

Trade Name: KR19 LFM-48

1. **Company Address:** Almit GmbH Ph.: +49 6066 96884-0
 Dekan-Groh-Straße 4 Fax: +49 6066 96884-18
 (D) 64720 Michelstadt - near Frankfurt

2. **Validity:** This specification is specified for:
 Almit-Solder-Wire KR19 LFM-48
 Delivered by Almit GmbH to: _____

3. Diameter & Allowance:

Diameter (mm)											
	0.2	0.3	0.38	0.5	0.65	0.8	1.0	1.2	1.6	2.0	2.7
± 0.05											

3.1. Deliverable Reel Size:

Net Weight per Reel (kg)				
	0.1	0.5	0.8	1.0
+ 0.01 -0.00				

4. Physical Properties:

Solidus °C	Liquidus °C	Specific Gravity
217	220	7.4

5. Characterisitcs:

Test	Characteristics	Test Methods
Flux Content	3,5% 3.0 ~ 4.0 (%)	IPC-TM-650:2.3.34
Copper Mirror Test	pass	IPC-TM-650:2.3.32
Silver Chromate	n.a	IPC-TM-650:2.3.33
Dryness	pass	JIS-Z-3197:1999
Flux materials composition	RO	J-Std-004:1.2
Quantitative Halide	M1	IPC-TM-650:2.3.35
Solder spreading	n.a	IPC-TM-650:2.4.46
SIR (85°C, 85%, 168hr) (Ω)	≥ 1 x 10 ⁸	IPC-TM-650:2.6.3.3
Corrosion Test	pass	IPC-TM-650:2.6.15

6. Chemical Composition: (%)

Composition	Components							
	Sn	Ag	Cu	Pb	Sb	Bi	Au	In
Standard	Rest	3.0±0.2	0.5±0.2	<0.05	≤0.10	≤0.05	≤0.05	≤0.10
Composition	Components							
	Al	As	Cd	Fe	Ni	Zn		
Standard	≤0.001	≤0.03	≤0.002	≤0.02	≤0.01	≤0.001		

7. **Lot Size:** A single lot contains 500kg which is the amount of one melting.

8. **Identification:**

Reel		Cardboard	
Name	KR19 LFM-48	Name	KR19 LFM-48
Flux Content	3,5%	Flux Content	3,5%
Diameter	mm	Diameter	mm
Net-Weight	e.g. 500g	Net-Weight	e.g. 5kg
Lot Nr.	e.g. 11.11.25	Lot Nr.	e.g. 11.11.25
Maker	Nihon Almit Co. Ltd.	Maker	Nihon Almit Co. Ltd.

9. **Packing:**

Individual Package		Outer Package
Weight (kg)	Packing	Cardboard
0.05 ; 0.1 ; 1.0	Plastic Bag	
0.5 ; 0.8	Plastic Sheet	

10. **Maker Address:** Nihon Almit Co. Ltd. - Productive Engineering Center
8154-227, Uenohara, Kitatsuru-gun, Yamanashi, 409-0112 Japan

11. **In case of changing this specification it should be accepted by:**

Signature_____ Date_____

12. This product is manufactured, using all guaranteed materials according to the legal law regulations.

13. **Shelf Life:**

Up to two (2) years from the manufactured date (lot number).