

ALL RIGHTS RESERVED. NO PORTION OF THIS PUBLICATION, WHETHER IN WHOLE OR IN PART CAN BE REPRODUCED WITHOUT THE EXPRESS WRITTEN CONSENT OF SPC TECHNOLOGY.

| REVISIONS |     |             |       | DDC. NO. SPC-F004 * Effective: 12/21/98 * DCP No: 680 |        |          |        |          |  |
|-----------|-----|-------------|-------|-------------------------------------------------------|--------|----------|--------|----------|--|
| DCP #     | REV | DESCRIPTION | DRAWN | DATE                                                  | CHECKD | DATE     | APPRVD | DATE     |  |
| 1955      | A   | RELEASED    | JN    | 07/08/08                                              | JN     | 07/10/08 | JN     | 07/10/08 |  |
|           |     |             |       |                                                       |        |          |        |          |  |

| SPC Type No. | Standard Wire Gauge (AWG) | Diameter |      | Alloy Content Tin/Lead | Weight   | Flux % | Flux Type     | Softening Point Celsius (Flux Extract) | Acid Number (mgKOH/ G Sample) | SIR (Surface Insulation Resistance) |
|--------------|---------------------------|----------|------|------------------------|----------|--------|---------------|----------------------------------------|-------------------------------|-------------------------------------|
|              |                           | Inches   | mm   |                        |          |        |               |                                        |                               |                                     |
| SPC22123     | 23                        | 0.025    | 0.63 | 60/40                  | 1lbs.    | 3.30%  | Rosin (RA)    | 80°C                                   | 150-160                       | >1.0 x 10 <sup>9</sup>              |
| SPC22124     | 21                        | 0.032    | 0.81 | 60/40                  |          |        |               |                                        |                               |                                     |
| SPC22126     | 21                        | 0.032    | 0.81 | 60/40                  |          |        |               |                                        |                               |                                     |
| SPC22127     | 19                        | 0.04     | 1.01 | 60/40                  |          |        |               |                                        |                               |                                     |
| SPC22128     | 18                        | 0.05     | 1.27 | 60/40                  |          |        |               |                                        |                               |                                     |
| SPC22129     | 16                        | 0.062    | 1.57 | 60/40                  |          |        |               |                                        |                               |                                     |
| SPC22130     | 25                        | 0.02     | 0.5  | 60/37                  |          |        |               |                                        |                               |                                     |
| SPC22131     | 23                        | 0.025    | 0.63 | 60/37                  |          |        |               |                                        |                               |                                     |
| SPC22132     | 21                        | 0.032    | 0.81 | 60/37                  |          |        |               |                                        |                               |                                     |
| SPC22133     | 19                        | 0.04     | 1.01 | 60/37                  |          |        |               |                                        |                               |                                     |
| SPC22134     | 18                        | 0.05     | 1.27 | 60/37                  | 0.5 lbs. | 2.20%  | No Clean      | 75°C                                   | 190-210                       |                                     |
| SPC22135     | 16                        | 0.062    | 1.57 | 60/37                  |          |        |               |                                        |                               |                                     |
| SPC22125     | 23                        | 0.025    | 0.63 | 60/37                  |          |        |               |                                        |                               |                                     |
| SPC22136     | 21                        | 0.032    | 0.81 | 60/40                  |          |        | Water Soluble | 60°C                                   | 120-130                       |                                     |
| SPC22137     | 21                        | 0.032    | 0.81 | 60/37                  |          |        | Rosin (RMA)   | 92°C                                   | 150-160                       |                                     |
| SPC22138     | 21                        | 0.032    | 0.81 | 60/37                  | 1lbs.    | 2.20%  | No Clean      | 75°C                                   | 190-210                       |                                     |
| SPC22139     | 21                        | 0.032    | 0.81 | 60/37                  | 1lbs.    |        |               |                                        |                               |                                     |
| SPC22140     | 25                        | 0.02     | 0.5  | 60/37                  | 1lbs.    |        |               |                                        |                               |                                     |

#### Notes:

1. The Water Soluble Solder has a flux within that must be cleaned; therefore, the Flux Extract Softening Point Test does not apply.
2. Acid Number test is based upon the IPC-TM-650 test method.
3. Flux Appearance: Amber Solid

#### Rosin Activated (RA) Flux:

It is a high activity core flux designed for excellent instant wetting action, even on Nickel surfaces. Although it is a RA-based material, the residues are non-corrosive if not cleaned. Per J-STD-004. Classified as ROM1 flux.

#### Water Soluble Flux:

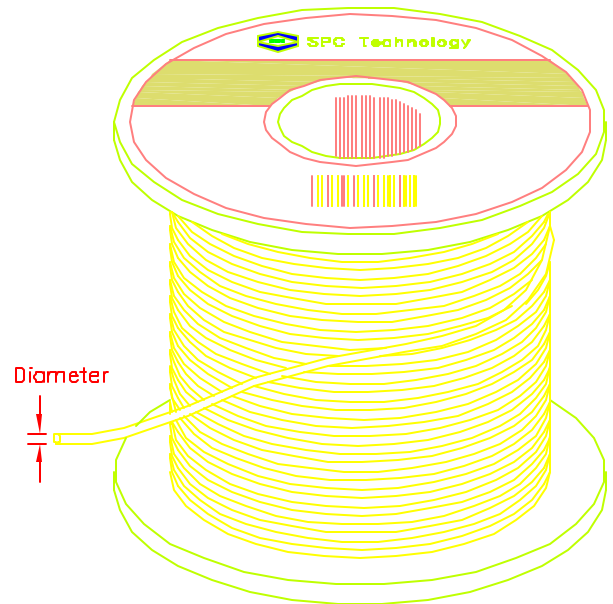
It is a high-activity water-soluble core flux for soldering difficult metals. It is designed for optimal cleanability, along with minimal smoke and odor. Its residues must be removed. It is classified as ORH1 per J-STD-004.

#### Rosin Mildly Activated (RMA) Flux:

It is an RMA based core flux that provides wetting action comparable to typical RA flux. Although it is an RMA-based material, the residues are non-corrosive if not cleaned. It is categorized as ROL1 per J-STD-004.

#### No-Clean Flux:

It is a halide-free, rosin based no-clean core flux that provides excellent wetting combined with optimal reliability and cosmetics. It is compliant to Bellcore GR-78 and is classified as ROL0 per J-STD-004.



SPC-F004.DWG

**DISCLAIMER:**  
ALL STATEMENTS AND TECHNICAL INFORMATION CONTAINED HEREIN ARE BASED UPON INFORMATION AND/OR TESTS WE BELIEVE TO BE ACCURATE AND RELIABLE. SINCE CONDITIONS OF USE ARE BEYOND OUR CONTROL, THE USER SHALL DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE INTENDED USE AND ASSUME ALL RISK AND LIABILITY WHATSOEVER IN CONNECTION THEREWITH.



**SPC TECHNOLOGY**

|                                                                         |              |          |                |          |                     |  |               |  |  |  |
|-------------------------------------------------------------------------|--------------|----------|----------------|----------|---------------------|--|---------------|--|--|--|
| UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE FOR REFERENCE PURPOSES ONLY. | DRAWN BY:    | DATE:    | DRAWING TITLE: |          |                     |  |               |  |  |  |
|                                                                         | Jason Nash   | 07/08/09 | SOLDER WIRE    |          |                     |  |               |  |  |  |
|                                                                         | CHECKED BY:  | DATE:    | SIZE           | DWG. NO. | ELECTRONIC FILE     |  | REV           |  |  |  |
|                                                                         | Jason Nash   | 07/10/08 | A              | TA-885   | TA-885.DWG          |  | A             |  |  |  |
|                                                                         | APPROVED BY: | DATE:    | SCALE:         |          | U.O.M.: INCHES [mm] |  | SHEET: 1 OF 1 |  |  |  |
|                                                                         | Jason Nash   | 07/10/08 | NTS            |          |                     |  |               |  |  |  |