

## Sn60Pb40 CF-10

*No Clean Core Wire*

### Product Description

“CF-10” Resin Flux is an activated rosin formula for use in flux-core solder wire. This cored flux exhibits the so-called “instant action” wetting behaviour. The high mobility and fast spreading action of this flux result in fast production line soldering.

### Application

Sn60Pb40 CF-10 no clean core flux solder wire is easy to use for automatic, manual, rework, point and brush soldering. For the best soldering results, the recommended parameters are shown:

Solder Iron Tips: All Types especially the tapered types  
 Soldering Temp: 270 - 350°C  
 Soldering Time: 1 - 3 secs

- Keep solder iron tips clean.
- Tinned iron tips before use.
- Wear gloves when soldering to avoid contaminating the wire.

(Note: Soldering parameters are dependent on tip type, soldering station wattage configuration, wire diameter and type of applications.)

### Specification

Item	Result
Alloy Composition	Sn60Pb40
Flux Content	2.0 +/- 0.3 wt%
Density of Core Flux @ 25°C	1.08
Halide Content	0.7 wt%
<small>JIS Z 3197 8.1.4.2.1</small>	
Water Extract Resistivity	> 1 x 10 <sup>4</sup> Ω-cm
<small>JIS Z 3197 8.1.1</small>	
Surface Insulation Resistance (85°C, 85%RH, 168hrs)	> 1 x 10 <sup>8</sup> Ω, Pass
<small>IPC-TM-650 2.6.3.3</small>	
Electromigration (85°C, 88.5%RH, 596hrs)	Pass
<small>IPC-TM-650 2.6.14.1</small>	
Copper Corrosion Test	Pass
<small>IPC-TM-650 2.6.15</small>	
<small>JIS Z 3197 8.4.1</small>	
Copper Mirror Test	Classified as “H”, Pass
<small>IPC-TM-650 2.3.32</small>	
<small>JIS Z 3197 8.4.2</small>	
Flux Activity Classification	ROH1
<small>IPC J-STD-004</small>	
Spread Factor	> 90%
<small>JIS Z 3197 8.3.1.1</small>	
Residue Dryness Test	Dry
<small>JIS Z 3197 8.5.1</small>	
Residue Appearance	Light Yellowish

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### RESIDUAL REMOVAL

Since the residues are transparent, minimal, dry, non-tacky and practically inert after soldering, removal is usually not necessary. For assemblies that require cleaning, Sn60Pb40 CF-10 no clean core flux solder wire can be completely removed by any solvent type flux cleaner available in the market.

### STORAGE

Store the solder wire in a cool, dry and non-corrosive environment. Wrap up the solder wire when not in use to reduce exposure to environment. Sn60Pb40 CF-10 no clean core flux solder wire can be kept for 2 years if proper storage conditions are observed.

### HEALTH and SAFETY

Wear a chemical mask if the operators are allergic to the fumes released during soldering. For more information, please refer to Material Safety Data Sheet.

### PACKAGING

Sn60Pb40 CF-10 no clean core flux solder wire is commonly available in various diameters such as 0.5, 0.6, 0.8, 1.0, 1.2, 1.6 and 2.0 mm. For different diameters, please specify your requirements.

Packaging	0.25kg	0.50kg	1.0kg
Diameter (mm)	0.5 to 2.0	0.5 to 2.0	0.8 to 2.0

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