

## SOLDER & SOLDER BRAID



Fig. 1



Fig. 2



Fig. 4\*



Fig. 5\*



Fig. 6



Fig. 7

### Solder

| Retail Part No. | Bulk Part No. | Fig. No. | Description                         | Gauge | Diameter | Spool Size | Tin/Lead Percentage | Length (Feet) | Color |
|-----------------|---------------|----------|-------------------------------------|-------|----------|------------|---------------------|---------------|-------|
| 6033            |               | 1        | 60/40 Rosin Core Solder             | 20    | .032"    | 1/2 lb.    | 60/40               |               |       |
| 6039            |               | 1        | 60/40 Rosin Core Solder             | 16    | .047"    | 1/2 lb.    | 60/40               |               |       |
| 6044            |               | 1        | 60/40 Rosin Core Solder             | 14    | .062"    | 1/2 lb.    | 60/40               |               |       |
| 6034            |               | 1        | 60/40 Rosin Core Solder             | 20    | .032"    | 1 lb.      | 60/40               |               |       |
| 6040            |               | 1        | 60/40 Rosin Core Solder             | 16    | .047"    | 1 lb.      | 60/40               |               |       |
| 6045            |               | 1        | 60/40 Rosin Core Solder             | 14    | .062"    | 1 lb.      | 60/40               |               |       |
| 6035            |               | 1        | Low-melt Solder                     | 20    | .032"    | 1/2 lb.    | 63/37               |               |       |
| 6056            |               | 1        | Silver Bearing Solder               | 20    | .032"    | 1/2 lb.    | 60/38/2             |               |       |
| 6059            |               | 1        | Silver Bearing Solder               | 20    | .032"    | 1 lb.      | 60/38/2             |               |       |
| 9132            |               | 2        | Fine Line Solder-32 Tubes of Solder | 20    | .032"    |            | 60/40               | 12            |       |
| H3-391          |               | 2        | Fine Line Solder-Carded             | 20    | .032"    |            | 60/40               | 12            |       |
| 9134            |               | 2        | Standard Solder-32 Tubes of Solder  | 16    | .050"    |            | 60/40               | 6.5           |       |
| H3-390          |               | 2        | Standard Solder-Carded              | 16    | .050"    |            | 60/40               | 6.5           |       |
| 13-9612         |               | 4*       | SnAg3Cu0.5Ni0.06Ge0.01 Solder       | 14    | .062"    | 1/2 lb.    | Lead Free           |               |       |
| 13-9620         |               | 4*       | SnAg3Cu0.5Ni0.06Ge0.01 Solder       | 20    | .032"    | 1 lb.      | Lead Free           |               |       |
| 13-9621         |               | 4*       | SnAg3Cu0.5Ni0.06Ge0.01 Solder       | 16    | .047"    | 1 lb.      | Lead Free           |               |       |

(\*=Requires more than 60W iron)

### Solder Braid

| Retail Part No. | Bulk Part No. | Figure No. | Description                                | Gauge | Width Solder/Braid | Spool Size | Tin/Lead Percentage | Length (Feet) | Color  |
|-----------------|---------------|------------|--|-------|--------------------|------------|---------------------|---------------|--------|
| 12-5001         |               | 6          | 1 Reel of GC Solder and 1 Reel of GC Braid |       | .031"/.075"        |            | 60/40               | 20            |        |
| 12-5025         | 12-5025-BU    | 7          | GC Braid                                   |       | .025"              |            |                     | 5             | Silver |
| 12-5050         | 12-5050-BU    | 7          | GC Braid                                   |       | .050"              |            |                     | 5             | Gold   |
| 12-5075         | 12-5075-BU    | 7          | GC Braid                                   |       | .075"              |            |                     | 5             | Green  |
| 12-5100         | 12-5100-BU    | 7          | GC Braid                                   |       | .100"              |            |                     | 5             | Blue   |
| 12-5125         | 12-5125-BU    | 7          | GC Braid                                   |       | .125"              |            |                     | 5             | Brown  |
| 12-6025         |               | 7          | GC Braid                                   |       | .025"              |            |                     | 25            | Silver |
| 12-6050         |               | 7          | GC Braid                                   |       | .050"              |            |                     | 25            | Gold   |
| 12-6075         |               | 7          | GC Braid                                   |       | .075"              |            |                     | 25            | Green  |
| 12-6100         |               | 7          | GC Braid                                   |       | .100"              |            |                     | 25            | Blue   |

## PRODUCT SPECIFICATIONS SHEET

**CAT NO.**      **PRODUCT NAME**

6035                      Low Melt Solder  
~~6037~~

**DESCRIPTION:**

Solder

**TECHINCAL PROPERTIES:**

| NO | Item                               | Specification  | Standard   |
|----|------------------------------------|--|------------|
| 1  | Appearance                         | Bright and shiny surface finishes.   |            |
| 2  | Alloy                              | Sn/Pb37  | JIS-Z-3282 |
| 3  | Melting Point                      | 183°C  | DSC        |
| 4  | Flux Content                       | 2.0 ± 1.0 %  | JIS-Z-3283 |
| 5  | Halide Content                     | Under 0.5%   | JIS-Z-3197 |
| 6  | Gravity                            | 8.4  |            |
| 7  | Spread ability                     | > 75%  | JIS-Z-3197 |
| 8  | Packaging                          | 0.5、1、5、10kg/Roll  | JIS-Z-3283 |
| 9  | Diameters Tolerances               | 0.3~0.6±0.05 mm、0.8~3.0 ± 0.1 mm.  | JIS-Z-3283 |
| 10 | Features                           | Excellent solder joint reliability. Superior joint strength. Excellent thermal & Mechanical fatigue resistance. Low cleaning required after solder joint.              |            |
| 11 | Purpose                            | For use in applications requiring good activation.   |            |
| 12 | Storage, Handling, and Shelf Life: | Storage must be in a dry, non-corrosive and shine environment. Avoids the oxidant, the acid and the hydrogen peroxide. Shelf life is 2 years from date of manufacture. |            |

**PHYSICAL PROPERTIES AND RELIABILITY DATA:**

| No | Test Item                      | Test Result                | Test Method          |
|----|--------------------------------|----------------------------|----------------------|
| 1  | Copper Mirror Test             | PASS                       | IPC-TM-650, 2.3.32   |
| 2  | Copper plate Corrosion         | PASS                       | JIS-Z-3197, 6.6.1    |
| 3  | S.I.R Test                     | PASS 1×10 <sup>10</sup> up | IPC-TM-650, 2.6.3.3  |
| 4  | Electrochemical migration Test | PASS 1×10 <sup>10</sup> up | IPC-TM-650, 2.6.14.1 |

**ALLOY COMPOSITIONS:**

| Sn            | Pb   | Ag          | Sb          | Bi          | Cd           | Cu          | Au          | In          | Al           | As          | Fe          | Ni          | Zn           |
|---------------|------|-------------|-------------|-------------|--------------|-------------|-------------|-------------|--------------|-------------|-------------|-------------|--------------|
| 62.5~<br>63.5 | Rem. | 0.10<br>MAX | 0.05<br>MAX | 0.10<br>MAX | 0.002<br>MAX | 0.05<br>MAX | 0.05<br>MAX | 0.10<br>MAX | 0.001<br>MAX | 0.03<br>MAX | 0.02<br>MAX | 0.01<br>MAX | 0.001<br>MAX |

**SHELF LIFE:** 2 Years

## SOLDER TOOLS



Fig. 1



Fig. 2

### Solder Tools

| Retail Part No. | Bulk Part No. | Figure No. | Description   | Features   |
|-----------------|---------------|------------|---|--|
| 12-031          |               | 1          | Soldering Kit ( <b>Not Recommended for Lead Free Solder</b> )       | 30 W, Solder Aid Tool & Brush End                      |
| 12-055          |               | 2          | 30 W Soldering Iron ( <b>Not Recommended for Lead Free Solder</b> ) | Light Weight Iron, 117V AC, Comes with Replacement Tip |
| 12-056          |               |            | Replacement Tip for 12-055 & 12-031                                 |  |

## PORTABLE BUTANE SOLDERING IRONS AND TIPS



Fig. 6



Fig. 7



Fig. 10



Fig. 11



Fig. 12



Fig. 13



Fig. 15



Fig. 17



Fig. 18

### Portable Butane Solder Irons

| Retail Part No.  | Bulk Part No. | Figure No. | Description                                   | Features  |
|------------------|---------------|------------|---|---|
| <del>P-2-C</del> |               | 5          | <del>Portable Butane Solder Iron P-2</del>    | <del>Variety of Tips Available, 90 Minutes of Operation</del> |
| 12-133           |               | 6          | 3 fl. oz. Aerosol Butane Gas for Solder Irons |   |

### Ten Professional-Quality, Iron-plated Tips for PSI-100

| Retail Part No. | Bulk Part No. | Figure No. | Description    | Size           | Temperature Range |
|-----------------|---------------|------------|----------------|----------------|-------------------|
| PSI1            |               | 7          | Single Flat    | 1/32" (1.0 mm) | Up to 450°C/850°F |
| PSI4            |               | 10         | Single Flat    | 3/16" (4.8 mm) | Up to 450°C/850°F |
| PSI5            |               | 11         | Double Flat    | 1/32" (1.0 mm) | Up to 450°C/850°F |
| PSI6            |               | 12         | Double Flat    | 3/32" (2.4 mm) | Up to 450°C/850°F |
| PSI7            |               | 13         | Double Flat    | 1/8" (3.2 mm)  | Up to 450°C/850°F |
| PSI9            |               | 15         | Hot Blower Tip |                | Up to 450°C/850°F |

### Professional-Quality, Iron-plated Tips for P-2-C

| Retail Part No. | Bulk Part No. | Figure No. | Description | Size           |
|-----------------|---------------|------------|-------------|----------------|
| PPT-1           |               | 17         | Single Flat | 1/32" (1.0 mm) |
| PPT-6           |               | 18         | Double Flat | 3/32" (2.4 mm) |

## PORTABLE BUTANE SOLDERING IRONS AND TIPS (Cont.)



Fig. 1

Fig. 2



Fig. 7

### Replacement Tips (for P-1K Kit)

| Retail Part No. | Bulk Part No. | Figure No. | Description | Size           | Temperature Range |
|-----------------|---------------|------------|-------------|----------------|-------------------|
| T-1             |               | 1          | Solder Tip  | 1/32" (1.0 mm) |                   |
| T-2             |               | 2          | Solder Tip  | 3/32" (2.4 mm) |                   |

### Portable Butane Solder Tool Kit

| Retail Part No. | Bulk Part No. | Figure No. | Description                                   | Kit Includes:   |
|-----------------|---------------|------------|---|---|
| P-2K-C          |               | 7          | Model P-2K Portable Butane Soldering Tool Kit | Portable Butane P-2 Soldering Tool, 3/32" (2.3 mm) Standard Soldering Tip, Hot Blow Tip (Heat Tip), Blow-torch Tip, Double Flat Tip, Tip Cleaning Sponge, Wire Hot-iron Stand, Plastic Storage Case |

## SOLDER PRODUCTION TOOLS



Fig. 8



Fig. 9



Fig. 10



Fig. 12

### Solder Production Tools

| Retail Part No. | Bulk Part No. | Figure No.    | Description  |
|-----------------|---------------|---------------|--|
| 9065            |               | 8             | 4 Piece Solder Aid Kit                                 |
| 9069            |               | 9             | 6-1/2" Long Reamer and Scraper Tip (Plastic)           |
| 9073            |               | 10            | 6-1/2" Long Brush and Forked Tip (Plastic)             |
| <del>9074</del> |               | <del>11</del> | <del>6-1/2" Long Brush and Scraper Tip (Plastic)</del> |
| 12-6962         |               | 12            | Soldering Aid Kit - 6 Piece Standard Solder Aid Tools  |

## SOLDER PRODUCTION TOOLS (Cont.)



Fig. 1



Fig. 3

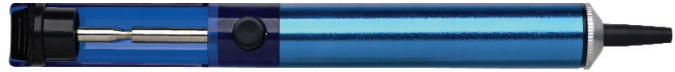


Fig. 4-A



Fig. 5-A



Fig. 4-B



Fig. 5-B

Fig. 5-C



Fig. 6



Fig. 7

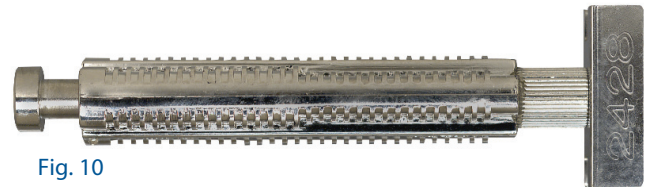


Fig. 10

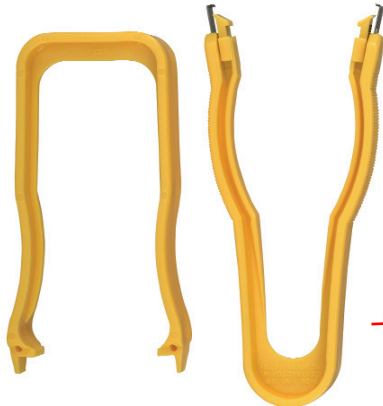


Fig. 8

~~Fig. 9~~

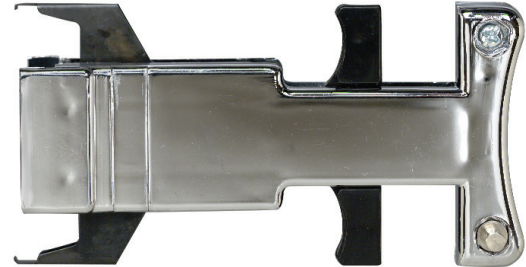


Fig. 11

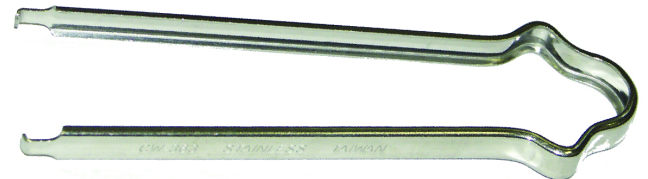


Fig. 12

### Solder Production Tools

| Retail Part No.    | N.S.N. Part No.  | Figure No.           | Description   |
|--------------------|------------------|----------------------|---|
| 9088               | 5120-00-611-7136 | 1                    | 8" Long Heavy-Duty Brush and Forked Tip (Plastic)         |
| 9086               |                  | 3                    | Straight Reamer and Forked Tip                            |
| 12-2105            |                  | 4-A                  | Anti-static Solder Removal Tool                           |
| 12-2106            |                  | 4-B                  | Replacement "O" Rings for 12-2105                         |
| 12-2157            |                  | 5-A                  | Solder Popper   |
| 12-2160            |                  | 5-B                  | Replacement Tips for 12-2157                              |
| 12-2161            |                  | 5-C                  | Replacement "O" Ring Seal for 12-2157                     |
| H3-388             |                  | 6                    | Heat Sink Clamp   |
| 9077-1             |                  | 7                    | Heat Sink Clamp   |
| 12-4125            |                  | 8                    | Anti-static 8-28 Pin IC Inserter Tool                     |
| <del>12-4127</del> |                  | <del>8 &amp; 9</del> | <del>Anti-static 8-28 Pin IC Extractor/Inserter Kit</del> |
| <del>12-4128</del> |                  | <del>10</del>        | <del>Anti-static Insertion Tool (24-28 Pin)</del>         |
| 12-4140            |                  | 10                   | Anti-static Insertion Tool (36-40 Pin)                    |
| 12-4612            |                  | 11                   | 28-40 Pin Grounded DIP IC Extractor                       |
| 12-4614            |                  | 12                   | 28-40 Pin IC Extractor                                    |