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## Product Data Sheet

Product **SAC3-XM3S**  
 Productgroup Solder Paste Printing  
 Date 22-08-2007  
 Release 06.2

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5	Especially made for this purpose
4	Generally qualified for this purpose
3	Generally usable, but not the best choice
2	Generally not usable for this purpose
1	Wrong choice

ISO 9454-1	1.2.2.C
JIS Z3284	1.2.3.N.II
IPC-ANSI-J-STD-004 (flux)	REL1
IPC-ANSI-J-STD-005 (Powder)	3.
No-Clean process	5
Post-solder cleaning	2
Pb-Free process - Air, Standard	4
Pb-Free process - Air, Extended	2
Pb-Free process - N2	5
Vapor Phase	5
Consumer electronics	4
Mid-Rel electronics	4
Hi-Rel electronics	5
1-layer, video/tv boards	-
2-layer boards	-
Multi-layer boards	-
OSP compatible	4
Ni/Au compatibel	5
Ni/Pd compatible	3
Ag compatible	3
Sn compatible	4
Squeegee	5
Closed Printhead (Proflow etc)	5
Dispensing [> awg 22]	2
Short cycle time	5
Long stencil-life	5
Long open time	5
Sharp print definition	5
Reduces dog ears	4
Reduces smearing	4
Reduces stencil wiping	4
Reduces solder balling	4
Reduces solder beading	5
Reduces bridging	4
Reduces tombstoning	5
Reduces de-wetting	4
Reduces slumping	5
Reduces voiding	5
Brilliant joint appearance	4
Cosmetic cleanliness	4
Reduces flux build-up in reflow oven	5
ICCT compatible	5
Conformal coating	5

Flux code	M3S
Particle size code	X
Alloy code	SAC3
Alloy type	Sn96.5/Ag3/Cu0.5
Liquidus [°C]	219.
Solidus [°C]	217.
Recommended peak temp. [°C]	232-245
Particle size [µm]	25-45
Oxide content powder [ppm]	100.
Acid number [mgKOH] (+/-2.5%)	60.20
Halides [Potentiometric]	Pass
Halides [Silver-Chromate Test]	Detected
Flux [% w/w]	10.88
Metal [% w/w]	89.12
Filmformer(s)	Resin
Color of the residue	Colorless
Viscosity @25 °C [Pa's] Plate/Plate (+/-18%)	189.
Viscosity @ 25°C [Pa's] Malcom PCU205 (+/-18%)	179.
Max. print speed [mm/sec]#	100.
Rec.separation speed [mm/sec]	10.
Tackiness time 20°C/ 70%RH [H]	18.
Tackiness force Malcom TK1 [gr]	110.
Telcordia/Bellcore TR-NWT-000078/3	Compliant
IPC/ANSI-J-STD-004	Compliant
Test report(s)	-
ISO-TS-16949 (IATF nummer)	0043973
Certificate of Compliance	Website
SPC-data*	Auditable
Environmental Load Unit**	3.02
RoHS-Compliance Certificate	Available
User's Guidelines	English
<b>Packaging</b>	
Jar (PP) [gram]	500
Small cartridge (HDPE) [gram]	500, 650
Large cartridge (HDPE) [gram]	1000, 1200, 1300, 1500
Cassette (HDPE) [gram]	800
<b>Recommended shelf-life (Weeks)</b>	
Storage 8 [°C]	20.
Storage 20 [°C]	6.

