



**ESL EUROPE**

SOLDER PASTES &  
THICK-FILM MATERIALS

8 COMMERCIAL ROAD  
READING, BERKSHIRE, RG2 0QZ, UK

T: +44 (0) 118 918 2400  
F: +44 (0) 118 986 7331

[www.solderpaste.co.uk](http://www.solderpaste.co.uk)

## SOLDER PASTE

## 3703-G

**Lead-free\***

3703-G is a solder paste with a rosin based mildly activated, flux system. This solder paste exhibits good printing properties and enables surface mounting of components to printed circuit boards and hybrid circuits. 3703-G uses standard 96.5Sn / 3.5Ag alloy powders.

It is recommended that this solder paste is stored in a tightly closed jar in a dry environment at room temperature. Printed boards should also be stored in a dry environment.

### PASTE DATA

<b>Rheology:</b>	Screen-printable paste
<b>Viscosity:</b> (Brookfield RVTD, Helipath Stand, 5 rpm, TF spindle, 25.5 ± 0.5 °C)	650 ± 50 Pa.s
<b>Solids:</b>	90 ± 0.5 %
<b>Shelf Life:</b> (at 20 °C)	6 months

### PROCESSING

<b>Screen Mesh, Emulsion:</b>	Screen 80 S/S, 150 - 200 µm Stencil: Laser cut, nickel formed or etched S/S 120 - 200 µm
<b>Reflow Temperature Range:</b>	> 250 °C in air
<b>Thinner:</b>	ESL 401
<b>Flux Removal:</b>	The residues can be removed using standard flux or saponifier cleaners

ESL Europe 3703-G 0507-E

#### ESL Worldwide

ESL ElectroScience (USA) • 416 East Church Road • King of Prussia • PA 19406-2625 • U.S.A • Tel: +1 610-272-8000 • Fax: +1 610-272-6759 • Sales@ElectroScience.com

ESL Nippon • Sukegawa Bldg. 6<sup>th</sup> floor, 3-4 Yanagibashi 1-chome, Taito-ku, Tokyo 111, Japan • Tel: +81-3-3864-8521 • Fax: +81-3-3864-9270 • Sales@ESL-Nippon.co.jp

ESL China • Room #2712, Far East International Plaza, No.317 Xianxia Road, Changning District, Shanghai, China 200051 • Tel: +86-21-6237-0336 • Fax: +86-21-6237-0338 • ESLChina@eslshanghai.net

ESL Taiwan • 14F, No. 168, Tun Hwa N. Road, Sungsan District, Taipei, Taiwan • Tel: +886-975-553-612 • dshih@esl-taipei.com

ESL in Korea • AMT, #109-405, 85(4/2), Bakdal 2-Dong, Manan-Ku, Anyang-Si, KyunggiDo, South Korea • Tel: +82-31-466-0651 • Fax: +82-31-466-0658 • yumikim@esl-amt.co.kr

See Caution and Disclaimer on next page.

## TYPICAL PROPERTIES

(225 ± 25 µm wet print thickness)

<b>Approximate Coverage:</b>	12.5 cm <sup>2</sup> / g
<b>Printing Resolution:</b> (line / space)	0.400 mm / 0.400 mm
<b>Screen Time:</b>	> 10 hours
<b>Tack Time:</b>	> 72 hours

## CLEANING

Because of the relatively high reflow temperature of 260 °C cleaning is recommended if any flux charring has occurred.

ESL Europe 3703-G 0507-E

---

\*Complies with RoHS

**CAUTION:** Proper industrial safety precautions should be exercised in using these products. Use with adequate ventilation. Avoid prolonged contact with skin or inhalation of any vapours emitted during use or heating of these compositions. The use of safety eye goggles, gloves or hand protection creams is recommended. Wash hands or skin thoroughly with soap and water after using these products. Do not eat or smoke in areas where these materials are used. Refer to appropriate MSDS sheet.

**DISCLAIMER:** The product information and recommendations contained herein are based on data obtained by tests we believe to be accurate, but the accuracy and completeness thereof is not guaranteed. No warranty is expressed or implied regarding the accuracy of these data, the results obtained from the use hereof, or that any such use will not infringe any patent. ElectroScience assumes no liability for any injury, loss, or damage, direct or consequential, arising out of its use by others. This information is furnished upon the condition that the person receiving it shall make his own tests to determine the suitability thereof for his particular use, before using it. User assumes all risk and liability whatsoever in connection with his intended use. ElectroScience's only obligation shall be to replace such quantity of the product proved defective.

---