



SPECIFICATION

NAME : ALMIT KR - 19 SH RMA LFM-48
Lead Free Cored Solder Wire (Tin/Copper/Silver)

| Lot No. | Marketing Name |
|----------------|--|
| | ALMIT KR-19 SH RMA LFM-48 Flux Content P-3 type (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-48 P3

2. **Scope:** This specification is for Almit flux cored solder wire, Almit KR-19 SH RMA LFM-48 P3
Delivered by Nihon Almit Co, Ltd to Messrs. _____

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

| Composition | Sn | Cu | Ag | Sb | Pb | Bi | Zn | Fe |
|-----------------------|-----------|---------|---------|-------|-------|-------|--------|--------|
| KR19 SH LFM 48 | 95.5~97.5 | 0.3~0.7 | 2.8~3.2 | <0.50 | <0.09 | <0.10 | <0.005 | <0.020 |

| Al | As | Cd | Au | In | Ni | P | S |
|--------|--------|--------|--------|-------|--------|--------|--------|
| <0.005 | <0.030 | <0.005 | <0.080 | <0.10 | <0.010 | <0.010 | <0.005 |

4. **Physical Properties:**

| | LFM-48 | Sn63 |
|------------------------------------|--------|------|
| Melting Point: Solidus (°C) | 217 | 183 |
| Liquidus(°C) | 220 | 183 |
| Specific Gravity | 7.4 | 8.4 |

5. **Characteristics:**

| Items | Characteristics | Test Methods |
|--------------------------------------|---------------------------------|------------------------------|
| Flux Content (%) | P-3 (2.7~3.9) | QQ-S-571F |
| Chloride and Bromide | Pass | QQ-S-571F |
| Dryness | Pass | QQ-S-571F |
| Copper Plate Test | Pass | JIS-Z-3197:1999 |
| Copper Mirror Corrosion 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 | > 1 x 10 ⁹ | QQ-S-571F 85°C/85%RH:168h |
| Spreadability (%) | >70 | JIS-Z-3197:1999 |
| Flux Type | L1 | J-STD-0004 |

6. **Dimensions: Weight and Tolerances as follows:**

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

*0.5 mm= 0.5kg spool, 0.8mm to 1.6mm =0.8kg spool

7. **Construction of one Lot:**

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

8. Packaging: Almit KR-19 SH RMA LFM-48

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

9. Identification:

| Roll | | Cardboard Box | |
|---------------------|----------------------------|----------------------|----------------------------|
| Name | Almit KR-19 SH RMA LFM-48 | Name | Almit KR-19 SH RMA LFM-48 |
| 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 99.1.10) | Lot No. | (Ex. 99.1.10) |
| Maker | Nihon Almit Co.Ltd. | Maker | Nihon Almit Co.Ltd. |

10. Makers Address:

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

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

Signed _____ Date _____

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