



SPECIFICATION

NAME : ALMIT KR - 19 SH RMA Sn 60 P-3 Flux Cored Solder Wire

Lot No.	Marketing Name
	ALMIT KR - 19 SH RMA Sn 60 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 – Sn60 P-3

2. **Scope:** This specification is specified for Almit flux cored solder wire, Almit KR-19 SH RMA Sn60 P-3

Delivered by Nihon Almit Co, Ltd to Messrs: _____

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

Dia (mm)						Weight of one Roll (Kg.Nett)		
0.5	0.65	0.8	1	1.2	1.6	0.5	0.8	1
± 0.05						+ 0.01 - 0		

* 0.65 Dia reel contains 0.8 Kgs, 0.5 Dia 0.5 Kgs, Rest contain 1.0 Kg.

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

Composition	Sn	Sb	Bi	Cu	Zn	Fe	Al	As	Au
Standards	59.5~61.5	≤ 0.5	≤ 0.1	≤ 0.08	≤ 0.005	≤ 0.02	≤ 0.005	≤ 0.03	≤ 0.2

Ag	In	Ni	P	S	Cd	Pb
≤ 0.1	≤ 0.1	≤ 0.01	≤ 0.01	≤ 0.005	≤ 0.005	Rest

5. **Characteristics:**

Items	Characteristics	Test Methods
Flux Content (%)	P-3 (2.7~3.9)	QQ-S-571F
Chloride & Bromide	Pass	QQ-S-571F
SIR after Humid Conditions (Ω)	Class AA > 1 x 10 ¹²	JIS-Z-3197
Surface Insulation Resistance (Ω)	> 1 x 10 ⁹	QQS-571F 85°C/85%RH;168hr
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
183	190	8.5

7. **Construction of one Lot:**

A lot contains up to 1,000 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.)	0.5 0.65, 0.8, 1.0, 1.2, 1.6 : ± 0.05
5	Weight (Kg.Nett)	0.5 0.8, 1.0 : +0.01 - 0
6	Sn (%)	59.5~61.5
7	Pb and Impurities	Rest
8	Sb (%)	< 0.50
9	Flux Content (%)	P-3 (2.7 ~ 3.9)
10	Chloride & Bromide	Pass
11	Solution Resistance (Ω cm)	> 100,000
12	SIR after Humidity (Ω)	Class AA: $> 1 \times 10^{12}$
13	Spreadability	> 80

9. Test Method:

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

10. Packaging: Almit KR-19 SH RMA

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8, 1.0 Kg	Vinyl film roll	5, 8, 10 Kg	Cardboard

11. Identification:

Roll		Cardboard	
Name	Almit KR-19 SH RMA	Name	Almit KR-19 SH RMA
Weight	1 Kg.	Weight (Nett)	10 Kg.
Lot No.	(Ex 62.3.13)	Lot No.	(Ex. 62.3.13)
Sn Content	Sn60	Sn Content	Sn60
Flux Content	P-3	Flux Content	P-3
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