created : 11/04/02	SPECIFICATION	
Ref. : Alloy	**High Temperature Machine ALLOY**	
Revised: 23/04/13	**Sn 60 HTF**	

1 – GENERAL CHARACTERISTICS:

Sn60HTF is a ternary solder alloy with a high resistance to oxidation and for use at high temperature.
Sn60HTF is produced exclusively by MBO.

This alloy conforms to NFC 90550 : Sn60PbCuP

2 – CHEMICAL CHARACTERISTICS:

2.1 Amount of Tin : 60 % +/- 0.5%
2.2 Amount of lead : 39.5 to 40.3 %
2.3 Amount of copper : 0.05 to 0.15 %
Cu is not an impurity in this instance, but added.
2.4 Chart of maximum impurities :

Ag	Cd	Sb	Fe	Zn	Al	Bi	As	others
<0.005 %	<0.002 %	<0.05 %	<0.02 %	<0.001 %	<0.001 %	<0.01 %	<0.01 %	<0.05 %

3– PHYSICAL CHARACTERISTICS:

3.1 Melting point : Solidus 183°C to Liquidus 189°C.
3.2 Working temperature : 380°C to 500°C
3.3 Specific Weight : 8.5

4– METHODS OF USE:

This alloy is especially suitable for soldering parts used at high temperatures, and can be used in pots and baths.
A surface film forms at 380°C which allows the penetration of wire for tinning but stops air oxidising the molten alloy.
In particular this works very well strip/tinning enamelled copper wires.

5 – PACKAGING :

4.1 Standard : Sticks – 380x16x8mm in Cartons of 25 Kg.
Extruded bars in cartons of approx. 22 Kg
4.2 Others : Wire, ingots, other: on request.
4.3 Labelling : Cartons/containers labels show manufactured lot N° and Alloy.
4.4 QA : Certificates of conformity can be supplied with each lot if required.

6 – STORAGE :

5.1 : In original packaging, at an average temperature of 20°C for 12 months.

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