

## 自動焊錫機專用錫絲

### Auto-Solder Machine Solder Wire

- (1) **適用範圍** 自動焊錫機專用錫絲適用於各類電子連接器、LED燈串、視頻音頻線插頭、耳機線、電腦數據線、小型線路板及小型電子元器件在線束中間的焊接和對接等。專用於自動焊錫機高效率使用，焊接速度快，焊點平整，光亮。

**Application** Auto-Solder Machine Solder Wire is suitable for various types of electronic connectors, LED string lights, video audio plug, headset line, computer data line, small circuit board and small electronic components online beam welding and butt joint. It is suitable for automatic-soldering machine with high efficiency, high welding speed, smooth and bright spot.

- (2) **Name of Product** Auto-Solder Machine Solder Wire  
**產品名稱** 自動焊錫機專用錫絲

**Alloy Composition** Sn/0.7Cu  
**主合金成份** 錫/0.7銅

- (3) **Manufacturing (Country) and Supplier Name**  
**製造地(國)及供應商名稱**

**Country of Origin**

**原產地** 中國

**Supplier** LIAN JING METAL MATERIAL CO.,LTD

**供應商** 聯景金屬材料(惠州)有限公司

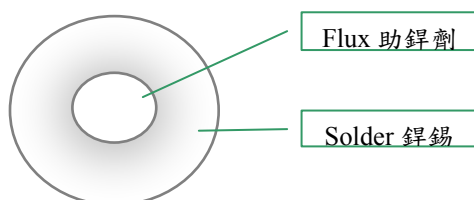
**Manufacturer** LIAN JING METAL MATERIAL CO.,LTD

**製造廠名稱** 聯景金屬材料(惠州)有限公司

- (4) **Appearance and Dimension (For Reference)**

**外觀與尺寸(參考用)**

Figure (1) Wire Cross Section 圖 (1) 錫絲剖面圖

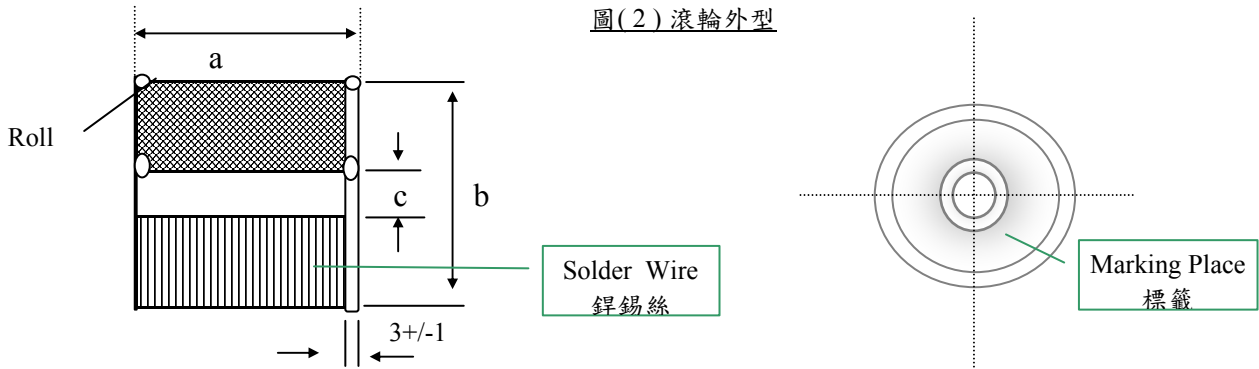


| Dimension ( inch ) | Dimension ( mm ) |
|--------------------|------------------|
| 尺寸大小(英寸)           | 尺寸大小(公厘)         |
| 0.015 +/- 0.002    | 0.4 +/- 0.05     |
| 0.020 +/- 0.002    | 0.5 +/- 0.05     |
| 0.025 +/- 0.002    | 0.6 +/- 0.05     |
| 0.03 +/- 0.005     | 0.8 +/- 0.1      |
| 0.04 +/- 0.005     | 1.0 +/- 0.1      |

|                |             |
|----------------|-------------|
| 0.05 +/- 0.005 | 1.2 +/- 0.1 |
| 0.06 +/- 0.005 | 1.6 +/- 0.1 |
| 0.08 +/- 0.005 | 2.0 +/- 0.1 |

Figure ( 2 ) Roll-Shape

圖(2) 滾輪外型



| Weight/ Roll<br>量/捲 | 重 | Dimension 尺寸 |      |      |
|---------------------|---|--------------|------|------|
|                     |   | a            | b    | c    |
| 1kg                 |   | 63mm         | 67mm | 20mm |

## (5) Characteristics 特性

### 5.1 Chemical Composition 化學成分

| Item<br>項次   | Specification 規格              |      |     |                  |         |       |        |       |       |       |      |        |
|--------------|-------------------------------|------|-----|------------------|---------|-------|--------|-------|-------|-------|------|--------|
|              | Composition 成分 (%)            |      |     | Impurity 不純物 (%) |         |       |        |       |       |       |      |        |
| Solder<br>錒錫 | Sn                            | Ag   | Cu  | Pb               | Sb      | Zn    | Fe     | As    | Ni    | Bi    | Cd   | Al     |
|              |                               | Bal. | --- | 0.7<br>±0.1      | <0.08 % | <0.12 | <0.002 | <0.02 | <0.03 | <0.01 | <0.1 | <0.002 |
| Flux 助錒劑     | Flux Content 助錒劑含量 2.8 ~ 3.2% |      |     |                  |         |       |        |       |       |       |      |        |

### 5.2 Physical Characteristic 物理特性

| Alloy Designation 合金 | Melting Point 熔點 | Specific Gravity 比重  |
|----------------------|------------------|----------------------|
| Sn/0.7Cu             | 227 °C           | 7.3g/cm <sup>3</sup> |

### 5.3 Characteristics of Flux 助錒劑特性

| Item 項次                        | Specification 規格  | Test Methods  |
|--------------------------------|---|---------------|
| 1. Halogen Content 鹵素含量        | <0.15%  | JIS Z 3197-86 |
| 2. Dryness 乾燥度                 | The surface of the residue shall be free from tackiness permitting easy removal.<br>產品表面殘留無黏著力, 容易清除. | JIS Z 3197-86 |
| 3. Copper Plate Corrosion 銅板腐蝕 | No corrosion occurred. 沒有腐蝕發生   | JIS Z 3197-86 |

|  |                      |               |
|--|----------------------|---------------|
| 4. Water Extraction Resistivity 水溶液比電阻 | >100000 $\Omega$ -cm | JIS Z 3197-86 |
| 5. SIR Value 表面絕緣阻抗                    | >1×10 <sup>11</sup>  | JIS Z 3197-86 |

#### 5.4 Solderability 錫性

| Item 項次           | Specification 規格 | Test Methods 測試方法 |
|-------------------|------------------|-------------------|
| Spread Factor 擴散率 | >85%             | JIS Z3197-86      |

Remark: The melting temperature shall be 227°C

備註: 熔解溫度應該是 227°C

### (6) Quality 品質

6.1 The Flux should be compounded and processed in such a manner as to be uniform in quality and should be free from deleterious material and other details that will after life serviceability or appearance.

助錫劑應該要複合加工，在品質上講求一致性並且是屬於無毒物料。

其他細節是在生活上可使用或是外觀上可詳見。

6.2 Recommended temperature of soldering iron tip : 370~430°C

( According to different dimension, adjust the suitable temperature of soldering )

建議錫工作溫度為：370~430°C(依線徑粗細不同, 調整最適合的工作溫度條件)

### (7) Marking and Packing 標示與包裝

Flux cored lead-free solder wire should be coiled to the roll and package with the specified method with 10 rolls in one package. Each box shall be indicated following items on the side of roll in and on the package.

無鉛錫絲包裝是盤繞成一個線捲輪，並且10個捲輪裝成一箱，每一個捲輪都應該於側包裝標示且每一箱都應該標示，如下所示

7.1 Manufacturer's name or trademark 製造商名稱或商標

7.2 Production date or code ( including production lot number) 生產日期或型號(包括生產料號)

7.3 Designation, symbol and trade name of the product 產品名稱，符號，及產品交易名稱

7.4 Weight 重量

7.5 Guaranteed shelve life 產品保固期限

7.6 Classification of solvent etc. Toxic or safety of chemical goods specified by the municipal law chlorine and bromine activation.

溶劑的分類等等...化學產品的有毒或安全性,特別是法律規定氯和溴的活化性。

7.7 Material and capacity of container 產品及容器的容積。

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