



SPECIFICATION

NAME : ALMIT KR - 19 SH RMA LFM-14
Lead Free Cored Solder Wire (Tin/Copper/Silver)

Lot No.	Marketing Name
	ALMIT KR-19 SH RMA LFM-14 Flux Content P-3 (2.7~3.9%) Dia (mm): 0.5, 0.65, 0.8, 1.0, 1.2, 1.6.

NIHON ALMIT Co. Ltd.

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1. Product Name: Almit KR - 19 SH RMA LFM-14 P-3

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2. Scope: This specification is for Almit flux cored solder wire, Almit KR-19 SH RMA LFM-14 P-3
Delivered by Nihon Almit Co, Ltd to Messrs. _____

3. Chemical Composition: (%) :

Composition	Sn	Cu	Ag	Sb	Pb	Bi	Zn	Fe
KR19 SH RMA LFM14	94.8~96.8	0.5~0.9	3.3~3.7	<0.5	<0.09	<0.1	<0.005	<0.02

Al	As	Cd	Au	In	Ni	P	S
<0.005	<0.03	<0.005	<0.08	<0.1	<0.01	<0.01	<0.005

4. Physical Properties:

	LFM-14	Sn63
Melting Point: Solidus (°C)	217	183
Liquidus(°C)	220	183
Specific Gravity	7.4	8.4
Spreadability (%) KR-19 flux	73.9	91.6
Wetting Balance Zero cross time secs Wetting Force (g)	1.44	0.55
	0.69	0.65
Tensile Strength (kg-f/mm²)	4.80	4.38
Uniform elongation (%)	49.0	59.0
Hardness (HV)	15.5	10.4

5. Characteristics:

Items	Characteristics	Test Methods
Flux Content (%)	P-3 (2.7~3.9)	QQ-S-571F
Chloride & Bromide	Pass	QQ-S-571F
Dryness	Pass	QQ-S-571F
Copper Plate Corrosion Test	Pass	JIS-Z-3197:1999
Copper Mirror Test	Pass	QQ-S-571F
Solution Resistance (Ω cm)	> 100,000	QQ-S-571F
Insulation Resistance (Ω)	Class AA > 1 x 10 ¹²	JIS-Z-3197:1999
Surface Insulation Resistance (Ω)	> 1 x 10 ⁹	QQS-571F 85°C/85%RH;168hr
Spreadability (%)	73.9	JIS-Z-3197:1999
Flux Type	L1	J-STD-0004

6. Dimensions: Weight and Tolerances as follows:

Dia (mm)						Weight of one Roll (Kg. Nett)	
0.5	0.65	0.8	1.0	1.2	1.6	0.5	0.8
± 0.05						+0.01 -0	

7. Construction of one Lot:

A lot contains 500 Kgs which is the amount of a single melting.

8. Quality & Inspection:

Test No.	Test Items	Estimation Results
1	Crack	Usable State
2	Smear	Usable State
3	Lustre	Usable State
4	Diameter (mm)	0.5, 0.65, 0.8, 1.0, 1.2, 1.6. ± 0.05
5	Weight (Kg.Nett)	0.5, 0.8, + 0.01 - 0
6	Sn (%)	95.8 $\pm$ 1.0
	Cu (%)	0.7 $\pm$ 0.2
	Ag (%)	3.5 $\pm$ 0.2
7	Flux Content (%)	P-3 (2.7 ~ 3.9)
8	Chloride & Bromide	Pass
9	Solution Resistance (Ω cm)	>100,000
10	Insulating Resistance (Ω)	Class AA: $> 1 \times 10^{12}$
11	Spreadability	73.9

9. Test Method: The tests are executed according to Federal Specifications QQ-S-571F and JIS-Z-3197 (Test method for Resin Flux for Soldering)

10. Packaging: Almit KR-19 SH RMA LFM-14

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8 Kg	Plastic Bag	5 & 8 Kg	Cardboard Box

11. Identification:

Roll		Cardboard Box	
Name	Almit KR-19 SH RMA LFM-14	Name	Almit KR-19 SH RMA LFM-14
Flux Content	P-3	Flux Content	P-3
Diameter	mm Dia	Diameter	mm Dia
Weight	0.8 Kg.	Weight (Nett)	8 Kg.
Lot No.	(Ex 980220)	Lot No.	(Ex. 980220)
Maker	Nihon Almit Co.Ltd.	Maker	Nihon Almit Co.Ltd.

12. Makers Address:

Nihon Almit Co. Ltd. Almit Bldg. 2-14-2 Yayoicho, Nakano-ku. Tokyo, JAPAN.

13. Changes to this specification must be approved by:-

Signed _____ Date _____

14. This product is manufactured from guaranteed materials according to the
" LAW ON INSPECTION AND MANUFACTURING OF CHEMICAL SUBSTANCES"