

# ALPHA<sup>®</sup> RMA-390-DH7 Paste Flux

## Rosin-Based Paste Flux

### DESCRIPTION

**ALPHA RMA390-DH7** is a rosin-based halide-free, ROL0 paste flux designed for a broad range of applications and alloys. This is an ideal paste flux for reworking tin/lead or lead-free BGA components.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### PRODUCT INFORMATION

Packaging Sizes: 30cc syringe, 100 gram jar

RoHS Compliance: RoHS Directive EU/2015/863; amending Annex II of 2011/65/EU

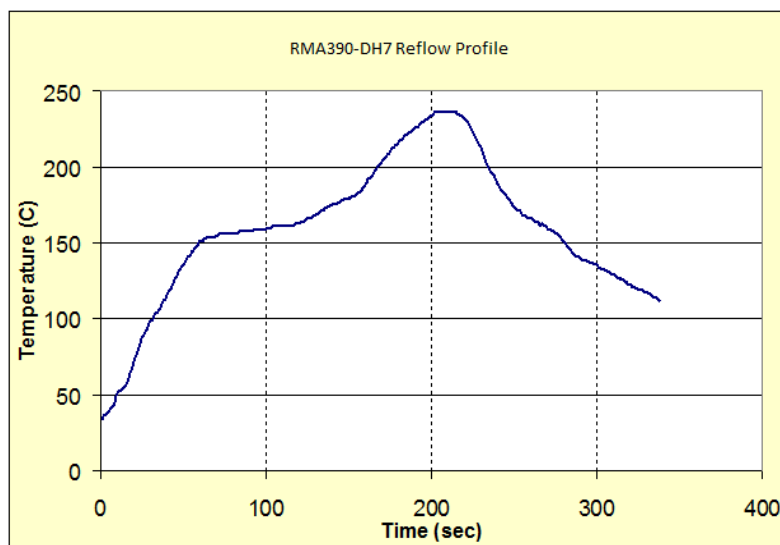
### APPLICATION GUIDELINES

ALPHA RMA-390-DH7 paste flux may be applied by screen printing or pin transfer (substrate) or doctor blade / dip coating (package). It can also be dispensed.

Reflow can be accomplished in dry air or nitrogen controlled atmosphere. The initial ramp rate should be 1 to 3 °C per second. If necessary, a dwell of 1 to 2 minutes at 120 to 160 °C is acceptable. Following this equilibrating period is a ramp of 0.5 to 1 °C per second to a peak temperature of 220 to 240 °C peak depending upon alloy. An example of an acceptable reflow profile is diagramed below (see page 2).

**TECHNICAL DATA**

Category	Results	Procedure/Remarks
<b>Chemical Properties</b>		
Activity Level	ROL0	IPC J-STD-004A
Halide Content	Halide - Free	By Titration
<b>Electrical Properties</b>		
IPC SIR (7 days @ 85 °C /85% RH)	<b>Pass</b>	IPC J-STD-004A (Pass > 10 <sup>8</sup> )
HP Electrochemical Migration (28 days @ 50 °C/90%RH 10V)	<b>Pass</b>	HP ECM
<b>Physical Properties</b>		
Color	Smooth, Amber Paste	
Viscosity (10rpm at 25 °C by Malcom Viscometer)	300 Poise (Typical Value)	
Fineness of Grind (µm)	<10 µm	

**REFLOW PROFILE**


Note: This profile was tested in the lab with acceptable reflow and coalescence performance, optimization to each board application should still be carried out by users to ensure best results.

**RECYCLING SERVICES**

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



**SAFETY & WARNING**

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at [MacDermidAlpha.com/assembly-solutions/knowledge-base](http://MacDermidAlpha.com/assembly-solutions/knowledge-base).**

**STORAGE**

The flux should be stored in sealed containers and need not be refrigerated. Shelf life of unopened containers at room temperature (19 to 25 °C / 66 to 77 °F) is 12 months from the manufacturing date. If the material has been chilled, the container should be allowed to reach room temperature before opening in order to prevent moisture condensation from ambient air onto the flux.

**CONTACT INFORMATION**

**To confirm this document is the most recent version, please contact  
 Assembly@MacDermidAlpha.com  
[www.macdermidalpha.com](http://www.macdermidalpha.com)**

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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