

Low melting point solder paste

**TB48-M742** Sn 58.0Bi



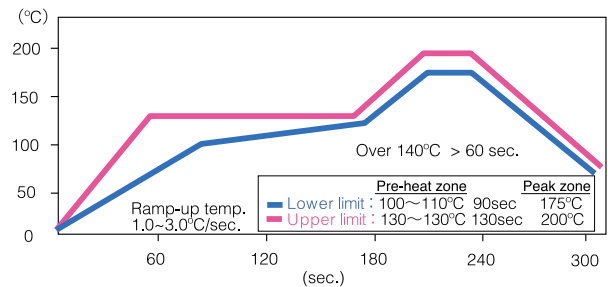
Combines reliability and workability with low temperature reflow

**Reduces damage to components, boards, and cost by low temperature reflow**

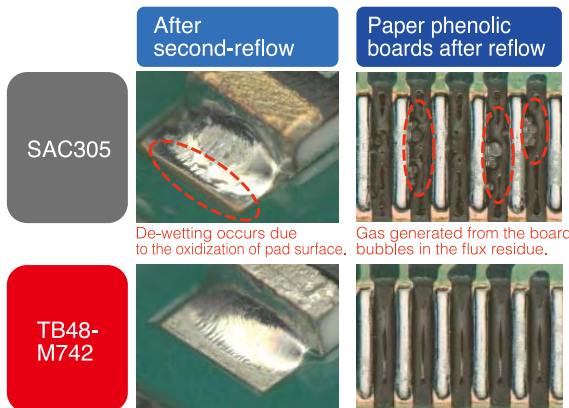
TB48-M742, a low melting point alloy (138°C), brings the following benefits associated with low temperature reflow;

1. Available with temperature sensitive materials
2. Less heat damage to components given by double sided reflow
3. Reduction of running costs by saving electricity consumption.

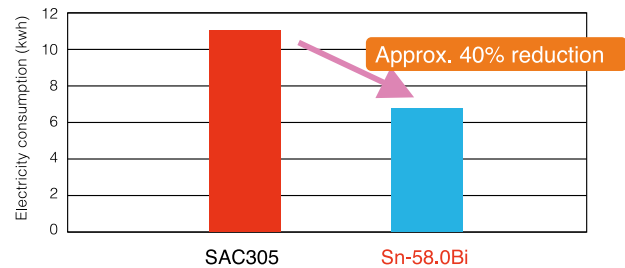
■ TB48-M742 Recommended reflow profile



■ Figure 1. Comparison of PCB's condition after reflow



■ Figure 2. Electricity consumption / hr during reflow process



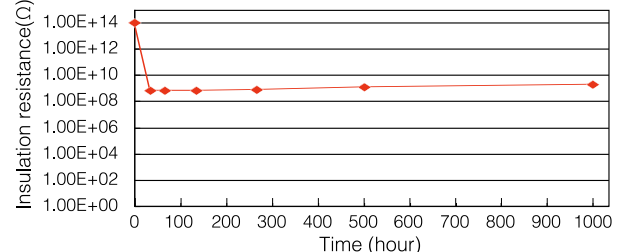
TB48-M742 enables a saving of approx. 40% reduction in running cost by low temperature reflow.

**High electrical reliability**

Optimized flux and solvent formulation of TB48-M742 realizes excellent compatibility between electrical reliability and workability for low temperature reflow with sufficient SIR, printing idle time and tack time.

■ Figure 3. Voltage applied SIR

- Condition: 85±2°C x 85%RH for 1000hrs
- Test piece: JIS type-II ● Voltage applied: DC50V



Product specifications		
Product name	TB48-M742	T4AB58-M742
Alloy composition (%)	Sn 58.0Bi	Sn 57.6Bi 0.4Ag
Melting point (°C)	138	138-140
Particle size (µm)	20-45	20-38
Viscosity (Pa.s)		190
Flux content (%)		10.0
Halide content (%)		0
Flux type		ROLO

SnBi type low MP alloy **Low MP**

Low voiding **Low V**

Fine pitch printing >0.4mm pitch >0.3mm dia. CSP **Yes**

No clean type **No-clean**

Low energy **Low E**

Halogen free **HF**

Tack time >16hours **>16h**