

Specifications for Asahi Sn60Pb40 (HF533) Core Wire

1) Alloy Composition:	Sn60Pb40	
Standard	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	Standards / Test Methods
Flux Content (wt%)	ROM0	IPC J-STD-004A
Copper Mirror Test	2.3 +/- 0.3	Singapore Asahi
Spread Factor	Classified as "M",	IPC-TM-650 2.3.32
Surface Insulation Resistance	Pass	JIS Z 3197: 1999 8.4.2
(85°C / 85 %RH)	>75% (Sn60Pb40)	JIS Z 3197: 1999 8.3.1.1
Water Extract Resistivity	>1 x 10 ⁸ Ω	IPC-TM-650 2.6.3.3
	>1 x 10 ¹¹ Ω	JIS Z 3197: 1999 8.5.4
	>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.	

SINGAPORE ASAHI CHEMICAL & SOLDER INDUSTRIES PTE LTD

47 Pandan Road S(609288)
Tel:6262-1616 Fax:6261-6311
Website: <http://www.asahisolder.com> E-mail: sales@sinasahi.com.sg
