



## SPECIFICATION

**NAME : ALMIT KR-19 SH (Ag2) HANDY REEL™**

<b>Lot No.</b>	<b>Marketing Name</b>
	ALMIT KR -19 SH (Ag2) HANDY REEL™ Flux Content P-2 type ( 1.6~2.6%) Dia (mm): 0.3, 0.5, 0.65, 0.8, 1.0.

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

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1. **Product Name:** Almit KR-19 SH (Ag2) HANDY REEL™

2. **Scope:** This specification is specified for Almit flux cored solder wire, Almit KR-19 SH (Ag2) HANDY REEL™.

Delivered by Nihon Almit Co, Ltd to Messrs: \_\_\_\_\_

3. **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				

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

Composition	Sn	Ag	Pb	Cu	Zn	Fe	Al	As
Standards	61.5~62.5	1.7~2.3	Rest	≤ 0.08	≤ 0.005	≤ 0.02	≤ 0.005	≤ 0.03

Au	Bi	In	Ni	P	S	Cd	Sb
≤ 0.2	≤ 0.1	≤ 0.1	≤ 0.01	≤ 0.01	≤ 0.005	≤ 0.005	≤ 0.5

5. **Characteristics:**

Items	Characteristics	Test Methods
Flux Content ( % )	P-2 (1.6~2.6)	QQ-S-571F
Chloride & Bromide	Pass	QQ-S-571F
SIR after Humid Conditions (Ω)	Class AA > 1 x 10 <sup>12</sup>	JIS-Z-3197
Surface Insulation Resistance (Ω)	> 1 x 10 <sup>9</sup>	QQS-571F 85C°/85% RH,165hr
Spreadability ( % )	> 80	JIS-Z-3197:1999
Copper Mirror Test	Pass	QQ-S-571F
Copper Plate Corrosion	Smaller than that of the Standard sample	JIS-Z-3197:1999
Dryness	Chalk powder should be easily removed from each test piece	QQ-S-571F
Solution Resistance (Ω cm)	> 100,000	QQ-S-571F
Flux Type	L1	J-STD-0004

6. **Physical Properties:**

Solidus Degs C	Liquidus Degs C	Specific Gravity
179	182	8.4

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	Luster	Usable State
4	Size (mm Dia.)	0.3 0.5, 0.65, 0.8, 1.0, 1.2 : ± 0.05
5	Length ( m.)	4.5, 4.0, 3.0, 2.0, 1.5 : + 0.05 - 0
6	Sn (%)	61.5~62.5
7	Pb and Impurities	Rest
8	Ag (%)	1.7~2.3
9	Flux Content (%)	P-2 (1.6 ~ 2.6)
10	Chloride & Bromide	Pass
11	Solution Resistance ( $\Omega$ cm)	100,000
12	SIR after Humidity ( $\Omega$ )	Class AA: $> 1 \times 10^{12}$
13	Spreadability (%)	$> 80$

## 9. Test Method:

Tests should be carried out to Federal Spec. QQ-S-571E and JIS - Z - 3197.

## 10. Packaging: Almit KR-19 SH (Ag2) HANDY REEL™

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
10	Shrinksealed	-	Cardboard

## 11. Identification:

Roll		Cardboard	
Name	Almit KR-19 SH (Ag2) HANDY REEL™	Name	Almit KR-19 SH (Ag2) HANDY REEL™
Length	metres	Length	metres
Lot No.	-	Lot No.	-
Sn Content	Sn62	Sn Content	Sn62
Flux Content	P-2	Flux Content	P-2
Size	mm Dia	Size	mm Dia
Maker	Nihon Almit Co.Ltd.	Maker	Nihon Almit Co.Ltd.
Standard	QQ-S-571F	Standard	QQ-S-571F

**12. Makers Address:**

Nihon Almit Co. Ltd.

Miyata Bldg. 6F, 1 - 38, Yoyogi, Shibuya-ku, Tokyo, 151, JAPAN.

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

Signed \_\_\_\_\_ Date \_\_\_\_\_

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

**End**