



## SPECIFICATION

**NAME : ALMIT KR - 19 SH RMA LFM-22 P-3  
Lead Free Cored Solder Wire**

<b>Lot No.</b>	<b>Marketing Name</b>
	ALMIT KR-19 SH RMA LFM-22 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-22 P-3

2. **Scope:** This specification is for Almit flux cored solder wire, Almit KR-19 SH RMA LFM-22 P-3  
Delivered by Nihon Almit Co, Ltd to Messrs. \_\_\_\_\_

3. **Chemical Composition: ( % ) :**

Composition	Sn	Cu	Ag	Sb	Pb	Bi	Zn	Fe
<b>KR19 SH RMA LFM 22</b>	Balance	0.5~0.9	<0.1	<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-22	Sn63
<b>Melting Point: Solidus (°C)</b>	227	183
<b>Liquidus(°C)</b>	227	183
<b>Specific Gravity</b>	7.3	8.4
<b>Spreadability (%) KR-19 flux</b>	73.9	91.6
<b>Wetting Balance Zero cross time secs</b>	1.44	0.55
<b>Wetting Force (g)</b>	0.69	0.65
<b>Tensile Strength (kg-f/mm<sup>2</sup>)</b>	4.80	4.38
<b>Uniform elongation (%)</b>	49.0	59.0
<b>Hardness (HV)</b>	15.5	10.4

5. **Characteristics:**

Items	Characteristics	Test Methods
<b>Flux Content ( % )</b>	P-3 (2.7~3.9)	QQ-S-571F
<b>Chloride &amp; Bromide</b>	Pass	QQ-S-571F
<b>Dryness</b>	Pass	QQ-S-571F
<b>Copper Plate Corrosion Test</b>	Pass	JIS-Z-3197:1999
<b>Copper Mirror Test</b>	Pass	QQ-S-571F
<b>Solution Resistance (Ω cm)</b>	> 100,000	QQ-S-571F
<b>Insulation Resistance (Ω )</b>	Class AA > 1 x 10 <sup>12</sup>	JIS-Z-3197:1999
<b>Surface Insulation Resistance (Ω)</b>	> 1 x 10 <sup>9</sup>	QQS-571F 85°C/85%RH;168hr
<b>Spreadability ( % )</b>	73.9	JIS-Z-3197:1999
<b>Flux Type</b>	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. $\pm 0.05$
5	Weight ( Kg.Nett )	0.5, 0.8, + 0.01 - 0
6	Sn (%)	Balance
	Cu (%)	$0.7 \pm 0.2$
	Ag (%)	<0.1
7	Flux Content (%)	P-3 (2.7 ~ 3.9)
8	Chloride & Bromide	Pass
9	Solution Resistance ( $\Omega$ cm)	>100,000
10	Insulating Resistance ( $\Omega$ )	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-22 P-3

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	
<b>Name</b>	Almit KR-19 SH RMA LFM- 22	<b>Name</b>	Almit KR-19 SH RMA LFM- 22
<b>Flux Content</b>	P-3	<b>Flux Content</b>	P-3
<b>Diameter</b>	mm Dia	<b>Diameter</b>	mm Dia
<b>Weight</b>	0.8 Kg.	<b>Weight (Nett)</b>	8 Kg.
<b>Lot No.</b>	( Ex 980220 )	<b>Lot No.</b>	( Ex. 980220 )
<b>Maker</b>	<b>Nihon Almit Co.Ltd.</b>	<b>Maker</b>	<b>Nihon Almit Co.Ltd.</b>



**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 SUBSTANCE “**

END.