



## ESL EUROPE

SOLDER PASTES &  
THICK-FILM MATERIALS

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## SOLDER PASTE

## 3701-G Series

### 62Sn/36Pb/2Ag Alloy Solder Paste Series

The 3701-G series are solder pastes with a resin based mildly activated flux system. These solder pastes exhibit good printing properties and enable surface mounting of components to printed circuit boards and hybrid circuits. The 3701-G Series uses standard 62Sn / 36Pb / 2Ag alloy powders and has a particle size of -325 / +500 mesh.

The series includes a Standard version, High Viscosity version (HV), Medium Viscosity version (MV) and a Rosin Activated version (RA). A syringe dispensable version, 3701-G 350 is also available. Please see separate data sheet.

It is recommended that these solder pastes are stored in a tightly closed jar in a dry environment at room temperature. Printed boards should also be stored in a dry environment. Printed boards, with components in place, can be stored for up to 3 days in clean, dry environments but it is recommended that reflow of the boards be carried out as soon as possible after the solder paste has been printed. If possible, do not return used paste to the original jar. After reflow, the flux residues can be removed using a proprietary cleaning liquid.

### PASTE DATA

#### Rheology:

Screen-printable pastes

#### Viscosity:

(Brookfield RVTD, Helipath Stand,  
5 rpm, TF spindle, 25.5 ± 0.5 °C)

<b>3701-G</b>	650 ± 50 Pa.s
<b>3701-G MV</b>	750 ± 50 Pa.s
<b>3701-G HV</b>	950 ± 50 Pa.s
<b>3701-G RA</b>	650 ± 50 Pa.s

#### Solids:

90 ± 0.5 %

#### Shelf Life:

(at 20 °C)

6 months

RA: Ambient typically 2 months

### PROCESSING

#### Screen Mesh, Emulsion:

Screen 80 S/S, 150 - 200 µm  
Stencil: Laser cut, nickel formed or etched S/S 120 - 200 µm

#### Reflow Temperature Range:

see reflow profiles

#### Thinner:

ESL 401  
Thinner not recommended for RA variant

#### Screen Life:

> 10 hours

#### Tack Time:

~ 70 hours

ESL Europe 3701-G Series 0507-D

#### ESL Worldwide

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See Caution and Disclaimer on next page.

## TYPICAL PROPERTIES

(225 ± 25 µm wet print thickness)

**Approximate Coverage:**

10 - 15 cm<sup>2</sup>/g

**Printing Resolution:**

(line / space)

0.200 mm / 0.200 mm

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ESL Europe 3701-G Series 0507-D

**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.

**DISCLAIMER:** The product information and recommendations contained herein are based on data obtained by tests we believe to be accurate, but the accuracy and completeness thereof is not guaranteed. No warranty is expressed or implied regarding the accuracy of these data, the results obtained from the use hereof, or that any such use will not infringe any patent. ElectroScience assumes no liability for any injury, loss, or damage, direct or consequential, arising out of its use by others. This information is furnished upon the condition that the person receiving it shall make his own tests to determine the suitability thereof for his particular use, before using it. User assumes all risk and liability whatsoever in connection with his intended use. ElectroScience's only obligation shall be to replace such quantity of the product proved defective.

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