

Sn60Pb40 HF533

Halide Free No Clean Core Wire

Product Description

Sn60Pb40 HF533 cored flux is formulated with high purity speciality chemicals with halide-free additives. Thus it gives a non-corrosive, colourless and transparent residue, which exhibits good electrical insulation properties.

Application

Sn60Pb40 HF533 core wire is easy to use for automatic, manual, rework, point and brush soldering. For the best soldering results, the recommended parameters are shown:

Solder Iron Tips:

All Types especially the tapered types

Soldering Temp: 270-320 °C

Soldering Time: 1 - 3 secs

- Keep solder iron tips clean.
- Tinned iron tips before use.
- Wear gloves when soldering to avoid contaminating the wire.

(Note: Soldering parameters are dependent on tip type, soldering station wattage configuration, wire diameter and type of applications.)

Specification

Item	Result
Alloy Composition	Sn60Pb40
Flux Content	2.0 +/- 0.3 wt% 3.0 +/- 0.3 wt%
Density of Core Flux @ 25 °C	1.08 g/cm ³
Halide Content	N.A
<small>JIS Z 3197 8.1.4.2.1</small> Water Extract Resistivity	> 1 x 10 ⁴ Ω-cm
<small>JIS Z 3197 8.1.1</small> Surface Insulation Resistance (85°C, 85%RH, 168hrs)	> 1 x 10 ⁸ Ω, Pass
<small>IPC-TM-650 2.6.3.3</small> <small>JIS Z 3197 8.5.3</small>	> 1 x 10 ¹¹ Ω, Pass
Electromigration (85°C, 88.5%RH, 596hrs)	Pass
<small>IPC-TM-650 2.6.14.1</small> Copper Corrosion Test	Pass
<small>IPC-TM-650 2.6.15</small> <small>JIS Z 3197 8.4.1</small>	Classified as "M", Pass
Copper Mirror Test <small>IPC-TM-650 2.3.32</small> <small>JIS Z 3197 8.4.2</small>	ROM0
Flux Activity Classification <small>IPC J-STD-004</small>	> 90%
Spread Factor <small>JIS Z 3197 8.3.1.1</small>	Dry
Residue Dryness Test <small>JIS Z 3197 8.5.1</small>	Light Yellowish

RESIDUAL REMOVAL

Since the residues are transparent, minimal, dry, non-tacky and practically inert after soldering, removal is usually not necessary. For assemblies that require cleaning, Sn60Pb40 HF-533 no clean core flux solder wire can be completely removed by any solvent type flux cleaner available in the market.

STORAGE

Store the solder wire in a cool, dry and non-corrosive environment. Wrap up the solder wire when not in use to reduce exposure to environment. Sn60Pb40 HF533 no clean core flux solder wire can be kept for 2 years if proper storage conditions are observed.

HEALTH and SAFETY

Wear a chemical mask if the operators are allergic to the fumes released during soldering. For more information, please refer to Material Safety Data Sheet.

PACKAGING

Sn60Pb40 HF533 no clean core flux solder wire is commonly available in various diameters such as 0.25, 0.3, 0.4, 0.5, 0.6, 0.8, 1.0, 1.2, 1.6 and 2.0 mm. For different diameters, please specify your requirements.

Packaging	0.25kg	0.50kg	1.0kg
Diameter (mm)	0.5 to 2.0	0.5 to 2.0	0.8 to 2.0

DISCLAIMER OF LIABILITY

"All statements, information and recommendations contained in this catalog are based on data and test results which we consider, to the best of our knowledge and belief, to be reliable and informative to the users but the accuracy and completeness thereof is not guaranteed. No warranty, expressed or implied, statutory or otherwise, is given regarding the use of the information and products contained in this catalog since the conditions and suitability for use, handlings, storage or possession of the products are determined by the users and are therefore beyond our control. We shall not be liable in respect of any liabilities, losses (including consequential losses), damages, proceedings, costs, claims or injuries whatsoever sustained or suffered by the users (including any third parties) in connection with the use of the information, recommendation and the products contained in this catalog."

Singapore Asahi Chemical and Solder Industries Pte Ltd
47 Pandan Road Singapore 609288
Tel: +65 6262-1616 Fax: +65 6261-6311
Website: <http://www.asahisolder.com> Email: enquiry@sinasahi.com.sg