

Trade Name: LFM-48W SSIM 13%
1. Company Address

Almit GmbH
Unterer Hammer 3
Deutschland
(D) 64720 Michelstadt -
bei Frankfurt

Tel.: +49 6061 96925-0
Fax: +49 6061 96925-18

2. Validity

This specification is specified for:
Solder Paste Lead Free LFM-48W SSIM 13%
Delivered by Almit GmbH to:

3. Diameter & Allowence

Weight	40g	80g	100g	250g	20g
Allowance	-0, +5g				

4. Deliverable Reel Size

Metal Name	Solidus °C	Liquidus °C	Specific Gravity
LFM-48	217	220	7.4

5. Physical Properties

Test	Characteristics	Test Methods
Metal Content	88.0 ± 1.0	IPC-TM-650 2.2.20
Silver Chromate	pass	IPC-TM-650:2.3.33
Copper Mirror Test	pass	IPC-TM-650:2.3.32
SIR (85°C, 85%, 168hr) (Ω)	≥ 1 x 10 ⁸	IPC-TM-650:2.6.3.3
Corrosion Test	pass	IPC-TM-650;2.6.15
Flux materials composition	L1 < 0.5%	J-Std-004:1.2
Quantitative Halide	M1	IPC-TM-650 2.3.35
Fluorides By Spot Test	pass	IPC-TM-650 2.3.35.1

6. Characteristics

Composition	Components							
	Sn	Ag	Cu	Pb	Sb	Bi	Au	In
Standard	Rest	3.0	0.5	<0.05	≤0.10	≤0.05	≤0.05	≤0.10
Composition	Components							
	Al	As	Cd	Fe	Ni	Zn		
Standard	≤0.001	≤0.03	≤0.002	≤0.02	≤0.01	≤0.001		

7. Solder Powder Size & Distribution

Type	larger than	less than 1%	at least 80%	at most 10%
n.a	n.a			

8. Lot Size

A single lot is consisted of, and may vary between 10 - 100kg, depends upon the production plan.

9. Quality and Inspection

Inspection items are applied to each lot as follows:

Test No.	Inspection Item	Contents	Standard
1	Appearance		
2	Weight		
3	Solder Powder Size		
4	Metal Composition		
5	Characteristics		

*Straight lines of solder paste are printed on the surface of the container with a microscope at 30X magnification. No more than one fifth the size of the pattern gap is allowed per container.

10. Packing

Individual Package		Outer Package
Unit	Packing	Unit
20g	5cc Cartridge	
40g	10cc Cartridge	
80g	30cc Cartridge	
100g	30cc Cartridge	
250g	100cc Cartridge	

11. Identification

	Polyethylene
Name	LFM-48W Solder
Lot Nr.	(Ex) 120119-9
Solder Powder Size	
Date of Mfg.	(Ex.) 19.01.2012
Net-Weight	(Ex.) 500g
Maker	Nihon Almit Co. Ltd.

12. Maker Address

Nihon Almit Co. Ltd.
Almit Bldg. 2-14-2 Yaveicho, Nakano-ku,
Tokyo, Japan

13. In case of changing this specification it should be accepted by

Signature _____ Date _____

14. This product is manufactured, using all guaranteed materials according to the legal law regulations

15. Shelf Life

1. Refrigerating is recommended at a temperature of 2-8°C to guarantee shelf life of 4 months
2. Paste can be stored at room temperature for 1 week up to 25°C prior to use (only applicable for jars)