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Contact us

Tel: +86-755-8981 8866 Fax: +86-755-8427 6832

Email & Skype: info@chipsmall.com Web: www.chipsmall.com

Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China



LOCTITE MP 218

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PRODUCT DESCRIPTION

LOCTITE MP 218 provides the following product characteristics:

Technology	Solder paste
Application	Sn/Pb soldering

LOCTITE MP 218 solder paste is a halide-free, no clean, pin testable solder paste, which has excellent humidity resistance and a broad process window, both for reflow and printing. LOCTITE MP 218 has high tack force to resist component movement during high speed placement, long printer abandon times and excellent solderability over a wide range of reflow profiles in air and nitrogen and across a wide range of surface finishes including HASL, Ni/Au, Immersion Sn, Immersion Ag and OSP copper.

FEATURES AND BENEFITS

- Outstanding humidity resistance - gives excellent coalescence even after 24 hours exposure to 75% RH, thus reducing process variation due to environmental conditions
- Colorless residues for easy post-reflow inspection
- Soft, non-stick, pin testable residues allow easy in-circuit testing
- Suitable for fine pitch, high speed printing up to 150mm/s (6"/s)
- Extended open time and tack life leading to low wastage.
- Halide free flux classification: ROL0 to ANSI/J-STD-004 (Jan. 1995)

TYPICAL PROPERTIES

Based on Type 3 powder

Solder Paste Typical Properties

Alloys	Sn62, SN63
Powder Particle Size, μm	25-45
Powder Size Coding	AGS
IPC Equivalent	Type 3
Metal Loading (Weight %)	89.5% and 90%
Slump J-STD-005, mm <i>RT, 15 minutes</i>	IPC A21 Pattern
0.33 x 2.03 mm pads	0.08
0.63 x 2.03 mm pads	0.33
<i>150°C, 15 minutes</i>	
0.33 x 2.03 mm pads	0.1
0.63 x 2.03 mm pads	0.33
Brookfield Viscosity TF spindle, 25°C, 5rpm after 2 minutes, mPa·s	89.5% metal 850,000 90% metal 950,000
Thixotropic Index (TI), 25°C (1.8/18 s ⁻¹)	89.5% metal 0.43 90% metal 0.52
Malcom Rheology, 25°C Shear rate 6 s ⁻¹	89.5% metal 2,140 90% metal 2,170
Initial tack force, gF	126
Useful open time, hours	>24

Based on Type 4 powder

Solder Paste Typical Properties

Alloys	Sn62, Sn63
Powder Particle Size, μm	38-20
Powder Size Coding	DAP
IPC Equivalent	Type 4
Metal Loading (Weight %)	89.5
Brookfield Viscosity @ 25°C, mPa·s Spindle TF, Speed 5 rpm, 2 minutes	840,000
Thixotropic Index (Ti) Ti = log (1.8/18 s ⁻¹)	0.54
Malcom Viscosity @ 25°C, Pa·s @ Shear Rate of 6 s ⁻¹	1,900

63S4 ANTI-TOMBSTONING ALLOY

63S4 alloy offers an instant solution where tombstoning is a particular process problem. 63S4 alloy is a blend of different melting point alloys with a special mix of solder particle sizes. This modification extends the melting range of the alloy reducing the possibility that one solder deposit at a component termination can fully reflow before the other.

Solder Paste Typical Properties

Alloys	63S4
Powder Size Coding	ACP
Metal Loading (Weight %)	89.5% metal
Slump, J-STD-005, mm <i>RT, 15 minutes</i>	IPC A21 Pattern
0.33 x 2.03 mm pads	0.08
0.63 x 2.03 mm pads	0.33
<i>150°C, 15 minutes</i>	
0.33 x 2.03 mm pads	0.1
0.63 x 2.03 mm pads	0.33
Brookfield Viscosity TF spindle, 25°C, 5rpm after 2 minutes, mPa·s	850,000
Thixotropic Index (Ti) @ 25 °C Ti = log (1.8/18 s ⁻¹)	0.43
Malcom Rheology @ 25°C, Pa·s @ Shear Rate of 6 s ⁻¹ , Speed 10 rpm	2,140
Initial tack force, gF	126
Useful open time, hours	>24

Solder Powder:

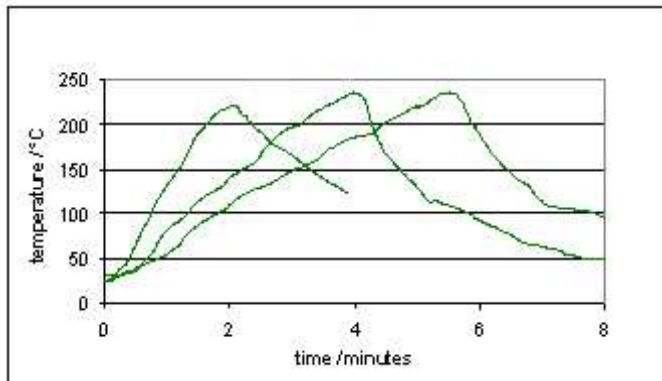
Careful control of the atomisation process for production of solder powders for LOCTITE MP 218 solder pastes ensures that the solder powder is produced to a quality level that exceeds IPC/J-STD-006 & EN29453 requirements for sphericity, size distribution, impurities and oxide levels. Minimum order requirements may apply to certain alloys and powder sizes.

DIRECTIONS FOR USE**Printing:**

1. LOCTITE MP 218 is available for stencil printing down to 0.4mm (0.016") pitch QFP devices, with type 3 (AGS) powder.
2. Printing at speeds between 25 mm/s (1 "/s) and 150 mm/s (6 "/s) can be achieved by using laser cut, electropolished or electroformed stencils and metal squeegees (preferably 60°).
3. Acceptable first prints have been achieved at 0.4 mm (16 mils) pitch after printer down times of 60 minutes without requiring a knead cycle.

Reflow:

- Any of the available methods of heating to cause reflow may be used including IR, convection, hot belt, vapor phase and laser soldering.
- LOCTITE MP 218 is not particularly sensitive to reflow profile type.
- There is no single reflow profile which is suitable for all processes and applications, but the following graphs show profile examples that have given good results in practice.
- 63S4 anti-tombstoning is selected when tombstone defects are experienced with standard alloys and when it is not possible to eliminate by design changes.
- Typical reflow profile as follows:
 1. Ramp to 130 to 165°C at no more than 2°C s⁻¹.
 2. Hold at 130 to 165°C for 60 to 120 seconds.
 3. Ramp to peak reflow temperature at no more than 2°C s⁻¹.
 4. Recommended peak reflow temperature is 205 to 225°C.
 5. Dwell time above liquidus of 30 to 75 seconds.

**Cleaning:**

1. LOCTITE MP 218 solder pastes are no-clean and are designed to be left on the PCB in many applications post-assembly since they do not pose a hazard to long-term reliability.
2. Residue removal can be achieved using conventional cleaning processes based on solvents such as LOCTITE MCF 800 or suitable saponifying agents.
3. For stencil cleaning and cleaning board misprints, LOCTITE MSC 01 solvent cleaner is recommended.

RELIABILITY PROPERTIES**Solder Paste Medium:**

LOCTITE MP 218 medium contains a stable resin system and slow evaporating solvents. The formulation has been tested to the requirements of ANSI/J-STD-004 for a type ROL0 classification.

Test	Specification	Results
Copper Plate Corrosion	ANSI/J-STD-004	Pass
Copper Mirror Corrosion	ANSI/J-STD-004	Pass
Chlorides & Bromides	ANSI/J-STD-004	Pass
Surface Insulation Resistance (without cleaning)	ANSI/J-STD-004	Pass
Electromigration (ECM)	Telecordia GR-78-Core	Pass
Flux Activity Classification (without cleaning)	ANSI/J-STD-004 (Jan. 1995)	ROL0

STORAGE AND SHELF LIFE**Storage:**

It is recommended to store LOCTITE MP 218 at 0 to 10°C. (NB cartridges should be stored tip down to prevent the formation of air pockets). The paste should be removed from cold storage a minimum of 8 hours before use. Do not use forced heating methods to bring solder paste up to temperature. LOCTITE MP 218 solder paste has been formulated to minimize flux separation on storage but should this occur, gentle stirring for 15 seconds will return the product to the correct rheological performance. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Center.

Shelf Life:

Provided Multicore LOCTITE MP 218 is stored tightly sealed in the original container at 0 to 10°C, a minimum shelf life of 183 days can be expected. Air shipment is recommended to minimize the time the containers are exposed to higher temperatures. Short term storage at room temperature during use is acceptable provided the paste is sealed in original containers. Laboratory testing has shown that the paste remains in a useable condition after 2 months of storage at room temperature.

DATA RANGES

The data contained herein may be reported as a typical value and/or a range. Values are based on actual test data and are verified on a periodic basis.

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Not for Product Specifications

The technical information contained herein is intended for reference only. Please contact Henkel Technologies Technical Service for assistance and recommendations on specifications for this product.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer**Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this

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Reference **N/A**

Americas
+1.888.943.6535

Europe
+32.1457.5611

Asia
+86.21.3898.4800

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