

## Solder Paste Water-Washable Sn63/Pb37 in 10cc Syringe 35g T4 Mesh

### Product Highlights

Printing speeds up to 100mm/sec  
Long stencil life  
Wide process window  
Clear residue  
Low voiding  
Excellent wetting compatibility on most board finishes  
Dispense grade  
Compatible with enclosed print heads

### Specifications

Alloy:	Sn63/Pb37
Mesh Size:	T4
Micron (µm) Range:	20-38
Flux Type:	Synthetic Water-Washable
Flux Classification:	RELO
Metal Load:	87% Metal by Weight
Melting Point:	183°C (361°F)
Packaging:	10cc/35g Syringe
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

>8 hours @ 20-50% RH 22-28°C (72-82°F)  
>4 hours @ 50-70% RH 22-28°C (72-82°F)

### Stencil Cleaning

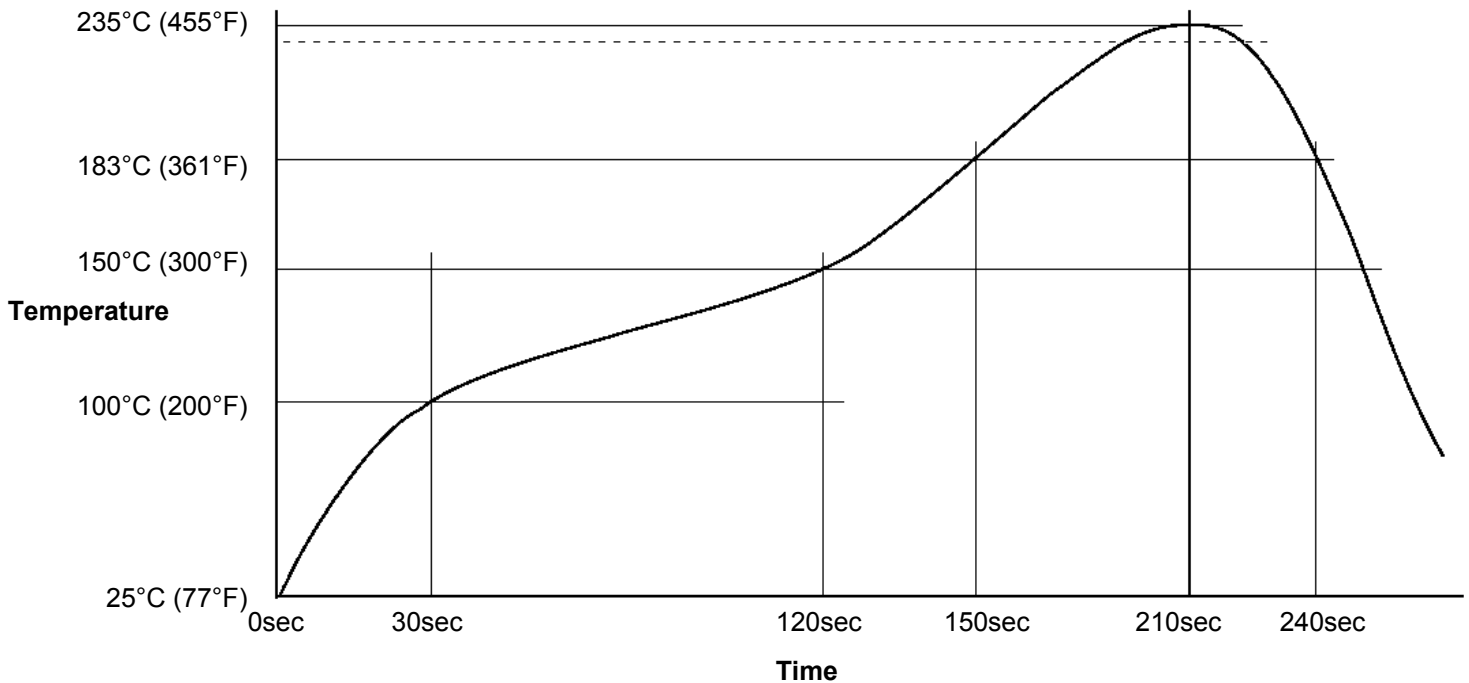
Automated stencil cleaning systems for both stencil and misprinted boards. Manual cleaning using isopropyl alcohol (IPA).

### 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.

## Recommended Profile

Reflow profile for Sn63/Pb37 solder assembly, designed as a starting point for process optimization.



## Test Results

Test J-STD-004 or other requirements as stated	Test Requirement	Result
Copper Mirror	IPC-TM-650: 2.3.32	L: No breakthrough
Corrosion	IPC-TM-650: 2.6.15	L: No corrosion
Quantitative Halides	IPC-TM-650: 2.3.28.1	L: <0.5%
Electrochemical Migration	IPC-TM-650: 2.6.14.1	L: <1 decade drop (No-clean)
Surface Insulation Resistance 85°C, 85% RH @ 168 Hours	IPC-TM-650: 2.6.3.7	L: ≥100MΩ (No-clean)
Tack Value	IPC-TM-650: 2.4.44	37g
Viscosity – Malcom @ 10 RPM/25°C (x10 <sup>3</sup> mPa/s)	IPC-TM-650: 2.4.34.4	Print: 200-275, Dispense: 100-140
Visual	IPC-TM-650: 3.4.2.5	Clear and free from precipitation
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:	No