

## Aluminum Solder Paste Water-Soluble Sn96.5/Ag3.5 T3 (400g cartridge)

### Product Highlights

Used for soldering Aluminum to Aluminum, Aluminum to Copper, Aluminum to Brass, Aluminum to plated terminals  
Printing speeds up to 100mm/sec  
Long stencil life

Wide process window  
Compatible with enclosed print heads  
RoHS II and REACH compliant

### Specifications

Alloy:	Sn96.5/Ag3.5
Mesh Size:	T3
Micron (µm) Range:	25-45
Flux Type:	Synthetic Water-Soluble
Flux Classification:	ROM1 (Water Soluble, Must be cleaned off post-use using Hot Water (60°C+) or IPA)
Metal Load:	75% Metal by Weight
Melting Point:	221°C (430°F)
Packaging:	6oz/400g Cartridge
Shelf Life:	Refrigerated >12 months, Unrefrigerated >6 months *See notes below:

**\*Shelf Life Notes:** Chip Quik® solder paste is good past its quoted shelf life, regardless of refrigeration. Before use, visually inspect the solder paste to ensure it is not dried out or clumpy, or check stencil release. If stored in a jar, stir the product thoroughly for 2-3 minutes before inspection and use.

Chip Quik® solder paste is manufactured using Made in USA high quality synthetic flux and precision atomized metal powder. Chip Quik® solder paste is guaranteed for 12 months from date of manufacture, regardless of refrigeration. If you have any issues with our solder paste, please contact Chip Quik® directly for no charge warranty replacement. Please retain original bill of sale, and solder paste in original container as we may request its return for internal R&D testing purposes.

### Printer Operation

Print Speed: 25-100mm/sec  
Squeegee Pressure: 70-250g/cm of blade  
Under Stencil Wipe: Once every 10-25 prints, or as necessary

### Stencil Life

>12 hours @ 20-50% RH 22-28°C (72-82°F)  
>4 hours @ 50-70% RH 22-28°C (72-82°F)

### Stencil Cleaning

Automated stencil cleaning systems for both stencil and misprinted boards. Manual cleaning using isopropyl alcohol (IPA).

### Storage and Handling

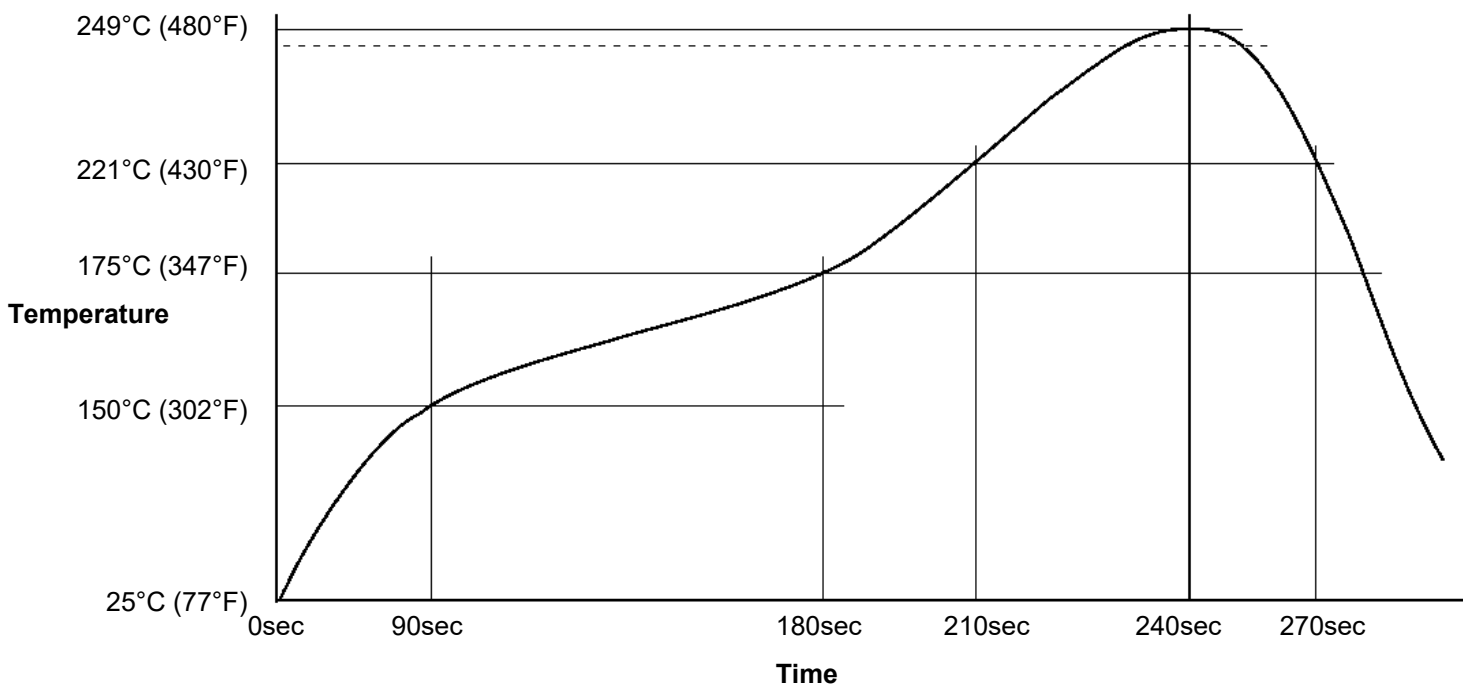
Refrigerate at 3-8°C (37-46°F). Do not freeze. Allow 4 hours for solder paste to reach an operating temperature of 20-25°C (68-77°F) before use.

### Transportation

This product has no shipping restrictions. Shipping below 0°C (32°F) or above 25°C (77°F) for normal transit times by ground or air will not impact this product's stated shelf life.

Recommended Profile

Reflow profile for Sn96.5/Ag3.5 solder assembly, designed as a starting point for process optimization.



Test Results

Test J-STD-004 or other requirements as stated	Test Requirement	Result
Viscosity – Malcom @ 10 RPM/25°C (x10 <sup>3</sup> mPa·s)	IPC-TM-650: 2.4.34.4	300-500
Conflict Minerals Compliance	Electronic Industry Citizenship Coalition (EICC)	Compliant
REACH Compliance	Articles 33 and 67 of Regulation (EC) No 1907/2006	Contains no substance >0.1% w/w that is listed as a SVHC or restricted for use in solder materials

Conforms to the following Industry Standards:

J-STD-004B, Amendment 1 (Solder Fluxes):	Yes
J-STD-005A (Solder Pastes):	Yes
J-STD-006C, Amendments 1 & 2 (Solder Alloys and Fluxed/Non-Fluxed Solders):	Yes
RoHS 2 Directive 2011/65/EU:	Yes