

<b>Product</b>	<b>S9M-XM3S</b>
<b>Date</b>	2018.05.18
<b>Release</b>	15.2
<b>Language</b>	English

**Solder paste****SUMMARY**

Pb-free - No-Clean solder paste - Anti tombstoning - Very low oven contamination

PASTE	S9M-XM3S
<b>PROCESS</b>	
No-Clean process	5
Post-solder cleaning	3

INDUSTRY APPLICATION	
Consumer electronics	3
Standard industrial electronics	4
Hi-Rel electronics (automotive)	5

PROCESS CAPABILITY	
Squeegee	5
ProFlow	4
Pb-free Profile Air, short	4
Pb-free Profile Air, long	3
Pb-free process N2	5
Vapor phase process	5
Shiny joint appearance	3
Cosmetic cleanliness	4
ICCT compatible	5
Conformal coating	5

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

**Check material compatibility with every process change!****Industrial chemical product.****Read MSDS before use.**

CLASSIFICATION	
DIN-EN-29454-1: 1994	1.2.2.C
IPC-J-STD-004-A: 2004	REL1
IPC-J-STD-005: 1995 (Powder)	T3
Particle size	[µm] 25-45

PROPERTIES		
Flux code	M3S	
Alloy Code	S9M	
Alloy composition	Sn96/Ag3.75/Cu0.25	
Liquidus	[°C]	221
Solidus	[°C]	217
Recommended peak temp.	[°C]	232-250
Acid number	[mg KOH/g]	60.7
Flux	[% w/w]	10.9
Residues	Colorless	
Tackiness Malcom TK1	JIS-Z-3284	[gf] @ 0h 110

TEST REPORTS	
IPC/ANSI-J-STD-005	Compliant
Certificate of Compliance	Website
RoHS Compliant	Available
Application Note	EN/DE

PACKAGING AND STORAGE		
Packaging jar	PP [g]	500
Packaging cartridge	HDPE [g]	650
Packaging cartridge	HDPE [g]	1300
Packaging Cassette Pro-Flow	[g]	800
Minimum shelf-life in months	4-10 °C	6

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