



TECHNICAL DATA SHEET

CATEGORY: **NO-CLEAN CORED WIRE SOLDER**
NAME: **209AXT**

FEATURES

- MAY BE USED IN PLACE OF NC or RMA PRODUCTS
- CLEAR, HARD RESIDUES
- HALIDE FREE
- CLEANABLE WITH SAPONIFIER
- TELECOMMUNICATION ACCEPTABLE
- LOW-MEDIUM RESIDUES

Passes BELLCORE & IPC, product testing results available upon request

DESCRIPTION

209AXT is a no-clean, synthetic resin-based flux core which is the same chemistry as that of AIM's NC 291AX solder paste. 209AXT flux promotes good thermal transfer, offering better solder penetration into plated through holes or surface mount interconnections. 209AXT cored wire produces low-to-medium post-process residues that are electrically safe and do not require cleaning. 209AXT is operator-friendly and can be used as a drop-in for any RMA type applications.

HANDLING

- 209AXT cored wire has an indefinite shelf life when proper storage conditions are observed.
- Store 209AXT in a clean, dry area away from moisture and sunlight. Do not freeze this product

APPLICATION

- Solder iron tip temperature should be between 650° and 750°F for Sn63 & Sn62 alloys.
- Hold the solder iron tip at a 45° to 60° angle to the work surface.
- The solder iron should contact both the component lead and PCB pad surface.
- Solder and flux should flow onto the lead and pad or lead and barrel to promote optimum flux activity for the joint being worked.
- If additional flux is needed, the use of AIM flux dispensing pens is recommended for dispensing precise amounts of flux and eliminating over-saturation.

CLEANING

209AXT can be cleaned, if necessary, with saponified tap water or an alcohol and water blend. AIMTERGE 520 is recommended. A water temperature of 140°F is recommended, and should be adequate for removing any post-process residues.

PACKAGING

- 209AXT is standard with a 2% flux core. Other flux core %'s are available upon request.
- 209AXT is available in Sn60, Sn62, Sn63, Sn96, CASTIN® and other custom alloys upon request.
- Standard spool sizes: ½ lb. for .010 and .015 diameters, and 1lb. for .020, .032, .040, .050 and .062 diameters. Other diameters and spool sizes are available upon special request.
- Packaging of ½ lb. and 1 lb. spools is available in 12 lb. and 24 lb. cases.

SAFETY

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying **Material Safety Data Sheet** for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

The information contained herein is based on data considered accurate and is offered at no charge. No warranty is expressed or implied regarding the accuracy of this data. Liability is expressly disclaimed for any loss or injury arising out of the use of this information or the use of any materials designated.



PRODUCT TESTING RESULTS

CATEGORY: **NO-CLEAN CORED WIRE MEDIUM**
 NAME: **209AXT**
 SUPPLEMENTAL

This Product has been tested in accordance with following specifications

TRACE LABORATORIES

Surface and Insulation Resistance - PASS

IPC	TM-650	Minimum (1 x 10 ⁸) - PASSED
IPC	SF-818	Minimum (1 x 10 ⁸) - PASSED

Copper Mirror Test -PASS Surface and Insulation Resistance - PASS

		<u>24 Hours in Ω</u>	<u>96 Hours in Ω</u>
Bellcore	TR-NWT-000078	2.68 x 10 ¹¹ 1.47 x 10 ¹²	1.83 x 10 ¹¹ 1.78 x 10 ¹²
IPC	TM-650	Minimum 1 x 10 ⁸ Ω - PASSED	

Electromigration - PASS

Bellcore	TR-NWT-000078	<u>96 Hours in Ω</u>	<u>500 Hours in Ω</u>
	(Comb Up)	2.56 x 10 ⁹	2.35 x 10 ¹⁰
	(Comb Down)	7.95 x 10 ⁹	1.67 x 10 ¹⁰

Silver Chromate - PASS

Bellcore	TR-TSY-000078	PASS
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Fluoride

Bellcore	TR-TSY-000078	PASS
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NORTHERN TELECOM

Surface and Insulation Resistance - PASS

Minimum- 3.8 x 10¹⁰ Ω
 Actual- 1.83 x 10¹¹ Ω

Electromigration - PASS

Tested on the following:

Ciba Geigy Probimer 52	Taiyo PSR 4000
Coates Imagecure AQ	Enthone DSR3241

Copper Mirror Test -PASS

Trace and NT BVW

AIM PRODUCTS LABORATORY

Copper Mirror

IPC	J-STD-005	PASS
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Silver Chromate

IPC	J-STD-005	PASS
Bellcore	TR-TSY-000078	PASS

Fluoride

Bellcore	TR-TSY-000078	PASS
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Solder Ball Test

IPC	J-STD-005	PASS
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