

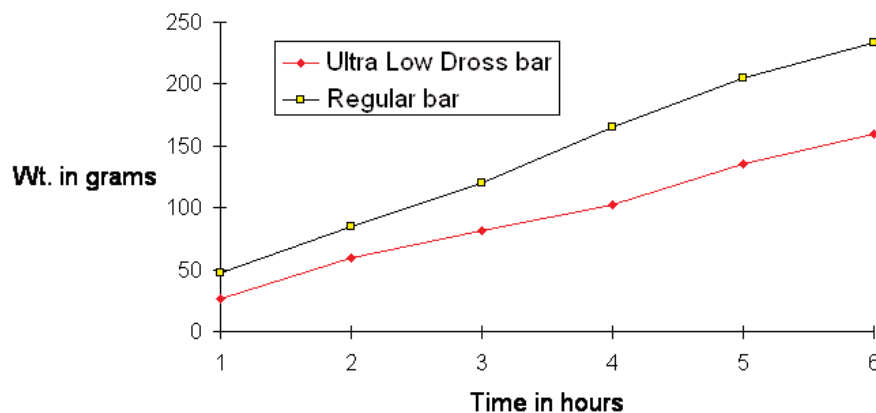
KESTER® ULTRA-LOW DROSS

Extruded Bar Solder Using Low Dross Technology

DESCRIPTION

Kester Ultra-Low Dross Bar Solder was developed to provide lower dross in wave solder, selective solder and dip solder processes. This product is a step above our Ultrapure® line of bar solder.

Dross weight comparison



Results are based on an “in-house” experiment using an aerated 2000 gram solder pot at 260 °C (500 °F).

Available Alloys with Low Dross Properties

Sn63Pb37

PROCESSING GUIDELINES

Many solder impurities have been known to contribute to dross formation. Kester Ultra Low Dross integrates low dross technology with Kester’s extruded bar manufacturing process. To minimize oxidation and alloy segregation, Kester pours and quick chills ingots of solder alloy. The ingot is inserted into an airtight hydraulic press which then extrudes bars in a highly efficient and automated manner.

Kester suggests, as with all our products, that this is purchased directly or through stocking distributors. Kester is the only manufacturer of Ultrapure and Ultrapure Low Dross quality solder. Both conform to the requirements of J-STD-006C (formerly QQ-S-571F).

Maximum Allowed Impurities

Ultrasure meets the requirements of current industry standards for allowable impurity requirements.

Element	J-STD-006C	Kester Ultrasure	Ultra Low Dross
Tin	Component	63.500	63.500
Lead	Component	Balance	Balance
Antimony	0.200	0.200	0.050
Copper	0.080	0.080	0.015
Gold	0.050	0.050	0.002
Aluminum	0.005	0.005	0.002
Cadmium	0.002	0.002	0.001
Zinc	0.003	0.003	0.001
Silver	0.100	0.100	0.050
Bismuth	0.100	0.100	0.020
Arsenic	0.030	0.030	0.020
Iron	0.020	0.020	0.010
Indium	0.100	0.100	0.007
Nickel	0.010	0.010	0.002

DOD-STD-2000-1A (Soldering Technology High Quality/High Reliability) states that it is the responsibility of the manufacturer to select those materials and processes that will produce acceptable high quality/high reliability products. Except where otherwise indicated, the component elements in each alloy shall deviate from their nominal mass percentage by not >0.10% of the alloy mass when their nominal percentage is $\leq 1.0\%$; by not > 0.20% of the alloy mass when their nominal percentage is > 1.0% to $\leq 5.0\%$ or by not > 0.50% when their nominal percentage is > 5.0%.

Storage, Handling and Shelf Life

See ALPHA and Kester Solid Solder Storage, Handling and Shelf Life reference bulletin document for more information.

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area.



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available.**

CONTACT INFORMATION

www.macdermidalpha.com

North America 140 Centennial Avenue Piscataway, NJ 08854 1.800.367.5460	Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400	Asia 8/F., Two Sky Parc 51 Hung To Road Kwun Tong, Kowloon, Hong Kong, SAR China 852.2500.5365
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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