



## SPECIFICATION

**NAME : ALMIT LFM HANDY REEL™  
Lead Free Cored Solder Wire ( Tin/Copper/Silver )**

<b>Lot No.</b>	<b>Marketing Name</b>
	ALMIT LFM HANDY REEL™ Flux Content P-3 type ( 2.7~3.9% ) Dia (mm): 0.3, 0.5, 0.65, 0.8, 1.0.

### **NIHON ALMIT Co. Ltd.**

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**1. Product Name:** Almit LFM HANDY REEL™

**2. Scope:** This specification is for Almit flux cored solder wire, Almit LFM HANDY REEL™  
Delivered by Nihon Almit Co, Ltd to Messrs. \_\_\_\_\_

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

Composition	Sn	Cu	Ag	Sb	Pb	Bi	Zn	Fe
LFM	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	Sn63
<b>Melting Point: Solidus (°C)</b>	217	183
<b>Liquidus(°C)</b>	220	183
<b>Specific Gravity</b>	7.4	8.4

**5. Characteristics:**

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

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

Dia ( mm ) / Length ( m )				
0.3 = 4.5	0.5 = 4.0	0.65 = 3.0	0.8 = 2.0	1.0 = 1.5
± 0.05				

**7. Construction of one Lot:**

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



**8. Packaging: Almit LFM HANDY REEL™**

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
10	Shrink sealed	-	Cardboard Box

**9. Identification:**

Roll		Cardboard Box	
<b>Name</b>	Almit LFM HANDY REEL™	<b>Name</b>	Almit LFM HANDY REEL™
<b>Flux Content</b>	P-3	<b>Flux Content</b>	P-3
<b>Diameter</b>	mm	<b>Diameter</b>	mm
<b>Length</b>	metres	<b>Length</b>	metres
<b>Lot No.</b>	-	<b>Lot No.</b>	-
<b>Maker</b>	<b>Nihon Almit Co.Ltd.</b>	<b>Maker</b>	<b>Nihon Almit Co.Ltd.</b>

**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"**