



## LOCTITE<sup>®</sup> BAR SOLDER

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

The LOCTITE<sup>®</sup> 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 SnO<sub>2</sub>).
- 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                      |
|         |                | 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

\*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.

## 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



Across the Board,  
Around the Globe.  
[www.henkel.com/electronics](http://www.henkel.com/electronics)



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