



Lead free solder wire IF R88

INTERFLUX®
ELECTRONICS N.V.



Technical data IF R88 LF

Ver: 1.6, 06-05-10

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Lead free, No-clean solder wire

Description:

Interflux® **IF R88** Lead-Free, No-Clean solder wire is a mildly activated rosin based wire recommended when soldering in **classes I, II** (IPC-A-610).

It is especially well suited for those applications where good solderability, fast wetting and excellent solder spreading are needed. It works well with Lead-free soldering alloys.

IF R88 has increased flux contents and very good through hole wetting and soldering speed even with SnCu lead-free alloys.

IF **R88** shows excellent results in automated, robotic soldering.



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Key advantages:

- Classification to IPC and EN: **ROL1**
- Mildly activated
- Long tip-life
- For automated soldering
- Excellent wetting on Cu, Ag, Sn ...

Availability

Flux type: **R88**
Flux content: 2,2% - 3,5% w/w

alloy	melting point	diameters					
		0,35	0,50	0,70	1,00	1,50	2,00
Sn96,5Ag3Cu0,5	217°C—219°C	●	●	●	●	●	●
Sn96,5Ag3,5	221°C	●	●	●	●	●	●
Sn95,5Ag3,8Cu0,7	217°C-219°C	●	●	●	●	●	●
Sn99,3Cu0,7	227°C	●	●	●	●	●	●

● = available ● = upon request



Work instructions

Manual soldering

The working temperature is between 360°C and 390°C. For more dense metals like Nickel, the temperature may be elevated to 420°C.

Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact surface with the component and

solder pad.

The use of a good soldering station is important in order to always have the correct temperature on the soldering joint. Use a soldering station with a response time as short as possible.

Heat up the surfaces of both component and island simultaneously. Slightly touch with the solder wire,

the point where component lead, soldering island and soldering tip meet (the small quantity of solder ensures a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. It is important that no solder wire is making contact with

the soldering tip during soldering to avoid flux spitting and premature flux consumption!

Handling

Storage

Store the solder wire in a clean environment between 0°C and 40°C

Handling

To avoid spool and wire damage, handle package with care



Test results

conform EN 61190-1-3(2007) and IPC J-STD-004

Property	Result	Method
Chemical		
flux designator	ROL1	J-STD-004
	F-SW 26	DIN 8511
	1.1.2	ISO 9454
qualitative copper mirror	pass	J-STD-004 IPC-TM-650 2.3.32
	pass	GR-78-CORE Rev. 9/97 13.1.6
qualitative halide silver chromate (Cl, Br)	pass	J-STD-004 IPC-TM-650 2.3.33
	pass	GR-78-CORE Rev. 9/97 13.1.4
	pass	J-STD-004 IPC-TM-650 2.3.35.1
Environmental SIR test	pass	J-STD-004 IPC-TM-650 2.6.3.3
	pass	GR-78-CORE Rev. 9/97 13.1.4
qualitative corrosion, flux electro chemical migration	pass	J-STD-004 IPC-TM-650 2.6.15
	pass	GR-78-CORE Rev. 9/97 13.1.5



Packaging

Spools of 100g, 500g and 1000g



D i s c l a i m e r

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