70 hours

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CAUTION: Proper industrial safety precautions should be exercised in using these products. Use with adequate ventilation. Avoid prolonged contact with skin or inhalation of any vapours emitted during use or heating of these compositions. The use of safety eye goggles, gloves or hand protection creams is recommended. Wash hands or skin thoroughly with soap and water after using these products. Do not eat or smoke in areas where these materials are used. Refer to appropriate MSDS sheet.

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