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.

**Availability**

**Flux type:** IF 1000M  
**Flux content:** 1,0% - 2,2 % w/w

<table>
<thead>
<tr>
<th>alloy</th>
<th>melting point</th>
<th>diameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sn60Pb40</td>
<td>183°C—191°C</td>
<td>![0.35] ![0.50] ![0.70] ![1.00] ![1.50] ![2.00]</td>
</tr>
<tr>
<td>Sn63Pb37</td>
<td>183°C</td>
<td>![0.35] ![0.50] ![0.70] ![1.00] ![1.50] ![2.00]</td>
</tr>
</tbody>
</table>

= available  
= upon request

**Products pictured may differ from the product delivered.**

**More information:**

- Work instructions 2
- Handling 2
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**Key advantages:**

- Increased wetting properties on surfaces that are difficult to solder
- Suitable for automated soldering
- RO L1
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.
The use of a good soldering station is important. Use a soldering station with a short response time and with enough power for your application.
Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact area with the surfaces to be soldered.
Heat up both the surfaces simultaneously.
Slightly touch with the solder wire, the point where soldering tip and the surfaces to be soldered 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. This will reduce the risk on 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.

**Safety**
Please always consult the safety data-sheet of the product.
Test results
conform EN 61190-1-3(2007) and IPC J-STD-004(A)

<table>
<thead>
<tr>
<th>Property</th>
<th>Result</th>
<th>Method</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Chemical</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>flux designator</td>
<td>RO L1</td>
<td>J-STD-004A</td>
</tr>
<tr>
<td></td>
<td>F-SW 26</td>
<td>DIN 8511</td>
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<tr>
<td></td>
<td>1.1.2</td>
<td>ISO 9454</td>
</tr>
<tr>
<td>qualitative copper mirror</td>
<td>passed</td>
<td>J-STD-004A  IPC-TM-650 2.3.32</td>
</tr>
<tr>
<td>% halide content</td>
<td>&lt; 0.5%</td>
<td>J-STD-004A  IPC-TM-650 2.3.32</td>
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<tr>
<td>acid value</td>
<td>210 ±30 mg KOH/g</td>
<td>J-STD-004A 2.3.13</td>
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<tr>
<td>visual</td>
<td>pass</td>
<td>J-STD-004 Ref. paragraph 3.5.4</td>
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<tr>
<td><strong>Environmental</strong></td>
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<td></td>
</tr>
<tr>
<td>SIR test</td>
<td>pass</td>
<td>J-STD-004  IPC-TM-650 2.6.3.3</td>
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<tr>
<td>qualitative corrosion, flux</td>
<td>pass</td>
<td>J-STD-004A  IPC-TM-650 2.6.15</td>
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<tr>
<td>electro chemical migration</td>
<td>pass</td>
<td>J-STD-004A  IPC-TM-650 2.6.14.1</td>
</tr>
</tbody>
</table>
Packaging

Spools of 100g, 500g and 1000g

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

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