



NC257 SN100C®



Lead-Free Solder Paste

Features:

- RoHS Compliant
- Vapor Phase Compatible
- Excellent Wetting
- Broad Printing Process Window
- Low-Tombstoning
- 12-14 Hour Tack Time
- Clear Pin-Probe Testable Residue
- 24 Hour Stencil Life
- Low Solder Beading

Description:

NC257 has been developed to offer extremely broad process windows for printing, wetting and pin-probe testing. The superior wetting ability of NC257 results in bright, smooth and shiny solder joints. It also offers very low post process residues, which remain crystal clear and easily probed even at the elevated temperatures required for today's lead-free alloys. This alloy offers a chemistry developed for use in air reflow, as well as providing slump and humidity tolerances to extend the useable life in facilities where environmental control is not at its optimum.

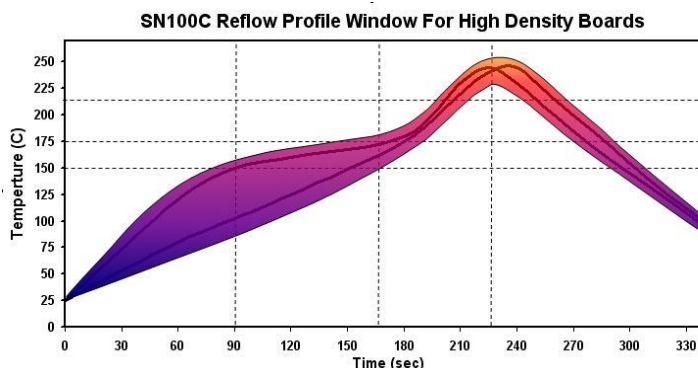
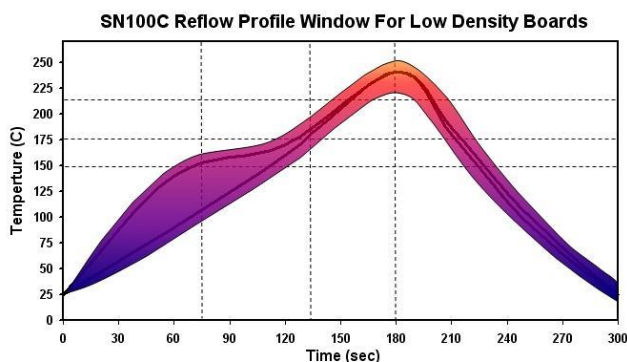
Printing:

- Apply sufficient paste to the stencil to allow a smooth, even roll during the print cycle (a bead diameter of 12 to 16 mm ($\frac{1}{2}$ to $\frac{5}{8}$ inch) is normally sufficient to begin).
- Apply small amounts of fresh solder paste to the stencil at controlled intervals to maintain paste chemistry and workable properties.
- NC257 provides the necessary tack time and force for today's high speed placement equipment, which will enhance product performance and reliability.
- Snap-off distance = On Contact 0.00 mm (0.00")
- PCB Separation Distance = 0.75-2.0 mm (.030-.080")
- PCB Separation Speed = Slow
- Squeegee Pressure = 0.10 – 0.30 kg/cm (.6 - 1.7 lbs/ In.) of blade
- Squeegee Stroke Speed = 25-50 mm/sec. (1-2 in./sec)

* Note: Recommended initial printer settings above are dependent on PCB and pad design

Reflow Profile:

Two unique profile families are depicted below; both can be used in ramp-spike or ramp-soak-spike applications, and they each have similar reflow temperatures. The two profiles differ in where they reach their respective peak temperatures, as well as the time above liquidus (TAL). The shorter profile of the two would apply to smaller assemblies, where as the longer profile would apply to larger assemblies, such as backplanes or high-density boards. The shaded area defines the process window. Oven efficiency, board size/mass, component type and density all influence the final profile for a given assembly. These profiles are starting points, and processing boards with thermal-couples attached is recommended to optimize the process.



<i>RATE OF RISE 2°C / SEC MAX</i>	<i>RAMP TO 150°C (302°F)</i>	<i>PROGRESS THROUGH 150°C-175°C (302°F- 347°F)</i>	<i>TO PEAK TEMP 235°C-255°C (455°F- 492°F)</i>	<i>TIME ABOVE 227°C (442°F)</i>	<i>COOLDOWN ≤ 4 °C / SEC</i>	<i>PROFILE LENGTH AMBIENT TO COOL DOWN</i>
Short Profiles	≤ 75 Sec	30-60 Sec	45-75 Sec	30-60 Sec	45± 15 Sec	2.75-3.5 Min
Long Profiles	≤ 90 Sec	60-90 Sec	45-75 Sec	60-90 Sec	45± 15 Sec	4.5-5.0 Min

- ❖ THE RECOMMENDED REFLOW PROFILE FOR NC257 IS PROVIDED AS A GUIDELINE. OPTIMAL PROFILE MAY DIFFER DUE TO OVEN TYPE, ASSEMBLY LAYOUT, OR OTHER PROCESS VARIABLES. CONTACT AIM TECHNICAL SUPPORT IF YOU REQUIRE ADDITIONAL PROFILING ASSISTANCE.
- ❖ THE REFLOW PROFILE FOR THE SN100C[®] PASTES USING A VAPOR PHASE REFLOW OVEN: PEAK TEMPERATURE RANGE IS 230°C – 245°C.

Compatible Products:

- AIM Lead-Free Electropure Solder Bar
- NC Paste Flux, No Clean Tacky Flux
- NC270 VOC-Free No Clean Spray Flux
- NC264-5 No Clean flux Spray/Foam
- Glowcore – No Clean Cored Wire
- Epoxy 4044 – Chip Bonding Epoxy

Cleaning:

- NC257 can be cleaned if necessary with saponified water or an appropriate solvent cleaner.
- Please refer to the AIM cleaner matrix for a list of compatible cleaning materials.

Handling and Storage:

- NC257 has a refrigerated shelf life of 6 months at 4°C (40°F) to 12°C (55°F).
- Allow the solder paste to warm up completely and naturally to ambient temperature (8 hrs.) prior to breaking the seal for use.
- Mix the product lightly and thoroughly (1-2 mins. max) to ensure even distribution of any separated material.
- Do not store new and used paste in the same container, and reseal any opened containers while not in use.
- Replace the internal plug and cap of the 500 gram jars to ensure the best possible seal.

Physical Properties:

<i>ITEM</i>	<i>SPECIFICATION</i>
Appearance	Gray, Smooth, Creamy
Alloy	SN100C [®]
Melting Point	227°C
Particle Size	T3, T4, T5
Metal Loading	88.5% (T3)
Viscosity	Print/Dispense Versions Available
Packaging	Available in all industry standard packaging.

Test Data Summary:

CLASSIFICATION			
Product Name	IPC Classification to J-STD-004	Copper Mirror to J-STD-004B	Silver Chromate to J-STD-004B
NC257	ROLO	LOW	DISSOLVE 35% - PASS
POWDER TESTING			
No.	Item	Results	Test Method
1	Powder Size	Type 3 – 45-25 micron Type 4 – 38-20 micron	IPC TM 650 2.2.14
2	Powder Shape	Spherical	Microscope
FLUX MEDIUM TESTING			
No.	Item	Results	Test Method
1	Acid Value	160.5 mg KOH/ g flux	J-STD-004B IPC TM 650 2.3.13
2	Halide Content	0.0025 ± 0.0001 Cl/g	J-STD-004B IPC TM 650 2.3.35
3	Fluorides Spot Test	No fluoride	J-STD-004B IPC TM 650 2.3.35.1 J-STD-004B IPC TM 650 2.3.35.2
4	Corrosivity Test/ Copper Mirror	L	J-STD-004B IPC TM 650 2.3.32
5	Corrosion Flux	Pass	J-STD-004B IPC TM 650 2.6.15
6	Halide-Free/Silver Chromate Paper Test	Pass	J-STD-004B IPC TM 650 2.3.33
7	Surface Insulation Resistance	> 1E9Ω at 96 and 168 h.- pass > 1E8Ω at 96 and 168 h. - pass > No dendrite growth or corrosion, after a visual inspection - pass	J-STD-004 IPC TM 650 2.6.3.3
8	Telcordia (Bellcore) Electromigration	65°C, 85% 500 hrs Initial: 7.26E+9Ω Final : 2.51 E+10Ω Rf/Ri > 0.1 - Pass	GR-78-CORE
9	Compatibility Test	See list of recommended products above	GR-78-CORE
VISCOSITY TESTING			
No.	Item	Results	Test Method
1	T-Bar Spindle Test Method	670 ± 10% kcps	J-STD-005 IPC TM 650 2.4.34
SOLDER PASTE TESTING			
No.	Item	Results	Test Method
1	Tack Test	31 g	J-STD-005 IPC TM 650 2.4.44
2	Tack Test	120 g	JIS Z 3284 Annex 9
3	Solder Ball Test	Pass	J-STD-005 IPC TM 650 2.4.43
4	Wetting Test	Pass	J-STD-005 IPC TM 650 2.4.45
5	Paste Shelf Life	4°C (39°F) = 6 months	AIM TM 125-11
6	Solder Paste Slump Test	Pass	J-STD-005 IPC TM 650 2.4.35

AIM IS ISO9001:2008 & ISO14001:2004 CERTIFIED

The information contained herein is based on data considered accurate and is offered at no charge. Product information is based upon the assumption of proper handling and operating conditions. All information pertaining to solder paste is produced with 45-micron powder. Liability is expressly disclaimed for any loss or injury arising out of the use of this information or the use of any materials designated. Please refer to <http://www.aimsolder.com/Home/TermsConditions.aspx> to review AIM's terms and conditions.