



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 no-clean solder pastes. **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° - 750°F for Sn63 and Sn62 alloys, 700° - 800°F for Sn/Ag and Sn/Ag/Cu 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.

Manufacturing and Distribution Worldwide

Americas +1-401-463-5605 • Europe +44-1737-222-258 • Asia-Pacific +852-2649-7183 • info@aimsolder.com • www.aimsolder.com



PRODUCT TESTING RESULTS

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

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	1.83 x 10 ¹¹
		1.47 x 10 ¹²	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-004	PASS
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Silver Chromate

IPC	J-STD-004	PASS
Bellcore	TR-TSY-000078	PASS

Fluoride

Bellcore	TR-TSY-000078	PASS
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Solder Ball Test

IPC	J-STD-004	PASS
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