



# Solder wire

## IF 1000M SnPb(Ag)

INTERFLUX®  
ELECTRONICS N.V.



Technical data IF 1000M SnPb(Ag)

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### Rosin based, activated no-clean solder wire

#### Description:

Interflux® **IF 1000M SnPb(Ag)** is a no-clean solder wire that has been developed to give increased wetting on surfaces that are difficult to solder, e.g. OSP, Ni, Zn, messing, German silver,...

The solder wire contains a colophony based body that has been designed to enhance spreading of the solder on solderable surfaces.

**IF 1000M SnPb(Ag)** is useable in both hand soldering and automated soldering processes.

Depending on the temperature settings, residues can vary from transparent to amber.

The solder wire contains halogens and is classified as RO L1 according to IPC and EN-standards.



#### More information:

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#### Key advantages:

- Increased wetting properties on surfaces that are difficult to solder.
- Suitable for automated soldering
- RO L1

### Availability

Flux type: IF 1000M  
Flux content: 2,2 % w/w

alloy	melting point	diameters					
		0,35	0,50	0,70	1,00	1,50	2,00
Sn60Pb40	183°C–191°C	●	●	●	●	●	●
Sn63Pb37	183°C	●	●	●	●	●	●
Sn62Pb36Ag2	179°C	●	●	●	●	●	●

● = available      ● = upon request



## Work instructions

### **Manual soldering**

The advised working temperature is between 320°C and 360°C. For more dense metals like Nickel, the temperature may be elevated to 400°C.

Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact surface with

the component and solder pad.

The use of a good soldering station is important in order to always have the correct temperature on the soldering joint. Use a soldering station with a response time as short as possible.

Heat up the surfaces of both component and island simultaneously. Slightly touch

with the solder wire, the point where component lead, soldering island and soldering tip meet (the small quantity of solder ensures a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. It is important that no solder wire is

making contact with the soldering tip during soldering to avoid flux spitting and premature flux consumption!

## Handling

### **Storage**

Store the solder wire in a clean environment at ambient temperature.

### **Handling**

To avoid spool and wire damage, handle package with care.



## Test results

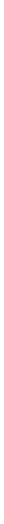
conform EN 61190-1-3(2007) and IPC J-STD-004(A)

Property	Result	Method
<b>Chemical</b>		
flux designator	<b>RO L1</b>	J-STD-004A
	<b>F-SW 26</b>	DIN 8511
	<b>1.1.2</b>	ISO 9454
qualitative copper mirror	<b>passed</b>	J-STD-004A IPC-TM-650 2.3.32
% halide content	<b>&lt; 0,5%</b>	
acid value	<b>210 ±30 mg KOH/g</b>	J-STD-004A 2.3.13
visual	<b>pass</b>	J-STD-004 Ref. paragraph 3.5.4
<b>Environmental</b>		
SIR test	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.3.3
qualitative corrosion, flux	<b>pass</b>	J-STD-004A IPC-TM-650 2.6.15
electro chemical migration	<b>pass</b>	J-STD-004A IPC-TM-650 2.6.14.1



## Packaging

Spools of 100g, 500g and 1000g



Trade name: IF 1000M leaded, rosin based, activated no-clean solder wire

D i s c l a i m e r

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