

## NC259 SERIES T6 NO CLEAN SOLDER PASTE

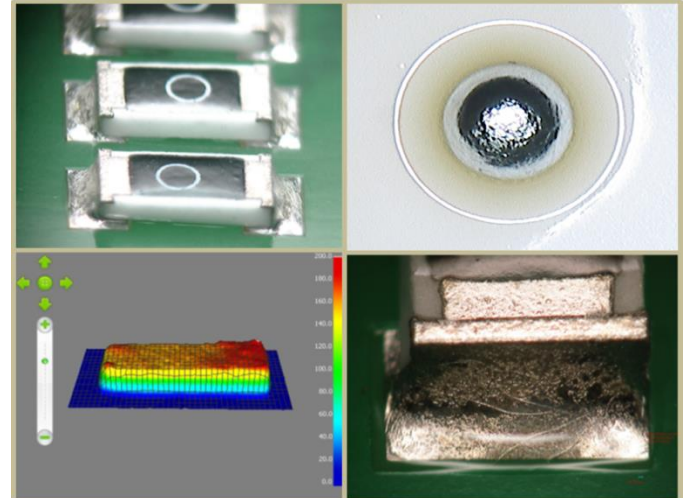
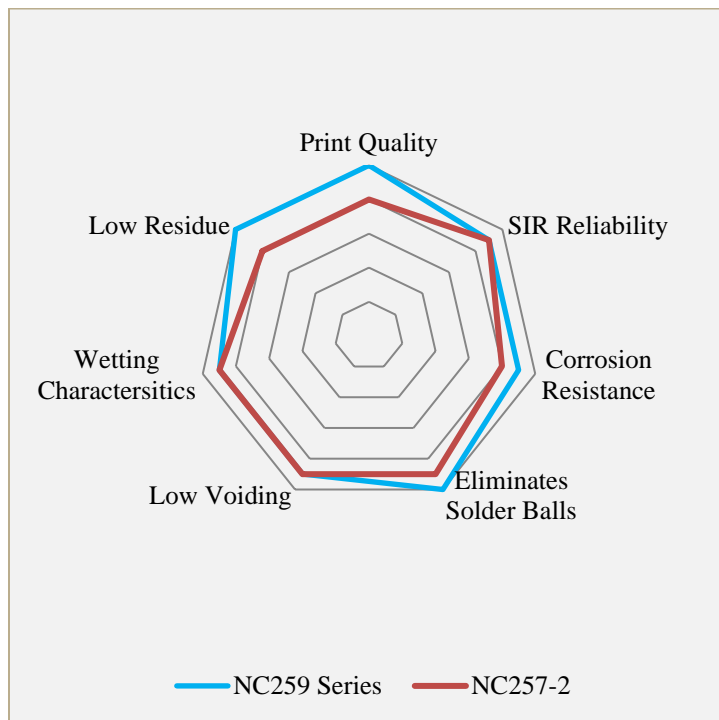
### FEATURES

- Extremely Low Residues
- 8 Hour Print Life
- Nitrogen Reflow Capable
- <0.66AR Print Capable
- High Tack

### DESCRIPTION

AIM's NC259 Series T6 solder pastes are compatible with SAC and no/low-silver alloy. The NC259 Series demonstrates pause-to-print capabilities >8 hours while providing high transfer efficiency and precise print definition. The unique activator system promotes wetting even in the absence of silver and tolerates peak reflow temperatures as high as 260°C.

### CHARACTERISTICS



NC259 Series T6 should be consumed within 24 hours after packaging seal is broken. Paste may remain on the printer for 6-8 hours, longer time is acceptable based on print and reflow performance. Do not add used paste to unused paste. Store used paste separately; keep unused paste tightly sealed with internal plug or end cap in place. See AIM's paste handling guidelines for further information. Alloy and storage conditions may affect shelf life. Please refer to NC259 Series Certificate of Analysis for product specific information. Additional handling recommendations can be found at [https://aimsolder.com/sites/default/files/aim\\_paste\\_handling\\_guideline\\_revnf1.pdf](https://aimsolder.com/sites/default/files/aim_paste_handling_guideline_revnf1.pdf)

### CLEANING

**Pre-Reflow:** AIM DJAW-10 effectively removes NC259 solder paste from stencils while in process. DJAW-10 can be hand applied or used in under stencil wipe equipment. DJAW-10 will not dry NC259 and will enhance transfer properties. Do not over-apply DJAW-10. Do not apply DJAW-10 to stencil topside. Isopropanol (IPA) is not recommended in process, but may be used as a final stencil rinse.

**Post-Reflow Flux Residue:** NC259 Series residues can remain on the assembly after reflow and do not require cleaning. Where cleaning is mandated, AIM has worked closely with industry partners to ensure that NC259 Series residues can be effectively removed with common defluxing agents. Contact AIM for cleaning information.

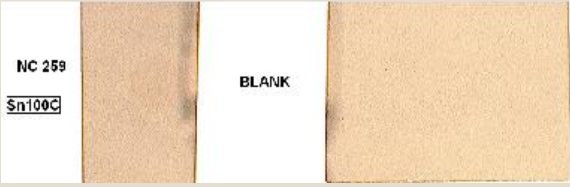
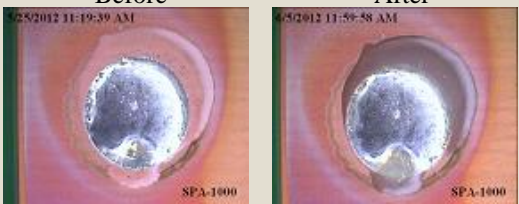

### HANDLING & STORAGE

Parameter	Time	Temperature
Refrigerated Shelf Life	3 months	0°C-12°C (32°F-55°F)

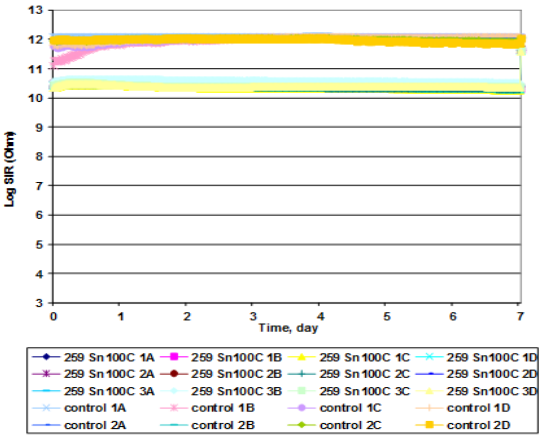
## REFLOW PROFILE

Detailed profile information may be found at <http://www.aimsolder.com/reflow-profile-supplements>. Contact AIM for additional information.



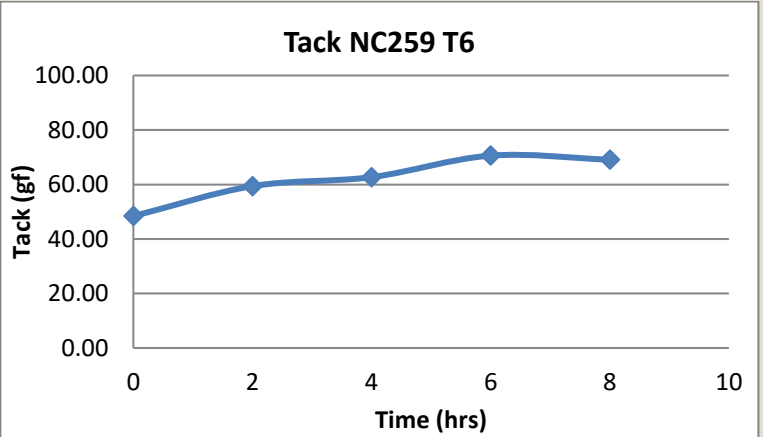
## TEST DATA SUMMARY

Name	Test Method	Results	
IPC Flux Classification	J-STD-004	ROLO	
IPC Flux Classification	J-STD-004B 3.3.1	ROL1	
Name	Test Method	Typical Results	Image
Copper Mirror	J-STD-004B 3.4.1.1 IPC-TM-650 2.3.32	LOW	
Corrosion	J-STD-004B 3.4.1.2 IPC-TM-650 2.6.15	PASS	
Quantitative Halides	J-STD-004B 3.4.1.3 IPC-TM-650 2.3.28.1	PASS	
Qualitative Halides, Silver Chromate	J-STD-004B 3.5.1.1 IPC-TM-650 2.3.33	PASS	
Qualitative Halides, Fluoride Spot	J-STD-004B 3.5.1.2 IPC-TM-650 2.3.35.1	No Fluoride	

# TECHNICAL DATA SHEET

Name	Test Method	Typical Results	Image
Surface Insulation Resistance	J-STD-004B 3.4.1.4 IPC-TM-650 2.6.3.7	PASS	
Electrochemical Migration	J-STD-004B 3.4.1.5 IPC-TM-650 2.6.14.1	PASS	
Flux Solids, Nonvolatile Determination	J-STD-004B 3.4.2.1 IPC-TM-650 2.3.34	95.6% Typical	
Acid Value Determination	J-STD-004B 3.4.2.2 IPC-TM-650 2.3.13	PASS	
Viscosity	J-STD-005A 3.5.1 IPC-TM-650 2.4.34 Malcom	150-350 PaS	
Viscosity	J-STD-005A 3.5.1 IPC-TM-650 2.4.34	500 – 1000 Kcps	
Visual	J-STD-004B 3.4.2.5	Gray, Smooth, Creamy	

# TECHNICAL DATA SHEET

Name	Test Method	Typical Results	Image												
Slump	J-STD-005A 3.6 IPC-TM-650 2.4.35	PASS													
Solder Ball	J-STD-005A 3.7 IPC-TM-650 2.4.43	PASS	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>15 Min</p>  </div> <div style="text-align: center;"> <p>4 Hours</p>  </div> </div>												
Tack	J-STD-005A 3.8 IPC-TM-650 2.4.44	48gf Typical	<div style="text-align: center;"> <p><b>Tack NC259 T6</b></p>  <table border="1"> <caption>Tack (gf) vs Time (hrs) Data</caption> <thead> <tr> <th>Time (hrs)</th> <th>Tack (gf)</th> </tr> </thead> <tbody> <tr> <td>0</td> <td>48</td> </tr> <tr> <td>2</td> <td>60</td> </tr> <tr> <td>4</td> <td>62</td> </tr> <tr> <td>6</td> <td>70</td> </tr> <tr> <td>8</td> <td>68</td> </tr> </tbody> </table> </div>	Time (hrs)	Tack (gf)	0	48	2	60	4	62	6	70	8	68
Time (hrs)	Tack (gf)														
0	48														
2	60														
4	62														
6	70														
8	68														
Wetting	J-STD-005A 3.9 IPC-TM-650 2.4.45	PASS													

+ All information for reference only. Not to be used as incoming product specifications or for process design. Consult Certificate of Analysis for product specific information.