

## NC722 Low Melting No-Clean Pb-Free Solder Paste

### Introduction

NC722 solder paste is a low melting no-clean Pb-free solder paste with pin-testable flux residue formulated for use with tin-bismuth alloys. NC722 is an excellent choice for applications which require reflow temperatures below that of standard Pb-free alloys. NC722 is also halide and halogen free (zero halogens).

### Attributes

- Low melting lead-free solder paste based on tin/bismuth alloys.
- Clear, pin-testable flux residue.
- Halide and halogen free. No intentionally added halogens (Zero halogens).

Solder Alloy	Solder Powder Size Availability (IPC J-STD-005B)	Melting Range (°C)
Sn42/Bi58	Type 3	138°C
Sn42/Bi57/Ag1	Type 3	138 - 140°C

- Other sizes of solder powder are available upon request.

Solder Paste Packaging	Net Weight (grams)
Jars	500
Cartridges	500-600 (6 oz), 700 (8 oz), 1200-1300 (12 oz)
Syringes	30 (10 cc), 100 (30 cc)

- Other packaging may be available upon request.

### Compatible Products

NC120, NC160, NC165 liquid fluxes.  
NC26 gel flux.

### Storage and Handling

Best practices for storage and handling of solder paste are listed below. Additional details can be found in the Solder paste storage and handling guide.

- Shelf life is 6 months when stored at 0 to 10 °C (32 to 50 °F).
- Warm the solder paste to room temperature (18 to 29 °C / 65 to 85 °F) before use. Do not force warming by heating the solder paste. Keep the solder paste sealed while warming, which typically takes 3 to 4 hours at room temperature. Warming overnight is acceptable.
- Ideally solder paste should be mixed before use to bring it to a normal working consistency. This can be done by hand-stirring in a jar or using a knead cycle on the printer.
- Best practice is to keep the solder paste at room temperature until completely used. Remaining fresh solder paste should be sealed in the original container along with all inserts, lids, etc.

- If solder paste is removed from the printer and stored, it is recommended to store it in a separate container from the fresh solder paste. The container should be sealed with all inserts, lids, etc.
- Once solder paste is applied to the circuit board, the best practice is to reflow the solder paste as soon as possible. It is acceptable to reflow within approximately 4 hours.

**Process Parameters**

The print and reflow process parameters shown below are simply guidelines. The optimal parameters may be different based upon your equipment, circuit boards, components, and process.

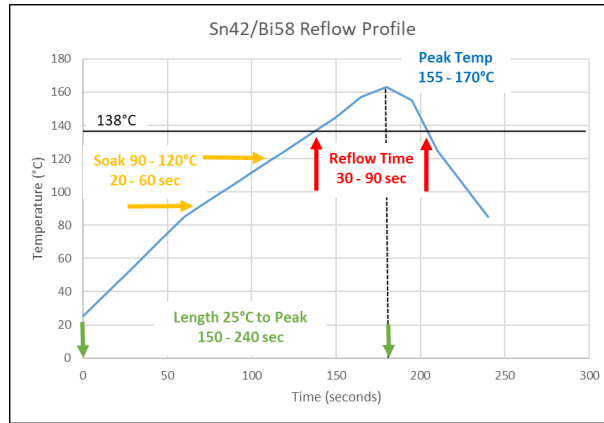
Print Parameter	Guideline	Notes
Solder paste bead size	1.0 to 2.5 cm (0.40 to 1.0 in)	Add solder paste regularly to maintain the bead size.
Squeegee blade	Stainless steel. 60° from horizontal. 45° for pin in paste.	Other blade angles and materials are usable.
Stencils	Fine grain laser cut stainless steel	All types of commercially available stencils are usable.
Print speed	20 to 200 mm/sec (0.8 to 8.0 in/sec)	Increased speeds may require higher blade pressures.
Pressure / blade length (increase with increasing speed)	0.18 to 0.54 kg/cm (1.0 to 3.0 lbs/in)	Set to the minimum required to scrape the stencil clean.
Separation speed	0.5 to 10.0 mm/sec	Higher separation speeds may improve solder paste release.
Underside stencil cleaning	Wet / vacuum / vacuum cycle every 1-20 prints	Clean more frequently to reduce the risk of bridging.
Stencil life	4 hours at 18-29 °C (65-85 °F) and 30-70% RH.	Stencil life may be shorter outside of these conditions.

- Higher blade pressures will increase stencil and blade wear and can lead to “scooping” and other print defects.
- Underside stencil cleaning is best accomplished with commercial cleaners and high-quality wipe materials. Nano-coated stencils can be used to reduce the frequency of underside cleaning.

Reflow Parameter	Guideline	Notes
Profile length (25 °C to peak)	2.5 to 4.0 min (150 to 240 sec)	Profile length is dependent upon the PCBA and process.
Heating ramp rate	1.0 to 3.0 °C/sec	Lower ramp rates tend to equalize reflow temperatures.
Preheat / soak time (90 - 120 °C)	20 to 60 sec	Linear profiles are a good starting place but may not work for all PCBAs.
Peak temperature	155 to 170 °C	15 to 30 °C above liquidus for other solder alloys.
Reflow time (time above liquidus)	30 to 90 sec	Time above the liquidus point of the solder alloy used.

Cooling ramp rate	1.0 to 6.0 °C/sec	Higher cooling rates may refine the grain structure.
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An example reflow profile graph is shown below.



Sn/Bi alloys should not be mixed with lead (Pb) bearing metals. If Pb is mixed with Sn and Bi, then a very low melting (approx. 95 °C) intermetallic compound can form. This very low melting Sn/Bi/Pb compound may cause solder joint failure due to heating during operation of the electronics.

### Cleaning

Raw solder paste can be removed from the stencil, squeegee blades, and circuit boards using a variety of commercial cleaners. Isopropyl alcohol (IPA) can also be used.

After reflow, no-clean solder paste residues are designed to be “safe” and do not need to be removed from the circuit board. If removal of the flux residues is desired, then a commercial cleaning agent should be used. Several common cleaning agents have been tested and found to be effective. Please contact your cleaning chemical supplier for details.

### Safety

Wear chemically resistant gloves when handling solder paste. Avoid breathing fumes, especially during reflow of the solder paste. Follow the guidelines detailed in the Safety Data Sheet (SDS).

J-STD-004C Flux Standard	Test Method	Result
J-STD-004C classification	J-STD-004C methods	ROLO
Halide ion content (Br <sup>-</sup> , Cl <sup>-</sup> , F <sup>-</sup> , I <sup>-</sup> )	IPC 2.3.28.1	0.0 % wt
Halogen content (Br and Cl)	EN 14582, IPC 2.3.28.1	0.0 % wt
Halide by silver chromate	IPC 2.3.33	No halides detected
Fluoride by spot test	IPC 2.3.35.1	None detected
Copper mirror	IPC 2.3.32	Low activity
Copper corrosion	IPC 2.6.15	No corrosion
Surface Insulation Resistance (SIR)	IPC 2.6.3.7	Pass

Electro Chemical Migration (ECM)	IPC 2.6.14.1	Pass
<b>J-STD-005A Solder Paste Standard</b>	<b>Test Method</b>	<b>Result</b>
Viscosity - Brookfield	IPC 2.4.34	Refer to the C of A
Slump - frosted glass	IPC 2.4.35	Pass
Solder balling - frosted glass	IPC 2.4.43	Acceptable
Wetting - copper	IPC 2.4.45	Pass
Tack force	IPC 2.4.44	30 gram force typical

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