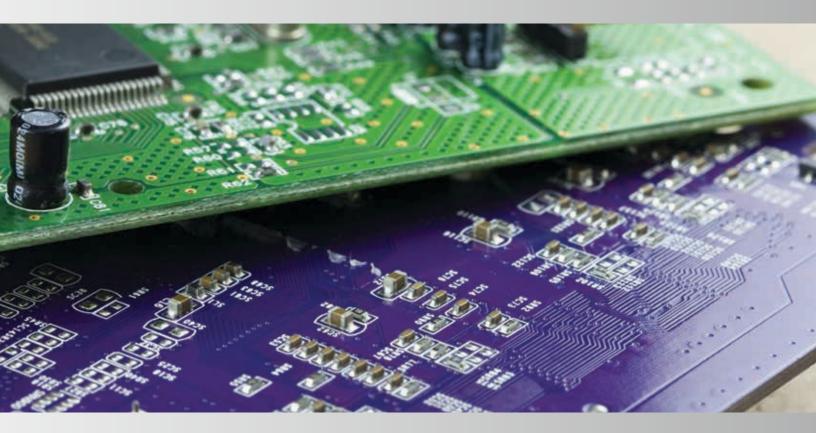
LOCTITE.



LOCTITE® BAR SOLDER

The Electronics group of Henkel, recognized as a global innovation leader in solder materials.

The LOCTITE® bar solder portfolio offers standard, high reliability and low-Ag, Pb-free alloys, as well as industry standard Sn-Pb alloys. Henkel's bar solder offers high purity, high reliability, low oxides and reduced dross levels. Each alloy can be available in standard bar, feeder bar and chips and chunk form.







Henkel's leading role in sustainable development and corporate social responsibility is confirmed by many international rating organizations and sustainability analysts. Our solder materials are Conflict Free, meeting all the regulatory requirements of the Conflict Minerals legislation passed in the U.S. in 2010.





Wave Soldering Testing

- Solder baths need to maintain alloy purity to guarantee high-reliability solder joints.
- Over time, dross forms when molten solder on the surface of the solder reservoir, or bath, comes in contact with oxygen, forming tin oxides (SnO and SnO₂).
- Dross can plug the wave nozzles, which directly affect the solder/lead/PCB interface.
 This can lead to skips or open solder joints.
- To maintain alloy purity, it is important to perform solder pot analysis.





Solder Bar Selector

ALLOY	RoHS COMPLIANT	BAR SOLDER ALLOYS	SILVER CONTENT %	DESCRIPTION	SHAPE	WEIGHT PER BAR (lbs.)	TOTAL WEIGHT PALLET (lbs.)
Pb-Free	Yes	Sn100	0	BAR	RECTANGULAR WITH ROUNDED EDGES	1.0 ± 0.2	250
		99C	0	BAR	TRAPEZOID	2.5 ± 0.2	1,000
		SAC0307	0.3	BAR	TRAPEZOID	2.5 ± 0.2	1,000
		SAC305	3.0	BAR	TRAPEZOID	2.5 ± 0.2	1,000
				FEEDER BAR	RECTANGULAR WITH HOLE	6.25 ± 0.4	1,000
				CHIPS AND CHUNKS	RECTANGULAR AND CYLINDRICAL	0.15	500
		90iSC*	3.8	BAR	TRAPEZOID	2.5 ± 0.2	1,000
Sn-Pb	No	Sn63	0	BAR	RECTANGULAR WITH ROUNDED EDGES	2.0 ± 0.2	2,000
			0	FEEDER BAR	RECTANGULAR WITH HOLE	7.0 ± 0.4	1,000
			0	CHIPS AND CHUNKS	RECTANGULAR AND CYLINDRICAL	0.15	500

All of our alloys conform to IPC J-STD-006B

Dross Recovery Program and Solder Analysis

Dross and scrap solder metal can be considered hazardous waste and should be recycled. Henkel offers solder dross recovery, solder pot swap and solder analysis programs that comply with environmental legislation. Solder pot analysis allows you to know the alloy purity drift against the IPC J-STD-006B industry standard.

Dross Recovery Process





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^{*}To avoid degradation in performance, the alloy should continuously be pumped while in the molten state. Component and PCB metallizations containing Pb should also be avoided.