

Specifications for Asahi Sn60Pb40 (HF532) Core Wire

1) Alloy Composition: Standard	Sn60Pb40 JIS Z 3282: 2006 (Wt%)	
Sn	60 +/- 0.5	
Pb	Remainder	
Sb	0.20 max	
Bi	0.10 max	
Cd	0.002 max	
Cu	0.08 max	
Au	0.05 max	
In	0.10 max	
Ag	0.10 max	
Al	0.001 max	
As	0.03 max	
Fe	0.02 max	
Ni	0.01 max	
Zn	0.001 max	
2) Physical Characteristics:		
Specific Gravity	8.53	
Liquidus Temperature	191 °C	
Solidus Temperature	183 °C	
3) Core Flux Characteristics:		
Flux Activity Classification	Specifications ROM0	Standards / Test Methods IPC J-STD-004A
Flux Content (wt%)	2.3 +/- 0.3	Singapore Asahi
Copper Mirror Test	Classified as "M", Pass	IPC-TM-650 2.3.32 JIS Z 3197: 1999 8.4.2
Spread Factor	>75% (Sn60Pb40)	JIS Z 3197: 1999 8.3.1.1
Surface Insulation Resistance (85°C / 85 %RH)	>1 x 10 ⁸ Ω >1 x 10 ¹¹ Ω	IPC-TM-650 2.6.3.3 JIS Z 3197: 1999 8.5.4
Water Extract Resistivity	>1 x 10 ⁴ Ω-cm	JIS Z 3197: 1999 8.1.1
4) Standard Packing:		
() 0.25 kg per roll.	100 rolls per carton	
() 0.5 kg per roll.	50 rolls per carton.	
() 1 kg per roll.	20 rolls per carton.	

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