

ALPHA[®] EXACTALLOY[®] Preforms

Exactalloy No-Clean, Flux Cored Solder Washers

DESCRIPTION

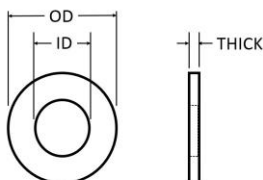
ALPHA SMT Cored Solder Washers are a HALIDE FREE, no-clean, cored flux solder preform. The SMT flux provides superior performance allowing for a lower flux content. This improves further residue appearance by reducing the quantity of flux residue on the joint.

Alpha SMT leaves post soldering residues that are hard and which can be safely left without the need to remove them. If removal is required, then semi-aqueous or aqueous systems can be used effectively.

FEATURES & BENEFITS

- Halide Free
- High performance flux - low flux content needed
- Minimal non-corrosive, clear and safe residues
- Fast wetting
- Good spread characteristics
- Pleasant pine smell
- Provides good joint appearance and low levels of flux residue

PRODUCT INFORMATION



All dimensions are mm

Item Number	Alloy Designation	Washer OD (±0.05)	Washer ID (±0.05)	Washer Thickness (±10%)	Cored Flux Type	Flux Amount (% by wt.)
161929	Sn96.5 Ag3.0 Cu0.5	2.80	1.65	1.00	SMT Plus	1.0% to 2.0%
172250	Sn96.5 Ag3.0 Cu0.5	3.43	2.29	1.00	SMT Plus	1.0% to 2.0%

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TECHNICAL DATA

Alloy Properties

Alloy Standard	Alloy Composition (%)	Liquidus/Solidus (°C)	Mass Density (g/cm ³)	Electrical Cond. (% of Cu)	CTE (ppm / °C)	Tensile Strength (MPa / PSI)
J-STD-006B	Sn96.5 Ag3.0 Cu0.5	220 / 217	7.37	16	21.5	49.6 / 7200

Flux Properties

Physical Properties	Typical Values
Rosin Softening Point:	71°C (160°F)
Rosin Grade	WW per Fed. Spec. LLL-R-626
Acid Value	362-402 (mg KOH/g)
Corrosiveness	Classified to J-STD-004 as M type material
Halide Content	None
Wetting Balance Test	Wetting times comparable to fully activated core solder fluxes
Surface Insulation Resistance	Passes IPC-SF-818 Class III. Test results to J-STD-004 85°C/85%RH/7 days CD = 1/35E10 Ohms CU = 1.22E10 Ohms (Pass > 1E08 Ohms)
Core Flux IPC Classification per J-STD-004	J-STD-004: ROM0 IPC-SF-818: M3CN ISO 12224: 1.1.3 DIN 8511-F –SW32

SAFETY

Observe standard precautions for handling and use. Use in well ventilated areas. DO NOT SMOKE during use. ALPHA SMT Core solder flux is not considered toxic. However, its use in typical soldering applications will generate a small amount of decomposition and fumes. These fumes should be adequately exhausted / vented for operator safety and comfort. For complete safety warnings refer the Safety Data Sheet (SDS).

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency directory assistance Chemtrec 1 - 800 - 424 - 9300.

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