

ECOREL™ EASY 802S-85



No-clean solder paste with low residue

BENEFITS

ECOREL™ EASY 802S-85 solder paste presents a rheology adapted to different systems of application by dots, no-end screw or direct pressure. It delivers reproducible volumes from dot to dot all along the application. Its resistance to slump is excellent during the temperature increase.

SPECIFICATIONS

Alloy	Sn62PbAg2
Melting point (°C)	178
Powder size distribution (microns)	25 – 45
Metal content (%)	85 ± 0,5
Non volatile residue (%)	57 – 64
Halogen content	No halogen
Viscosity* (Pas at 20°C)	450 - 600

CHARACTERISTICS

Application with needles of diameter over 0.5 mm.
 Good coalescence and wettability on any kind of supports.
 Conservation of adhesive power, during over 16 h at 22°C.
 No slump during preheat.
 Residue lightly coloured, compatible with point tester.
 Total absence of halogen.
 Especially high resistance of surface insulation.
 No residue alteration, even during accelerated aging.

FUNCTIONAL TESTS	Results	Procedures
Flux Classification	L 0	ANSI/J-STD-004
	113	ISO 9454
Solderballing test	class 1	C 90550
Copper mirror	pass	ANSI/J-STD-004
Chromate paper	pass	ANSI/J-STD-004
Copper corrosion	pass	ANSI/J-STD-004
Surface Insulation Resistance Ohms	pass	ANSI/J-STD-004
after 21 days		
85°C - 85 % HR - 50 Volts	> 10 ⁹	
end of cycle	> 10 ¹⁰	
20°C – 65 % HR		

PACKAGING

Syringe

30g or 100 g

STORAGE & SHELF LIFE

To ensure the best product performance, the recommended storage temperature range is 0°C to 10°C. A shelf life of 9 months is achieved under these conditions.

For an optimal preservation, store syringes in vertical position, tip downwards.

Before use, allow several hours at room temperature for the paste to stabilize.

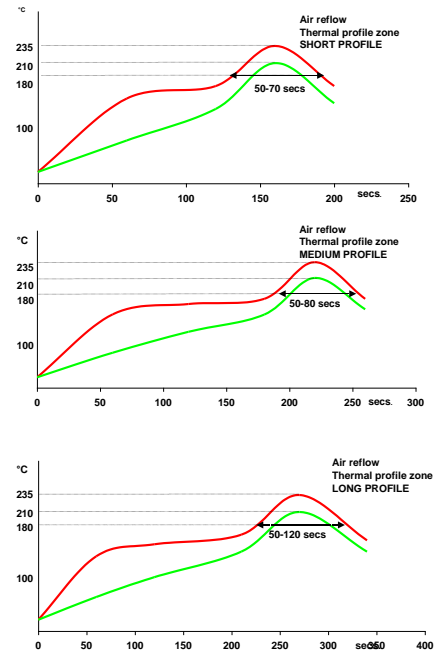
PROCESS PARAMETERS

Reflow thermal profile

The graphs below indicate, depending on the thermal mass of PCB and components, the minimum and maximum temperature profile zones to respect in order to get a good reflow under air.

A regular increase of preheat temperature is better than a too pronounced and long stage, this is to avoid pearling, to get a nicer aspect of metal and a steady repartition of residues.

Using an azote atmosphere allows to get a good coalescence and an excellent wettability in a larger window of reflow process.



Cleaning

ECOREL™ EASY 802S-85 can be cleaned with recommended INVENTEC cleaning solutions.

PROCESS Type	INVENTEC PCBA Defluxing solutions
Manual	Topklean™ EL10F/ Topklean™ EL60/ Quicksolv™ DEF90 EL
Aqueous System (Immersion or spray)	Promoclean™ DISPER 605 and DISPER 607
Novec™ HFE + Co-solvent	Topklean™ EL 20A and EL 20R
Under Vacuum System	Topklean™ EL 20D
Azeotropic Solvent	Promosolv™ 70ES

HSE

Contains lead. Please do not handle without gloves. Please refer to the Material Safety data sheet before using. No issues when used as recommended.

This data is based on information that the manufacturer believe to be reliable and offered in good faith. In no event will INVENTEC be responsible for special, incidental and consequential damages. The user is responsible to the Administrative Authorities (regulations for the protection of the Environment) for the conformity of his installation.

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