

# AMTECH

Advanced SMT Solder Products

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An ISO 9001 Certified Company

## Product Data Sheet

# RMA-259HT Rosin Mildly Activated Solder Paste

### Product Description

- Designed for high temperature applications
- VOC Free, Halide Free and Non-Hygroscopic
- Wide process window
- Excellent wetting compatibility on most board finishes
- Low voiding

### Alloys

AMTECH manufactures a low-oxide, spherical and uniformly sized powder. RMA-259HT is available in the following alloys: Sn5/Pb92.5/Ag2.5, Sn95/Ag5, Sn95/Sb5, Sn5/Pb85/Sb10, Sn10/Pb88/Ag2 and

### Powder Distribution

Micron Size	Type	Pitch Requirements
75 - 45	Type-2	24mil & above
45 - 25	Type-3	16mil to 24 mil
38 - 20	Type-4	12mil to 16mil
25 - 15	Type-5	<12mil
15 - 5	Type-6	<8mil

### Available Packaging

The following packaging options are available for stencil printing and dispensing applications: 250g and 500g jars; 250g and 600g cartridges; 650g ProFlow<sup>®</sup> cassettes; 35g and 100g syringes; 2,500g FreshMix<sup>®</sup> Kits.

### Stencil Life

6-8 hrs. @ 30–45% RH & 22–25°C  
~4 hrs. @ 45–70% RH & 22–25°C

### Viscosity

Viscosity is dependent upon alloy type, metal load and mesh size. Tested according to IPC-TM-650

### Tack Value

Typical tackiness: 34g force

### Printing

The print definition of RMA-259HT is ideal for fine pitch applications. The stencil life of this water-soluble product virtually eliminates waste of solder paste. Consult the powder distribution chart to determine your mesh size requirements.

### Printer Operation

The following are general guidelines for stencil printer optimization with RMA-259HT. Some adjustments may be necessary based on your process requirements.

Print Speed: 25–100mm/sec

Squeegee Pressure: 0.2–0.7kg/inch of blade

Under Stencil Wipe: Once every 10–25 prints or as necessary

### Stencil Cleaning

Automated stencil cleaning systems for both stencil and misprinted boards. Manual cleaning using 99% isopropyl alcohol (IPA) works well.

### Storage and Handling Procedures

Refrigerated storage at 42–47°F will prolong the solder paste shelf life to no less than 6 months. Syringes & cartridges should be stored vertically with the dispensing tip down. Solder paste should be allowed to reach ambient temperature naturally, prior to use (about 6-8 hours). NEVER FREEZE SOLDER PASTE.

(continued)

# RMA-259HT Solder Paste

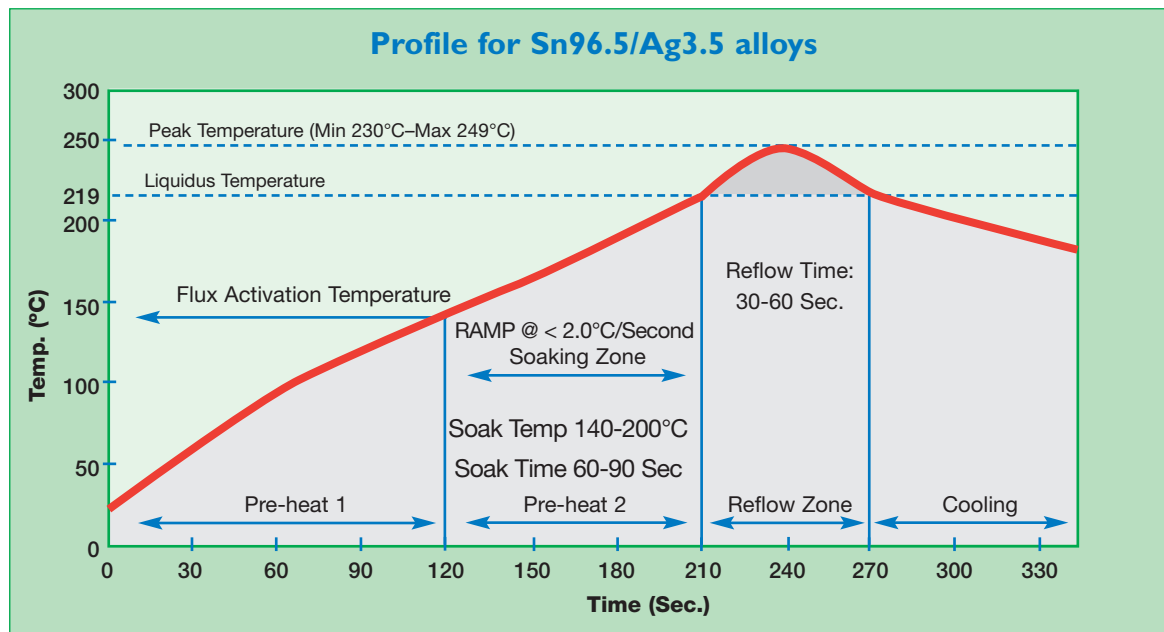
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## J-STD-004 (IPC-TM-650) Test Results

Test	Standard	Values	Results
Flux Designator	IPC-TM-650 2.3.35	NA	RELO

## Recommended Profile for Sn96.5/Ag3.5 alloy:

This profile was designed to serve as a starting point for process optimization using RMA-259HT. A cool down rate of (-) 2–4°C/second is ideal for the formation of a fine grain structure without risking damage to thermally sensitive components.



The information contained herein is based on technical data that we believe to be reliable and is intended for use by persons having technical skill, at their own risk. Users of our products should make their own tests to determine the suitability of each product for their particular process. AMTECH will assume no liability for results obtained or damages incurred through the application of the data presented.

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