

# ALPHA® Vaculoy® Wave Solder

## DESCRIPTION

Vaculoy is manufactured using high purity raw materials and the alloy is conditioned using Alpha's VACULOY viscosity and dross lowering treatment. This results in a pure low dross high fluidity solder alloy, which is free of cast in impurities and included oxides.

## FEATURES & BENEFITS

*VACULOY treated prior to casting:* this removes finely divided suspended oxides that are found in all virgin raw materials. This increases the fluidity and hence soldering defects.

- The remove of the finely divided oxide reduces crossing rate, the wave stays cleaner, longer.
- Has a proven track record; no need to take chances.

## APPLICATION

VACULOY is the ideal companion product for all wave soldering systems. VACULOY is idea for the following types of applications:

- High volume wave soldering processes
- Applications requiring dual wave and chip wave systems
- Boards that are densely populated

A solder pot temperature of 240-250° is recommended. For suitable wave solder fluxes, please see our selector guide. Reclaim services, including dedicated lead-free containers, are also available. Please consult your local sales office.

## TECHNICAL SPECIFICATIONS

The following indicates the alloy and impurity limits for VACULOY in relation to J-STD-006A.

| ELEMENT | VACULOY A  | J-STD-006A<br>(Variation A) |
|---------|------------|-----------------------------|
| Sn      | *62.5-63.5 | 62.5-63.5                   |
| Pb      | Balance    | Balance                     |
| Sb      | 0.50 max   | 0.50 max                    |
| Cu      | 0.08 max   | 0.08 max                    |
| Zn      | 0.003 max  | 0.003 max                   |
| Fe      | 0.01 max   | 0.02 max                    |
| As      | 0.03 max   | 0.03 max                    |
| Ni      | 0.01 max   | 0.01 max                    |
| Bi      | 0.10 max   | 0.10 max                    |
| Cd      | 0.002 max  | 0.002 max                   |
| Ag      | 0.005 max  | 0.005 max                   |
| Al      | 0.10 max   | 0.10 max                    |
| In      | 0.10 max   | 0.10 max                    |

All Figures are %

- 1) J-STD-006A: May 2001 Requirements for Electronic Grade Solder alloys and non-fluxed solders. Joint Industry Standard between IPC and Electronic Industries Alliance (US Based). IPC formed in 1957 as an Institute of Printed Circuits. J-STD-006A supercedes IPC-SF-818.

\*For 60Sn/40Pb 59.5-60.5 Sn

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## AVAILABILITY

VACULOY is available in 3.5 kg feeder bars, 1 kg bars, and solder chunks for first fill of solder baths.  
VACULOY is available in the following standard alloy: 63Sn/37Pb and 60Sn/40Pb.

## SAFETY

Please refer to MSDS for advice on proper handling and safety instructions.