



**STANNOL**<sup>®</sup>

Wenn's ums Löten geht  
When it's about soldering  
Quand il s'agit du soudage

## Technical Data Sheet

### STANNOL<sup>®</sup> Solder Wire HS10

The **electronic solder wire HS10** is a proven and reliable product of Stannol research, which was developed to meet high quality requirements in industrial electronic production as well as for quick rework.

#### Description:

**STANNOL<sup>®</sup> solder wire HS10** is very efficient by its high activity, which results in quick spread of solder and electrical safe residues.

**STANNOL<sup>®</sup> solder wire HS10** is a halide activated rosin (colophony) flux.

**STANNOL<sup>®</sup> solder wire HS10** conforms to DIN EN 29454-1 type 1.1.2. (former DIN 8511 F-SW26).

This activated rosin shows following properties:

- safe soldering even at low soldering temperatures
- solid and dry residues, pin testable
- fast soldering, high spread speed
- high reliability

#### Application:

**STANNOL<sup>®</sup> solder wire HS10** can be used for hand and robot soldering in electronics and electrical assembly, audio devices and telecommunication. Flux residues can remain on surfaces without cleaning. If cleaning is necessary for optical or technical reasons, we recommend the use of the cleaner **STANNOL<sup>®</sup> Flux-Ex 200B** or **STANNOL<sup>®</sup> Flux-Ex 500**.

#### Physical Properties and Data:

General properties	STANNOL <sup>®</sup> solder wire HS10	
Flux type:	type 1.1.2. acc. to DIN EN 29454-1 (F-SW26)	
Flux content:	standard 2.5 weight % ± 0.3 %	
Halide content:	0,9 %	
Corrosion effect:	none, according to DIN 8516	
Standard alloys acc. to DIN EN 29453	<b>lead-containing</b>	<b>lead-free (ECOLOY<sup>®</sup> Series):</b>
	S-Sn60Pb40	<b>ECOLOY<sup>®</sup> TS</b> (S-Sn96Ag4) - <b>not patented</b>
	S-Sn60Pb38Cu2	<b>ECOLOY<sup>®</sup> TSC</b> (Sn95,5Ag3,8Cu0,7)
	S-Pb60Sn40	<b>ECOLOY<sup>®</sup> TC</b> (S-Sn99Cu1) - <b>not patented</b>
	S-Sn62Pb36Ag2	<b>ECOLOY<sup>®</sup> TSC305</b> (Sn96,5Ag3,0Cu0,5)
		<b>ECOLOY<sup>®</sup> TSC263</b> (Sn97,1Ag2,6Cu0,3) - <b>not patented</b>
Available diameters:	from 0.3 mm	
Available reel sizes:	250 g, 500 g, 1 kg	

Other alloys, diameters flux contents or reel sizes are available on request.

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