

Trade Name: KR19 LFM -48 M

1. **Company Address:** Almit GmbH Ph.: +49 6061 96925-0
 Unterer Hammer 3 Fax: +49 6061 96925-18
 (D) 64720 Michelstadt - near Frankfurt

2. **Validity:** This specification is specified for:
 Almit-Solder-Wire KR19 LFM -48 M
 Delivered by Almit GmbH to: _____

3. Diameter & Allowance:

Diameter (mm)										
		0.3	0.38	0.5	0.65	0.8	1.0	1.2	1.6	0
± 0.05										

3.1. Deliverable Reel Size:

Net Weight per Reel (kg)				
		0.5	0.8	
± 0.01				

4. Physical Properties:

Solidus °C	Liquidus °C	Specific Gravity
217	221	7.4

5. Characterisitics:

Test	Characteristics	Test Methods
Flux Content	3,5% 3.0 ~ 4.0 (%)	IPC-TM -650:2.3.34.1
Copper Mirror Test		IPC-TM -650:2.3.32
Silver Chromate	n.a	n.a
Flux materials composition	RO	J-Std-004:1.2
Quantitative Halide	M1	IPC-TM -650:2.3.35
SIR (85°C, 85%, 168hr) (Ω)	≥ 1 x 10 ⁸	IPC-TM -650:2.6.3.3
Corrosion Test	pass	IPC-TM -650:2.6.15

6. Chemical Composition: (%)

Composition	Components							
	Sn	Ag	Cu	Pb	Sb	Bi	Au	In
Standard	Rest	3.0	0.5	≤0.05	≤0.10	≤0.05	≤0.05	≤0.10
Composition	Components							
	Al	As	Cd	Fe	Ni	Zn	Ga	
Standard	≤0.001	≤0.03	≤0.002	≤0.035	≤0.02	≤0.001	≤0.005	

7. **Lot Size:** A single lot contains 500kg which is the amount of one melting.

8. **Identification:**

Reel		Cardboard	
Name	KR19 LFM -48 M	Name	KR19 LFM -48 M
Flux Content	3,5%	Flux Content	3,5%
Diameter	mm	Diameter	mm
Net-Weight	e.g. 500g	Net-Weight	e.g. 5kg
Lot Nr.	e.g. 13.11.25	Lot Nr.	e.g. 13.11.25
Maker	Nihon Almit Co. Ltd.	Maker	Nihon Almit Co. Ltd.

9. **Packing:**

Individual Package		Outer Package
Weight (kg)	Packing	Cardboard
0.1, 1.0	Plastic Bag	
0.5, 0.8	Plastic Sheet	

10. **Maker Address:** Nihon Almit Co. Ltd. - Productive Engineering Center
8154-227, Uenohara, Kitatsuru-gun, Yamanashi, 409-0112 Japan

11. **In case of changing this specification it should be accepted by:**

Signature _____ Date _____

12. This product is manufactured, using all guaranteed materials according to the legal law regulations.

13. **Shelf Life:**

Up to two (2) years from the manufactured date (lot number).