

ALPHA® OM-338-PT

Fine Feature, Zero Halogen, Pin-Testable, Lead-Free Solder Paste

DESCRIPTION

ALPHA OM-338-PT is a lead-free, no-clean solder paste designed for a broad range of applications. **ALPHA OM-338-PT's** broad processing window is designed to minimize transition concerns from tin/lead to lead free solder paste. This material is engineered to deliver the comparable performance to a tin lead process. **ALPHA OM-338-PT** yields excellent print capability performance across various board designs; particularly with ultra fine feature repeatability (11 mil squares) and high "through-put" applications. **ALPHA OM-338-PT** is formulated to offer increased in-circuit pin test yields versus OM-338 without compromising electrical reliability.

Outstanding reflow process window delivers good soldering on CuOSP with excellent coalescence on a broad range of deposit sizes, excellent random solder ball resistance and mid-chip solder ball performance. **ALPHA OM-338-PT** is formulated to deliver excellent visual joint cosmetics. Additionally, **ALPHA OM-338-PT's** capability of IPC Class III for voiding and ROL0 IPC classifications ensures maximum long-term product reliability.

**Although the appearance of these lead-free alloys will be different to that of tin-lead, with mechanical reliability equal to or greater than with that of tin-lead or tin-lead-silver.*

FEATURES & BENEFITS

- Maximizes reflow yield for lead-free processing, allowing full alloy coalescence at circular dimensions as small as 0.225mm (0.011") with 0.100mm (4mil) stencil thickness
- Excellent print consistency with high process capability index across all board designs
- Print speeds of up to 150mm/sec (6"/sec), enabling a fast print cycle time and a high throughput
- Wide reflow profile window with good solderability on various board / component finishes
- Excellent solder and flux cosmetics after reflow soldering
- Reduction in random solderballing levels, minimizing rework and increasing first time yield
- Excellent pin-test yield for single and double reflow
- Meets highest IPC 7095 voiding performance classification of Class III
- Excellent reliability properties, halide-free material
- Compatible with either nitrogen or air reflow

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PRODUCT INFORMATION

<u>Alloys:</u>	SAC305 (96.5%Sn/3.0%Ag/0.5%Cu) SAC357 (95.8%Sn/3.5%Ag/0.7%Cu) SAC387 (95.5%Sn/3.8%Ag/0.7%Cu) SAC396 (95.5%Sn/3.9%Ag/0.6%Cu) SAC405 (95.5%Sn/4.0%Ag/0.5%Cu) SACX Plus™ 0307 SMT (98.9%Sn/0.3%Ag/0.7%Cu/0.1%Bi) SACX Plus™ 0807 SMT (98.4%Sn/0.8%Ag/0.7%Cu/0.1%Bi) e1 alloys per JESD97 Classification
<u>Powder Size:</u>	Type 3, (25-45µm per IPC J-STD-005) & Type 4 (20-38µm per IPC J-STD-005)
<u>Residues:</u>	Approximately 5% by (w/w)
<u>Packaging Sizes:</u>	500 gram jars, 6" & 12" cartridges, DEK ProFlo® cassettes, and 10cc and 30cc Dispense syringes
<u>Flux Gel:</u>	ALPHA OM-338-PT Flux Gel is available in 10cc or 30cc syringes for rework applications
<u>Lead Free:</u>	Complies with RoHS Directive 2011/65/EU

NOTE 1: For other alloys, powder size and packaging sizes, contact your local Alpha Sales Office.

APPLICATION

Formulated for both standard and fine pitch stencil printing, at print speeds of between 25mm/sec (1"/sec) and 150mm/sec (6"/sec), with stencil thickness of 0.100mm (0.004") to 0.150mm (0.006"), particularly when used in conjunction with **ALPHA Stencils**. Blade pressures should be 0.18-0.27 kg/cm of blade (1.0 -1.5 lbs/inch), depending upon the print speed. The higher the print speed employed, the higher the blade pressure that is required. The reflow process window will give high soldering yield with good cosmetics and minimized rework.

SAFETY

While the **ALPHA OM-338-PT** flux system is not considered toxic, its use in typical reflow will generate a small amount of reaction and decomposition vapors. These vapors should be adequately exhausted from the work area. Consult the SDS for additional safety information. The most recent version of the SDS is available from alpha.alent.com. **ALPHA OM-338-PT** should be stored in a refrigerator upon receipt at (1 to10)°C, (34-50)°F. **ALPHA OM-338-PT** should be permitted to reach room temperature before unsealing its package prior to use (see handling procedures on page 4). This will prevent moisture condensation build up in the solder paste. Consult the SDS for all safety information. The most recent version of the SDS is available from AlphaAssembly.com.

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TECHNICAL DATA

CATEGORY	RESULTS	PROCEDURES/REMARKS
CHEMICAL PROPERTIES		
Activity Level	ROLO	IPC J-STD-004A
Halide Content	Halide free (by titration)	IPC J-STD-004A
Ag Chromate Test	Pass	IPC J-STD-004A
Copper Corrosion Test	Pass , No Evidence of Corrosion	IPC J-STD-004A
ELECTRICAL PROPERTIES		
SIR (IPC 7 days @ 85° C/85% RH)	Pass , 4.1 x 10 ⁹ ohms	IPC J-STD-004A (Pass ≥ 1 x 10 ⁸ ohm)
SIR (Bellcore 96 hrs @ 35°C/85%RH)	Pass , 8.4 x 10 ¹¹ ohms	Bellcore GR78-CORE (Pass ≥ 1 x 10 ¹¹ ohm)
Electromigration (Bellcore 96 hours @ 65°C/85%RH 10V 500 hours)	Pass , Initial = 3.8 x 10 ⁹ ohms Final = 1.9 x 10 ⁹ ohms	Bellcore GR78-CORE (Pass=final > initial/10)
PHYSICAL PROPERTIES (Using 88.5% Metal, Type #3 Powder)		
Color	Clear, Colorless Flux Residue	
Tack Force vs. Humidity	Pass , Change of <1 g/mm ² over 24 hours at 25%, 50% and 75 % Relative Humidity	IPC J-STD-005
Tack Force vs. Time	Pass , Change of <10% when stored at 25±2°C and 50±10% relative humidity	JIS Z-3284, Annex 9
Viscosity	83.3% metal load for T3 designated M04 for dispensing. 88.5% metal load for T3 designated M15 and 88.5% metal load for T4 designated M16 for printing.	Malcom Spiral Viscometer; 1. J-STD-005
Solderball	Acceptable (SAC 305 and SAC405 alloys)	IPC J-STD-005
Spread	Pass	JIS-Z-3197: 1999 8.3.1.1
Slump	Pass	IPC J-STD-005 (10 min 150°C)

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PROCESSING GUIDELINES

STORAGE-HANDLING	PRINTING	REFLOW (See Figure #1)	CLEANING
<ul style="list-style-type: none"> •Refrigerate to guarantee stability @ (1-10)°C, (34-50)°F •Shelf life of refrigerated paste is six months from the manufacturing date. •Paste can be stored for 2 weeks at room temperatures up to 25°C (77°F) prior to use. •When refrigerated, warm-up of paste container to room temperature for up to 4 hours. Paste must be ≥19°C (66°F) before processing. Verify paste temperature with a thermometer to ensure paste is at 19°C (66°F) or greater before setup. Printing can be performed at temperatures up to 29°C (84°F). •Do not remove worked paste from stencil and mix with unused paste in jar. This will alter rheology of unused paste. •These are starting recommendations and all process settings should be reviewed independently. •Working range: 20°C to 32°C on the stencil 	<p><u>STENCIL</u>: Recommend ALPHA CUT or ALPHA FORM stencils @ 0.100mm - 0.150 mm (4-6 mil) thick for 0.4 - 0.5 mm (0.016” or 0.020”) pitch. Stencil design is subject to many process variables. Contact your local ALPHA Stencil site for advice.</p> <p><u>SQUEEGEE</u>: Metal (recommended)</p> <p><u>PASTE ROLL</u>: 1.5-2.0 cm diameter and make additions when roll reaches 1-cm (0.4”) diameter (min). Max roll size will depend upon blade. “Exceeding the maximum diameter may cause curtaining (sticking to the squeegee when it is lifted from the stencil).”</p> <p><u>PRESSURE</u>: 0.5 – 0.7 kg/inch of blade length</p> <p><u>SPEED</u>: 25 to 150mm per second (1 to 8 inches per second).</p> <p>Release speed: within 3- 10 mm/s. Setting done under microscope. Poor release settings: results in icicles or missing paste in small apertures.</p>	<p><u>ATMOSPHERE</u>: Clean-dry air or nitrogen atmosphere.</p> <p><u>PROFILE(SAC Alloys)</u>: Acceptable reflow / coalescence and IPC Class III voiding were obtained for the range of profiles depicted below.</p> <p>Note 2: Refer to component and board supplier data for thermal properties at elevated temperatures. Lower peak temperatures require longer TAL for improved joint cosmetics.</p>	<p>ALPHA OM-338-PT residue is designed to remain on the board after reflow. If reflowed residue cleaning is required, ALPHA BC-2200 aqueous cleaner is recommended. For solvent cleaning, agitation for 5 min in the following cleaners is recommended:</p> <ul style="list-style-type: none"> - ALPHA SM-110E - Kyzen Micronox MX2501 - ATRON® AC 205 (ZESTRON) <p>Misprints and stencil cleaning may be done with ALPHA SM-110E, ALPHA SM-440, ALPHA BC-2200 and ZESTRON® SD 301 cleaners.</p>

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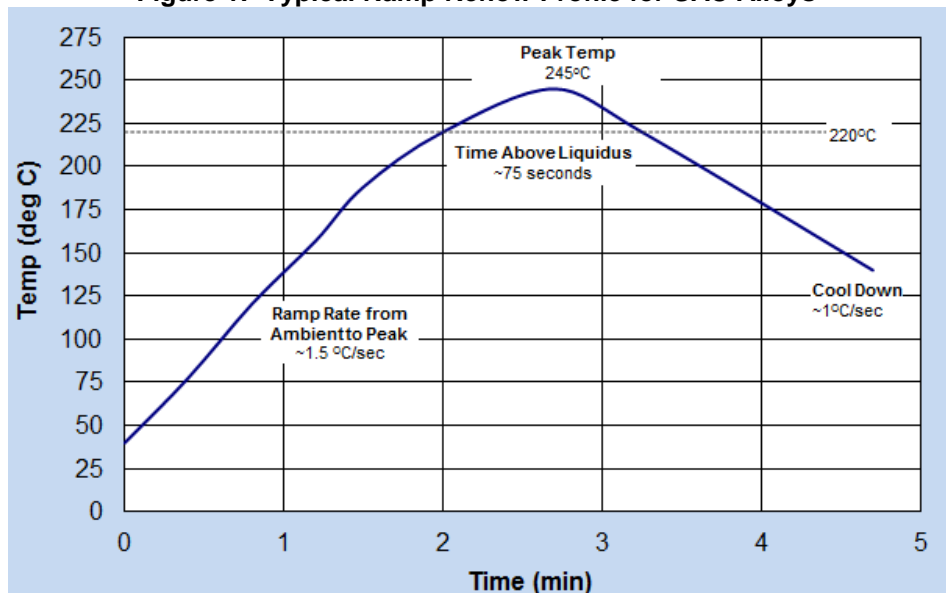
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HALOGEN STATUS

ALPHA OM-338-PT is a halogen free product and passes the standards listed in the Table below:

Halogen Standards			
Standard	Requirement	Test Method	Status
JEITA ET-7304 <i>Definition of Halogen Free Soldering Materials</i>	< 1000 ppm Br, Cl, F in solder material solids	TM EN 14582	Pass
IEC 612249-2-21	Post Soldering Residues contain < 900 ppm each or total of < 1500 ppm Br or Cl from flame retardant source		Pass
JEDEC <i>A Guideline for Defining "Low Halogen" Electronics</i>	Post soldering residues contain < 1000 ppm Br or Cl from flame retardant source		Pass
Halogen Free: No halogenated compounds have been intentionally added to this product			

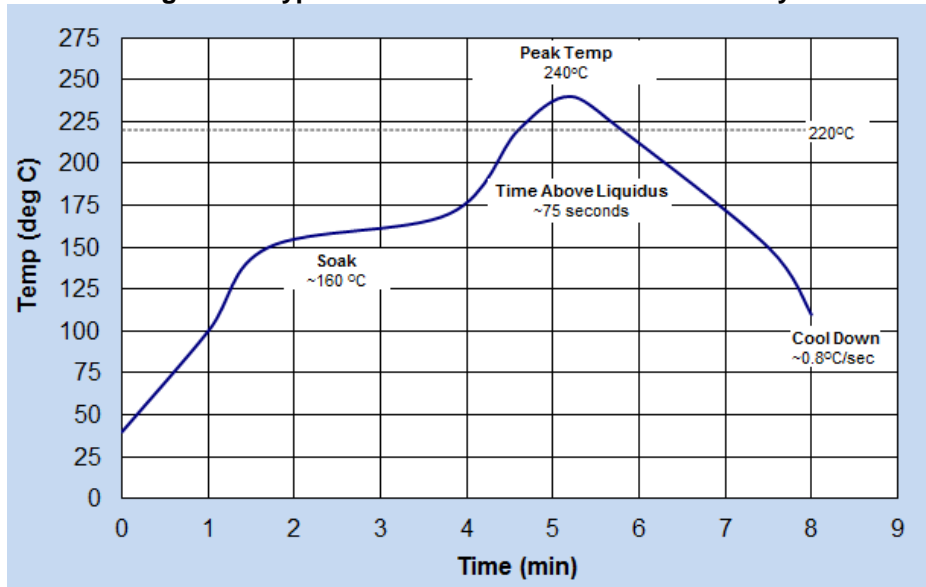
Figure 1: Typical Ramp Reflow Profile for SAC Alloys



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Figure 2: Typical Soak Reflow Profile for SAC Alloys



Note 3: These are processing guidelines that were tested in the lab with acceptable performance. Optimization to each board application should still be carried out by users to ensure best results.

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CONTACT INFORMATION

To confirm this is the most recent issue, please contact Alpha Assembly Solutions

AlphaAssembly.com

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency directory assistance Chemtrec 1 - 800 - 424 - 9300.

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