

Sn60Pb40 HF532

Halide Free No Clean Core Wire

Product Description

Sn60Pb40 HF532 is formulated with high quality purified Class A Type 1, Grade WW rosin conforming to U.S Federal Specification LLL-R-626 together with organic, halogen-free additives which are specially combined with regard to the thermal course of the soldering process. This non-corrosive RMA flux leaves minimal residue that exhibits good electrical insulation.

Application

Sn60Pb40 HF532 for SnPb 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 oC

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 > 1 x 10 ¹¹ Ω, Pass |
| <small>IPC-TM-650 2.6.3.3</small> | |
| <small>JIS Z 3197 8.5.3</small> | |
| 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> | |
| Copper Mirror Test | Classified as "M", Pass |
| <small>IPC-TM-650 2.3.32</small> | |
| <small>JIS Z 3197 8.4.2</small> | |
| Flux Activity Classification | ROM0 |
| <small>IPC J-STD-004</small> | |
| Spread Factor | > 90% |
| <small>JIS Z 3197 8.3.1.1</small> | |
| Residue Dryness Test | Dry |
| <small>JIS Z 3197 8.5.1</small> | |
| Residue Appearance | Transparent & Minimal |

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-532 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 HF532 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 HF532 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

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